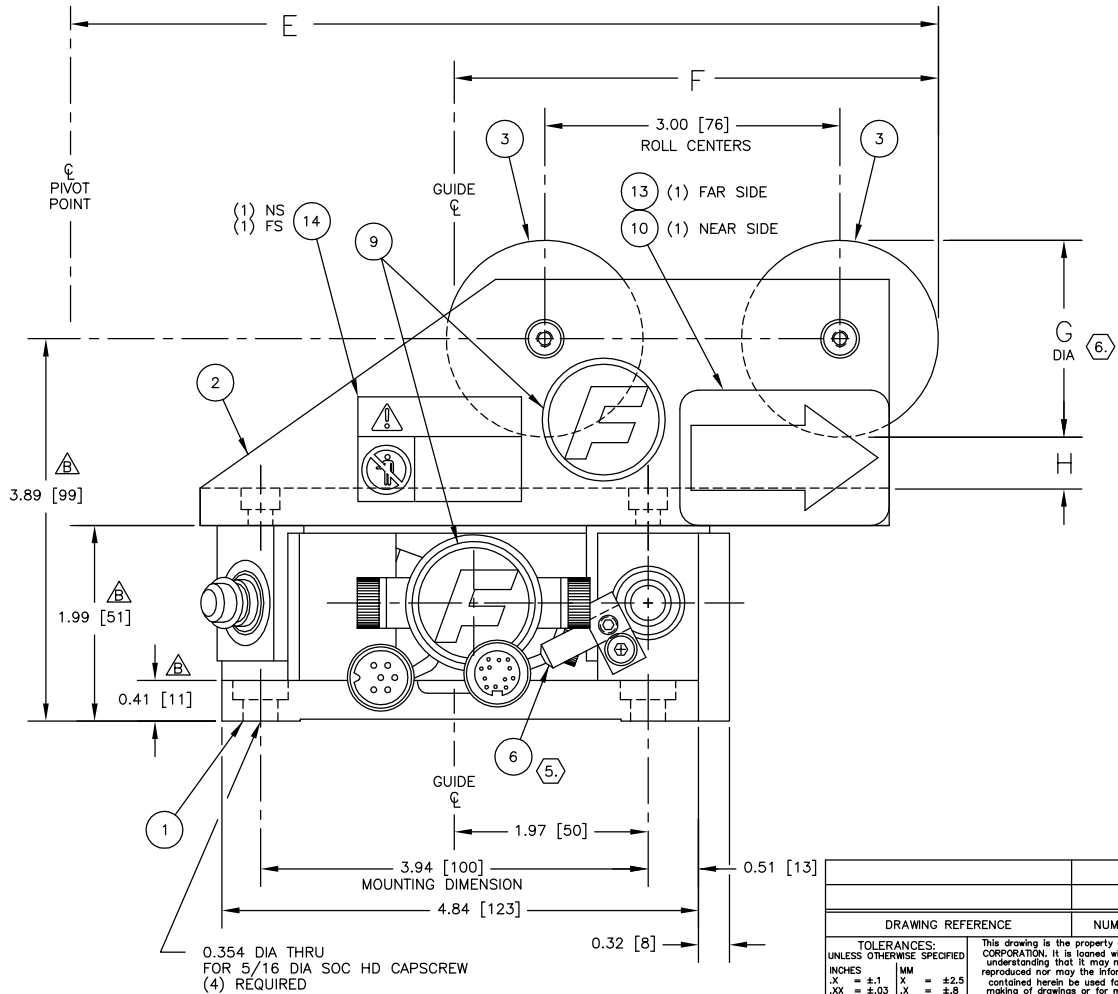


NOTES--

1. MAXIMUM ANGLE OF CORRECTION = $\pm 5.7^\circ$.
2. STANDARD FACTORY ALIGNMENT OF GUIDE ROLLERS TO EACH OTHER AND MOUNTING BASE TO BE WITHIN 0.010 TIR.
3. ALIGN THE CARRIER BLOCKS TO BE PERPENDICULAR TO THEIR RESPECTIVE RACERODS WHEN THE PIVOT CARRIER IS CENTERED AT MID-STROKE.
4. DIMENSIONS ARE INCHES [mm].
5. REFER TO SALES ORDER FOR SERVO CENTER REQUIREMENTS. IF REQUIRED, SEE SALES ORDER FOR CABLE LENGTH.
6. SEE SALES ORDER FOR ROLLER COVERING COVERING OR FINISH.
7. NOTED DIMENSIONS APPLY WHEN ROLLER(S) HAVE RUBBER CORK TAPE WRAP.

