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## DROP AWAY LEAF ASSEMBLY

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## DROP AWAY LEAF ASSEMBLY BILL OF MATERIALS (BOM’S)

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NOTE: ORDER THE COMPONENTS SEPARATELY AND NOT AS AN ASSEMBLY.

TABULATED INFORMATION ON FOLLOWING PAGE
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<td>E Steel Tub Size</td>
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¹Commercial ball bearing with seals both sides, lube for life  
²Commercial sheet metal shield compatible with ball bearing

**NOTE:** ORDER THE COMPONENTS SEPARATELY AND NOT AS AN ASSEMBLY.  
SEE DRAWING ON PREVIOUS PAGE
Tolerances:
1 PLACE ± 0.3
2 PLACE ±0.08

Weight: 0.59kg

NOTES & SPECIFICATIONS:
Material:  S.A.E. 1020  H.R.S.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
Tolerances:
1 PLACE ± 0.3
2 PLACE ±0.08

NOTES & SPECIFICATIONS:
Material: S.A.E. 1020 H.R.S.
THE SPACER MAY BE CUT IN HALF THROUGH THE HOLES AT ASSEMBLY
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
Tolerances:
1 PLACE ± 0.3
2 PLACE ± 0.08
Weight: 0.91 kg

NOTES & SPECIFICATIONS:
Material: S.A.E. 1020 H.R.S.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
Tolerances:
1 PLACE  ± 0.3
2 PLACE  ±0.08

NOTES & SPECIFICATIONS:
Material: S.A.E. 1020 H.R.S.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
Tolerances:
1 PLACE ± 0.3
2 PLACE ± 0.08

Weight: 1.59 kg

NOTES & SPECIFICATIONS:
Material: S.A.E. 1020 H.R.S.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
Tolerances:
1 PLACE ± 0.3
2 PLACE ±0.08
Weight: 0.18 kg

NOTES & SPECIFICATIONS:
Material: S.A.E. 1020 H.R.S.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

CONDITION | NAAMS CODE
---|---
UNCUT | ADP402
CUT ON AXIS X - X | ADP402A
CUT ON AXIS Y - Y | ADP402B
DUMP UNIT STUB SHAFT
ADP-501

Tolerances:
1 PLACE ± 0.3
2 PLACE ±0.08

Weight: 2.59 kg

NOTES & SPECIFICATIONS:
Material: S.A.E. 1020 H.R.S.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
Tolerances:
1 PLACE ± 0.3
2 PLACE ±0.08

Weight: 0.32 kg

NOTES & SPECIFICATIONS:
Material: S.A.E. 1020 H.R.S.
The spacer may be cut in half through the holes at assembly.
See page B-1.1 for global materials chart.

CONDITION | NAAMS CODE
---|---
UNCUT | ADP502
CUT ON AXIS X - X | ADP502A
CUT ON AXIS Y - Y | ADP502B
DUMP UNIT PIVOT ASSY. THRU SHAFT COMPOSITE BEARINGS
ADP400C SERIES

SHOWN USING ADP400C SERIES THROUGH SHAFTS
NOTE: ORDER THE COMPONENTS SEPARATELY AND NOT AS AN ASSEMBLY.

MAXIMUM ALLOWABLE ROUGHNESS SHALL BE:
1 PLACE FINISH DIMENSIONS TO BE 6 MICRONS
2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS
3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS
EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING ±0.3
1 PLACE FABRICATION ±1.5
2 PLACE ± 0.03 GENERAL
± 0.03 BETWEEN DOWELS
± 0.13 TO SCREW HOLES
ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

ASSEMBLE SHAFT TO BEARING USING LITHIUM GREASE.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

NOTE: THIS ONE PIECE THROUGH SHAFT ASSEMBLY
IS PREFERRED WHEN A PIVOT ASM. IS 900 MM LONG OR LESS.
A STUB SHAFT ASSEMBLY IS PREFERRED WHEN A PIVOT ASM. IS OVER 900 MM LONG
OR WHEN A ONE PIECE THROUGH SHAFT CANNOT BE REMOVED FOR MAINTENANCE.

