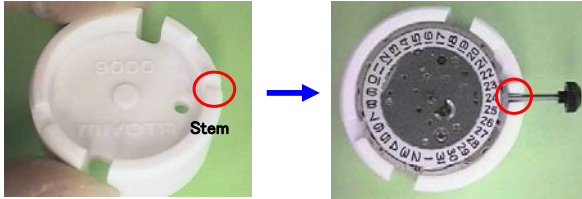


# Cal. 9015/90S5 Assembly manual



## 1. Setting movement on the movement holder.

Set movement as below pictures show. (\* Movement holder is enclosed with the products.)



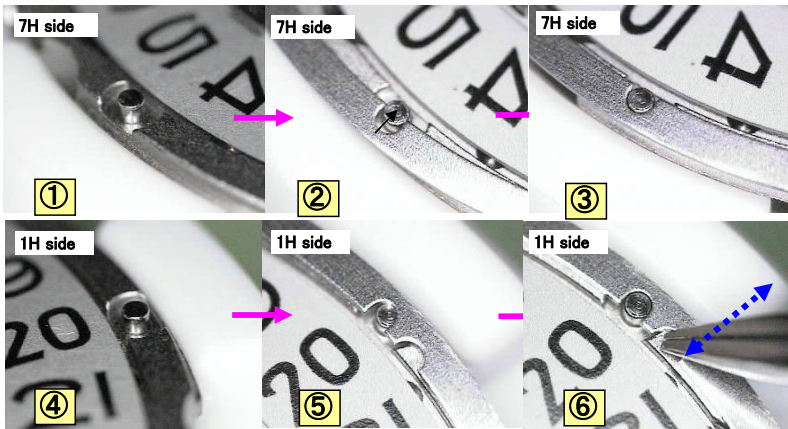
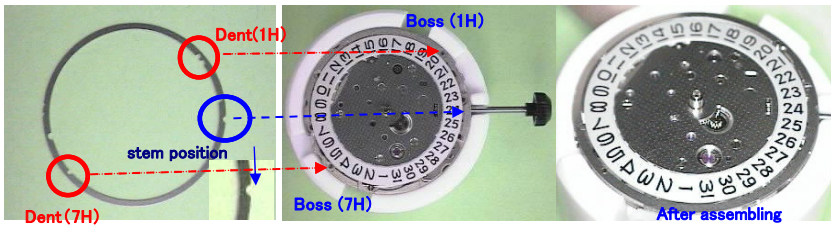
## 2. Setting the metal ring on the movement.

See below pictures and set the ring on boss of 1H/7H position. The dent of 3H stem position will be marker.

Note on setting 7H side at first when setting the ring. (\* The metal ring is enclosed with the product.)

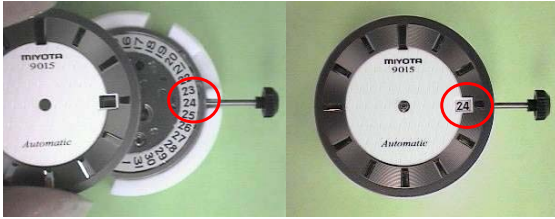
Also, note on below point when you set the ring.

- Not to scratch on date dial (9015)
- Not to uplift or slip from movement.



### 3. Assembling the dial.

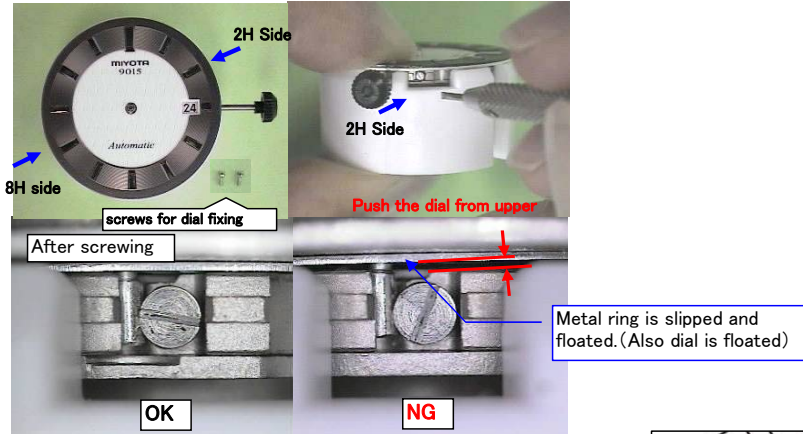
a:) Put the dial on the metal ring.



b:) Install "screws for dial fixing" in the threaded hole on 2H/8H side of the movement, and screw up tightly with pushing the dial from upper.

