

Stage1-2 Horizontal:

1. Align and attach "Actuator Assembly" to "stage2 interposer plate" (D0902162) with correct screws & pins.
2. Align and attach "Bobbin Bracket"(D0902155) to "Actuator Bobbin" with correct pins & screws.
3. Align and attach "Tooling Bracket"(D0902136) to "stage2 interposer plate" (D0902162) ) with correct screws & pins.
4. Align and insert 2x "Pin Key"(D0902434) through the "Tooling Bracket"(D0902136) and into the "Bobbin Bracket"(D0902155). Hold in place with correct screws.

Stage1-2 Vertical:

1. Align and attach "Actuator Assembly" to "stage2 Magnet Mount" (D0902161) with correct screws & pins.
2. Align and attach "Bobbin Bracket"(D0902155) to "Actuator Bobbin" with correct pins & screws.
3. Align and attach "Tooling Bracket"(D0902137) to "stage2 Magnet Mount" (D0902161) with correct screws & pins.
4. Align and insert 2x "Pin Key"(D0902434) through the "Tooling Bracket"(D0902137) and into the "Bobbin Bracket"(D0902155). Hold in place with correct screws.

Stage0-1 Horizontal:

1. Align and attach "Actuator Assembly" to Stage1 Magnet Bracket"(D0902310) with correct screws & pins.
2. Align and attach "Coil Bracket"(D0902427) to "Actuator Bobbin" with correct pins & screws.
3. Align and attach "Tooling Bracket"(D0902342) to "Coil Bracket"(D0902427) with correct screws & pins.
4. Align and insert 2x "Pin Key"(D0902433) through the "Tooling Bracket"( D0902342) and into the "Bobbin Bracket"(D0902155). Hold in place with correct screws.

Stage0-1 Vertical:

1. Align and attach "Actuator Assembly" to Stage1 Magnet Bracket"(D0902310) with correct screws & pins.
2. Align and attach "Coil Bracket"(D0902426) to "Actuator Bobbin" with correct pins & screws.
3. Align and attach "Tooling Bracket"(D0902342) to "Coil Bracket"(D0902426) with correct screws & pins.
4. Align and insert 2x "Pin Key"(D0902433) through the "Tooling Bracket"( D0902342) and into the "Bobbin Bracket"(D0902155). Hold in place with correct screws.

