

Casing Guide

ISA PACIFIC Co., Ltd.

Room 1605, 16/F., Eastern Centre, 1065 King's Road, Quarry Bay, Hong Kong Tel: (852) 2168 3388 Fax: (852) 2552 3181 Email: sales@isa-pacific.com Web site: www.isaswiss.com

Caliber : 9232 / 1940 Function : Date, Second Time Zone / 24-hour

Items		Operations	Tools	Remarks
1. Component's Visual checking	1) 2) 3)	Check the dial: need to flat, no scratches, no dust, no finger spots, no discoloration. Check the hands: flat, no scratches, no dust, no finger spots. Check the Case, case back and glass: no scratches, no dust, no finger spots, no discoloration.	موجد مود مود	On the casing line, each component has to be checked visually by the collaborator just before assembly.
	4)	Check the hand setting stem: not bent; the crown has to turn round.		
2. Dial fitting	1) 2)	Align the dial legs to correct position then assemble it. Check the centered of dial hole.	TRM03-01 3-head Handfitting tool with movement holder TRT01-32D (for fitting small hands)	If the dial hole is not centered, will affect the hands running or the hands offset.
3. Second Time Zone / 24 hour 、 Hour、Minute & Second	1)	Pull out the crown to position 3. Same as time-setting, turn the crown to change the date. Stop immediately as soon as the date jumps. Then put the movement into the movement holder TRT01-32D of the handfitting tool TRM03-01. Set the Second Time Zone / 24 hour hand onto the counter		This step must be followed accordingly when setting the hands, otherwise, the Second Time zone/24-hour hand will not synchronize with the central hour hand. Meanwhile, the date cannot be changed at 00:00 midnight. You have to reassemble the hour hand and minute hand.
hands Fitting	3)	pivot at 6 o'clock, and make it point to the hour index. Set the hour hand, minute hand and second hand in turn. Point it all to 12 o'clock.		
	4)	First check the flatness and the height of all hands, then check the Second Time Zone / 24 hour hand should synchronize with the hour hand.		
4. Stem Removing	1)	Use the tweezers tip or other suitable tooling to press down the setting lever slightly then take out the stem.	TRM03-01 3-head Handfitting tool with movement holder TRT01-32D (for fitting Hour, Minute & Second small hands)	
5. Casing	1) 2) 3)	Put the movement into the case and remove dust and particles. Fit the handsetting. Put and close the case back.		
6. Watch head Initialization	1.	Pull the crown out to position 2, test the quick date adjusting function, push the crown back to original position.Press the button on the case, test the quick adjusting function Second Time Zone / 24 hour in turn.	TRT01-32D Movement holder	 Do not quickly adjust date between 21 : 00 and 00 : 30 . Do not turn the crown anti-clockwise during quick date adjusting. If you turn the crown anti-clockwise for time-setting, the hour hand running will not synchronize with the second time zone hand running. Use the quick adjusting of second time zone hand to adjust.

© 2008 ISA Group. All rights reserved. ISA may make changes to specifications and product descriptions at any time, without prior notice.