

PIVOTS INDEX

DUMP ASSEMBLIES AND COMPONENTS

PAGE	DATE	NAAMS CODE	DESCRIPTION
N-1	09/06/12		Pivots Index
N-1.1	09/06/12		Pivots Index
N-2	09/06/02	ADP200, 300, 400, 500	Dump Unit Pivot Assembly
N-3	05/25/12	ADP200, 300, 400, 500	Dump Unit Pivot Assembly
N-4	08/24/07	ADP201	Dump Unit Stub Shaft
N-5	08/24/07	ADP202	Dump Unit Spacer
N-6	08/24/07	ADP301	Dump Unit Stub Shaft
N-7	08/24/07	ADP302 Series	Dump Unit Spacer
N-8	08/24/07	ADP401	Dump Unit Stub Shaft
N-9	08/24/07	ADP402 Series	Dump Unit Spacer
N-10	08/24/07	ADP501	Dump Unit Stub Shaft
N-11	08/24/07	ADP502 Series	Dump Unit Spacer
N-12	08/24/07	ADP400C	Dump Unit Pivot Assy. Thru Shaft Composite Bearings
N-13	08/24/07	ADP416C–ADP490C	40 MM Through Shafts
N-14	08/24/07	ADP500C	Dump Unit Pivot Assy. Thru Shaft Composite Bearings
N-15	08/24/07	ADP530C–ADP590C	50 MM Through Shafts
N-16	08/24/07	ADP600C	Dump Unit Pivot Assy. Thru Shaft Composite Bearings
N-17	08/24/07	ADP630C–ADP690C	60 MM Through Shafts
N-18	08/24/07	ADP400SC	Dump Unit Pivot Assy. Stub Shaft Composite Bearings
N-19	08/24/07	ADP500SC	Dump Unit Pivot Assy. Stub Shaft Composite Bearings
N-20	08/24/07	ADP600SC	Dump Unit Pivot Assy. Stub Shaft Composite Bearings
N-21	08/24/07	ADP413SC–ADP619SC	Stub Shafts
N-22	08/24/07	ADP999	Metric Keeper
N-23	09/06/12	ADP2550B–ADP6010B	Dump Unit Pivot Bronze Thrust Washer
N-24	02/25/00	ADP4050C–ADP6070C	Dump Unit Pivot Composite Bearing
N-25	09/06/12	ADP700	Dump Unit Pivot Stainless Steel Thrust Washer

PIVOTS INDEX

DROP AWAY LEAF ASSEMBLY

PAGE	DATE	NAAMS CODE	DESCRIPTION
N-26	05/31/17	ADL0100	Drop Away Leaf Assembly, 1 of 8
N-26.1	05/31/17	ADL0100	Drop Away Leaf Assembly, 2 of 8
N-26.2	05/31/17	ADL0100	Drop Away Leaf Assembly, 3 of 8
N-26.2.1	05/31/17	ADL0100	Drop Away Leaf Assembly, 4 of 8
N-26.3	05/31/17	ADL0100	Drop Away Leaf Assembly, 5 of 8
N-26.4	05/31/17	ADL0100	Drop Away Leaf Assembly, 6 of 8
N-26.5	05/31/17	ADL0100	Drop Away Leaf Assembly, 7 of 8
N-26.6	05/31/17	ADL0100	Drop Away Leaf Assembly, 8 of 8

A

DROP AWAY LEAF ASSEMBLY DETAILS

N-27	09/06/12	ADL0001	Angle Bracket
N-27.1	DISCONTINUED	ADL0003	Mounting Plate
N-27.2	09/06/12	ADL0005	Arm
N-27.3	DISCONTINUED	ADL0006	Plate
N-27.4	09/06/12	ADL0007	Lock Keeper
N-27.5	09/06/12	ADL0008	Stop Block
N-27.6	09/06/12	ADL0009	Trunnion Offset
N-27.7	09/06/12	ADL0011	Pivot Arm
N-27.8	09/06/12	ADL0012	Arm
N-27.9	09/06/12	ADL0013	Cover
N-27.10	09/06/12	ADL0014	Shock Block
N-27.11	09/06/12	ADL0015	Clevis
N-27.12	09/06/12	ADL0016	Pivot Hub
N-27.13	09/06/12	ADL0018	Switch Mounting Bracket
N-27.14	09/06/12	ADL0020	Keeper
N-27.15	09/06/12	ADL0021	Cover
N-27.16	09/06/12	ADL0022	Thrust Washer
N-27.17	05/31/17	ADL0023	Mounting Plate
N-27.18	05/31/17	ADL0024	Plate

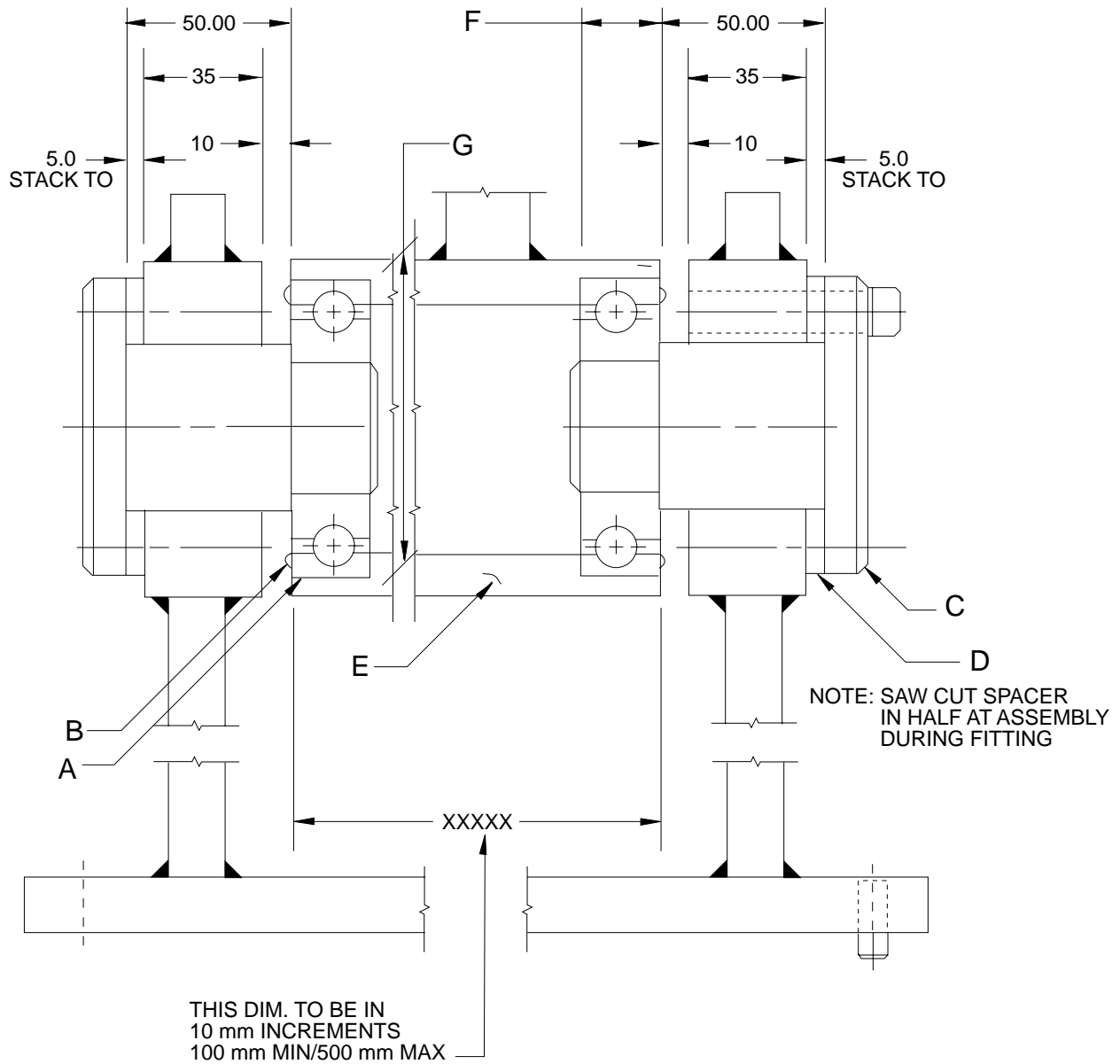
A

DROP AWAY LEAF ASSEMBLY BILL OF MATERIALS (BOM'S)

N-28	05/31/17	BOM, Sheet 1
N-28.1	05/31/17	BOM, Sheet 2
N-28.2	09/06/12	BOM, Sheet 3
N-28.3	05/31/17	BOM, Sheet 4

A

DUMP UNIT PIVOT ASSEMBLY



NOTE: ORDER THE COMPONENTS SEPARATELY AND NOT AS AN ASSEMBLY.
 TABULATED INFORMATION ON FOLLOWING PAGE

A

DUMP UNIT PIVOT ASSEMBLY

GLOBAL STANDARD COMPONENTS



Assembly

05/25/12

NAAMS CODE	ADP200	ADP300	ADP400	ADP500
A Bearing ¹	6304	6306	6308	6310
B Shield ²	6304	6306	6308	6310
C Stub Shaft	ADP201	ADP301	ADP401	ADP501
D Spacer	ADP202	ADP302	ADP402	ADP502
E Steel Tub Size	2-1/2 O.D. X 1-1/2 I.D.	3-1/2 O.D. X 2-1/2 I.D.	4 O.D. X 3 I.D.	5 O.D. X 3-3/4 I.D.
F Bearing Bore Depth	15.3	19.3	23.3	27.3
G Bearing Bore Dia Ref	52.000 ^{+0.000} _{-0.013}	72.000 ^{+0.000} _{-0.013}	90.000 ^{+0.000} _{-0.013}	110.000 ^{+0.000} _{0.013}
Max Load Rating N, (Lb)	15,900 (3,580)	28,100 (6,320)	41,000 (9,230)	61,800 (13,900)

B

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

A

DUMP UNIT STUB SHAFT ADP-201

GLOBAL STANDARD COMPONENTS



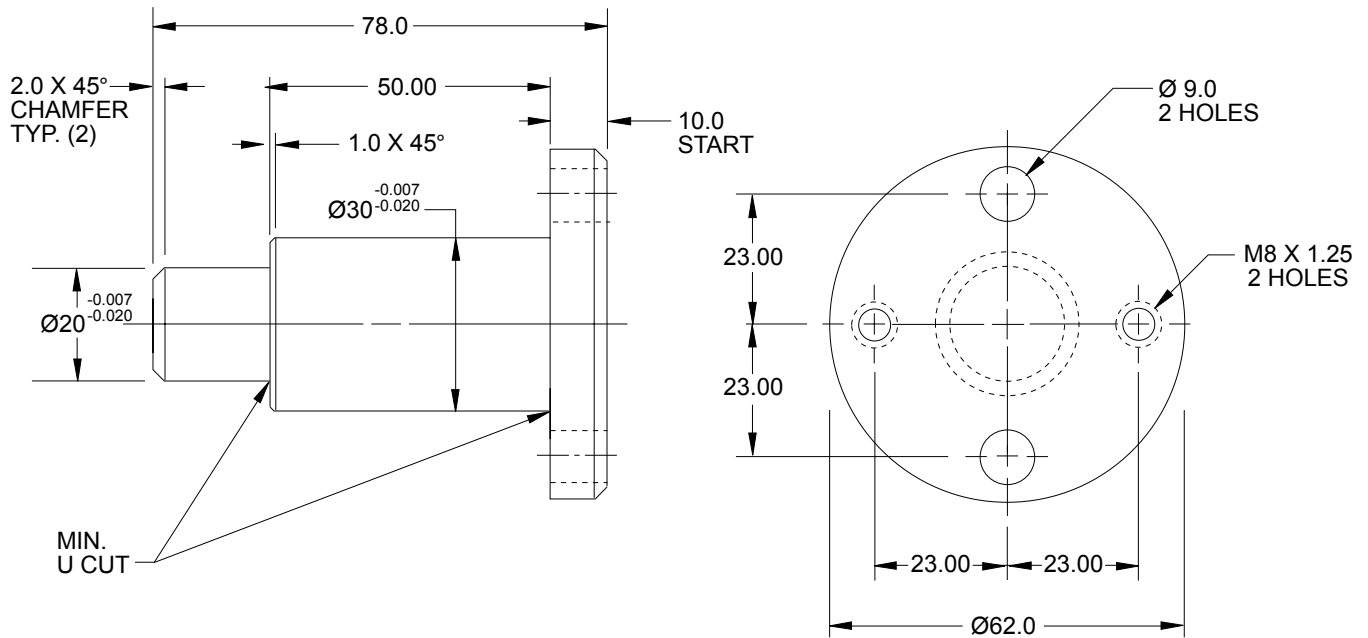
Assembly

08/24/07

B

Tolerances:
1 PLACE ± 0.3
2 PLACE ± 0.08

Weight: 0.59kg



C
A

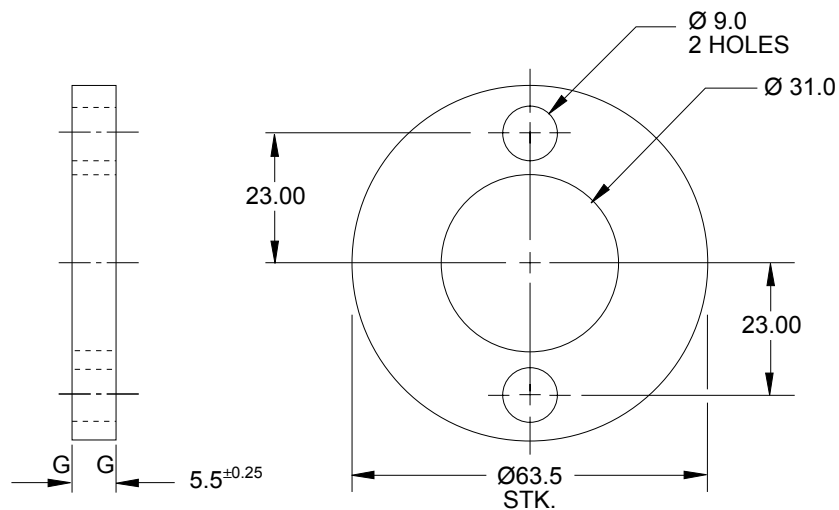
NOTES & SPECIFICATIONS:

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

DUMP UNIT SPACER ADP-202

Tolerances:

- 1 PLACE ± 0.3
- 2 PLACE ± 0.08



NOTES & SPECIFICATIONS:

Material: S.A.E. 1020 H.R.S.

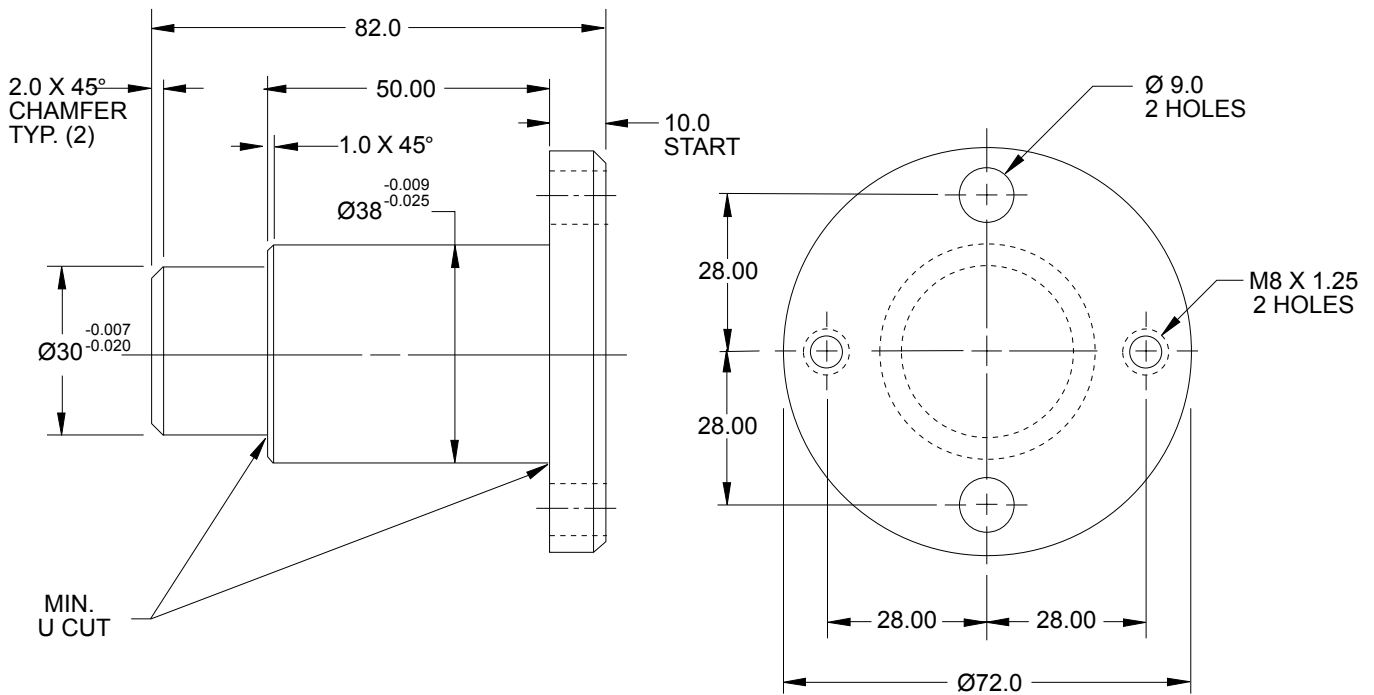
THE SPACER MAY BE CUT IN HALF THROUGH THE HOLES AT ASSEMBLY
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