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**EXCEPT AS NOTED TOLERANCES SHALL BE:**
1. PLACE MACHINING ±0.3
2. PLACE FABRICATION ±1.5
3. PLACE ± 0.03 GENERAL
4. ± 0.03 BETWEEN DOWELS
5. ± 0.13 TO SCREW HOLES

**ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.**

**MATERIAL:**
- 40.000 ±0.000 DIA. T.G.P. & C. S.A.E. 1045
- 28-32 R.C. THRU
- 0.25 CHROME, 64-70 R.C.
- 0.20-0.40 MICRO METERS (8-16 MICRO INCHES)

**SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART**
SHOWN USING ADP500C SERIES THROUGH SHAFTS
NOTE: ORDER THE COMPONENTS SEPARATELY AND NOT AS AN ASSEMBLY.

MAXIMUM ALLOWABLE ROUGHNESS SHALL BE:
1 PLACE FINISH DIMENSIONS TO BE 6 MICRONS
2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS
3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS
EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING ±0.3
1 PLACE FABRICATION ±1.5
2 PLACE ± 0.03 GENERAL
± 0.03 BETWEEN DOWELS
± 0.13 TO SCREW HOLES
ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

ASSEMBLE SHAFT TO BEARING USING LITHIUM GREASE.

SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
MATERIAL: 50.000 DIA. T.G.P. & C. S.A.E. 1045
C28-32 R.C. THRU 0.25 CHROME, 64-70 R.C. 0.20-0.40 MICRO METERS (8-16 MICRO INCHES)

SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING ±0.3
1 PLACE FABRICATION ±1.5
2 PLACE 0.03 GENERAL
± 0.03 BETWEEN DOWELS
± 0.13 TO SCREW HOLES
ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

MATERIAL: 50.000 DIA. T.G.P. & C. S.A.E. 1045 28-32 R.C. THRU 0.25 CHROME, 64-70 R.C. 0.20-0.40 MICRO METERS (8-16 MICRO INCHES)

SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

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SHOWN USING ADP600C SERIES THROUGH SHAFTS

NOTE: ORDER THE COMPONENTS SEPARATELY AND NOT AS AN ASSEMBLY.

0.12 TOTAL GAP TO 0.06 INTERFERENCE. GRIND ONE THRUST WASHER IF NECESSARY (0.12 TOTAL GAP MAX. ON DUMP UNITS WITH N.C. BLOCKS).

ADP6070C BEARING

15.0 MIN. WALL THK. AROUND TUB'G.

ADP6010B THRUST WASHER

4" DIA. ROUND STOCK (REF)

60.025 HOUSING DIA.

60.000 – 0.025 DIA. T.G.P.& C.
S.A.E. 1045
28–32 R.C. THRU
0.025 CHROME 64–70 R.C.
0.20–0.40 MICRO METERS
(8–16 MICRO INCHES)

F010810 SHCS

ADP999 KEEPER

3 1/2" O.D. X 2 1/2" I.D.
ROUND MECH. TUBING
PREFERRED SIZE (REF)

70.000 HOUSING DIA.

70.038 BEARING O.D. REF.

90.0 BEARING

93.0 BORE DEPTH

10.0 MIN.

60.0

5.0 +0.03 –0.00

(A + 10.00) –0.03

MAXIMUM ALLOWABLE ROUGHNESS SHALL BE:
1 PLACE FINISH DIMENSIONS TO BE 6 MICRONS
2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS
3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS

EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING ±0.3
1 PLACE FABRICATION ±1.5
2 PLACE ± 0.03 GENERAL
± 0.03 BETWEEN DOWELS
± 0.13 TO SCREW HOLES

ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

ASSEMBLE SHAFT TO BEARING USING LITHIUM GREASE.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

NOTE: THIS ONE PIECE THROUGH SHAFT ASSEMBLY IS PREFERRED WHEN A PIVOT ASM. IS 900 MM LONG OR LESS.
A STUB SHAFT ASSEMBLY IS PREFERRED WHEN A PIVOT ASSY. IS OVER 900 MM LONG OR WHEN A ONE PIECE THROUGH SHAFT CANNOT BE REMOVED FOR MAINTENANCE.
### 60 MM THROUGH SHAFTS

