

Casing Guide

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Caliber : 9232 / 1950

Function : Hour, Minute & Second hands, Date, Day

Items		Operations	Tools	Remarks
1. Component's Visual	1)	Check the dial: need to flat, no scratches, no dust, no finger spots, no discoloration.		On the casing line, each component has to be checked
checking	2)	Check the hands: flat, no scratches, no dust, no finger spots.		visually by the collaborator
	3)	Check the Case, case back and glass: no scratches, no dust, no finger spots, no discoloration.		just before assembly.
	4)	Check the hand setting stem: not bent; the crown has to turn round.	III	
2. Dial fitting	1)	Align the dial legs to correct position then assemble it.		If the dial hole is not
	2)	Check the centered of dial hole.	TRM03-01	centered, will affect the hands running or the hands offset.
3. Day hand	1)	Pull the crown out to position 3, same as time-setting, turn it	3-head Handfitting tool with	1) Incorrect positioning or
Fitting		until the date disc is going-to jump. Then put the Movement with dial into the Hand Fitting Holder (TRT01-32D) of TRM03-01 Hand Fitting Machine.	movement holder TRT01-32D (for fitting small hands)	excessive strength may result in breakage or bend of the small hand.
	2)	Set the day hand onto the day counter pivot at 9 o'clock, align it to point the centre of any day as printed on the day sub-dial. For example: "MON", the day hand should point to the centre of the letter "O".		 Do not set the day hand if the day counter is in the state to jump-turn, otherwise the hands may
			III	risk to be misplaced and point to wrong positions.
4. Hour, Minute & Second hands Fitting	1)	Keep the crown at 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.		This step must be followed accordingly when setting the hands, otherwise, the Second Time zone / 24 hour hand
	2)	Set the hour hand, minute hand and second hand in turn. Point it all to 12 o'clock.	TRM03-01 3-head Handfitting tool with	will not synchronize with the central hour hand. Meanwhile, the date cannot
	1)	Check the flatness and the height of all hands.	movement holder TRT01-32D (for fitting Hour, Minute & Second hands)	be changed at 00:00 midnight.
5. Test the adjusting functions of date, day	1)	Keep the crown at position 3. Turn it clockwise until the hour hand passes 00:00 midnight. The date hand will change for one day.		Date advances one step (change for one day) when the hour hand passes 00:00.
	2)	Continue to turn the crown clockwise, until the hour hand points to anytime between 00:00 midnight and 04:00 in the morning, the day will change for one day (Note : The day hand needs to jump 2 steps to complete the change for one day.)		If not, you have to reassemble the hour hand and minute hand.
	3)	Push the crown back to position 2, test the quick date adjusting function.	1 × 1 ×	
6. Stem Removing	1)	Use the tweezers tip or other suitable tooling to press down the setting lever slightly then take out the stem.	TRT01-32D Movement holder	
7. Casing	1)	Put the movement into the case and remove dust and particles.		
	2)	Fit the handsetting.		
	3)	Put and close the case back.		

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