A

DUMP UNIT STUB SHAFT ADP-301

Tolerances:
 1 PLACE ± 0.3
 2 PLACE ± 0.08
 Weight: 0.91 kg

B



NOTES & SPECIFICATIONS:

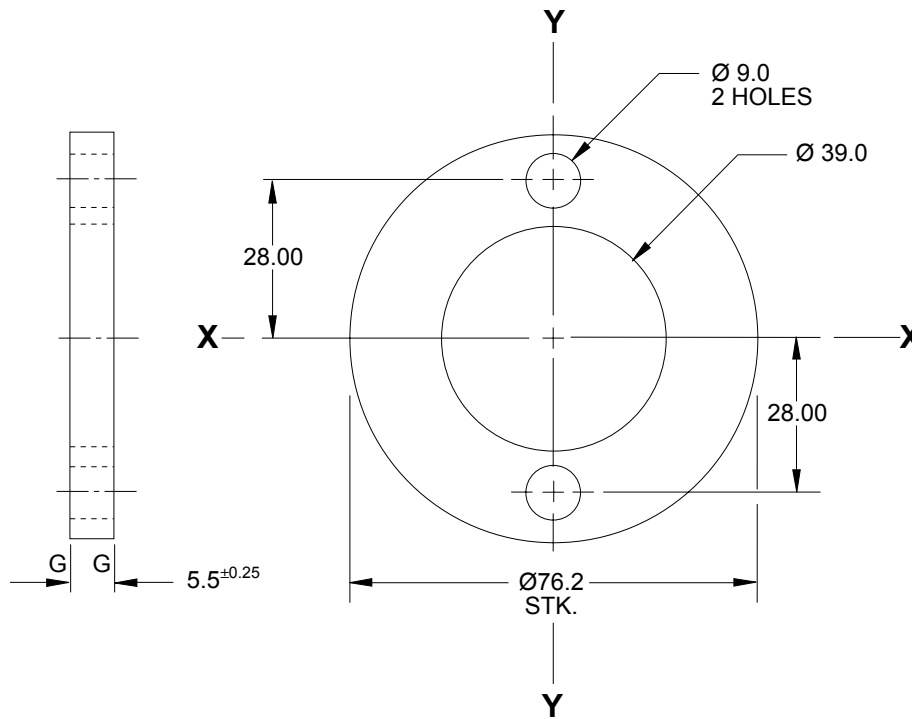
Material: S.A.E. 1020 H.R.S.
 SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

C

A

DUMP UNIT SPACER ADP302 SERIES

Tolerances:
 1 PLACE ± 0.3
 2 PLACE ± 0.08



A

CONDITION	NAAMS CODE
UNCUT	ADP302
CUT ON AXIS X - X	ADP302A
CUT ON AXIS Y - Y	ADP302B

NOTES & SPECIFICATIONS:

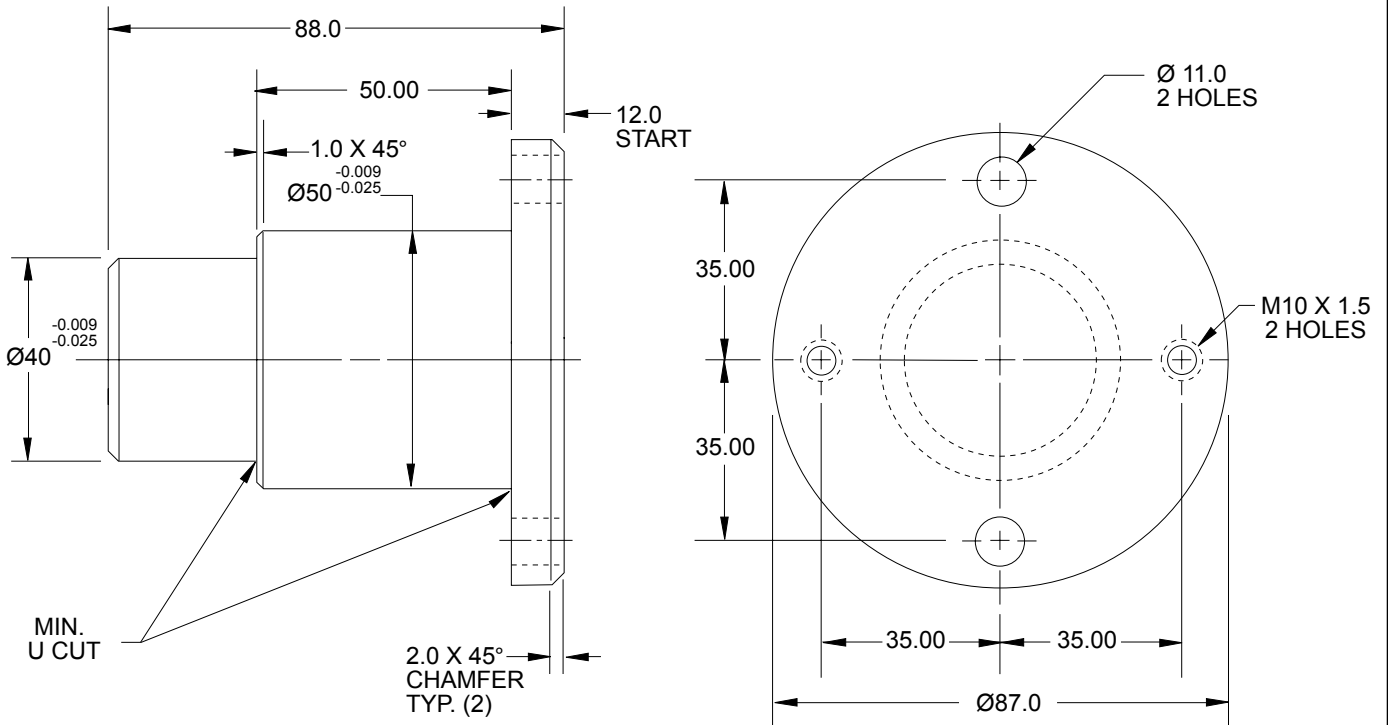
Material: S.A.E. 1020 H.R.S.
 SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

B

DUMP UNIT STUB SHAFT ADP-401

B

Tolerances:
1 PLACE ± 0.3
2 PLACE ± 0.08
Weight: 1.59 kg



NOTES & SPECIFICATIONS:

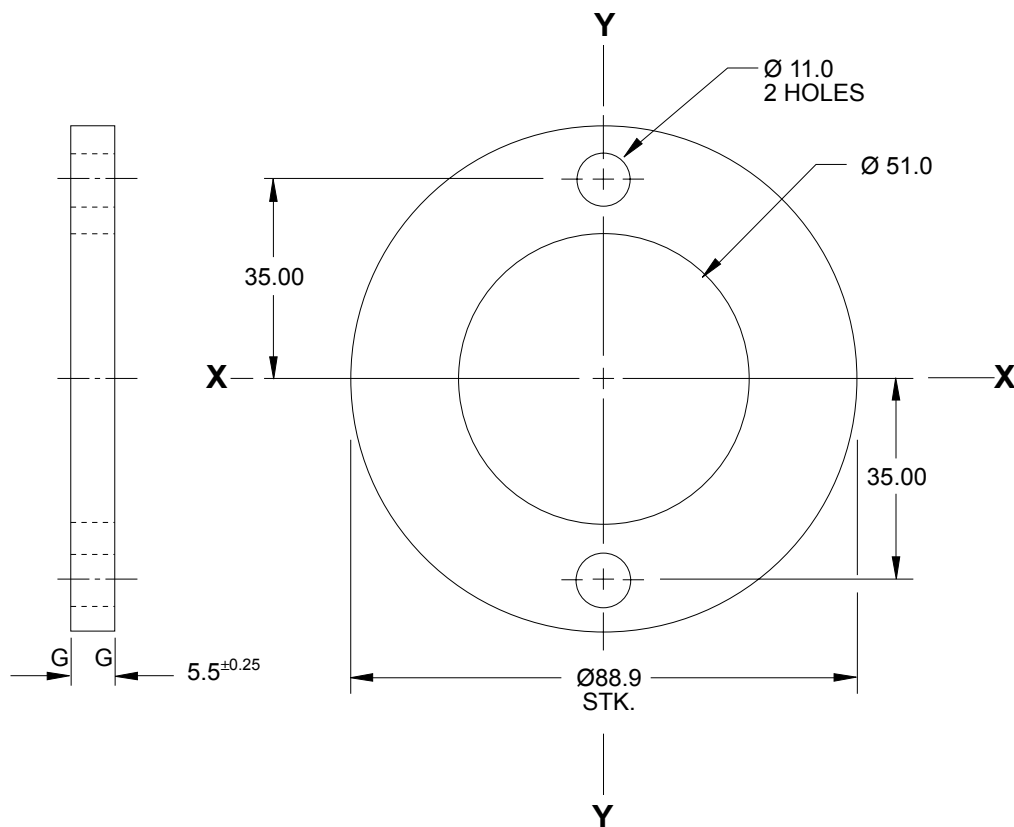
Material: S.A.E. 1020 H.R.S.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

C
A

DUMP UNIT SPACER ADP402 SERIES

Tolerances:
 1 PLACE ± 0.3
 2 PLACE ± 0.08

Weight: 0.18 kg



CONDITION	NAAMS CODE
UNCUT	ADP402
CUT ON AXIS X - X	ADP402A
CUT ON AXIS Y - Y	ADP402B

NOTES & SPECIFICATIONS:

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

DUMP UNIT STUB SHAFT ADP-501

GLOBAL STANDARD COMPONENTS



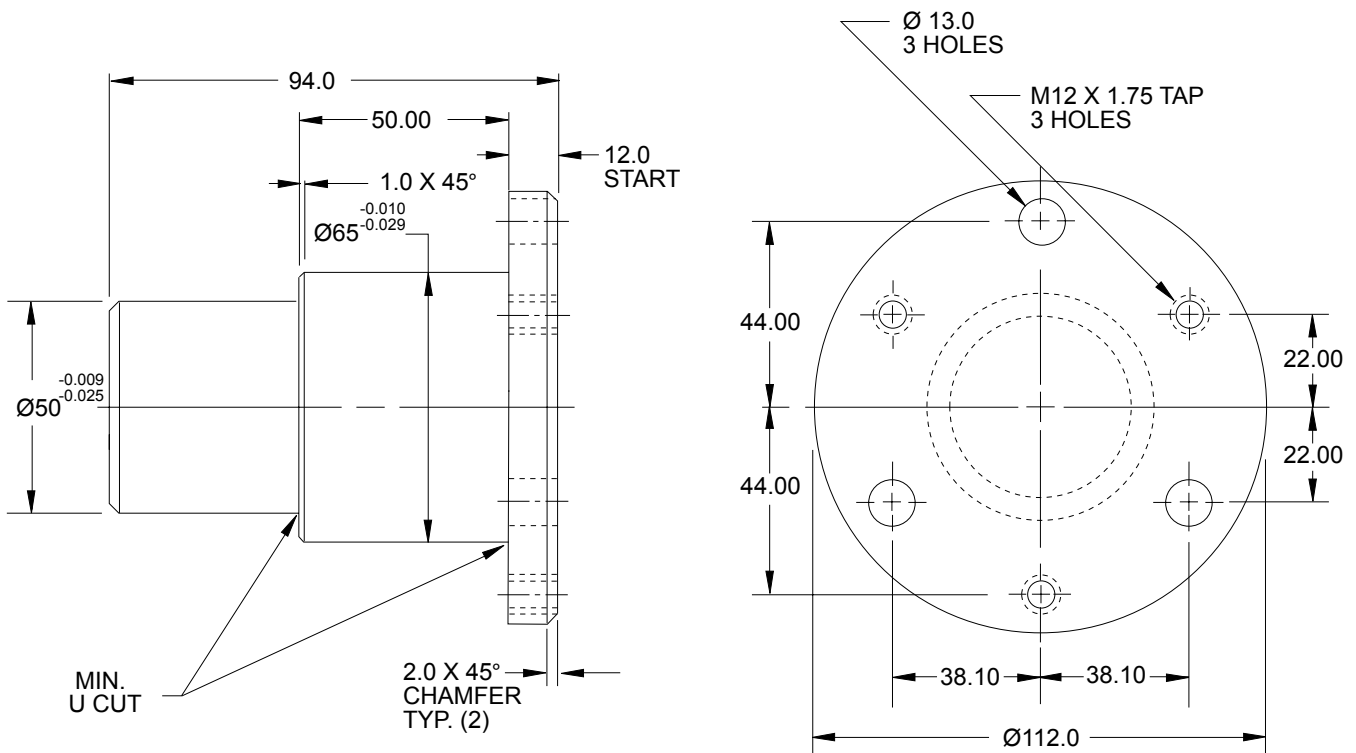
Assembly

08/24/07

B

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

C

A

DUMP UNIT SPACER ADP502 SERIES

GLOBAL STANDARD COMPONENTS



Assembly

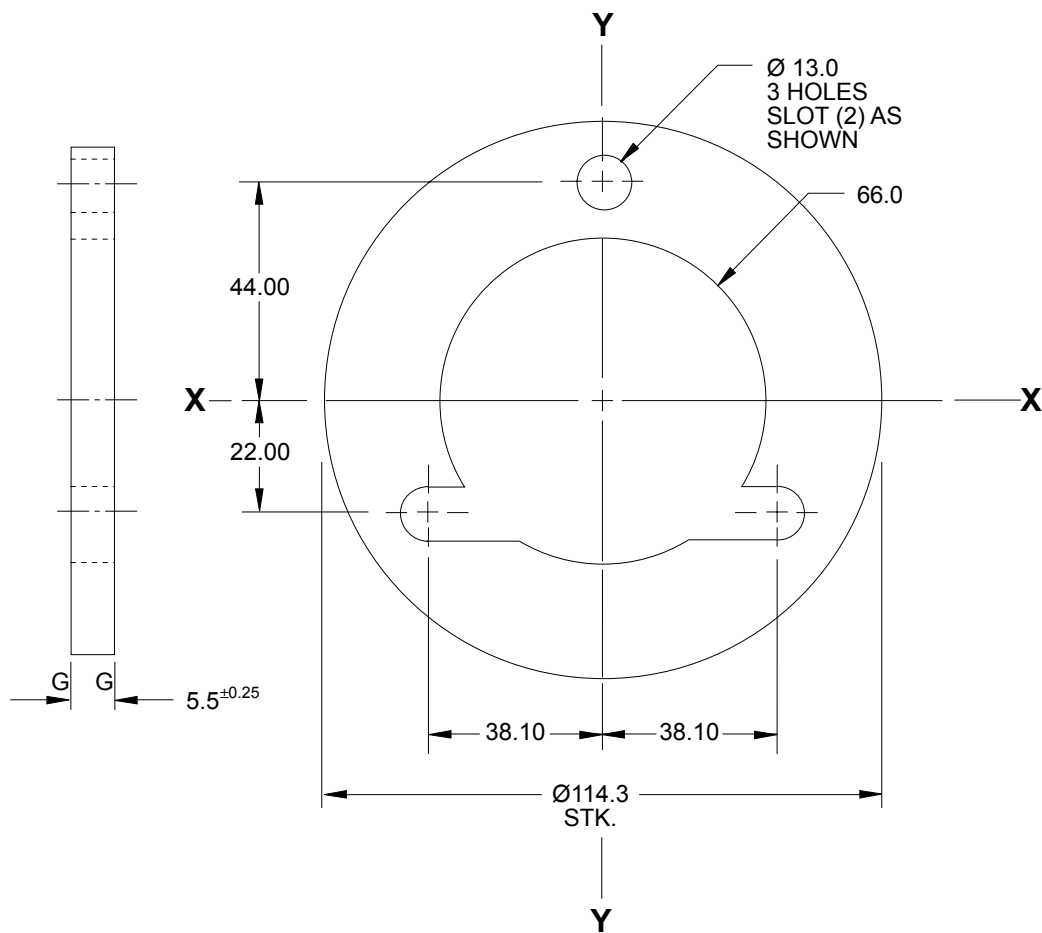
08/24/07

Tolerances:

