



NOTES:

- POSITION LOGOS TO BE RIGHT SIDE UP AFTER GUIDE IS INSTALLED. REFER TO THE WRAP STYLE ORIENTATION DIAGRAM FOR PROPER ORIENTATION.
- MAXIMUM ANGLE OF CORRECTION = $\pm 5.7^\circ$.
- STANDARD FACTORY ALIGNMENT OF GUIDE ROLLERS TO EACH OTHER AND MOUNTING BASE TO BE WITHIN 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.
- DIMENSIONS ARE INCHES [mm].
- REFER TO SALES ORDER OR SYSTEM BLOCK DIAGRAM FOR SERVO CENTER REQUIREMENT AND CABLE LENGTH.

FIFE P/N	ROLLER FINISH	U NOMINAL DIA
29L62054001	STANDARD	2.00 [50.8]
29L62054003	HARD COAT ANODIZE	2.00 [50.8]
29L62054005	DRAGON ELITE II PLASMA COAT	2.00 [50.8]
29L62054007	RUBBER CORK TAPE	2.13 [54.0]
29L62054009	IMPREGLON #PC60331/4001F	2.00 [50.8]

NO. REQD					ITEM NO.	QTY	PART NO.	DESCRIPTION	MATERIAL	REMARKS
29L62054009	29L62054007	29L62054005	29L62054003	29L62054001						
1	1	1	1	1	1		52M388221	RACEWAY BASE ASSEMBLY		UNPAINTED
1	1	1	1	1	2		29L76877005	PIVOT CARRIER		
-	-	-	-	2	3		29L76881003	ROLLER, 2.00 DIA X 9.84 FACE		STANDARD
-	-	-	2	-			29L76881008	ROLLER, 2.00 DIA X 9.84 FACE		HARD COAT ANODIZE
-	-	2	-	-			29L76881011	ROLLER, 2.00 DIA X 9.84 FACE		D.E. II PLASMA COAT
-	2	-	-	-			29L76881018	ROLLER, 2.00 DIA X 9.84 FACE		RUBBER CORK TAPE
2	-	-	-	-			29L76881028	ROLLER, 2.00 DIA X 9.84 FACE		IMPREGLON
4	4	4	4	4	4		29L76882001	STUB SHAFT		
4	4	4	4	4	5		29L26704001	CUP PT SOC SET SCR, M4 X 4mm LG		
					6					
3	3	3	3	3	7		29L90907002	SOC HD CAP SCR (LOW HD), M6 X 12mm LG		
3	3	3	3	3	8		29L26715004	SPRING LOCKWASHER, M6		
3	3	3	3	3	9		29L16409001	FIFE LOGO, 1-1/4 DIA		
1	1	1	1	1	10		29L76938001	WEB DIRECTION LABEL		
1	1	1	1	1	11		29L76939001	OPG NAMEPLATE		
1	1	1	1	1	12		29L46833004	GROUNDING STRAP KIT		
1	1	1	1	1	13		29L76938002	WEB DIRECTION LABEL		
2	2	2	2	2	14		29L80039002	FIFE CAUTION LABEL		

LIST OF MATERIAL

LOGO POSITION	WRAP STYLE	
	ALL	ALL
	1	
	2	
	3	
	4	
	5	
	6	
	7	
	8	
	9	
	10	
	11	
	12	
	13	
	14	
	15	
	16	

K	ADDED 'U' NOMINAL DIA UPDATED NOTE 7. ECR #84565	PO 10/03/16	BC 10/03/16
J	OBSOLETE P/Ns 29L62054002/004/ 006/008/010 DELETED ITEM 6 (SERVO CENTER) UPDATED BOM WITH EPICOR P/Ns ECR #84323	PO 07/25/16	LZ 07/25/16
H	ADDED P/Ns 62054-009 & -010 ECR #81287	PO 08/29/14	JMP 08/29/14
G	ITEM 1 P/N WAS M365602 ECR #80094	PO 02/19/14	KF 02/19/14
F	ITEM 1 P/N WAS M326851 ADDED DP-30 CABLE TO NOTE 7 ECR #77998	PO 04/10/12	JP 04/10/12
E	ADDED P/N 62054-007 AND -008 ADDED 76881-018 TO ITEM 3 ECR #75274	JGR 09/13/11	PO 09/14/11
D	ITEM 12 P/N WAS 46833-015 ECR #72352	PO 03/24/09	RS 03/24/09
C	ITEM 1 P/N WAS 76943-015 ITEM 12 P/N WAS 46833-005 ADDED ITEM 14 ADDED P/Ns -002 THRU -006 REVISED AND RENUMBERED NOTES TITLE WAS "SYMAT 25" REVISED BASE DIMS FOR NEW CASTING ECR #72114	PO 12/18/08	MG 12/31/08

SYM	REVISION	BY	DATE	APVD
BY	DATE			
DRAWN RBH	01/26/98			
CHECKED RDF	01/27/98			
APPROVED KIH	01/27/98			
DRAWING REFERENCE NUMBER				
TOLERANCES: UNLESS OTHERWISE SPECIFIED				
INCHES: .X = ±.1, .XX = ±.03, .XXX = ±.010				
MILLIMETERS: .X = ±.25, .XX = ±.1, .XXX = ±.05				
FRACTIONS = STOCK SIZE				
SURFACE FINISH: EXPOSED 250 AA, MACHINED 125 AA, DE-BURR ALL EDGES 0.020 (0.5) MAX				
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STANDARD SHOP PRACTICES AND STANDARD SHOP RUN TOLERANCES PER DRAWING 40400				
LOCATION	OK	SCALE	3/4	SIZE
THIRD ANGLE PROJECTION				
TITLE: SYMAT 25B OFFSET PIVOT GUIDE ASSEMBLY (INSTALLATION)				
DIMENSIONS ARE SHOWN IN INCHES (mm) UNLESS OTHERWISE NOTED				
DRAWING NO. 62054				
SHEET NO. 1 OF 1				
REV K				

	A ±0.10	B ±0.03	C ±0.10	D ±0.10	E ±0.10	G ±0.010	J ±0.10	L ±0.10	APPROXIMATE WEIGHT
INCHES	10.75	9.84	0.08	11.98	7.25	4.300	0.71	6.30	9 LBS
MILLIMETERS	273.1	249.9	2.0	304.3	184.2	109.22	18.0	160.0	4 KGS