

Caliber : 9231 / 1910

Function : Hour, Minute, Second hands, Sun & Moon

Items	Operations	Tools	Remarks
<b>1. Component's Visual checking</b>	<ol style="list-style-type: none"> <li>1) Check the dial: need to flat, no scratches, no dust, no finger spots, no discoloration.</li> <li>2) Check the hands: flat, no scratches, no dust, no finger spots.</li> <li>3) Check the Case, case back and glass: no scratches, no dust, no finger spots, no discoloration.</li> <li>4) Check the hand setting stem: not bent; the crown has to turn round.</li> </ol>		On the casing line, each component has to be checked visually by the collaborator just before assembly.
<b>2. Dial fitting</b>	<ol style="list-style-type: none"> <li>1) Align the dial legs to correct position then assemble it.</li> <li>2) Check the centered of dial hole.</li> </ol>	<p><b>TRM03-01</b> 3-head Handfitting tool with movement holder TRT01-32B ( for fitting hour, minute &amp; second hands)</p>	If the dial hole is not centered, will affect the hands running or the hands offset.
<b>3. Hour, Minute &amp; Second hands Fitting</b>	<ol style="list-style-type: none"> <li>1) The crown remains at position 2. Same as time-setting, turn the crown clockwise to change the Sun &amp; Moon disc. As soon as the sun or the moon is point to 12 o'clock, stop immediately. Then, put the movement into the movement holder TRT01-32B of the handfitting tool TRM03-01.</li> <li>2) Set the hour hand, minute hand and second hand one after one. Point them all to 12 o'clock.</li> <li>3) First check the flatness and the height of all hands. Then turn the crown clockwise check if the Sun &amp; Moon indicator run synchronize with the hour &amp; minute hands:</li> </ol>		<ol style="list-style-type: none"> <li>1) This step must be followed accordingly, if not, the hour hand running will not synchronize with the Sun &amp; Moon disc running .</li> <li>2) If the sun or the moon of the Sun &amp; moon disc can not point to the 12 o'clock when the hour &amp; minute hands point to 12 o'clock , you have to reassemble the hour hand and minute hands.</li> </ol>
<b>4. Stem Removing</b>	<ol style="list-style-type: none"> <li>1) Use the tweezers tip or other suitable tooling to press down the setting lever slightly then take out the stem.</li> </ol>	<p><b>TRT01-32B</b> Movement holder</p>	
<b>5. Casing</b>	<ol style="list-style-type: none"> <li>1) Put the movement into the case and remove dust and particles.</li> <li>2) Fit the handsetting.</li> <li>3) Put and close the case back.</li> </ol>		