

GENERAL DYNAMICS
SATCOM Technologies

4096-351
May 13, 2016
REVISION D

ASSEMBLY MANUAL

**2.4 METER
FEED SYSTEM STABILIZER**

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2.4 METER FEED SUPPORT STABILIZER

D	Add Conover Address	5/13/16	RAH
C	Revised per ECN# 4847	3/25/2014	JWL
B	Revised Company Name, Logo, and Part Tables	7/14/09	RAH
A	REV. FOR BOTH 4-PC & 2-PC 2.4 METER	03/21/95	RF
-	ORIGINAL RELEASE	1/04/94	RF
REV.	DESCRIPTION	DATE	APPROVED

ASSEMBLY INSTRUCTIONS

NOTE: General Dynamics' Feed Support Stabilizer is attached after the antenna system is aligned and all hardware has been securely tightened. Refer to the figures and the parts list. Follow the instructions in the listed sequence.

4 PIECE 2.4M

STEP 1: Remove one (1) feed support bolt and attach one mounting bracket (item# 1) to the feed support with a longer bolt (item# 9, supplied in the parts kit) and the original washers. Securely tighten the bolt, making sure the bracket is parallel with the feed support tube. **Note: Do not loosen both feed support bolts simultaneously as this may effect the feed alignment.**

2 PIECE 2.4M

Remove the feed support bolt on the right side when looking from rear, and attach with right side mounting bracket (item# 1) to the feed support with a longer bolt (item #9) and the original washers. Securely tighten the bolt, making sure the bracket is parallel with the feed support tube. **Note: Do not loosen both feed support bolts simultaneously as this may effect the feed alignment.** Attach left side mounting bracket (item #1a) on left side when looking from rear, now.

STEP 2: Place a 1/2" flatwasher (item# 10) on one post of the pivot collar (item# 2) and insert through the mount bracket. Place a 1/2" flatwasher on the opposite post of the pivot collar and attach the remaining mount bracket, as detailed in step #1, with the 1/2" nut on the swivel collar pointing away from the feed support tube. Tighten securely.

STEP 3: Bolt the two mast collar brackets (items# 3,4) around the mast pipe with two 2.25" long bolts (item# 6), two flatwashers, two lockwashers, and two hex nuts of the appropriate size. The two mounting tabs on item# 4 go toward the feed support tube. Do not tighten.

STEP 4: Slide the feed stabilization tube (item# 5) through the swivel collar with the drilled end towards the mast. Loosely attach the tube between the mast collar mounting tabs with the 3/8-16 x 3.00" bolt, two flatwashers, lockwasher, and 3/8-16 hex nut (items# 8,11,13,15).

STEP 5: By sliding the mast collar up or down the mast, you can position the feed stabilization tube as parallel to the feed support tube as the feed components allow. Tighten the mast collar hardware, keeping the stabilization tube in-line with the feed support tube.

STEP 6: Tighten the 3" bolt in the stabilization tube, then insert the 1/2-13 x 1.50" square head screw and 1/2-13 hex nut (items# 7,14) into the swivel collar and tighten securely.

STEP 7: Place a 1/2" flatwasher, lockwasher, and hex nut (items# 10,12,14) on each post of the swivel collar and tighten securely.

PARTS LIST			
ITEM#	PART#	DESCRIPTION	QTY
1	0490-489	MOUNTING BRACKET - 4-Pc	2
1A	0490-528	MOUNTING BRACKET - RH - 2PC	2
1A	0490-529	MOUNTING BRACKET, LH - 2PC	2
2	0490-368	PIVOT COLLAR	1
3	0188-113	MAST COLLAR BRACKET W/O TABS	1
4	0490-393	MAST COLLAR BRACKET W/ TABS	1
5	0250-469	FEED STABILIZATION TUBE	1
6	8032-018	BOLT, 3/8-16 x 2.25"	2
7	8317-002	SCREW, SHCP, 1/2-13 x 1.50"	1
8	8032-024	BOLT, 3/8-16 x 3.00"	1
9	8031-012	BOLT, 5/16 x 1.50"	2
10	8201-043	FLATWASHER, 1/2"	4
11	8201-042	FLATWASHER, 3/8"	6
12	8202-043	LOCKWASHER, 1/2"	2
13	8202-042	LOCKWASHER, 3/8"	3
14	8104-007	NUT, HEX, 1/2-13	2
15	8102-007	NUT, HEX, 3/8-16	3