**MATERIAL:** 60.000 DIA. T.G.P. & C. S.A.E. 1045

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**EXCEPT AS NOTED TOLERANCES SHALL BE:**
- 1 PLACE MACHINING ±0.3
- 1 PLACE FABRICATION ±1.5
- 2 PLACE ± 0.03 GENERAL
- ± 0.03 BETWEEN DOWELS
- ± 0.13 TO SCREW HOLES

**ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.**

**MATERIAL:** 60.000 DIA. T.G.P. & C. S.A.E. 1045
- 28-32 R.C. THRU
- 0.25 CHROME, 64-70 R.C.
- 0.20-0.40 MICRO METERS (8-16 MICRO INCHES)

SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
SHOWN USING ADP413SC STUB SHAFT
NOTE: ORDER THE COMPONENTS SEPARATELY AND NOT AS AN ASSEMBLY.

MAXIMUM ALLOWABLE ROUGHNESS SHALL BE:
1 PLACE FINISH DIMENSIONS TO BE 6 MICRONS
2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS
3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS
EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING ±0.3
1 PLACE FABRICATION ±1.5
2 PLACE ± 0.03 GENERAL
± 0.03 BETWEEN DOWELS
± 0.13 TO SCREW HOLES
ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

LIGHT – MEDIUM DUTY
STUB SHAFT APPLICATIONS

NOTE: A STUB SHAFT IS PREFERRED WHEN A PIVOT ASSY. IS OVER 900 MM LONG OR WHEN A ONE PIECE SHAFT CANNOT BE REMOVED FOR MAINTENANCE.

NOTE: THE TAPPED HOLES IN THE STUB SHAFTS ARE FOR REMOVAL.

ASSEMBLE SHAFT TO BEARING USING LITHIUM GREASE.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
NOTE: ORDER THE COMPONENTS SEPARATELY AND NOT AS AN ASSEMBLY.

MAXIMUM ALLOWABLE ROUGHNESS SHALL BE:
1 PLACE FINISH DIMENSIONS TO BE 6 MICRONS
2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS
3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS

EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING ±0.3
1 PLACE FABRICATION ±1.5
2 PLACE ± 0.03 GENERAL
± 0.03 BETWEEN DOWELS
± 0.13 TO SCREW HOLES

ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

NOTE: A STUB SHAFT IS PREFERRED WHEN A PIVOT ASSY. IS OVER 900 MM LONG OR WHEN A ONE PIECE SHAFT CANNOT BE REMOVED FOR MAINTENANCE.

NOTE: THE TAPPED HOLES IN THE STUB SHAFTS ARE FOR REMOVAL.

ASSEMBLE SHAFT TO BEARING USING LITHIUM GREASE.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
SHOWN USING ADP619SC STUB SHAFT

NOTE: ORDER THE COMPONENTS SEPARATELY AND NOT AS AN ASSEMBLY.

ADP6070C BEARING

15.0 MIN. WALL THK. AROUND TUB’G.

70.000 HOUSING DIA.

70.038 BEARING O.D. REF.

3 1/2” O.D. X 2 1/2” I.D. ROUND MECH. TUB’G PREFERRED SIZE (REF)

F010812 SHCS (2)

1.5 X 45° CHAMF.

MAXIMUM ALLOWABLE ROUGHNESS SHALL BE:
1 Place Finish Dimensions to be 6 Microns
2 Place Finish Dimensions to be 3 Microns
3 Place Finish Dimensions to be 1.6 Microns

EXCEPT AS NOTED TOLERANCES SHALL BE:
1 Place Machining ±0.3
1 Place Fabrication ±1.5
2 Place ± 0.03 General
± 0.03 Between Dowels
± 0.13 to Screw Holes

ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

ASSEMBLE SHAFT TO BEARING USING LITHIUM GREASE.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

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MATERIAL: B DIA. X E MM LG.    T.G.P. & C. S.A.E. 1045

28-32 R.C. THRU
0.13 CHROME, 64-70 R.C.
0.20-0.40 MICRO METERS
(8-16 MICRO INCHES)
C DIA. X 13.0MM LG., S.A.E. 1020 H.R.S.

SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING ±0.3
1 PLACE FABRICATION ±1.5
2 PLACES ± 0.03 GENERAL
± 0.03 BETWEEN DOWELS
± 0.13 TO SCREW HOLES

ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.
EXCEPT AS NOTED TOLERANCES SHALL BE:

1 PLACE MACHINING ±0.3
1 PLACE FABRICATION ±1.5
2 PLACE ± 0.03 GENERAL
± 0.03 BETWEEN DOWELS
± 0.13 TO SCREW HOLES

ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

STK: 1/8" X 7/8" X 35.0 MM LG. S.A.E. 1018 C.R.S.

SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
DUMP UNIT PIVOT
BRONZE THRUST WASHER

MATERIAL: BRONZE CDA93200 / S.A.E. 660
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART
DUMP UNIT PIVOT
COMPOSITE BEARING

MATERIAL: REINFORCED TEFLOM COMPOSITE LINER
WITH FIBER REINFORCED EPOXY SHELL
MEETING THE FOLLOWING SPECIFICATIONS:
ASTM D570 (WATER ABSORPTION)
ASTM D635 (FLAMMABILITY)
Maximum P (STATIC) 138 MPa (20,000 psi)
Maximum V (CONTINUOUS) 2.54 m/sec (500 ft/min)
Maximum PV 1.22 MPa m/sec (35,000 psi ft/min)

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DUMP UNIT PIVOT
STAINLESS STEEL
THRUST WASHER

MATERIAL: STAINLESS STEEL
400 SERIES
0.81 MICRONS (32 MICRO INCH) MAXIMUM

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ADL0100
DROP AWAY LEAF

AVAILABLE OPENING ANGLES:
15°, 30°, 45°, 60°, 75°, 90°
ASSEMBLY INCORPORATES SEVERAL COMMERCIAL COMPONENTS. USER IS RESPONSIBLE TO ENSURE ACTUAL COMMERCIAL COMPONENTS SELECTED BY THE USER MEET THE FIT, FORM, AND FUNCTION REQUIRED FOR THE APPLICATION.

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<td>23 kg/50.7 lbs</td>
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<td>AIR PRESSURE</td>
<td>4.5 - 5.5 bar/165.27 - 79.77 psi</td>
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ARH SERIES TOP MOUNT RISERS ARE ORDERED SEPARATELY (REF. NAAMS ASSEMBLY SECTION E-PAGE E-31)

MOUNTING OPTIONS FOR TOP MOUNT RISERS

MOUNT OPTION A

MOUNT OPTION B
MOUNTING OPTIONS FOR SIDE MOUNT RISERS

ARV SERIES SIDE MOUNT RISERS ARE ORDERED SEPARATELY (REF. NAAMS ASSEMBLY SECTION E-PAGE E-32)
ADL0100
DROP AWAY LEAF

NOTE: DO NOT USE NAAMS ARS SERIES STACK RISERS

FLOW CONTROL
(USER SUPPLIED) TYP.

PIVOT

CLEARANCE LINE

8.0" dia. dwl. thru (2) holes typ. ref.

PIVOT

535.00

500.0

465.0

36.0

SET UP

USER SUPPLIED
(21) adjustable shock absorbers
33mm x 1.0 threaded body stroke ref.

PIVOT

SHOWN WITH STANDARD 80MM BORE CYLINDER (NO ROD LOCK)
ADL0100
DROP AWAY LEAF

NOTE: DO NOT USE NAAMS ARS SERIES STACK RISERS

FLOW CONTROL TUBE SUPPLIED TYP.

OPTION B USER SUPPLIED
ISO 15592 CYLINDER
Ø 80MM BORE 240MM STROKE
W/CYLINDER BRAKE
CENTER TRUNNION MOUNT
XV DIM = 270.0MM TYP.