1 PLACE ± 0.3

2 PLACE ± 0.08

Weight: 0.32 kg



CONDITION	NAAMS CODE
UNCUT	ADP502
CUT ON AXIS X - X	ADP502A
CUT ON AXIS Y - Y	ADP502B

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

DUMP UNIT PIVOT ASSY. THRU SHAFT COMPOSITE BEARINGS ADP400C SERIES

GLOBAL STANDARD COMPONENTS

NAAMS

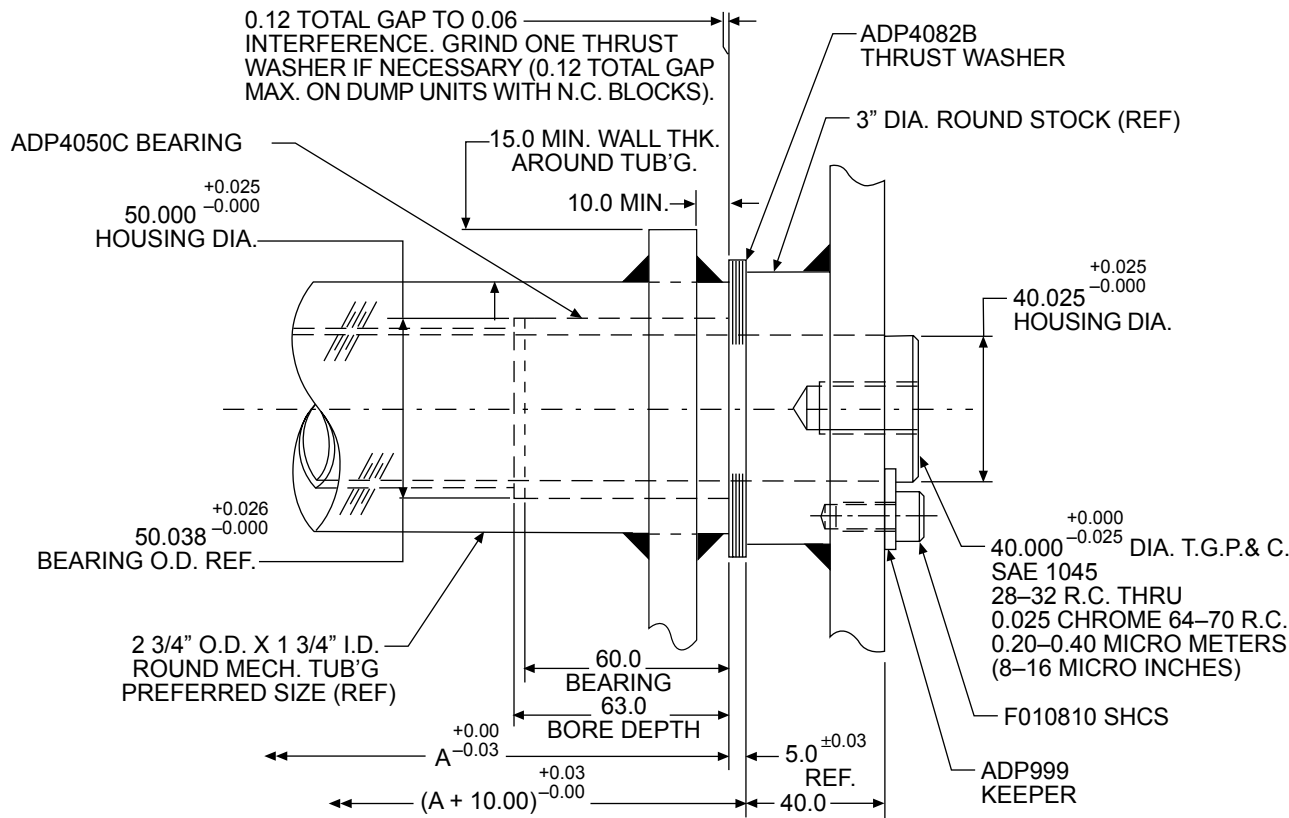


Assembly

08/24/07

SHOWN USING ADP400C SERIES THROUGH SHAFTS

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



LIGHT - MEDIUM DUTY THROUGH SHAFT APPLICATIONS

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.

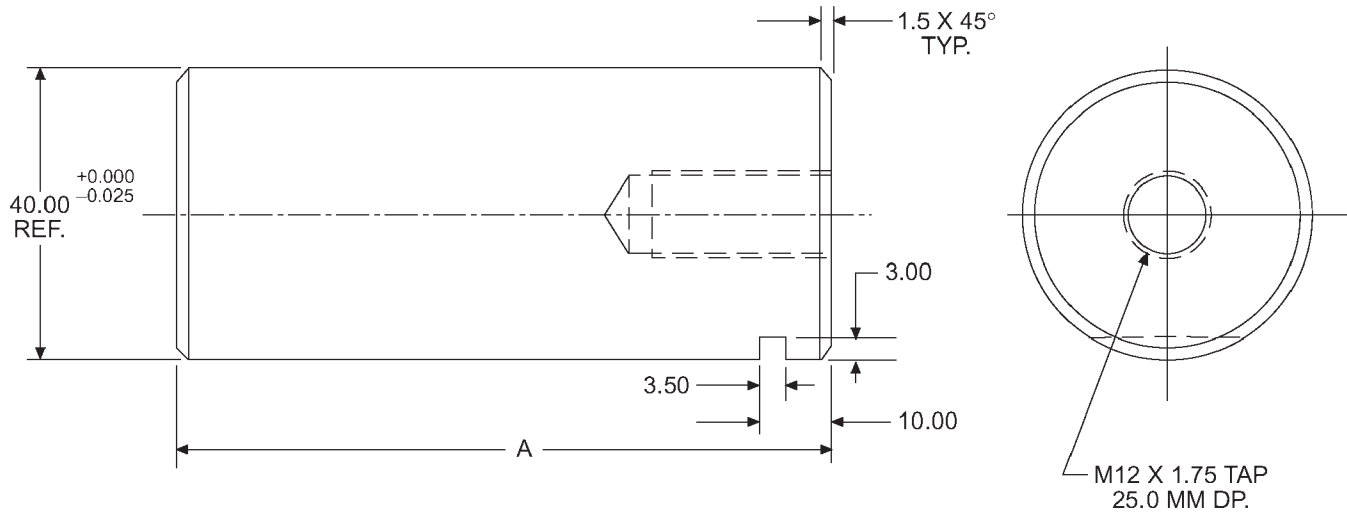
40 MM THROUGH SHAFTS

GLOBAL STANDARD COMPONENTS



Assembly

08/24/07



NAAMS CODE	A DIM.	WT. kg	NAAMS CODE	A DIM.	WT. kg	NAAMS CODE	A DIM.	WT. kg	NAAMS CODE	A DIM.	WT. kg
ADP416C	160.00	1.5	ADP436C	360.00	3.5	ADP456C	560.00	5.4	ADP476C	760.00	7.4
ADP417C	170.00	1.6	ADP437C	370.00	3.6	ADP457C	570.00	5.5	ADP477C	770.00	7.5
ADP418C	180.00	1.7	ADP438C	380.00	3.7	ADP458C	580.00	5.6	ADP478C	780.00	7.6
ADP419C	190.00	1.8	ADP439C	390.00	3.8	ADP459C	590.00	5.7	ADP479C	790.00	7.7
ADP420C	200.00	1.9	ADP440C	400.00	3.9	ADP460C	600.00	5.8	ADP480C	800.00	7.8
ADP421C	210.00	2.0	ADP441C	410.00	4.0	ADP461C	610.00	5.9	ADP481C	810.00	7.9
ADP422C	220.00	2.1	ADP442C	420.00	4.1	ADP462C	620.00	6.0	ADP482C	820.00	8.0
ADP423C	230.00	2.2	ADP443C	430.00	4.2	ADP463C	630.00	6.1	ADP483C	830.00	8.1
ADP424C	240.00	2.3	ADP444C	440.00	4.3	ADP464C	640.00	6.2	ADP484C	840.00	8.2
ADP425C	250.00	2.4	ADP445C	450.00	4.4	ADP465C	650.00	6.3	ADP485C	850.00	8.3
ADP426C	260.00	2.5	ADP446C	460.00	4.5	ADP466C	660.00	6.4	ADP486C	860.00	8.3
ADP427C	270.00	2.6	ADP447C	470.00	4.6	ADP467C	670.00	6.5	ADP487C	870.00	8.4
ADP428C	280.00	2.7	ADP448C	480.00	4.6	ADP468C	680.00	6.6	ADP488C	880.00	8.5
ADP429C	290.00	2.8	ADP449C	490.00	4.7	ADP469C	690.00	6.7	ADP489C	890.00	8.6
ADP430C	300.00	2.9	ADP450C	500.00	4.8	ADP470C	700.00	6.8	ADP490C	900.00	8.7
ADP431C	310.00	3.0	ADP451C	510.00	4.9	ADP471C	710.00	6.9			
ADP432C	320.00	3.1	ADP452C	520.00	5.0	ADP472C	720.00	7.0			
ADP433C	330.00	3.2	ADP453C	530.00	5.1	ADP473C	730.00	7.1			
ADP434C	340.00	3.3	ADP454C	540.00	5.2	ADP474C	740.00	7.2			
ADP435C	350.00	3.4	ADP455C	550.00	5.3	ADP475C	750.00	7.3			

A

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: 40.000 ^{+0.000}/_{-0.025} 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

B

DUMP UNIT PIVOT ASSY. THRU SHAFT COMPOSITE BEARINGS ADP500C SERIES

GLOBAL STANDARD COMPONENTS

NAAMS

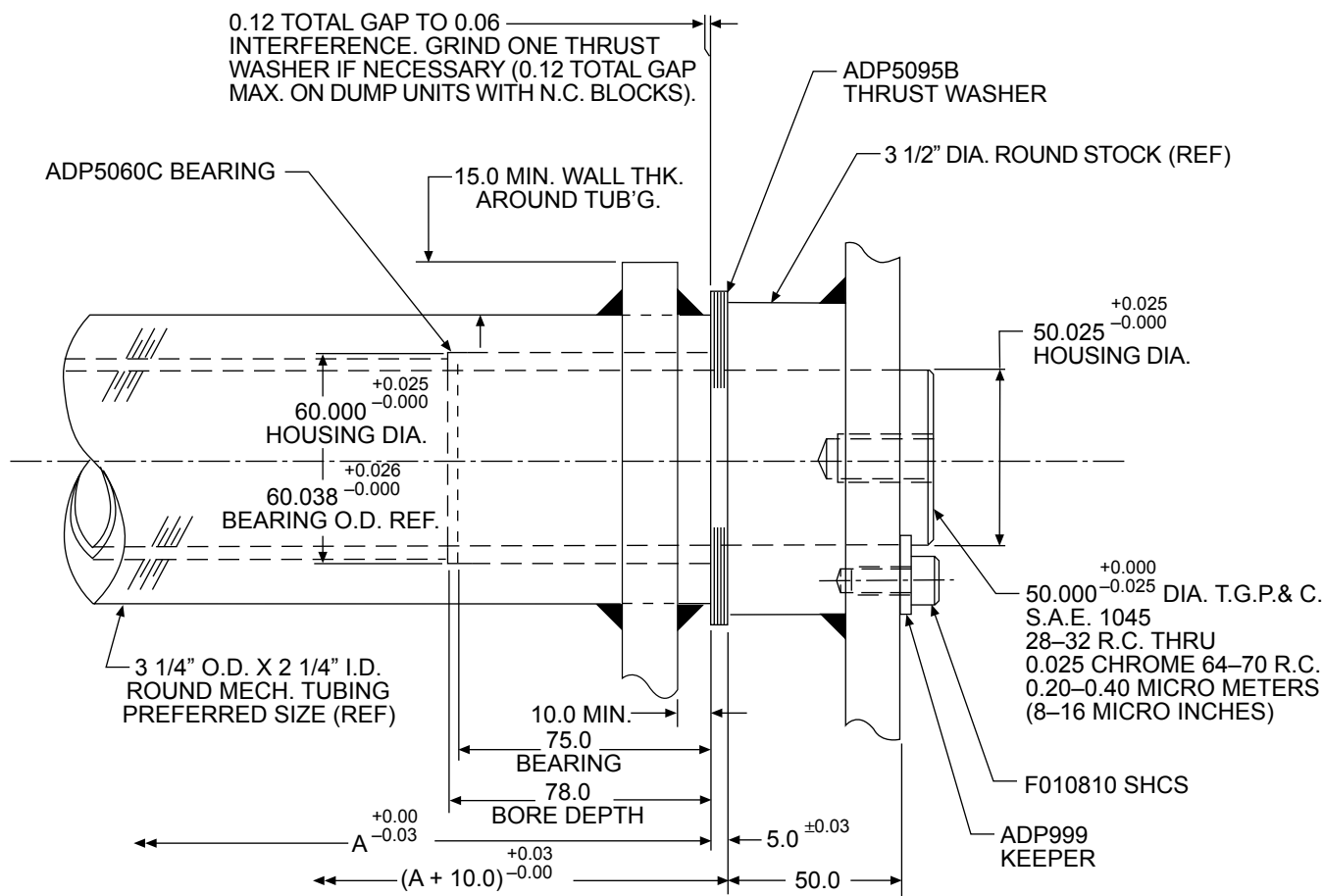


Assembly

08/24/07

SHOWN USING ADP500C SERIES THROUGH SHAFTS

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



MEDIUM – HEAVY DUTY THROUGH SHAFT APPLICATIONS

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.

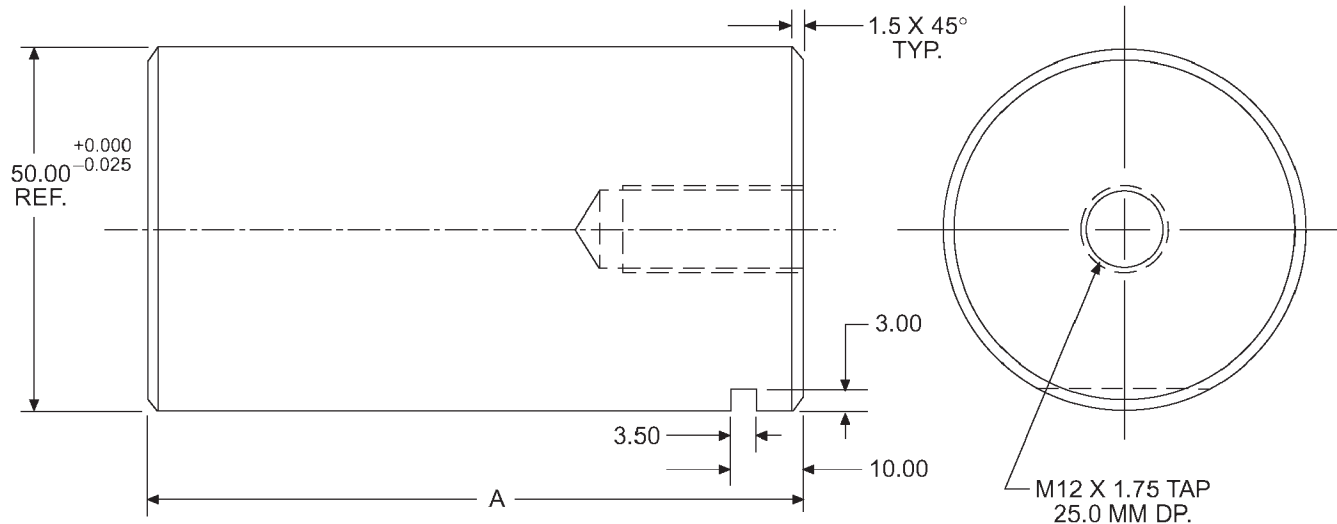
50 MM THROUGH SHAFTS

GLOBAL STANDARD COMPONENTS



Assembly

08/24/07



NAAMS CODE	A DIM.	WT. kg	NAAMS CODE	A DIM.	WT. kg	NAAMS CODE	A DIM.	WT. kg	NAAMS CODE	A DIM.	WT. kg
ADP530C	300.00	4.5	ADP545C	450.00	6.8	ADP560C	600.00	9.1	ADP575C	750.00	11.4
ADP531C	310.00	4.7	ADP546C	460.00	7.0	ADP561C	610.00	9.3	ADP576C	760.00	11.5
ADP532C	320.00	4.8	ADP547C	470.00	7.1	ADP562C	620.00	9.4	ADP577C	770.00	11.7
ADP533C	330.00	5.0	ADP548C	480.00	7.3	ADP563C	630.00	9.6	ADP578C	780.00	11.8
ADP534C	340.00	5.1	ADP549C	490.00	7.4	ADP564C	640.00	9.7	ADP579C	790.00	12.0
ADP535C	350.00	5.3	ADP550C	500.00	7.6	ADP565C	650.00	9.9	ADP580C	800.00	12.1
ADP536C	360.00	5.5	ADP551C	510.00	7.7	ADP566C	660.00	10.0	ADP581C	810.00	12.3
ADP537C	370.00	5.6	ADP552C	520.00	7.9	ADP567C	670.00	10.2	ADP582C	820.00	12.5
ADP538C	380.00	5.8	ADP553C	530.00	8.0	ADP568C	680.00	10.3	ADP583C	830.00	12.6
ADP539C	390.00	5.9	ADP554C	540.00	8.2	ADP569C	690.00	10.5	ADP584C	840.00	12.8
ADP540C	400.00	6.1	ADP555C	550.00	8.3	ADP570C	700.00	10.6	ADP585C	850.00	12.9
ADP541C	410.00	6.2	ADP556C	560.00	8.5	ADP571C	710.00	10.8	ADP586C	860.00	13.1
ADP542C	420.00	6.4	ADP557C	570.00	8.6	ADP572C	720.00	10.9	ADP587C	870.00	13.2
ADP543C	430.00	6.5	ADP558C	580.00	8.8	ADP573C	730.00	11.1	ADP588C	880.00	13.4
ADP544C	440.00	6.7	ADP559C	590.00	9.0	ADP574C	740.00	11.2	ADP589C	890.00	13.5
									ADP590C	900.00	13.7

