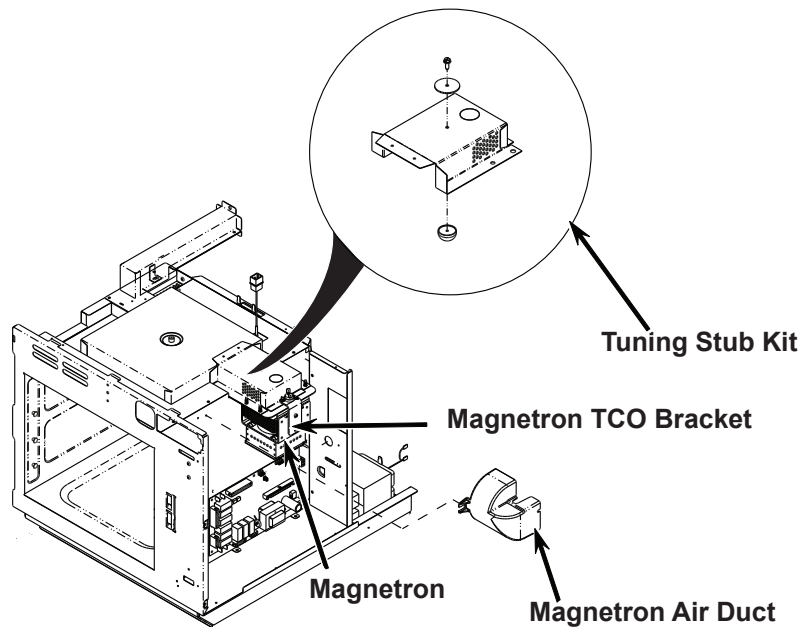


# INSTRUCTION SHEET

# 16200031

Description: ACE Tuning Stub Kit # 14090020

Contents: 1 – 12392204 Tuning Stub  
1 – 13041501 Screw  
1 – 20003201 Washer  
1 – 16200031 Instruction Sheet



1. Remove outer case.
2. Remove screws holding magnetron tco bracket to magnetron.
3. Remove hex head screw holding magnetron air duct and remove magnetron air duct.
4. Remove hex head nuts securing magnetron tube to wave guide and remove magnetron tube to access wave guide.
5. Remove existing tuning stub.
6. Inspect inside of wave guide with flashlight through magnetron opening checking for arcing in wave guide and around tuning stub mounting surface.

**Important:** If arcing has occurred it is critical to thoroughly clean area around tuning stub using straight edge putty knife followed by emery cloth or equivalent to remove arc debris from tuning stub surface. All residue from this cleaning must be removed from wave guide.

7. Using a piece of tape wrapped around finger with sticky side out, place tuning stub to the end of finger and place it up into wave guide through magnetron tube opening and align it with the screw hole in the wave guide. Install screw and washer and tighten securely. Flat washer should deform, which assures proper tightening.
8. Replace magnetron, tco bracket, magnetron air duct and reattach wires as required.
9. Reinstall outer case and check for proper operation.