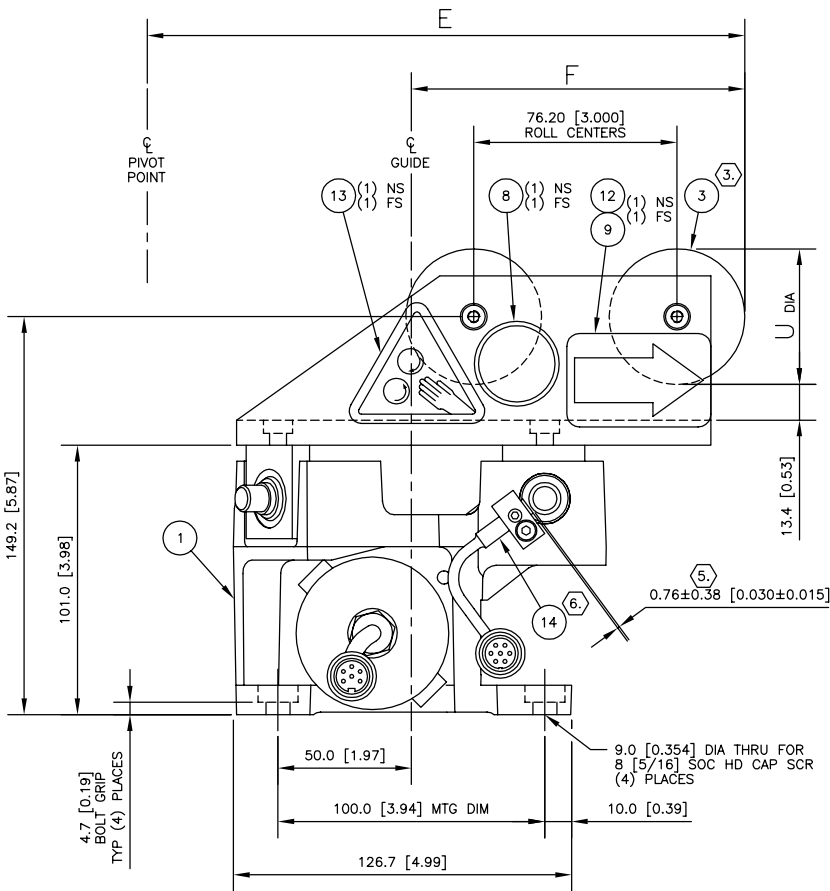
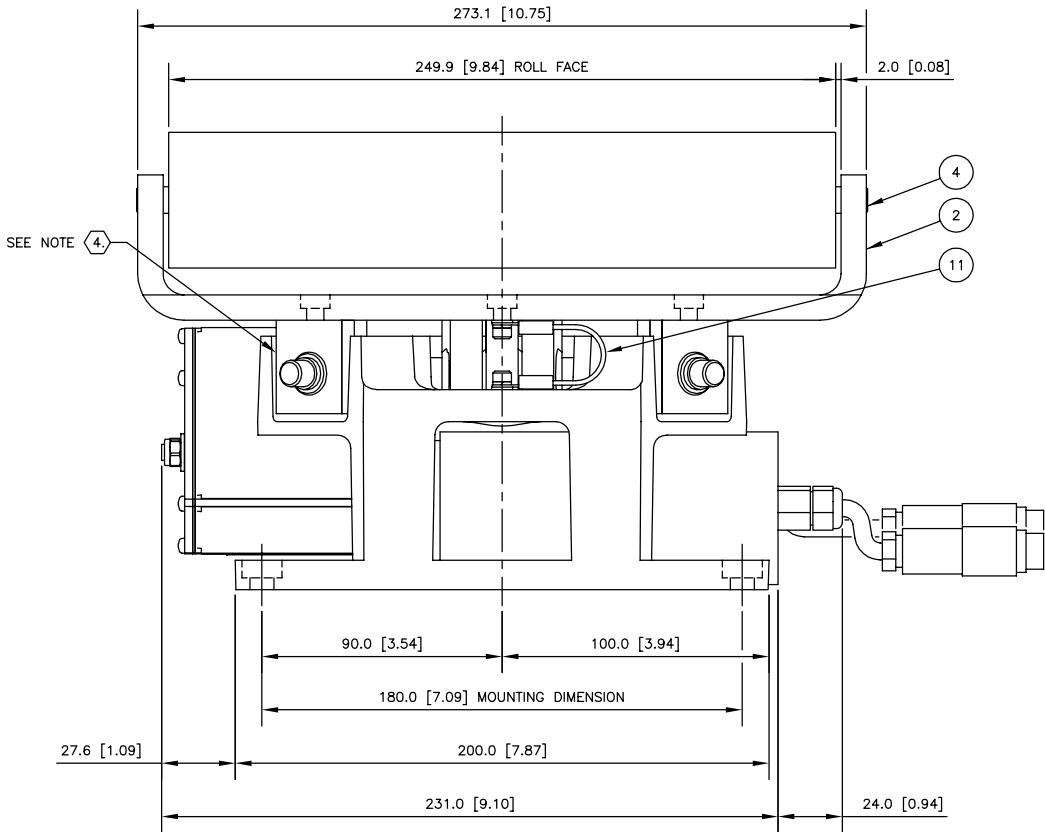