A
B

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^{+0.000}_{-0.025} 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

C

DUMP UNIT PIVOT ASSY. THRU SHAFT COMPOSITE BEARINGS ADP600C SERIES

GLOBAL STANDARD COMPONENTS

NAAMS

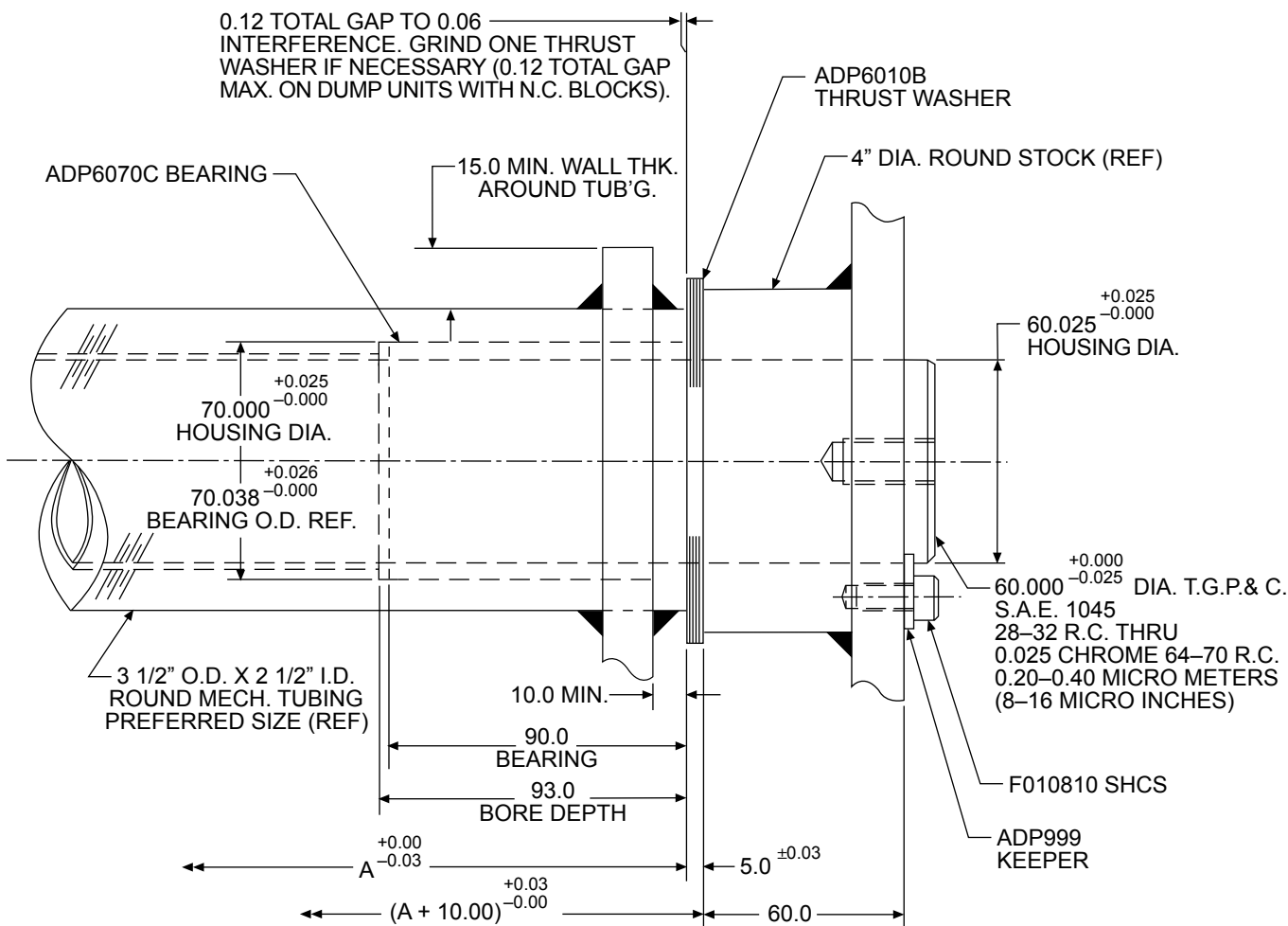


Assembly

08/24/07

SHOWN USING ADP600C SERIES THROUGH SHAFTS

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



EXTRA HEAVY DUTY THROUGH SHAFT APPLICATIONS

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.

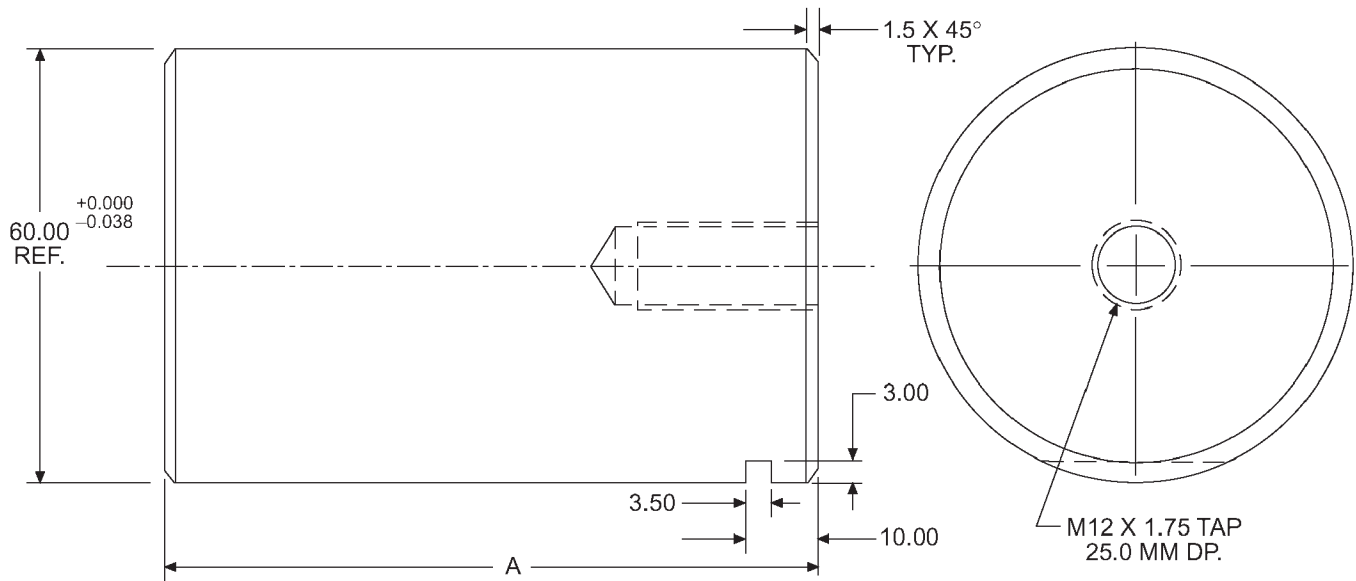
60 MM THROUGH SHAFTS

GLOBAL STANDARD COMPONENTS



Assembly

08/24/07



NAAMS CODE	A DIM.	WT. kg	NAAMS CODE	A DIM.	WT. kg	NAAMS CODE	A DIM.	WT. kg	NAAMS CODE	A DIM.	WT. kg
ADP630C	300.00	6.5	ADP645C	450.00	9.8	ADP660C	600.00	13.1	ADP675C	750.00	16.4
ADP631C	310.00	6.8	ADP646C	460.00	10.1	ADP661C	610.00	13.3	ADP676C	760.00	16.6
ADP632C	320.00	7.0	ADP647C	470.00	10.3	ADP662C	620.00	13.6	ADP677C	770.00	16.8
ADP633C	330.00	7.2	ADP648C	480.00	10.5	ADP663C	630.00	13.8	ADP678C	780.00	17.1
ADP634C	340.00	7.4	ADP649C	490.00	10.7	ADP664C	640.00	14.0	ADP679C	790.00	17.3
ADP635C	350.00	7.6	ADP650C	500.00	10.9	ADP665C	650.00	14.2	ADP680C	800.00	17.5
ADP636C	360.00	7.9	ADP651C	510.00	11.1	ADP666C	660.00	14.4	ADP681C	810.00	17.7
ADP637C	370.00	8.1	ADP652C	520.00	11.4	ADP667C	670.00	14.7	ADP682C	820.00	17.9
ADP638C	380.00	8.3	ADP653C	530.00	11.6	ADP668C	680.00	14.9	ADP683C	830.00	18.2
ADP639C	390.00	8.5	ADP654C	540.00	11.8	ADP669C	690.00	15.1	ADP684C	840.00	18.4
ADP640C	400.00	8.7	ADP655C	550.00	12.0	ADP670C	700.00	15.3	ADP685C	850.00	18.6
ADP641C	410.00	9.0	ADP656C	560.00	12.2	ADP671C	710.00	15.5	ADP686C	860.00	18.8
ADP642C	420.00	9.2	ADP657C	570.00	12.5	ADP672C	720.00	15.7	ADP687C	870.00	19.0
ADP643C	430.00	9.4	ADP658C	580.00	12.7	ADP673C	730.00	16.0	ADP688C	880.00	19.3
ADP644C	440.00	9.6	ADP659C	590.00	12.9	ADP674C	740.00	16.2	ADP689C	890.00	19.5
									ADP690C	900.00	19.7

A

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 ^{+0.000}/_{-0.038} 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

B

DUMP UNIT PIVOT ASSY. STUB SHAFT COMPOSITE BEARINGS ADP400SC SERIES

GLOBAL STANDARD COMPONENTS

NAAMS



Assembly

08/24/07

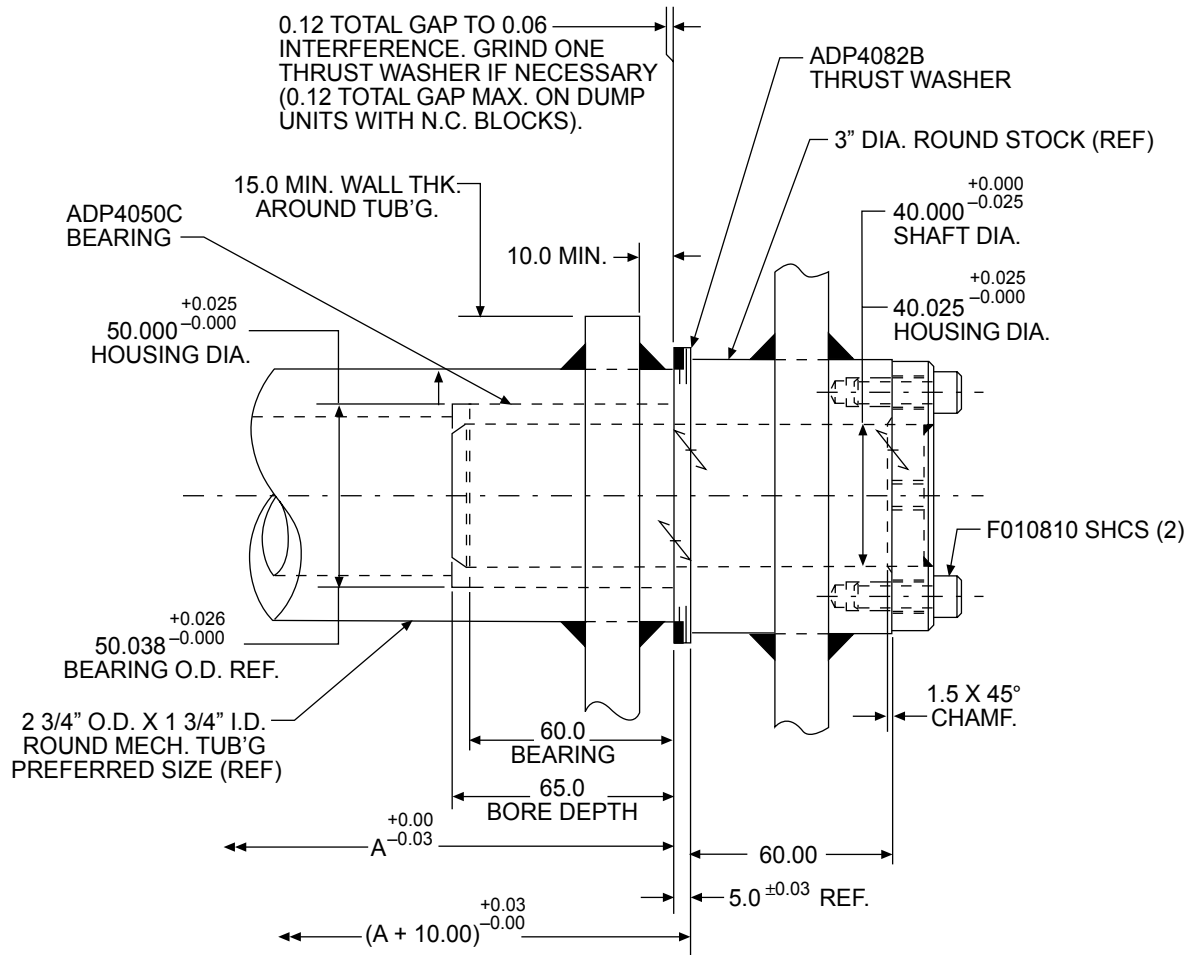
B

A

C

SHOWN USING ADP413SC STUB SHAFT

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



LIGHT – MEDIUM DUTY STUB SHAFT APPLICATIONS

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: 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.