\* Check below points

- Not to slip the dial from movement when the movement upside down after screwing up.
- Not to slip the metal ring from movement. (ref. below pictures)

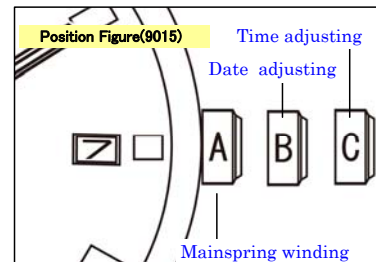


### 4. Hand fitting.

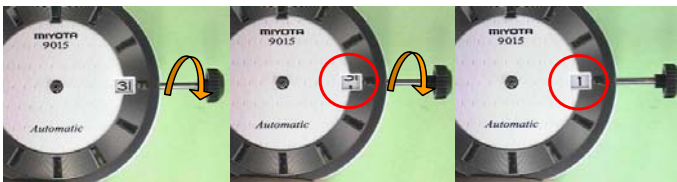
a:) Push the crown back to A position (ref. Right figure)  
Turn the crown clockwise over 10 times and wind the mainspring.

b:) (9015)

Pull the crown out to C position  
Turn the crown counter-clockwise, and **stop right after changing the date.**

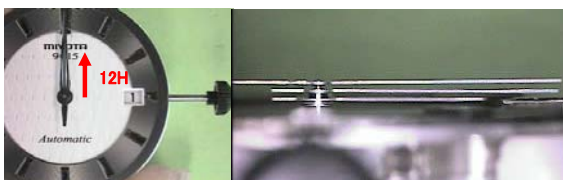


\*90S: A=Mainspring winding / B=Time adjusting / C=N/A



C:) Fit each hands standing straight up as following order.

- 1 Hour hand
- 2 Minute hand
- 3 Second hand



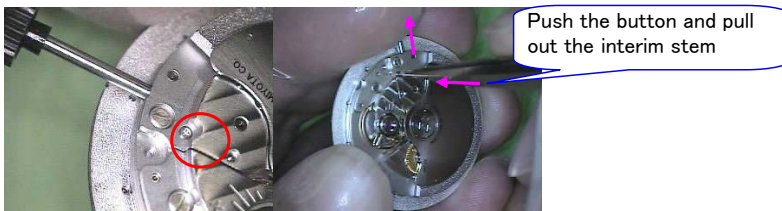
Fit each hands(H/M)

D:) Check below points.

- 1 Turn the crown clockwise & counter clockwise, and check each hands turning well.
- 2 Check the time of changing the date whether the time is within your standard (9015).
- 3 Check the gap between hour hand and minute hand when adjusting the time 12H position whether the gap is within your standard.

## 5. Case fitting

- a) Push the crown back to A position, and pull out the interim stem as the following picture shows.  
\*The stem can be pulled out easily by pushing the button near the stem.



- b) Clean inside the case by blowing the air into the case.  
\*Do not blow the air around the balance wheel of movement.

- c) Fit the movement into the case by the following procedures.



- d) Insert the stem slowly.  
\*Check the crown is set and stem length is correctly adjusted.



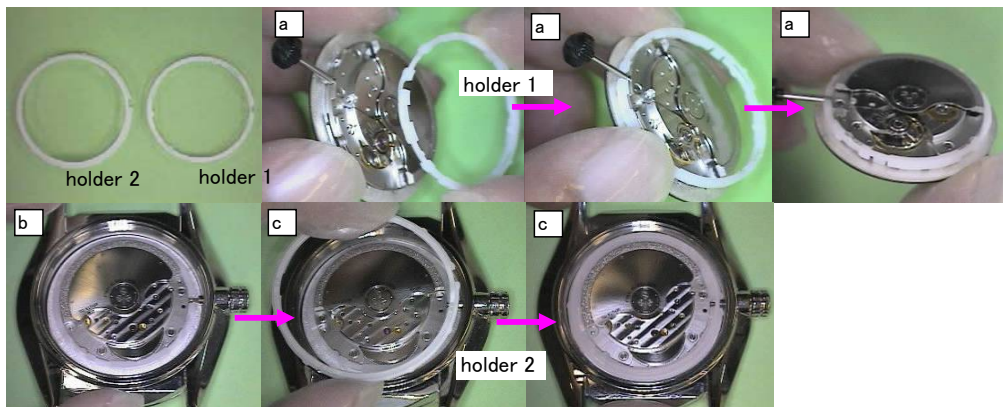
## 6. Plastic movement holder fitting (In the case of united holder)

Set the movement holder inside the case as the following picture shows.



### **Supplement) In the case of separated holder**

- a:) After matching stem position, and set the holder 1 from downward of the interim stem.  
b:) Pulling out the interim stem, and fit the movement into the case.  
b:) After matching stem position, and set the holder 2.



## 7. Fasten the caseback.

## 8. Check the running condition.

- a) Confirm hands and case are not touching each other.  
b) Turn the crown and confirm the calendar and time setting can be done correctly.