NOTES:

- THIS GUIDE HAS BEEN APPROVED FOR ALL WRAP STYLES. POSITION THE LOGOS TO BE RIGHT SIDE UP AFTER THE GUIDE IS INSTALLED. SEE WRAP STYLE FOR PROPER ORIENTATION.
- MAXIMUM ANGLE OF CORRECTION = 5.7°
- STANDARD FACTORY ALIGNMENT OF GUIDE ROLLERS TO EACH OTHER AND MOUNTING BASE TO BE WITHIN 0.254 [0.010] TIR.
- ALIGN THE CARRIER BLOCKS TO BE PERPENDICULAR TO THEIR RESPECTIVE RACERODS WHEN THE PIVOT CARRIER IS CENTERED AT MID-STROKE.
- THE NOTED DIMENSION IS THE 'AIR GAP' BETWEEN THE END OF THE SERVO CENTER AND THE O.D. OF THE 12mm RACEROD IF THE GUIDE IS EQUIPPED WITH THE SERVO CENTER OPTION.
- REFER TO SALES ORDER OR SYSTEM BLOCK DIAGRAM FOR SERVO CENTER REQUIREMENT AND CABLE LENGTH. SERVO CENTER KIT P/Ns ARE AS FOLLOWS:  
201848-005 VARIABLE LENGTH, 1M [3 FT] TO 4.7M [15 FT]  
201848-006 5M [16 FT]
- APPROXIMATE WEIGHT IS 3 KG [6.6 LB]

| NO. REQD |     |     |     |     |     |     |     |     |     | LIST OF MATERIAL |     |            |  |
|----------|-----|-----|-----|-----|-----|-----|-----|-----|-----|------------------|-----|------------|--|
| 216912-  |     |     |     |     |     |     |     |     |     | ITEM NO.         | M K | PART NO.   | DESCRIPTION                                      |
| 010      | 009 | 008 | 007 | 006 | 005 | 004 | 003 | 002 | 001 |                  |     |            | DS-25 OFFSET PIVOT GUIDE ASSEMBLY                |
| 1        | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1                |     | 201003-001 | RACEWAY BASE ASSEMBLY                            |
| 1        | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 2                |     | 82664-001  | PIVOT CARRIER                                    |
| -        | -   | -   | -   | -   | -   | -   | -   | 2   | 2   | 3                |     | 76881-003  | ROLLER ASSY, 50.8 [2.00] DIA X 249.9 [9.84] FACE |
| -        | -   | -   | -   | -   | -   | 2   | 2   | -   | -   |                  |     | 76881-008  | ROLLER ASSY, 50.8 [2.00] DIA X 249.9 [9.84] FACE |
| -        | -   | -   | -   | 2   | 2   | -   | -   | -   | -   |                  |     | 76881-011  | ROLLER ASSY, 50.8 [2.00] DIA X 249.9 [9.84] FACE |
| -        | -   | 2   | 2   | -   | -   | -   | -   | -   | -   |                  |     | 76881-018  | ROLLER ASSY, 50.8 [2.00] DIA X 249.9 [9.84] FACE |
| 2        | 2   | -   | -   | -   | -   | -   | -   | -   | -   |                  |     | 76881-022  | ROLLER ASSY, 50.8 [2.00] DIA X 249.9 [9.84] FACE |
| 4        | 4   | 4   | 4   | 4   | 4   | 4   | 4   | 4   | 4   | 4                |     | 76882-001  | STUB SHAFT                                       |
| 4        | 4   | 4   | 4   | 4   | 4   | 4   | 4   | 4   | 4   | 5                |     | 26704-001  | CUP PT SET SCR, M4 X 4mm LG                      |
| 3        | 3   | 3   | 3   | 3   | 3   | 3   | 3   | 3   | 3   | 6                |     | 90907-002  | SOC HD CAP SCR (LOW HD), M6 X 12mm LG            |
| 3        | 3   | 3   | 3   | 3   | 3   | 3   | 3   | 3   | 3   | 7                |     | 26715-004  | SPRING LOCKWASHER, M6                            |
| 2        | 2   | 2   | 2   | 2   | 2   | 2   | 2   | 2   | 2   | 8                |     | 16409-001  | FIFE LOGO, 32 [1-1/4] DIA                        |
| 1        | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 9                |     | 76938-001  | WEB DIRECTION LABEL, RIGHT HAND                  |
| 1        | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 10               |     | 202984-001 | OPG NAMEPLATE                                    |
| 1        | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 11               |     | 46833-004  | GROUNDING STRAP KIT                              |
| 1        | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 1   | 12               |     | 76938-002  | WEB DIRECTION LABEL, LEFT HAND                   |
| 2        | 2   | 2   | 2   | 2   | 2   | 2   | 2   | 2   | 2   | 13               |     | 92403-051  | WARNING LABEL                                    |
| 1        | -   | 1   | -   | 1   | -   | 1   | -   | 1   | -   | 14               |     | 201848-XXX | ISCT-03 SERVO CENTER KIT                         |