D

DUMP UNIT PIVOT ASSY. STUB SHAFT COMPOSITE BEARINGS ADP500SC SERIES

GLOBAL STANDARD COMPONENTS

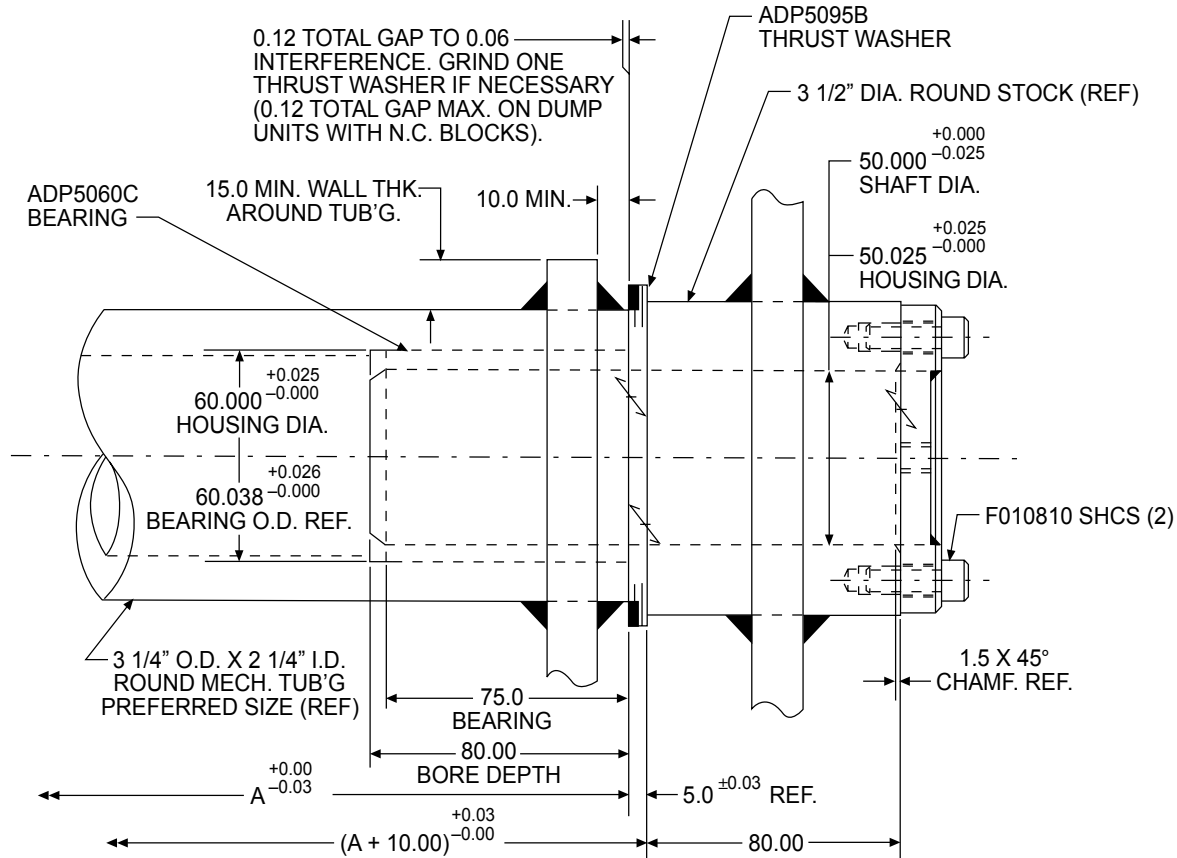


Assembly

08/24/07

SHOWN USING ADP515SC STUB SHAFT

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



MEDIUM – HEAVY DUTY STUB SHAFT APPLICATIONS

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

DUMP UNIT PIVOT ASSY. STUB SHAFT COMPOSITE BEARINGS ADP600SC SERIES

GLOBAL STANDARD COMPONENTS



Assembly

08/24/07

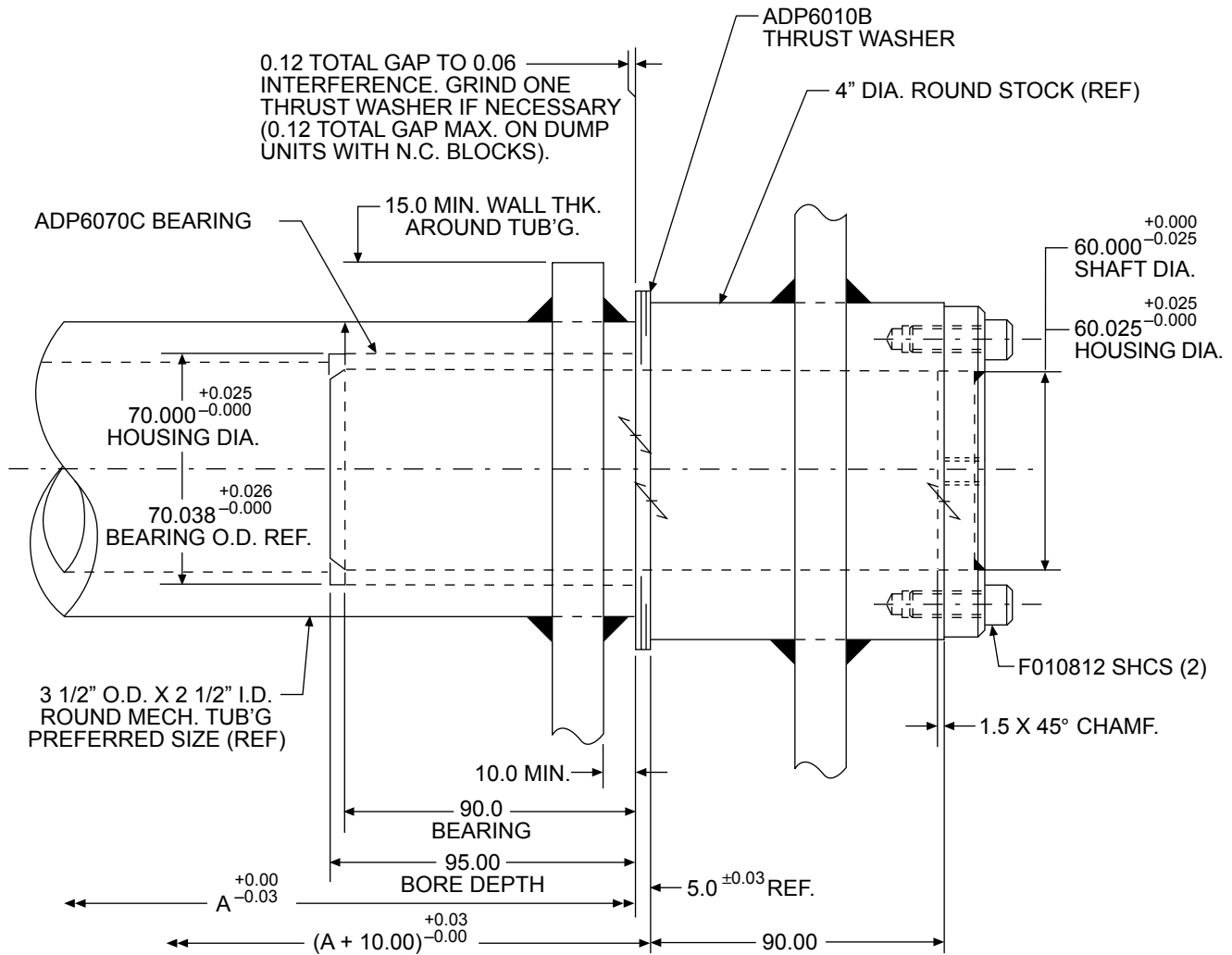
B

A

C

SHOWN USING ADP619SC STUB SHAFT

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



EXTRA HEAVY DUTY STUB SHAFT APPLICATIONS

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.

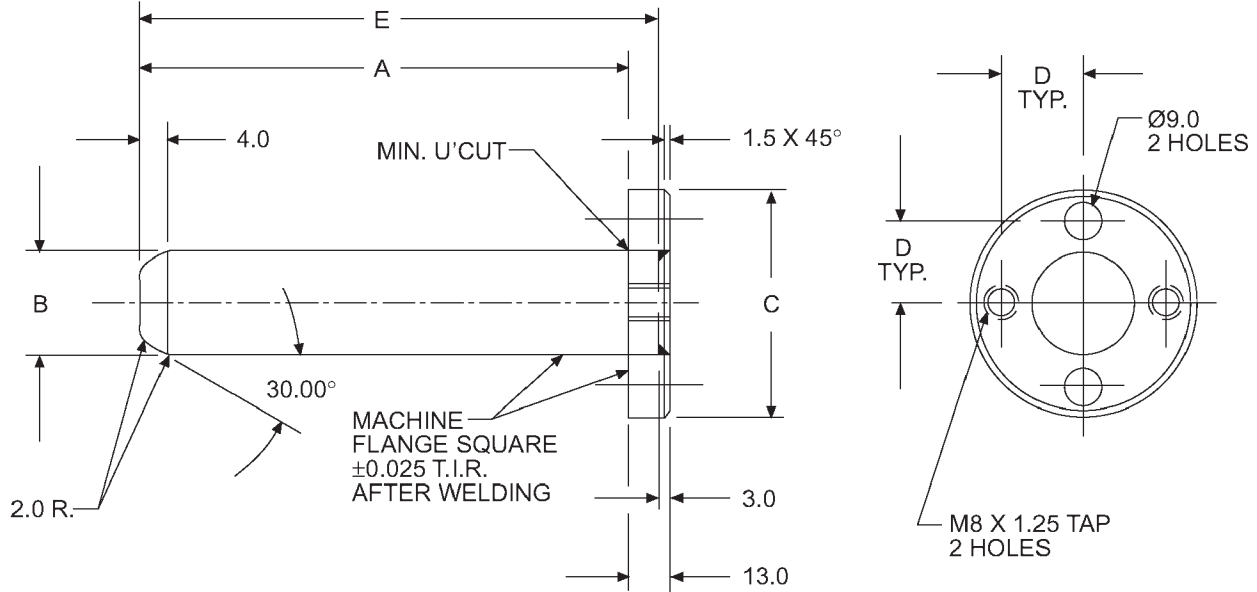
ASSEMBLE SHAFT TO BEARING USING LITHIUM GREASE.
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

NOTE: 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.

D

STUB SHAFTS



NAAMS CODE	A DIM.	B DIM.	C DIM.	D DIM.	E DIM.	WT. kg
ADP413SC	130.00	40.00 +0.000/-0.025	75.0	28.00	140.0	1.68
ADP515SC	165.00	50.00 +0.000/-0.025	87.0	35.00	175.0	3.08
ADP619SC	190.00	60.00 +0.000/-0.038	100.00	40.00	200.0	4.90

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: 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

A

B

C

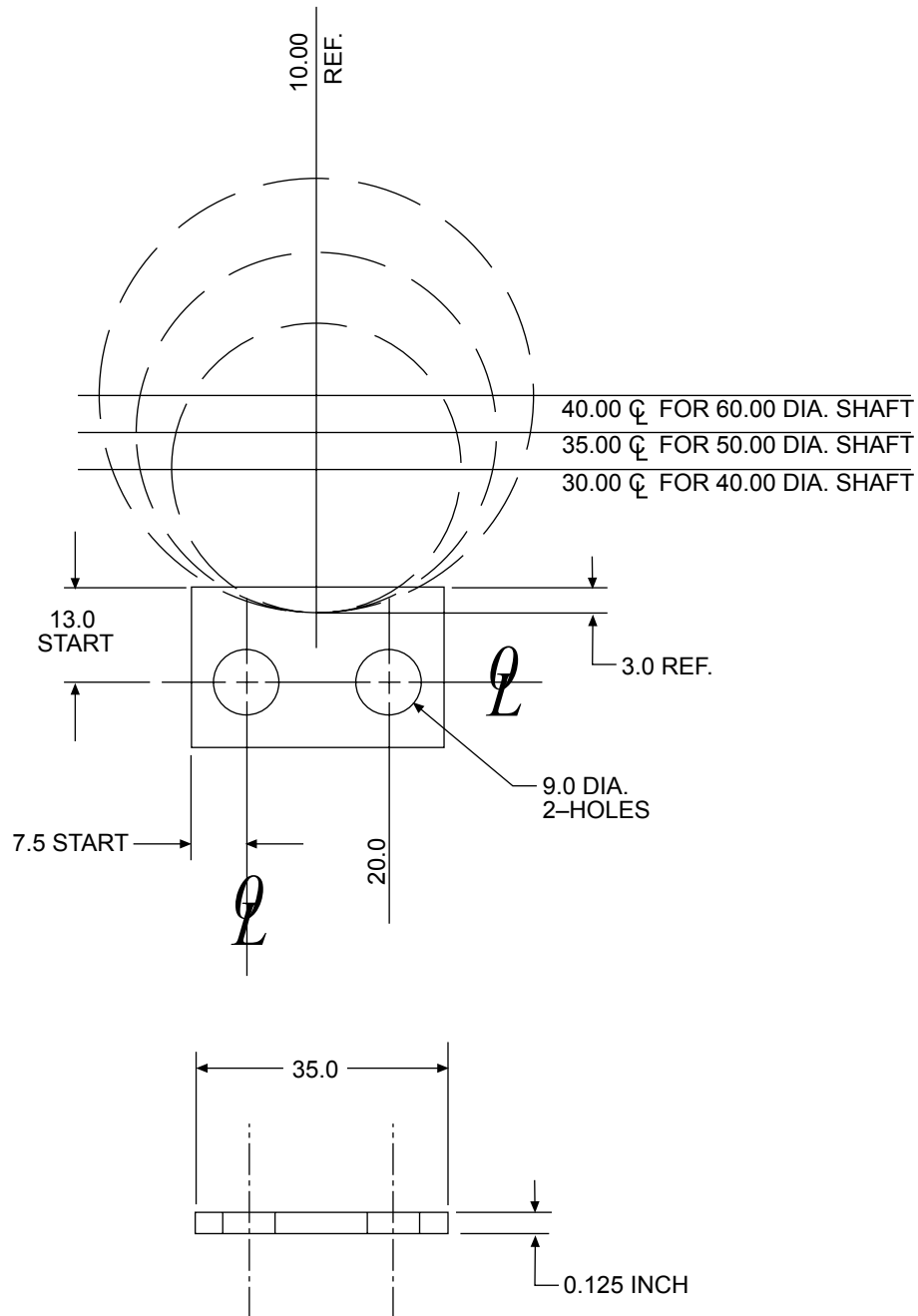
METRIC KEEPER ADP999

GLOBAL STANDARD COMPONENTS



Assembly

08/24/07



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.

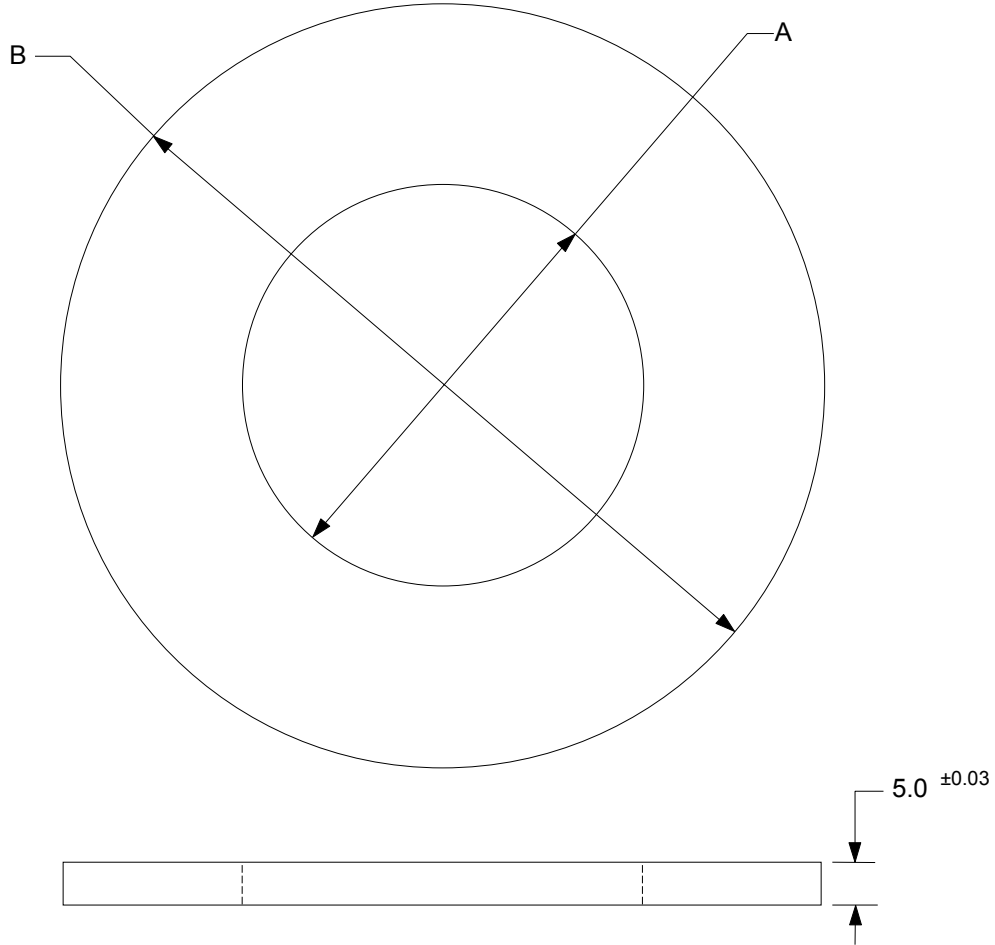
SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

A

B

C

DUMP UNIT PIVOT BRONZE THRUST WASHER



NAAMS CODE	A DIM. $+0.25/-0.00$	B DIM. ± 0.25	WT. kg
ADP2550B	25.00	50.00	0.07
ADP4082B	40.00	82.00	0.14
ADP5095B	50.00	95.00	0.18
ADP6010B	60.00	108.00	0.32

MATERIAL: BRONZE CDA93200 / S.A.E. 660
 SEE PAGE B-1.1 FOR GLOBAL MATERIALS CHART

A
C

B

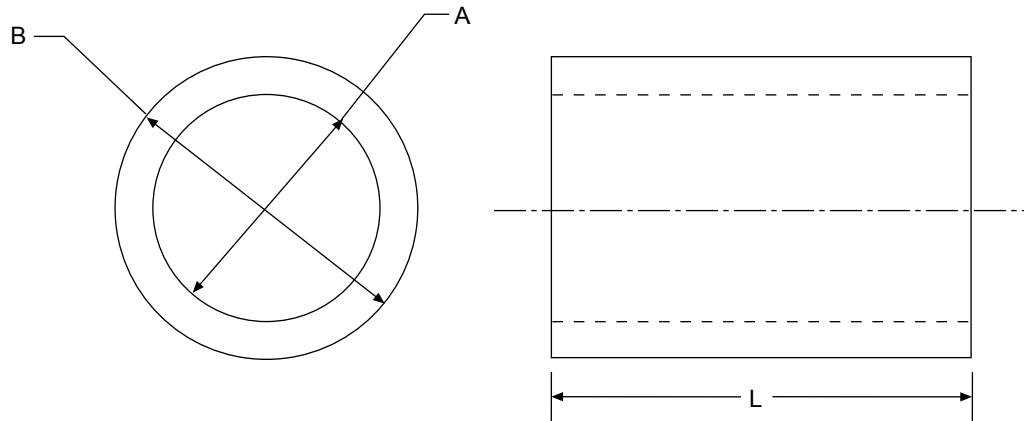
DUMP UNIT PIVOT COMPOSITE BEARING

GLOBAL STANDARD COMPONENTS



Assembly

02/25/00



NAAMS CODE	A DIM.	B DIM.	L DIM. ±0.13	PRESS FIT	RECOM. HSG. BORE	RECOM. SHAFT DIA.
ADP4050C	<u>40.094</u> 40.068	<u>50.064</u> 50.038	60	0.064 0.013	<u>50.025</u> 50.000	<u>40.000</u> 39.975
ADP5060C	<u>50.100</u> 50.074	<u>60.064</u> 60.038	75	0.064 0.013	<u>60.025</u> 60.000	<u>50.000</u> 49.975
ADP6070C	<u>60.100</u> 60.074	<u>70.064</u> 70.038	90	0.064 0.013	<u>70.025</u> 70.000	<u>60.000</u> 59.962

MATERIAL: REINFORCED TEFLON COMPOSITE LINER
WITH FIBER REINFORCED EPOXY SHELL

MEETING THE FOLLOWING SPECIFICATIONS:

ASTM D570 (WATER ABSORPTION)