SHOWN WITH 80MM BORE CYLINDER WITH ROD LOCK

CLEARANCE LINE

RISER SHOWN IN MOUNTING POSITION "A"

RISER SHOWN IN MOUNTING POSITION "B"

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N-26.4
ADL0003
MOUNTING PLATE

GLOBAL STANDARD COMPONENTS

STK: SAE1020 HRS
1-1/2" x 4" x 156mm
APPROX wt. 3.35kg

NOTE:
UNIT DIMENSIONS IN MILLIMETERS. ALL TOLERANCES ARE PLUS OR MINUS .02 IN.

1. FACE FINISH DIMENSIONS TO BE 3 MICRONS
2. FACE FINISH DIMENSIONS TO BE 5 MICRONS
3. FACE FINISH DIMENSIONS TO BE 1 MICRON

EXCEPT AS NOTED TOLERANCES SHALL BE:
1. TOLERANCE +0.3
2. TOLERANCE -0.3
3. TOLERANCE -0.1
4. TOLERANCE ±0.005

DOWEL HOLE TOLERANCES
FOR PRECISION USE H6
FOR QUICK FIT USE F7

ALL MACHINED SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN OR COLD ROLLED SURFACES

SURFACES GRIND FLAT & PARALLEL WITH 0.13 T.I.R.

NOTE: ALL DIM’S. ARE METRIC UNLESS OTHERWISE NOTED.
**STK: ASTM A36**

3/4" x 5" x 250mm

APPROX wt. 1.80kg

---

**NOTE:** ALL DIM’S. ARE METRIC UNLESS OTHERWISE NOTED.
ADL0006
PLATE

METRIC DETAIL TOLERANCES

NOTE:
EXCEPT AS NOTED, TOLERANCES SHALL BE:
1. PLANE MACHINING ±.03
2. PLATING -0.01 BETWEEN MACHINED SURFACES
3. R10 SURFACE RADIUS FOR ROLLED SURFACES
4. R10 TO ROLL OR BEND HOLE INDENTIONS
5. .001 TO .002 DEEP X SENT IN DIFFERENT PLANE
6. ALL MACHINED PLANES TO CLEAR HOLES, NON-ACCUMULATIVE

STK: ASTM A36
1-1/4" x 308mm x 523mm
APPROX wt. 14.18kg

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DISCONTINUED
ADL0007
LOCK KEEPER

METRIC DETAIL TOLERANCES

NOTE:
UNLESS OTHERWISE SPECIFIED:
1. PLASTIC ALLOYS ARE NOT ACCEPTABLE.
2. PLACE FINISH DIMENSIONS TO BE 5 MICRONS.
3. PLACE FINISH DIMENSIONS TO BE 2.5 MICRONS.
EXCEPT AS NOTED TOLERANCES SHALL BE:
1. PLACE MACHINING +0.3, -0.7
2. PLACE =0.00 BETWEEN MACHINED SURFACES
3. PLACE =0.00 BETWEEN TUMBLE POLISHED SURFACE
4. PLACE =0.00 BETWEEN MACHINED PLANES
5. PLACE =0.00 BETWEEN HOLES IN DIFFERENT PLANES
6. +0.13 TO SCREW HOLES, NON-ACCUMULATIVE.

DOWEL HOLE TOLERANCES:
DOWEL TOLERANCE FOR PRESS FIT USE "H7" FOR SLIP FIT USE "F7"

ALL MACHINED SURFACES MUST BE FINISHED EXCEPT FOR COIL DRUM OR COIL KILLED SURFACES.

STK: SAE 1020 HRS
3/16" x 1" x 32mm
APPROX wt. 0.03kg

* NOTE: ALL DIM'S. ARE METRIC UNLESS OTHERWISE NOTED.
ADL0008
STOP BLOCK

METRIC DETAIL TOLERANCES

NOTE:

1. PLACE FINISH DIMENSIONS TO BE 6 MICRONS
2. PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS
3. PLACE FINISH DIMENSIONS TO BE 60 MICRONS

EXCEPT AS NOTED TOLERANCES SHALL BE:

1. PLATE MACHINING 0.3
2. PLATE FABRICATION 1.4
3. PLATE DIMENSIONS 0.3
4. PLATE TOLERANCE 0.3
5. PLATE TOLERANCE 0.3
6. PLATE TOLERANCE 0.3

DOWEL HOLE TOLERANCES
DOWEL TOLERANCE
FOR PRESS FIT USE H7
FOR SPLIT FIT USE F7

ALL MACHINED SURFACES MUST BE FINISHED EXCEPT FOR COLD DrawN OR COLD KILLED SURFACES.

