

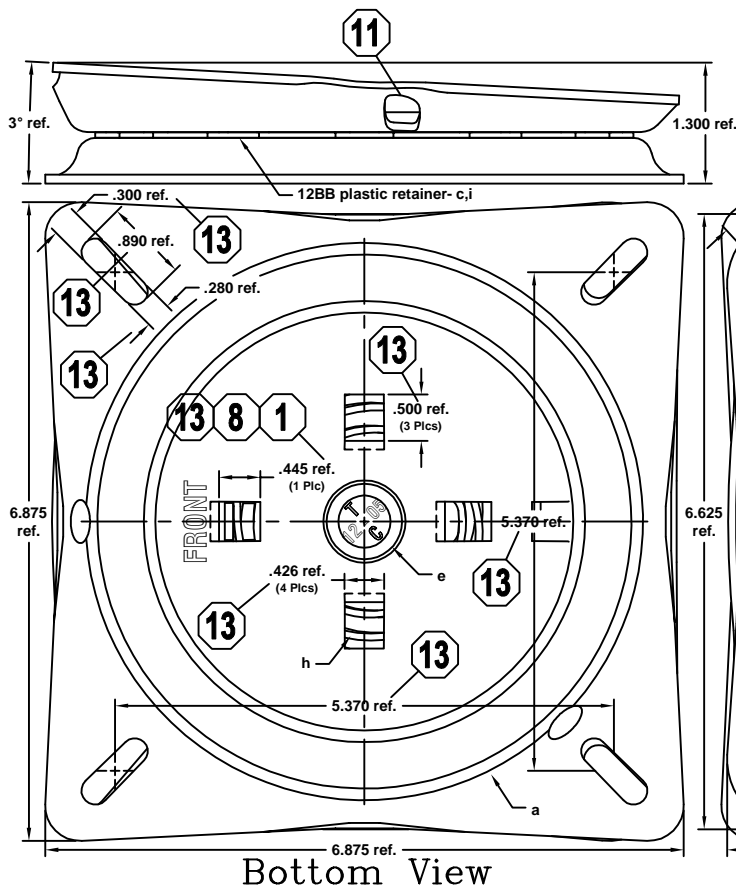
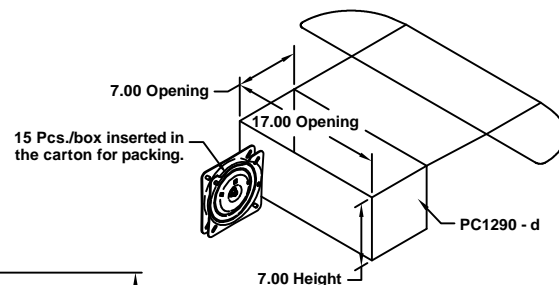
101118

Legend

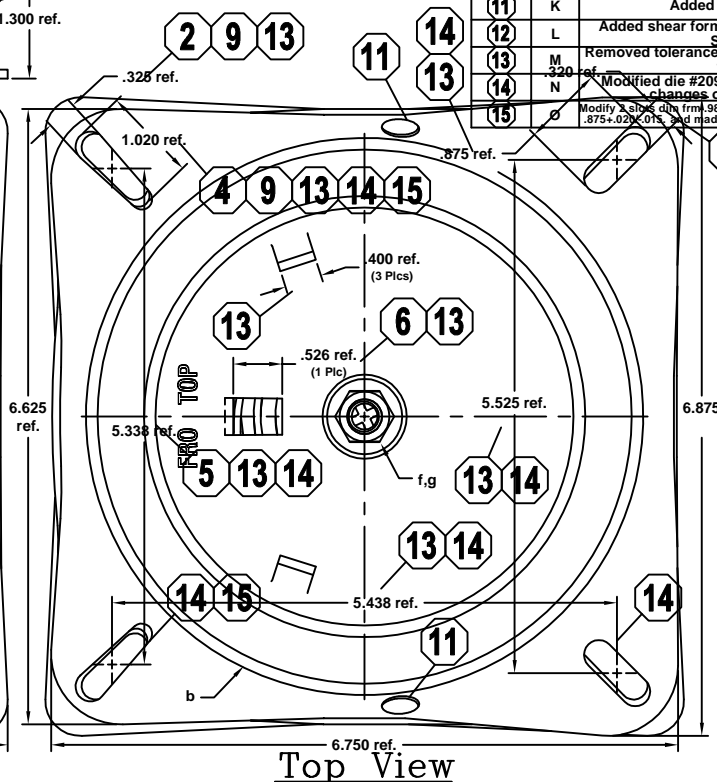
ROUTING SEQUENCE:

101118(SHEAR FORM ASSEMBLE & TEST)

12



Bottom View



Top View

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
1	A	Change width of shear form openings from .513±.010 to .435±.010.	09/27/00	FC
2	B	Change slot widths to an opening of .325±.025/-.000.	12/12/00	FC
3	C	Keep top shear form as .435±.010 and change three other shear form openings from .435±.010 to .500±.010.	07/26/01	FC
4	D	Change length of slots from .755±.015 to .880±.005.	02/12/02	FC
5	E	Change slot distance from 5.580±.015 to 5.250±.015.	02/12/02	FC
6	F	Change shear form opening from .465±.010 to .526±.010.	08/27/02	FC
7	G	Added "RETURN SWIVEL TEST" to testing standards per ECN "RETURN SWIVEL TESTING".	09/10/02	TEH
8	H	Change shear form opening from .435±.005 to .445±.005.	12/06/02	FC
9	I	Change slot dimensions from .880±.005 x .325±.025/-.000 to .860±.005 x .325±.005.	05/07/03	MAS
10	J	Change slot dimension from .325±.025/-.000 to .320±.010/-.000.	05/07/03	MAS
11	K	Added casino stop openings to top plate.	05/28/04	MAS
12	L	Added shear forming process in assembly per ECN "RETURN SWIVELS SHEAR FORMING".	07/27/05	MAS
13	M	Removed tolerances on dimensions as shown and added note on tolerances for components.	12/03/05	MAS
14	N	Modified die #209 to extend 4 slots by 1/8" and made the related changes on where used list per ECN#200117-4.	06/12/07	YD
15	O	Modify 2 slots dim from .365±.005 to 1.020±.005/-.020 and 2 slots dim from .875±.015 to .875±.020/-.015, and made the related changes on where used list per ECN#200117-5.	07/25/07	YD

****NOTE: For tolerances on components see specific components.**

Material Specifications

SWIVEL TENSION - NOT APPLICABLE
LOAD CAPACITY - 500 LB.

TEST STANDARDS (TC):

- TENSION TEST (TORQUE)
- ANSI/BIFMA X5.1-1993:
- BACK STRENGTH TEST - STATIC - TYPE IIA
- BACK DURABILITY TEST - CYCLIC - TYPE IIA & IIB
- SWIVEL TEST - CYCLIC

RETURN SWIVEL TEST:

SWIVEL MUST RETURN FREELY TO ORIGINAL POSITION WHEN TESTED AT 45 DEGREES.

BOM

	QTY (U/M):
a. 200062:PLB 712 RS NF	1.000 ea
b. 200117:PLT 712 LN 3D NF	1.000 ea
c. 300008:PLASTIC RETAINER FOR 7"	1.000 ea
d. PC1290:CTN SWL 17.00 x 7.00 x 7.00	0.067 ea
e. PF1120:BOLT CGE 3/8-24 x .875 PH HD1.000	ea
f. PF4070:NUT FLG 3/4-24 SIDE LOCK ZC	1.000 ea
g. PG1100:Grease Swivel #725	0.015 lb
h. PP1020:PLASTIC NYLATRON WSHR .75 x	1.000 ea
i. PS1030:SPRING, CLOCKWORK FOR SWIVELS2.000	ea
j. PZ1000:BALL BEARING 5/16 CARBON STL	12.00 ea

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN DECIMAL INCHES & TOLERANCES ARE SHOWN ON THE DRAWING OR BELOW.

TOLERANCES ARE:		
FRACTIONS	ANGLES	DECIMALS
±	±	.XX ±
		.XXX ±

712 3D RS90 12BB NF

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DRAWN BY: MAS	DRAWING NO: 101118	LAST UPDATE:
DATE: 05/15/97	SCALE: No Scale	

CRITICAL DIMENSIONS ARE IN BOLD LETTERING