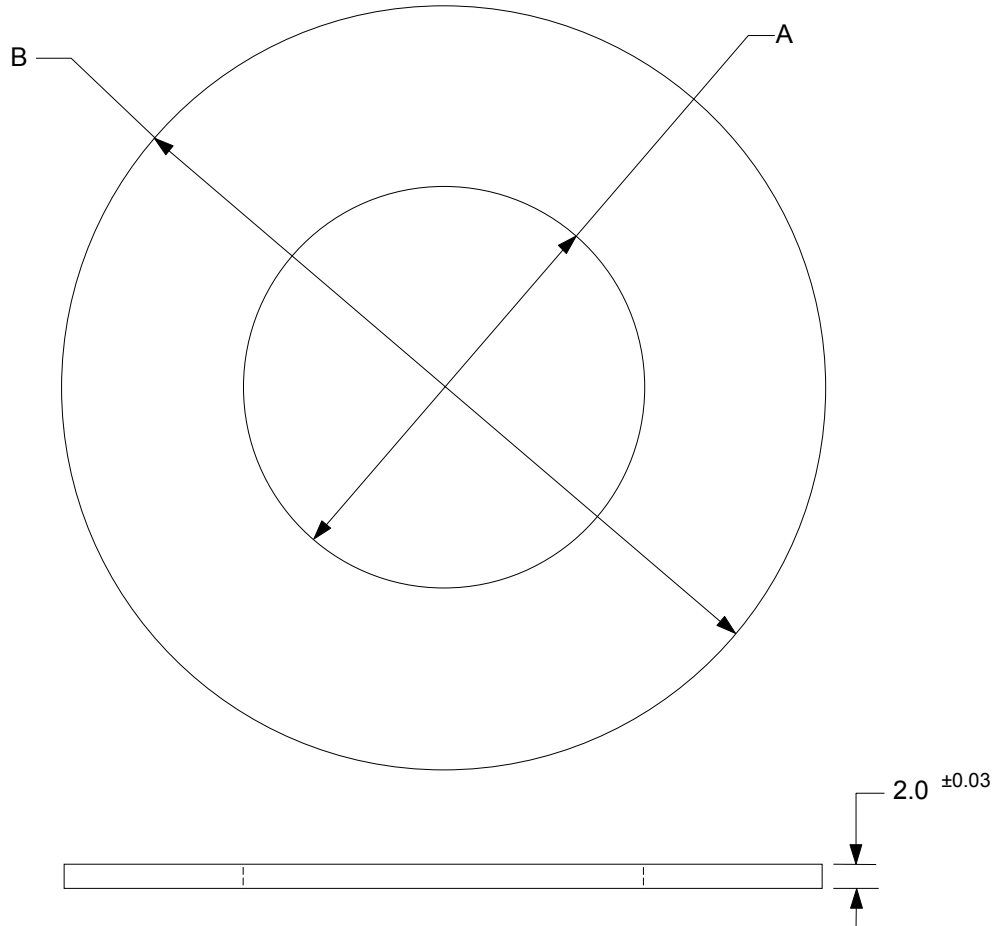
ASTM D635 (FLAMMABILITY)

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)

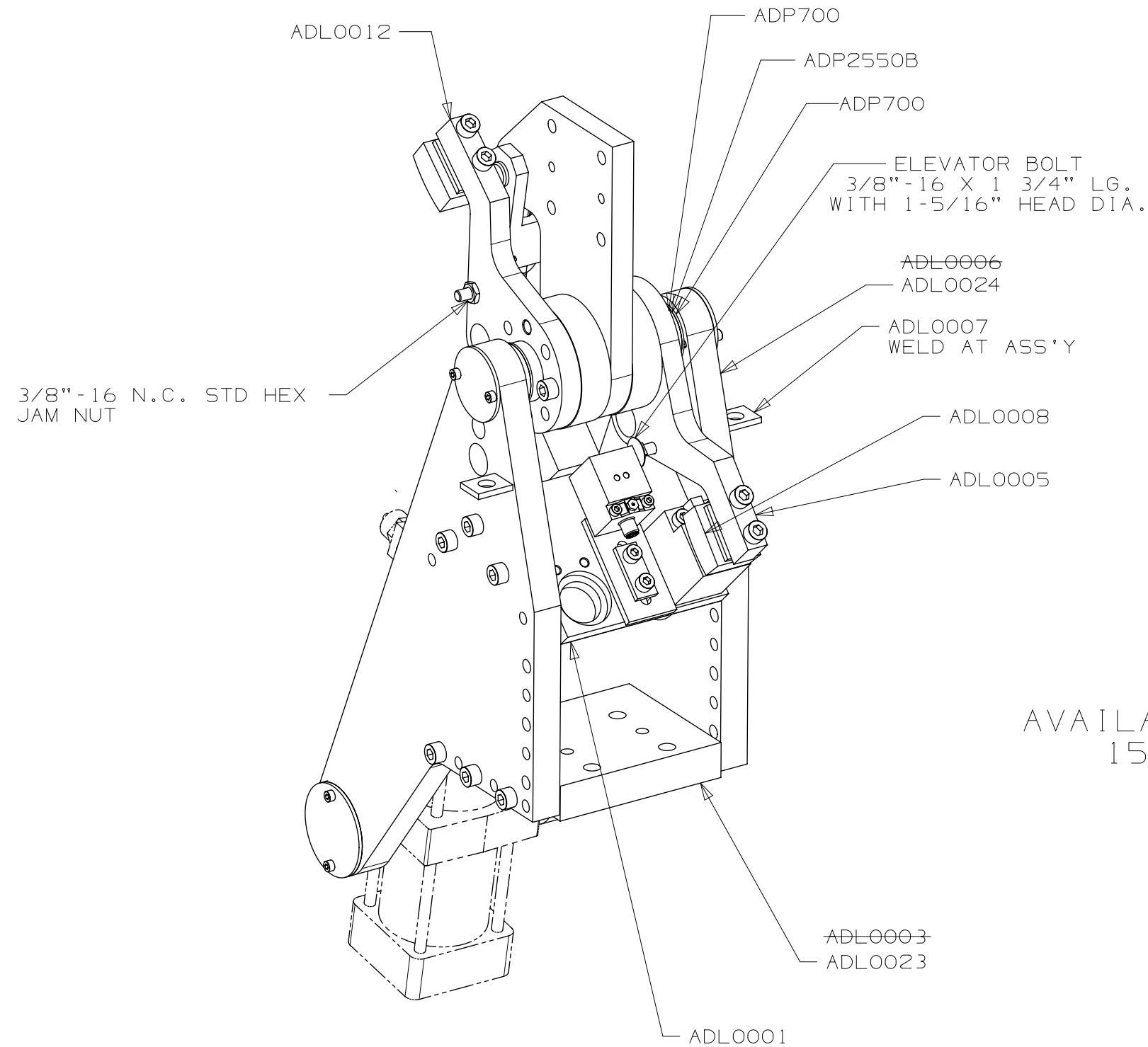
DUMP UNIT PIVOT STAINLESS STEEL THRUST WASHER



NAAMS CODE	A DIM. +0.25/-0.00	B DIM. ±0.25	WT. kg	NOTE
ADP700	29	50	0.14	FOR LIGHT DUTY DROP AWAY LEAF

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

ADL0100 DROP AWAY LEAF

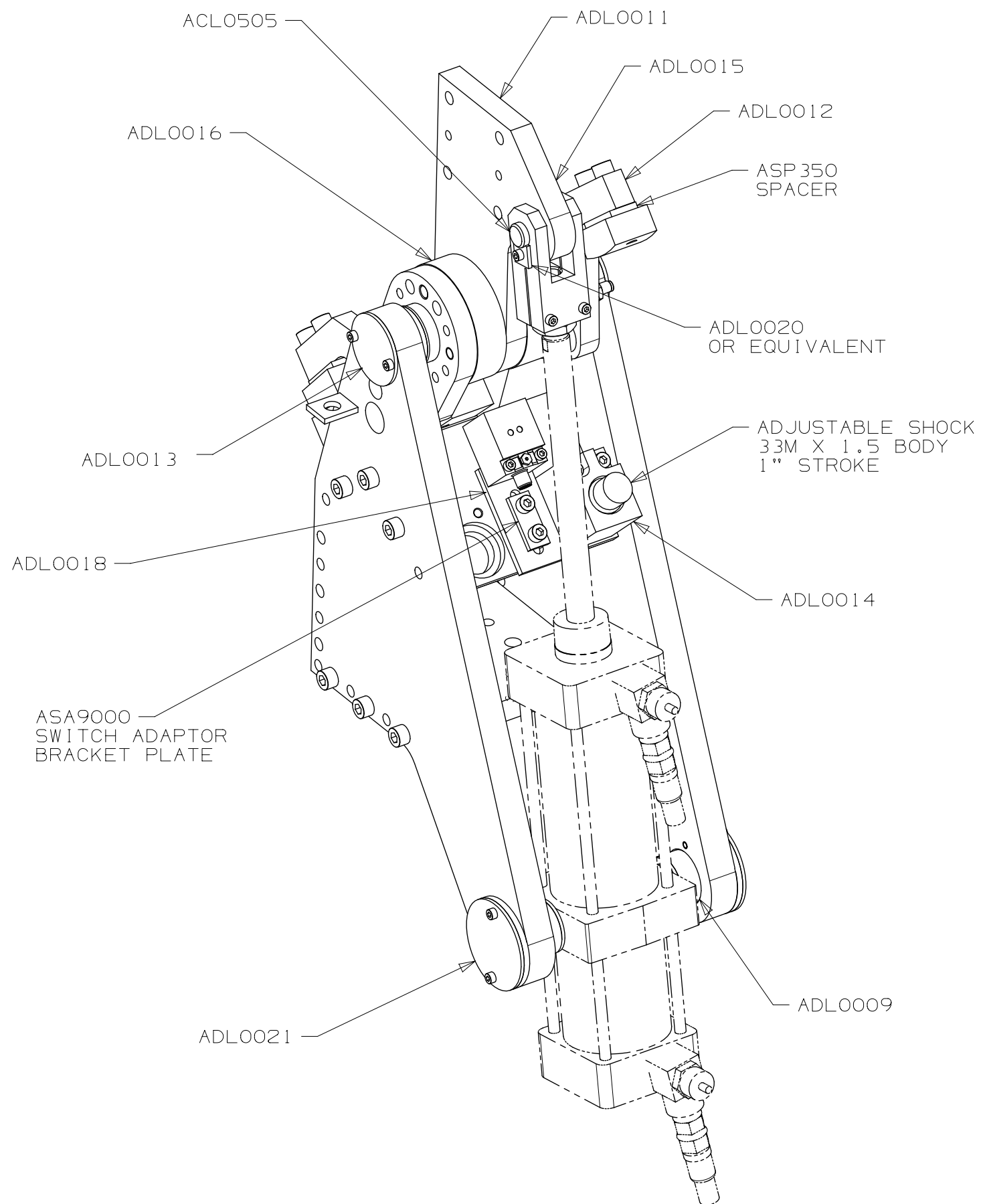


AVAILABLE OPENING ANGLES:
15°, 30°, 45°, 60°, 75°, 90°

A

A

ADL0100 DROP AWAY LEAF



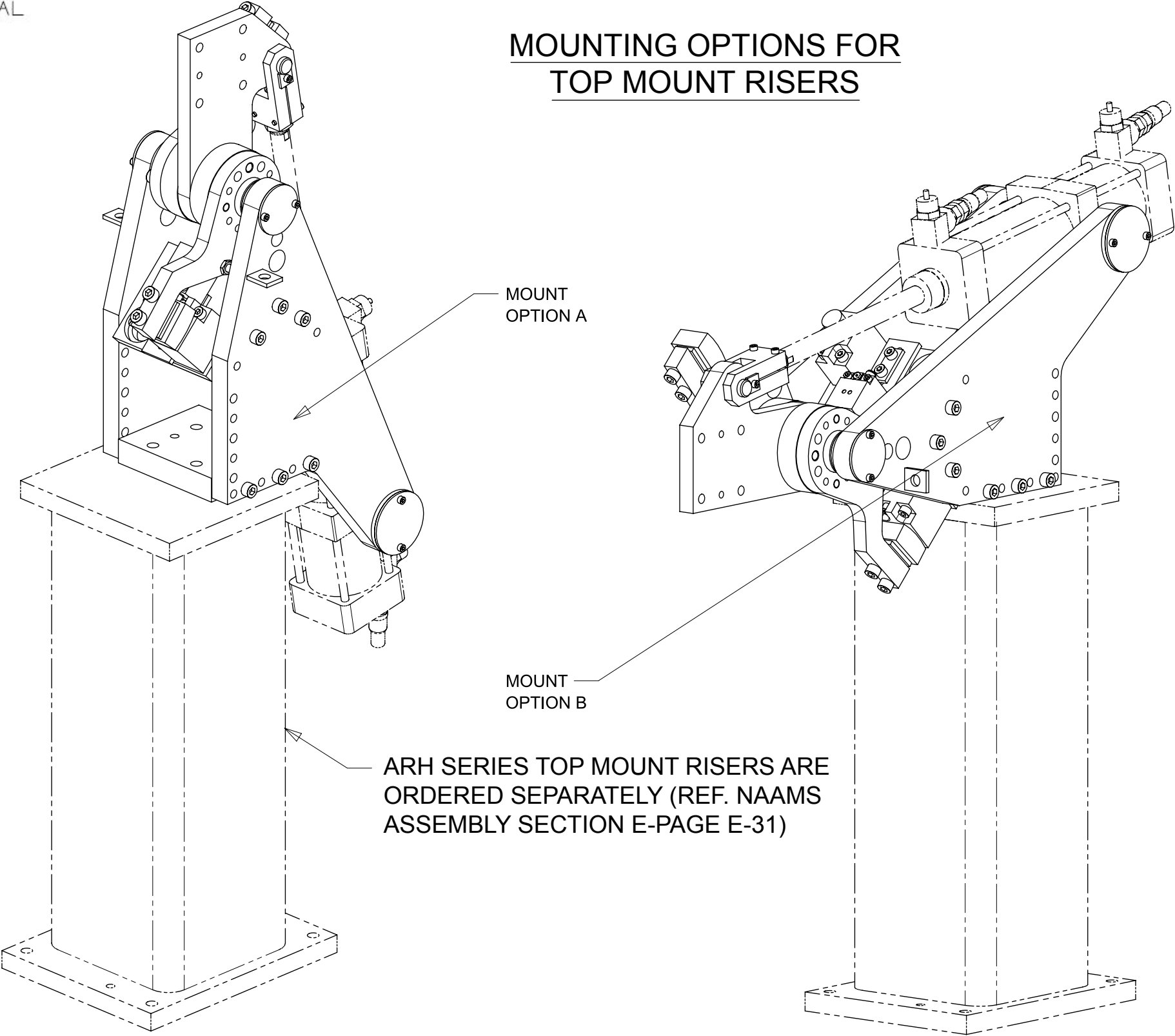
A

ADL0100 DROP AWAY LEAF

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

PIVOT MOTION	VERTICAL	HORIZONTAL
APPLIED LOAD	23 KG (50.7 LBS)	66 KG (145.5 LBS)
CENTER OF MASS FROM PIVOT	300 MM (11.8")	
AIR PRESSURE	4.5 - 5.5 BAR (65.27 - 79.77 PSI)	