STK: SAE 1060
1-1/4" x 2" x 40mm
APPROX wt. 0.35kg

STOP BLOCK
MATERIAL: SAE 1060
STK: 1 1/4" X 2" X 40MM

FLAME HARDEN THIS SURFACE
3.0 DEEP MIN., Rc 55-60

* NOTE: ALL DIM’S. ARE METRIC UNLESS OTHERWISE NOTED.
ADL0009
TRUNNION OFFSET

METRIC DETAIL TOLERANCES

NOTE:

UNLESS OTHERWISE SPECIFIED:
1. PLACE FiniSH DIMENSIONS TO BE ± 5 micronS
2. PLACE FiniSH DIMENSIONS TO BE ± 2 micronS
3. PLACE FiniSH DIMENSIONS TO BE ± 1.5 micronS

EXCEPT AS NOTED: TOLERANCES SHALL BE:
1. PLACE MACHINING: ± 0.3
2. PLACE: ± 0.08 BETWEEN MACHINED SURFACES
3. PLACE: ± 0.05 BETWEEN INDIFFERENT PLANES
4. PLACE: 1.3 BETWEEN PIN HOLES, NON ACCUMULATIVE

Dowel HOLE TOLERANCES
FOR PRECISION USE ± 3 µM
FOR QUICK FIT USE ± 7 µM

ALL MACHINED SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAINED OR ROLL-BURNT SURFACES

ø 6.6 THRU 12 HOLLHES

ø 29.00

30.00

76.2
STK. REF.

41.75

R 0.50
MAX.

31.00

47.00
START

1.0 X 45°
CHAMFER

ø 30.00
+0.013
-0.000

ø 45.00
+0.00
-0.05

+ NOTE: ALL DIMENSIONS ARE METRIC UNLESS OTHERWISE NOTED.
ADL0011
PIVOT ARM

METRIC DETAIL TOLERANCES

NOTE:

N.B. TOLERANCES IN ALL CASES
1. PLACE TOLERANCES IN ALL CASES
2. PLACE FINISH DIMENSIONS TO BE ± 0.013
3. PLACE FINISH DIMENSIONS TO BE ± 0.001

STK: ASTM A36
1" x 7" x 250mm
APPROX wt. 3.76kg

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N-27.7
STK: ASTM A36
3/4" x 5" x 250mm
APPROX wt. 1.80kg

NOTE: ALL DIM.‘S. ARE METRIC UNLESS OTHERWISE NOTED.
STK: SAE 1020 HRS
2-3/8" DIA x 3mm
APPROX wt. 0.06kg

METRIC DETAIL TOLERANCES

NOTE:
UNLESS OTHERWISE SPECIFIED:
1. PLACE TOLERANCES APPLICABLE TO ALL:
   2 PLACE FINISH DIMENSIONS TO BE ±0.0005 INCHES
   3 PLACE FINISH DIMENSIONS TO BE ±0.002 INCHES

EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING ±0.3
2 PLACE ±0.0005 BETWEEN MACHINED SURFACES
25.00 ±0.0005 BETWEEN TANGENT CIRCUMFERENTIAL SURFACES
25.00 ±0.0005 BETWEEN TANGENT MACHINED SURFACES IN SAME PLANE
25.10 ±0.0005 BETWEEN MACHINED SURFACES IN DIFFERENT PLANES
25.10 ±0.0005 BETWEEN MACHINED SURFACES IN DIFFERENT PLANES
5.10 ±0.0005 BETWEEN TANGENT CIRCUMFERENTIAL SURFACES IN DIFFERENT PLANES

Dowel hole tolerances:
(Dowel tolerance for press fit use H7
For slip-fit use F7)

All machining & surfaces must be finished except for cold drawn or cold rolled surfaces.