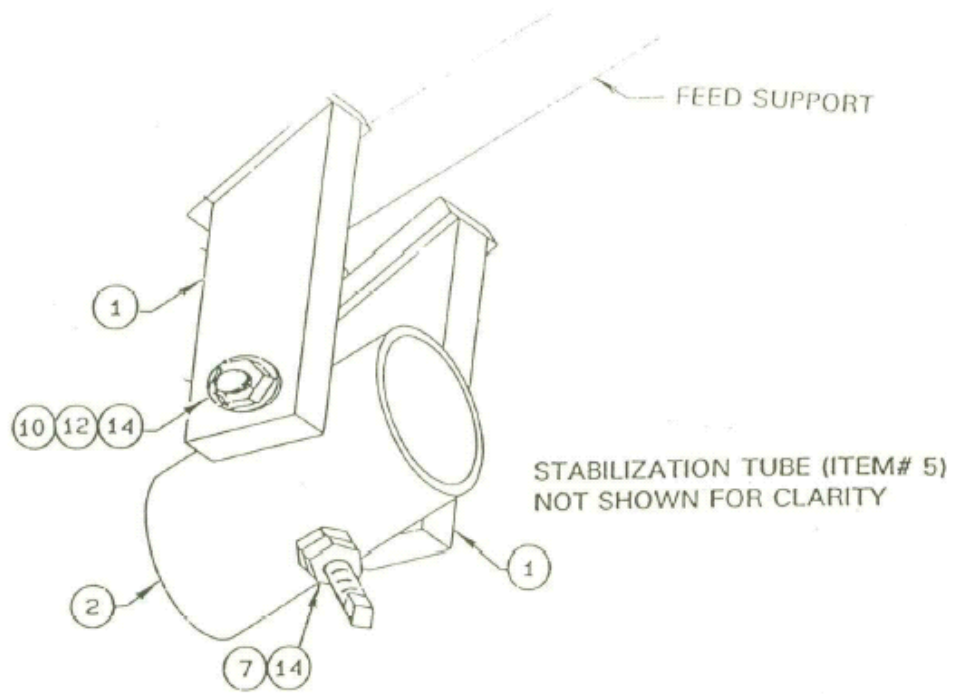


Figure 1

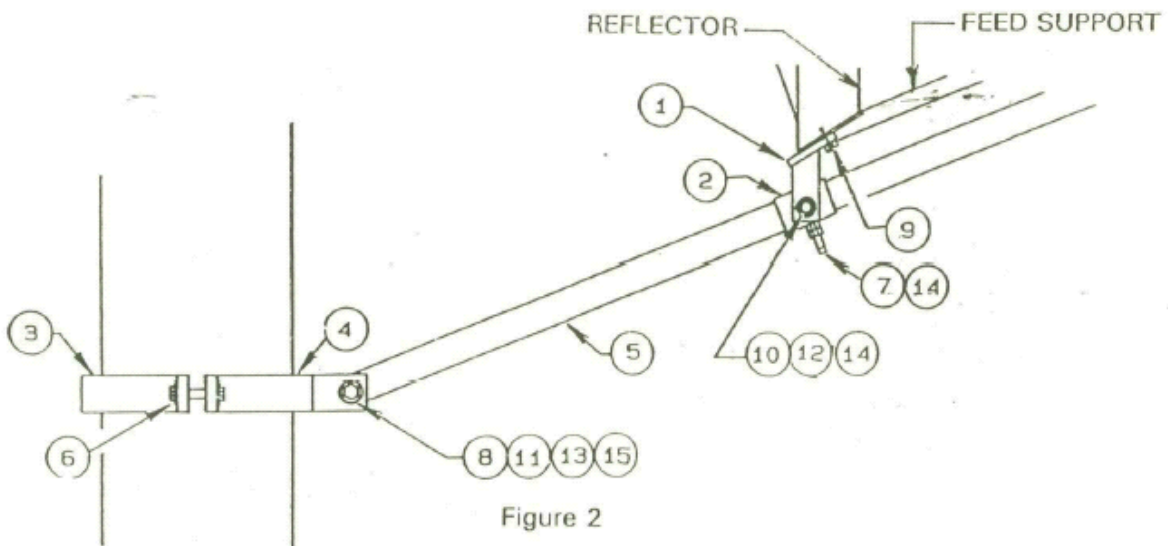
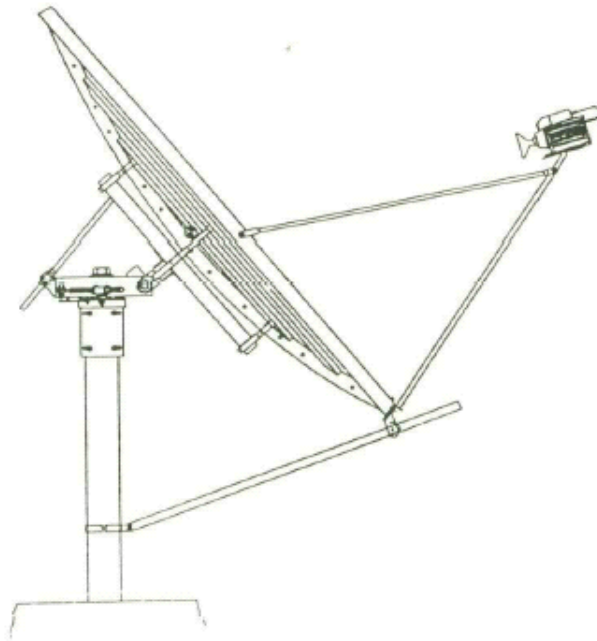
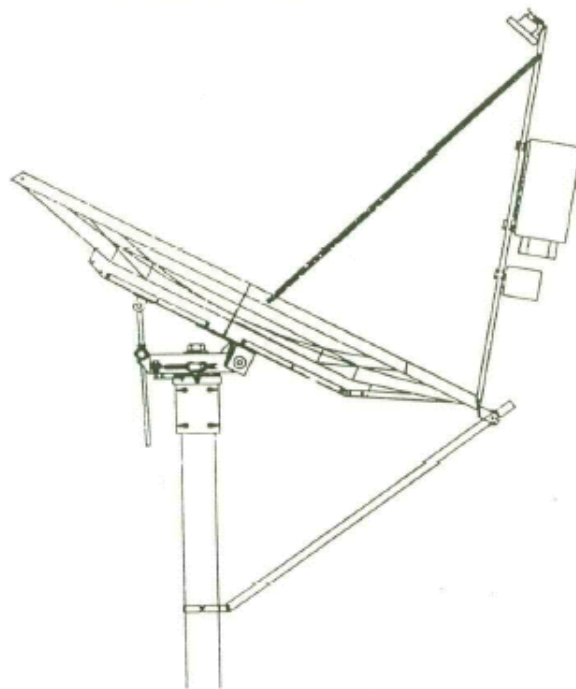


Figure 2



2 Piece 2.4 Meter



4 piece 2.4 Meter