MOUNTING OPTIONS FOR TOP MOUNT RISERS

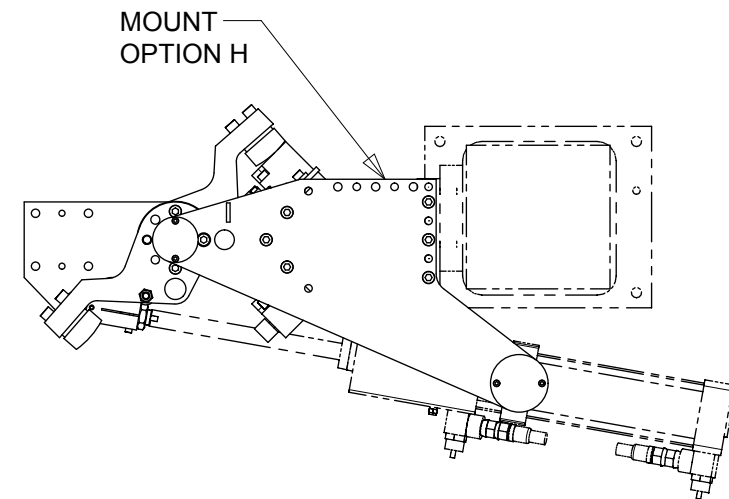
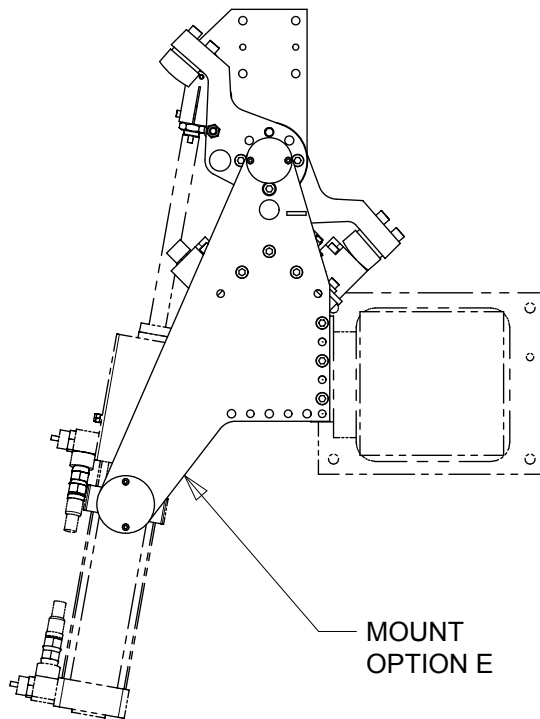
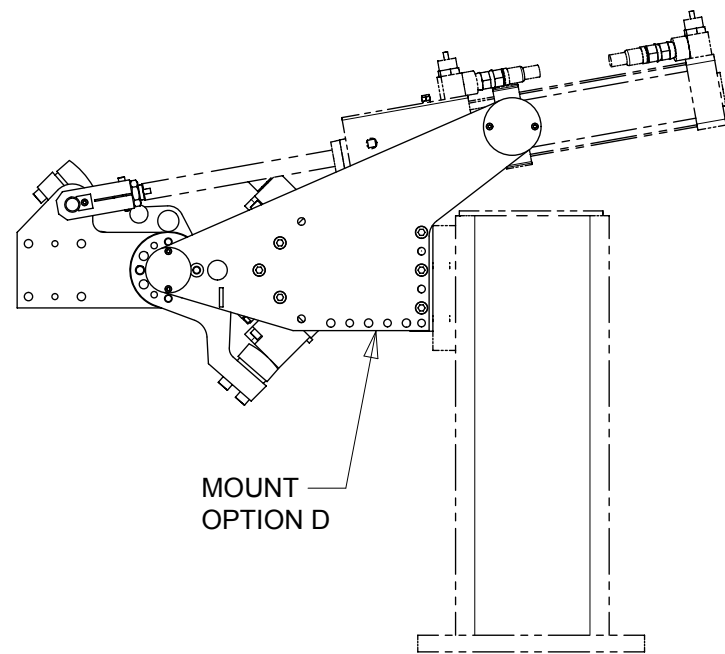
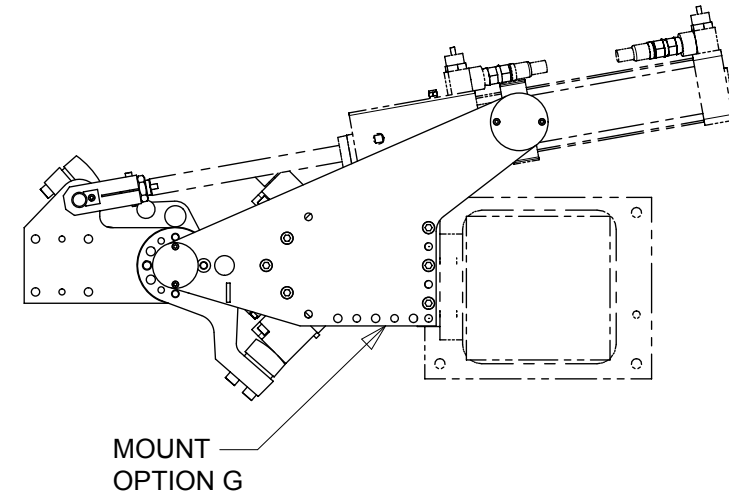
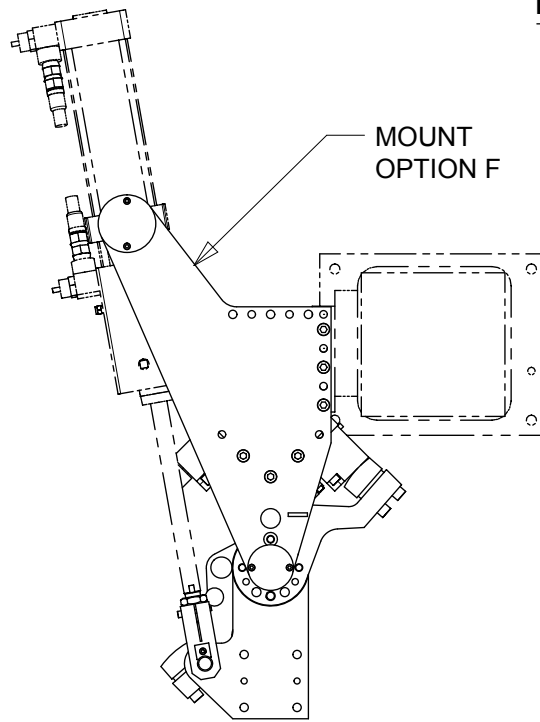
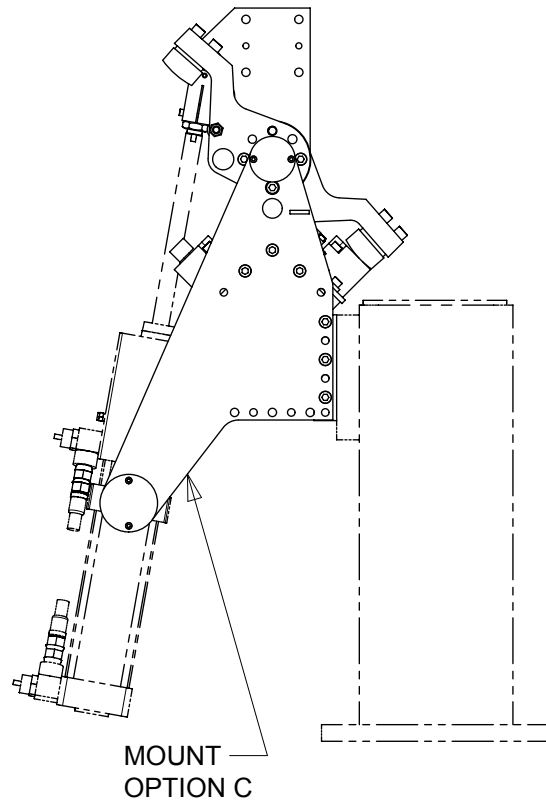


A

A

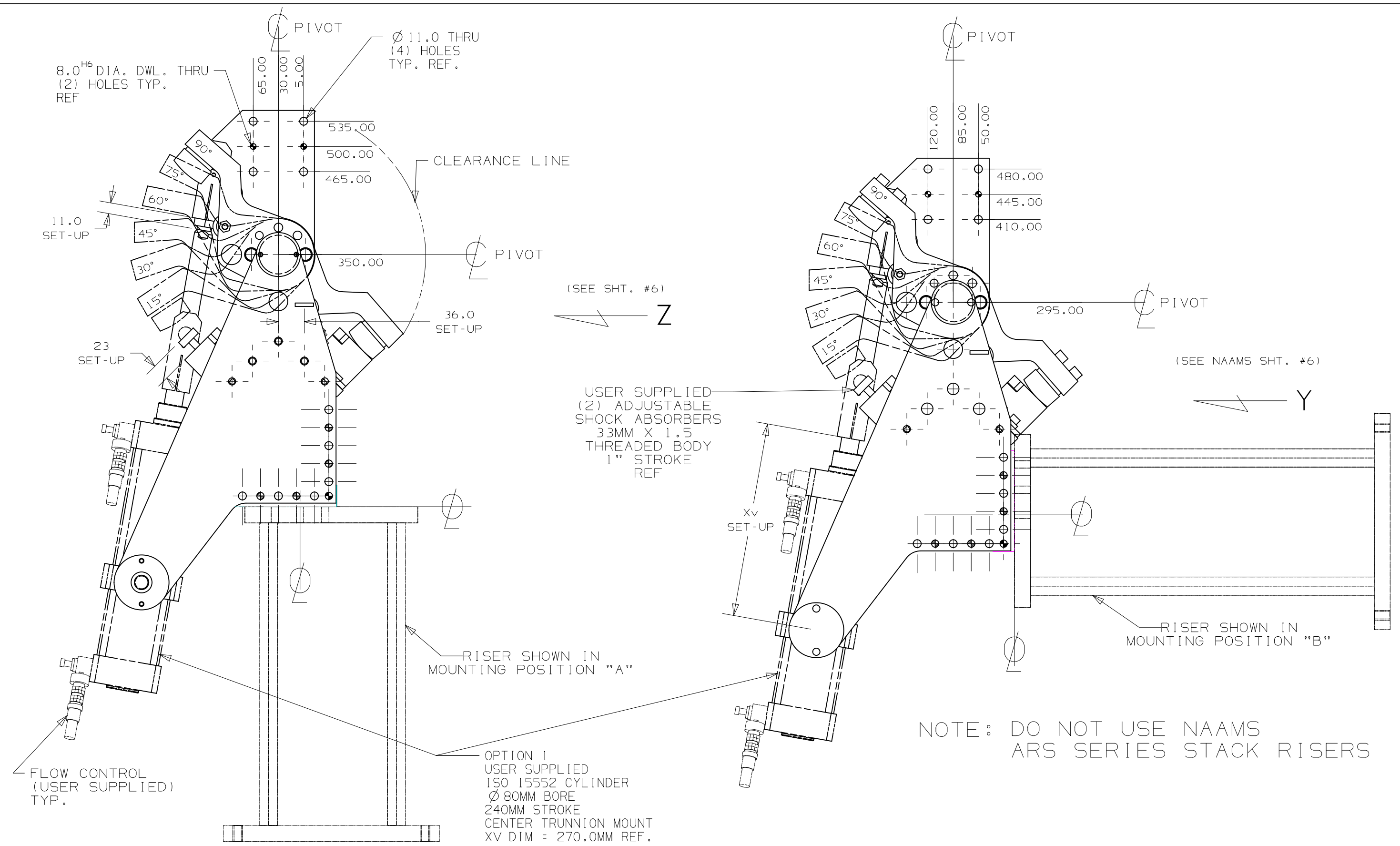
ADL0100 DROP AWAY LEAF

MOUNTING OPTIONS FOR SIDE MOUNT RISERS



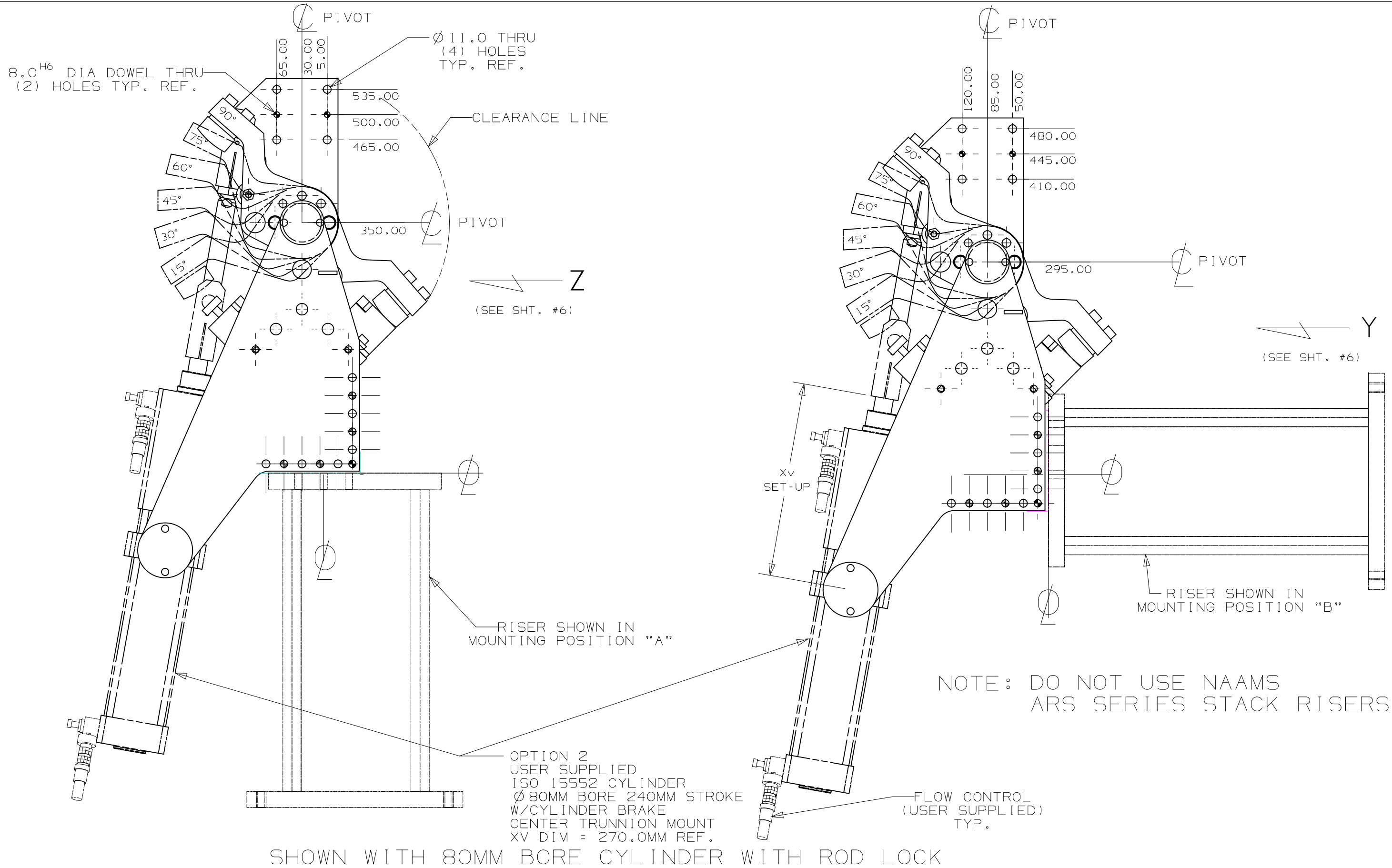
ARV SERIES SIDE MOUNT RISERS ARE ORDERED SEPE-
RATELY (REF. NAAMS ASSEMBLY SECTION E-PAGE E-32)

ADL0100 DROP AWAY LEAF



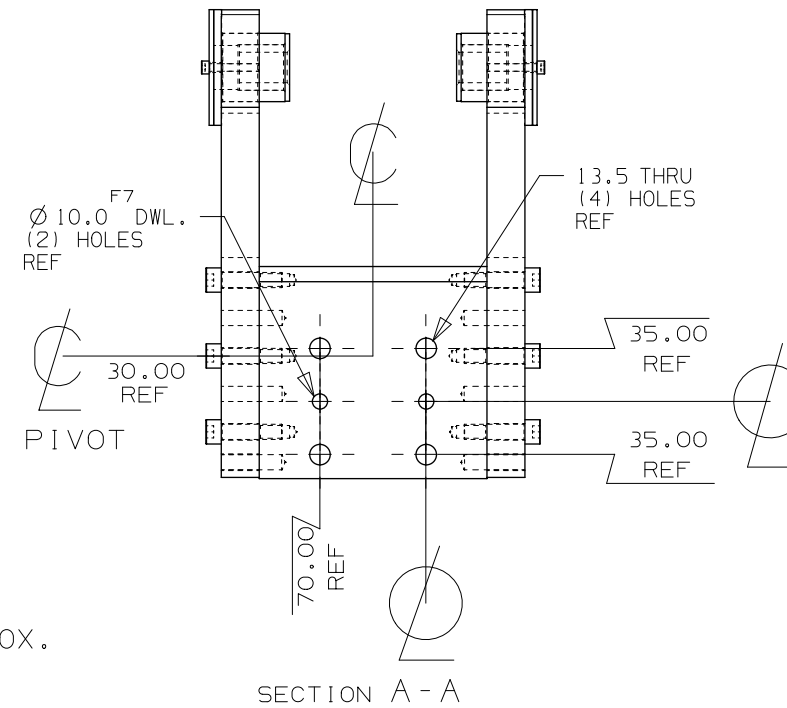
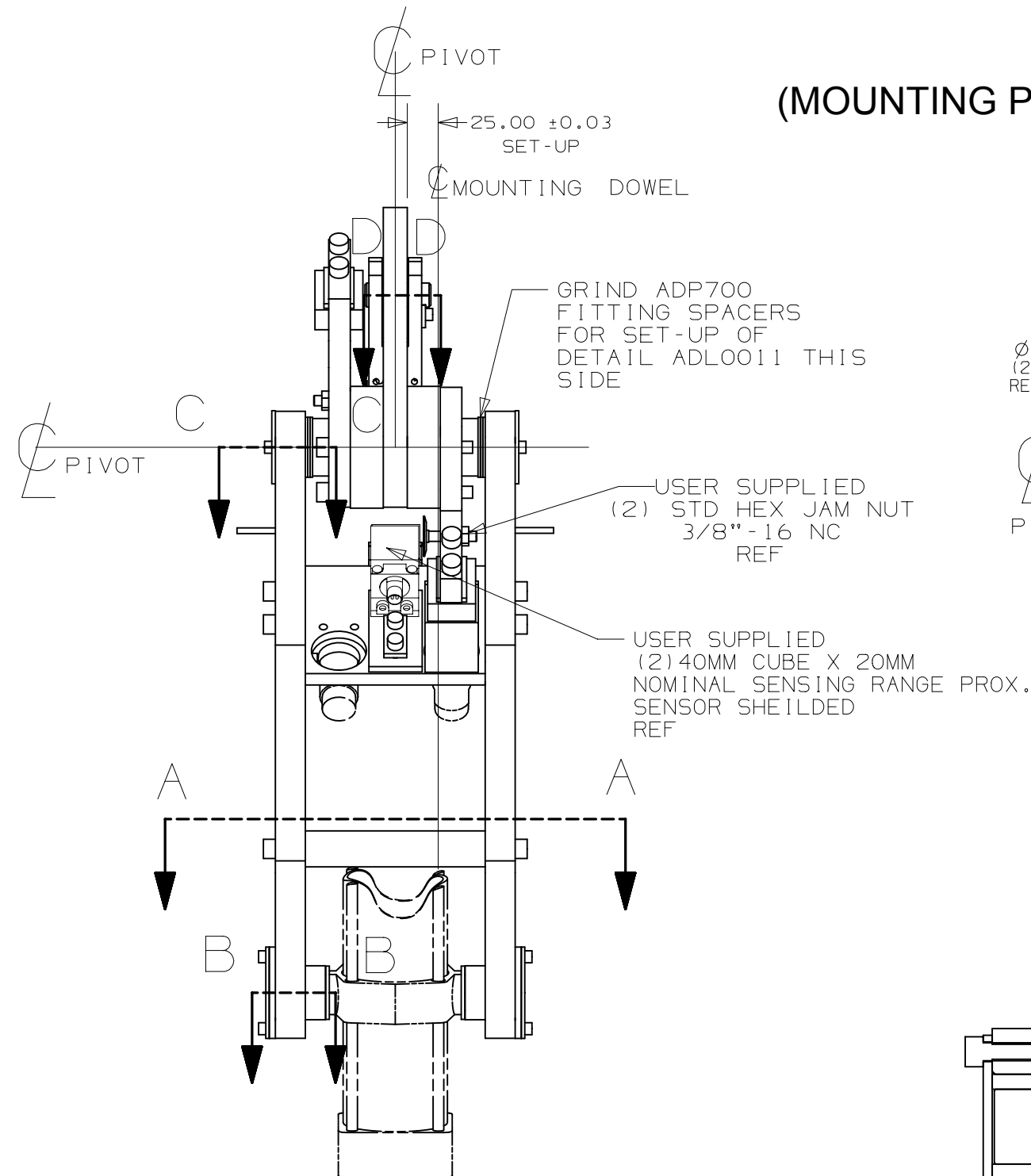
SHOWN WITH STANDARD 80MM BORE CYLINDER (NO ROD LOCK)