Φ 6.6 THRU (2) HOLES

25.00
3.0
STK. REF.

* NOTE: ALL DIM'S. ARE METRIC UNLESS OTHERWISE NOTED.
ADL0014
SHOCK BLOCK

STK: SAE 1060 HRS
1-3/4" x 2-1/2" x 65mm
APPROX wt. 0.82kg

METRIC DETAIL TOLERANCES

NOTE:

ALL UNLESS OTHERWISE SPECIFIED:

1 PLACE FINISH DIMENSIONS TO BE ± 6 MICRONS
2 PLACE FINISH DIMENSIONS TO BE ± 3 MICRONS
EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING ±0.3
2 PLACE ±0.00 BETWEEN MACHINED SURFACES
25.00 BETWEEN DOUBLE WORK PLANE
R 6.35 TYP.
ALL DRILL HOLES IN DIFFERENT PLANES
R 0.5 MIN R 1.0 MAX
63.5
STK. REF.

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STK: SAE 4140 HRS
1-1/2" x 1-3/4" x 100mm
APPROX wt. 0.80kg

NOTE: ALL DIM'S. ARE METRIC UNLESS OTHERWISE NOTED.

Ô 20.00-0.00 THRU 2 HOLES INLINE

80.0 START

M6 THRU (2) PLACES

16.5

M6 TAP THRU (2) HOLES FAR SIDE

10.0 X 45°

40.0

1.5" REF

2.0

SAW CUT CENTRAL

50.0

6.8 DRILL NEAR SIDE (2) HOLES

70.0

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GLOBAL STANDARD COMPONENTS

ADL0016
PIVOT HUB

STK: SAE 4140 HRS
4" DIA x 100.0mm
APPROX wt. 2.30kg

NOTE: ALL DIM’S. ARE METRIC UNLESS OTHERWISE NOTED.

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ADL0018
SWITCH MTG BRKT

STK: SAE 1020 HRS
1/4" x 1-3/4" x 90mm
APPROX wt. 0.20kg

GLOBAL STANDARD COMPONENTS
NAAMS

METRIC DETAIL TOLERANCES

NOTE: ALL DIMS. ARE METRIC UNLESS OTHERWISE NOTED.

STK: SAE 1020 HRS
1/4" x 1-3/4" x 90mm
APPROX wt. 0.20kg

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NOTE: ALL DIM’S. ARE METRIC UNLESS OTHERWISE NOTED.

STK: SAE 1018 CRS
1/8” x 3/4” x 19mm
APPROX wt. 0.01kg
STK: SAE 1020 HRS
3" DIA x 3.0mm
APPROX wt. 0.10kg

NOTE: ALL DIM’S. ARE METRIC UNLESS OTHERWISE NOTED.
ADL0022
THRUST WASHER

METRIC DETAIL TOLERANCES

NOTE: UNLESS OTHERWISE SPECIFIED
1. PLACE FINISH DIMENSIONS TO BE 5 MICRONS
2. PLACE FINISH DIMENSIONS TO BE 3 MICROPS
3. PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS

EXCEPT AS NOTED TOLERANCES SHALL BE:
1. PLACE MACHINING +/- 0.3
2. PLACE FABRICATION 1.6
3. PLACE +/- 0.08 BETWEEN MACHINED SURFACES
4. PLACE +/- 0.05 BETWEEN TUBULAR DOWELS IN THE SAME PLANE
5. PLACE +/- 0.10 BETWEEN DOWELS IN DIFFERENT PLANES
6. +/- 0.10 TO SCREW HOLES, NON ACCUMULATIVE