FIFE PART NO. 61471--	A	B	C	D	E	F	G	H
001	7.21 [183.1]	6.30 [160.0]	0.08 [2.0]	8.83 [224.3]	8.82 [224.0]	4.92 [124.9]	2.00 [50.8]	0.53 [13.5]
002	8.79 [223.3]	7.88 [200.2]	0.08 [2.0]	10.41 [264.4]	8.95 [227.3]	5.05 [128.3]	2.25 [57.2]	0.40 [10.2]
003	10.75 [273.1]	9.84 [249.9]	0.08 [2.0]	12.37 [314.2]	7	7	7	7



DRAWING REFERENCE		NUMBER	
TOLERANCES:		UNLESS OTHERWISE SPECIFIED	
INCHES		MM	
.X = ± 0.1		X = ± 2.5	
.XX = ± 0.03		X = ± 0.8	
.XXX = ± 0.010		XX = ± 0.2	
FRACTIONS = STOCK SIZE		UNLESS OTHERWISE SPECIFIED	
SURFACE FINISH		UNLESS OTHERWISE SPECIFIED	
EXPOSED	250 AA	MACHINED	125 AA
DE-BURR ALL EDGES		0.020 [0.5] MAX	
STANDARD SHOP PRACTICES AND STANDARD SHOP RUN TOLERANCES PER DRAWING 40400		OK	
SCALE	NONE	SIZE	D
DRAWING NO.		61471	
SHEET NO.		1 OF 1	
REV		E	

NO. REQD		LIST OF MATERIAL			
61471--		ITEM NO.	M K	PART NO.	DESCRIPTION
003	002	001			SYMAT 25 KANTIROLLER ASSEMBLY
1	1	1	1	M388221	RACEWAY BASE ASSEMBLY
			2	82664-003	PIVOT CARRIER
	1			82664-002	PIVOT CARRIER
1				82664-001	PIVOT CARRIER
		2	3	76881-001	ROLLER, 2.0 DIA X 'B' FACE
	2			76881-002	ROLLER, 2.0 DIA X 'B' FACE
2				76881-003	ROLLER, 2.0 DIA X 'B' FACE
4	4	4	4	76882-001	STUB SHAFT
4	4	4	5	26704-001	CUP PT SOC SET SCR, M4 X 4mm LG
--	--	--	6		ISCT-03 SERVO CENTER KIT, W/CABLE
3	3	3	7	90907-002	SOC HD CAP SCR (LOW HD), M6 X 12mm LG
3	3	3	8	26715-004	SPRING LOCKWASHER, M6
3	3	3	9	16409-001	FIFE LOGO, 1-1/4 DIA
1	1	1	10	76938-001	WEB DIRECTION LABEL
1	1	1	11	12013-001	KANTIROLLER NAMEPLATE
1	1	1	12	46833-004	GROUNDING STRAP KIT
1	1	1	13	76938-002	WEB DIRECTION LABEL
2	2	2	14	80039-002	CAUTION LABEL

E	ITEM 1 P/N WAS M365602 ECR #80092	PO 02/19/14	KF 02/19/14
D	ITEM 1 P/N WAS M326851 ECR #79100	PO 02/14/13	JMP 02/14/13
C	DWG WAS FOR SYMAT 25 KANTIROLLER ITEM 1 WAS 76943-015 ITEM 12 WAS 46833-005 ADDED ITEM 14 ECR #73706	LZ 06/10/10	PO 06/10/10
B	ITEM 1 P/N WAS 76943-010 3.89 DIM WAS 3.87 1.99 DIM WAS 1.97 0.41 DIM WAS 0.39 ECR #65514	PO 01/19/05	RDF 01/19/05
A	REVISED TO CURRENT ENG STANDARDS. ITEM 1 WAS P/N 76943-005. MOVED ITEM 10, P/N 76938-001 AND REVISED THE NOTES. ECR #63703	DW 06/09/04	RDF 06/10/04
SYM		REVISION	
BY		DATE	
DRAWN		10/10/97	
CHECKED		10/11/97	
APPROVED		10/11/97	
THIRD ANGLE PROJECTION		DIMENSIONS ARE SHOWN IN INCHES (MM) UNLESS OTHERWISE NOTED	
TITLE		FIFE SYMAT 25B KANTIROLLER ASSEMBLY (INSTALLATION) WITH DUAL ROLLERS	
DRAWING NO.		61471	
SHEET NO.		1 OF 1	
REV		E	