| FIFE P/N   | SERVO CENTER | ROLLER FINISH               | E            | F            | U           |
|------------|--------------|-----------------------------|--------------|--------------|-------------|
| 216912-001 | WITHOUT      | STANDARD                    | 224.0 [8.82] | 124.9 [4.92] | 50.8 [2.00] |
| 216912-002 | WITH         | STANDARD                    | 224.0 [8.82] | 124.9 [4.92] | 50.8 [2.00] |
| 216912-003 | WITHOUT      | HARD COAT ANODIZE           | 224.0 [8.82] | 124.9 [4.92] | 50.8 [2.00] |
| 216912-004 | WITH         | HARD COAT ANODIZE           | 224.0 [8.82] | 124.9 [4.92] | 50.8 [2.00] |
| 216912-005 | WITHOUT      | DRAGON ELITE II PLASMA COAT | 224.0 [8.82] | 124.9 [4.92] | 50.8 [2.00] |
| 216912-006 | WITH         | DRAGON ELITE II PLASMA COAT | 224.0 [8.82] | 124.9 [4.92] | 50.8 [2.00] |
| 216912-007 | WITHOUT      | RUBBER CORK TAPE            | 225.5 [8.88] | 126.5 [4.98] | 54.0 [2.13] |
| 216912-008 | WITH         | RUBBER CORK TAPE            | 225.5 [8.88] | 126.5 [4.98] | 54.0 [2.13] |
| 216912-009 | WITHOUT      | 11036 PLASMA COAT           | 224.0 [8.82] | 124.9 [4.92] | 50.8 [2.00] |
| 216912-010 | WITH         | 11036 PLASMA COAT           | 224.0 [8.82] | 124.9 [4.92] | 50.8 [2.00] |



| DRAWING REFERENCE   |  | NUMBER   |  |
|---|--|--|--|
| UNLESS OTHERWISE SPECIFIED  |  | THIS DRAWING IS THE PROPERTY OF FIFE CORPORATION. IT IS LOANED WITH THE UNDERSTANDING THAT IT MAY NOT BE REPRODUCED NOR MAY THE INFORMATION CONTAINED HEREIN BE USED FOR THE MAKING OF DRAWINGS OR FOR MANUFACTURING PURPOSES WITHOUT THE WRITTEN CONSENT OF FIFE CORPORATION. |  |
| GENERAL TOLERANCES:   |  | ISO 2768-mk  |  |
| GEOMETRICAL SYMBOLS:  |  | ISO 1101   |  |
| SURFACES:   |  | ISO 1302   |  |
| STANDARD SHOP PRACTICES AND STANDARD SHOP TOLERANCES PER DRAWING 201724 |  | DE-SURE ALL EDGES 0.5 [0.020] MAX  |  |
| LOCATION  |  | OK   |  |
| SCALE   |  | 3:4  |  |
| SIZE  |  | A1   |  |
| DRAWING NO.   |  | 216912   |  |
| SHEET NO.   |  | 1 OF 1   |  |
| REV   |  |  |  |