Dowel Hole Tolerances
Dowel Tolerance
20.00
+0.25
-0.00

FACE NEAR AND FAR
SURFACE TO 0.81 MICRONS
132 MICRO INCHES MAXIMUM

3.00
+0.03
-0.03

1.6 X 45° CHAMFER
ONE SIDE ONLY

NO CHAMFER
THIS SIDE

* NOTE: ALL DIM'S ARE METRIC UNLESS OTHERWISE NOTED.
ADL0023
MOUNTING PLATE

METRIC DETAIL TOLERANCES

STK: ASTM A36
1-1/2" x 5-1/2" x 156mm
APPROX wt. 5kg

NOTE:

UNLESS OTHERWISE SPECIFIED
WEIGHT ALLOWANCES ARE AS DEFINED IN ASME Y14.5
3 PLACE FINISHED DIMENSIONS TO BE ± .015 INCHES
2 PLACE FINISHED DIMENSIONS TO BE ± .005 INCHES
1 PLACE FINISHED DIMENSIONS TO BE ± .001 INCHES

EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACED MACHINING ± 0.3
2 PLACED ± 0.002 BETWEEN MACHINED SURFACES
5 PLACED ± 0.002 BETWEEN MACHINED SURFACES IN DIFFERENT PLANES
10 PLACED ± 0.0015 BETWEEN MACHINED SURFACES IN DIFFERENT PLANES
10 PLACED ∓ 0.0025 BETWEEN SURFACES IN DIFFERENT PLANES

DOWEL HOLE TOLERANCES

DOWEL TOLERANCE FOR PRECISION USE INS
FOR SLIP FIT USE F7

ALL UNMACHINED SURFACES MUST BE FINISHED EXCEPT FOR COLO DRAWN OR COLO ROLLED SURFACES

SURFACES GRIND FLAT & PARALLEL WITH .02 T.I.R.

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STK: ASTM A36
1-1/4" x 308mm x 523mm
APPROX wt. 14kg
THERMAL STRESS RELIEVE
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<td>MOUNTING PLATE 1020 HRS 1 1/2&quot; X 4&quot; X 156MM</td>
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**DROP AWAY LEAF ASSEMBLY - 80MM BORE**

File: NAAMS_drp_awa_if_asm_UNIT_BOM.XLSM  Rev. Date: 5/31/17  N-28
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**CHG LTR** | **DATE** | **REVISIONS / REASONS FOR** |
--- | --- | --- |
A | 05/31/17 | DETAIL ADL0006 DISCONTINUED & REMOVED, WAS 2 REQ'D - G.B. |
# NAAMS ADL100

## Drop Away Leaf Assembly - 80mm Bore

**Customer:** NAAMS  
**Program:**  
**Design Source:** NAAMS  
**Build Source:**  

<table>
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<td>ADL0018</td>
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<td>1/4&quot; X 1-3/4&quot; X 90mm</td>
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<td>Dia 10 X 30mm LG.</td>
<td>Pull Dowel</td>
<td>STD</td>
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**File:** NAAMS_drp_awa_if_asm_UNIT_BOM.XLSM  
**Rev. Date:** 9/6/2012  
**N-28.2**
## DESCRIPTION

( FILL OUT ON SHEET ONE ONLY )

**DROP AWAY LEAF ASSEMBLY - 80MM BORE**

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### UNIT B.O.M.

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#### BOM PAGE

4 OF 4

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#### MOUNTING PLATE ASTM A36

- 1 1/2" X 5 1/2" X 156MM

#### PLATE ASTM A36

- 1 1/4" X 308MM X 523MM

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### CHG LTR

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<th>REVISIONS / REASONS FOR</th>
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### SOURCE LEGEND

- M - MAKE ITEM
- P - PURCHASE ITEM
- X - APPROVAL REQUIRED FOR SUBSTITUTION
- F - FURNISHED BY CUSTOMER
- NC - NUMERICAL CONTROLLED MACHINING

---

### PROJECT MGR.

<table>
<thead>
<tr>
<th>PROJECT MGR.</th>
<th>MR</th>
<th>DESIGN SUPV.</th>
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<th>SOURCE</th>
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### GLOBAL STANDARD COMPONENTS

NAAMS

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### FILE

File: NAAMS_drp_awa_fl_asm_UNIT_BOM.XLSM  Rev. Date: 5/31/17  N-28.3