ADL0100 DROP AWAY LEAF

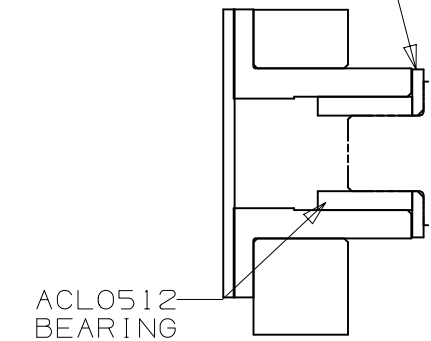


ADL0100 DROP AWAY LEAF

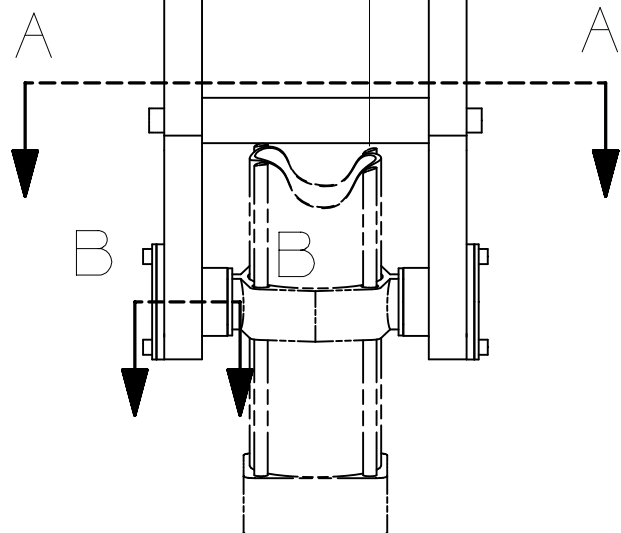
(MOUNTING POSITION A SHOWN)



ADL0022
THRUST WASHER
INSTALL WITH CHAMFER
FACING CYLINDER

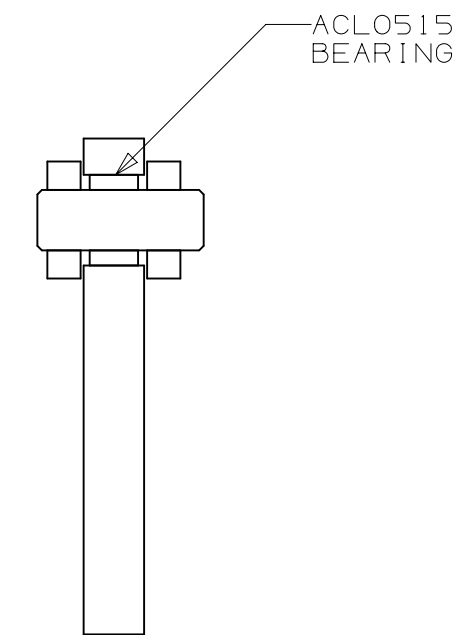
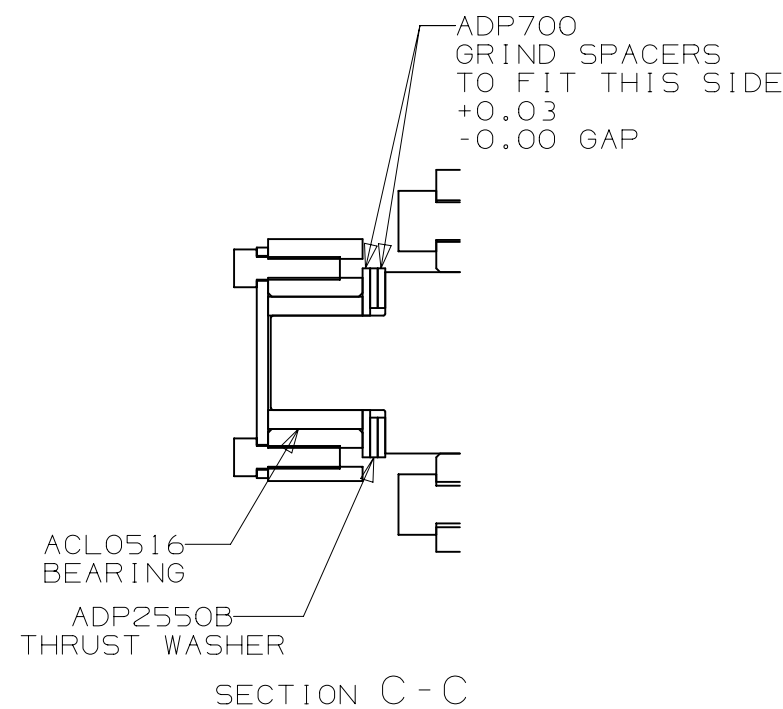


SECTION B-B



VIEW Z

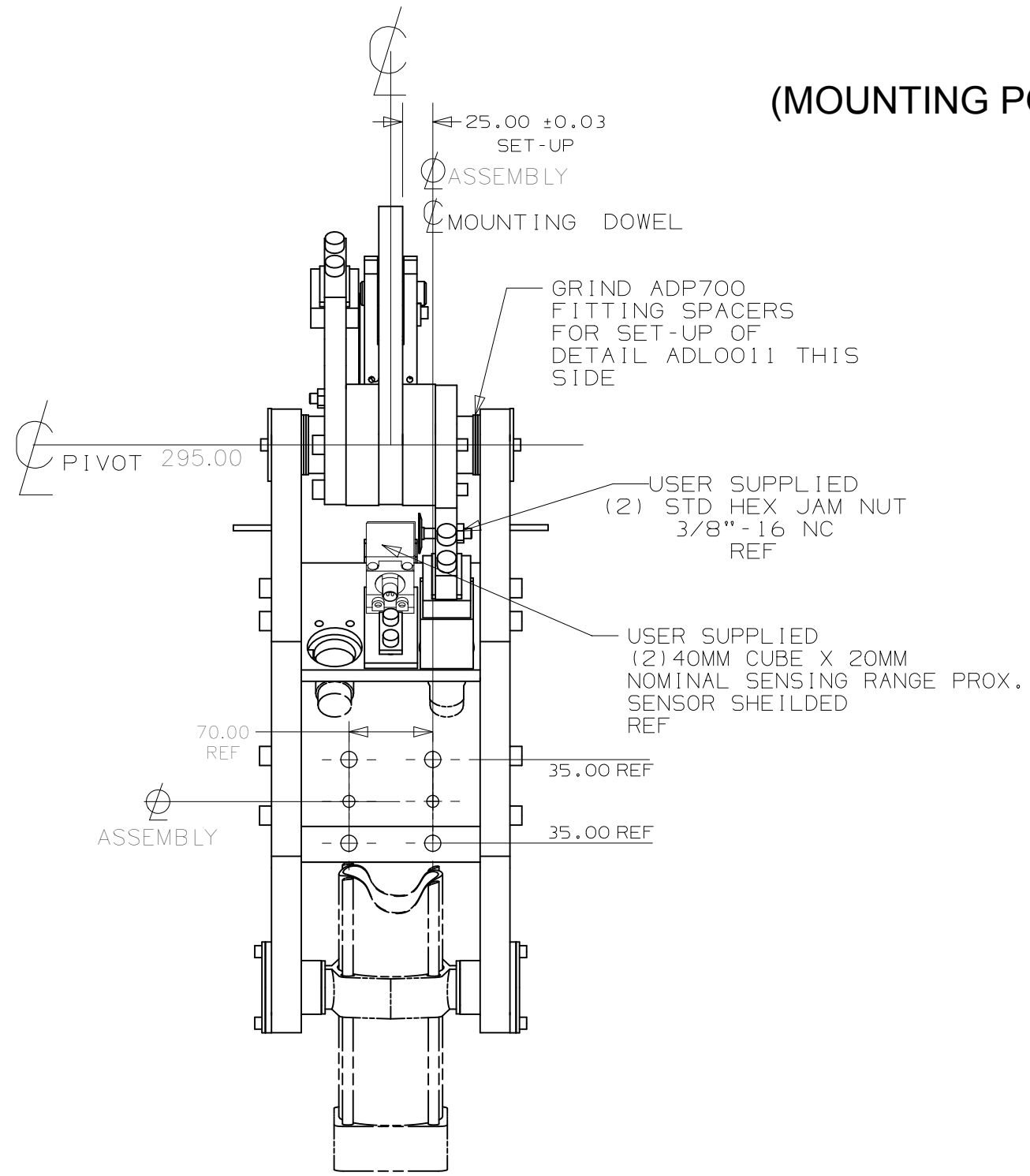
(FROM PAGE N-26.3 & N-26.4)
COMMON VIEW
WITH AND WITHOUT
CYLINDER ROD LOCK



SECTION D-D

ADL0100 DROP AWAY LEAF

(MOUNTING POSITION B SHOWN)



VIEW Y

(FROM PAGE N-26.3 & N-26.4)
 COMMON VIEW
 WITH AND WITHOUT
 CYLINDER ROD LOCK

A

ADL0001 ANGLE BRACKET

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

UNLESS OTHERWISE SPECIFIED:
 MAXIMUM ALLOWABLE ROUGHNESS OF ALL:
 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:

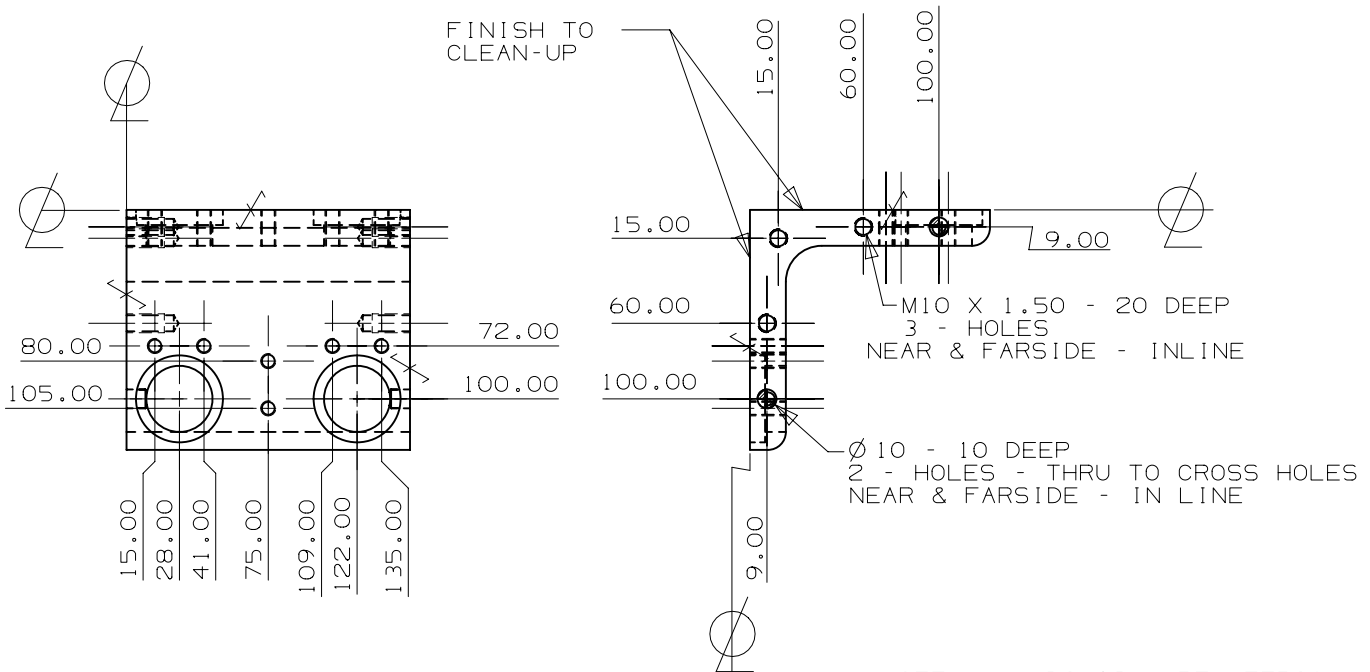
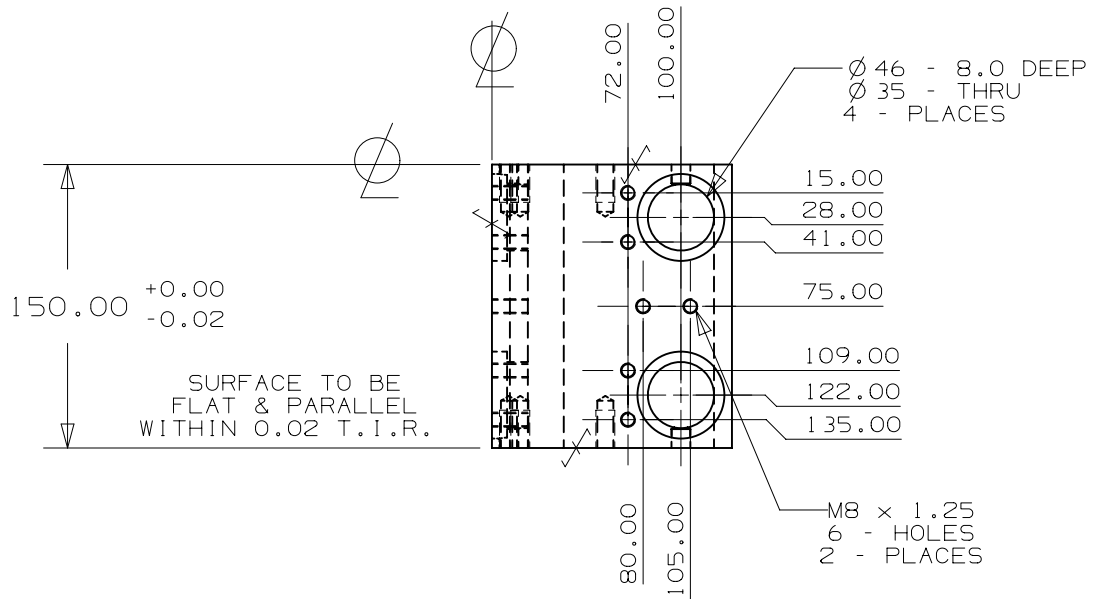
- 1 PLACE MACHINING ± 0.3
- 1 PLACE FABRICATION ± 1.5
- 2 PLACE ± 0.08 BETWEEN MACHINED SURFACES
- ± 0.03 BETWEEN SINGLE DOWEL AND HEEL SURFACE
- ± 0.03 BETWEEN DOWELS IN THE SAME PLANE
- ± 0.10 BETWEEN DOWELS IN DIFFERENT PLANES
- ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
 FOR PRESS FIT USE H6
 FOR SLIP FIT USE F7

DOWEL TOLERANCE
 m6

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

STK: STL ANGLE
 5" x 5" x 3/4" x 156mm
 APPROX wt. 4.37kg



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

ADL0003 MOUNTING PLATE

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

UNLESS OTHERWISE SPECIFIED:
 MAXIMUM ALLOWABLE ROUGHNESS OF ALL:
 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:

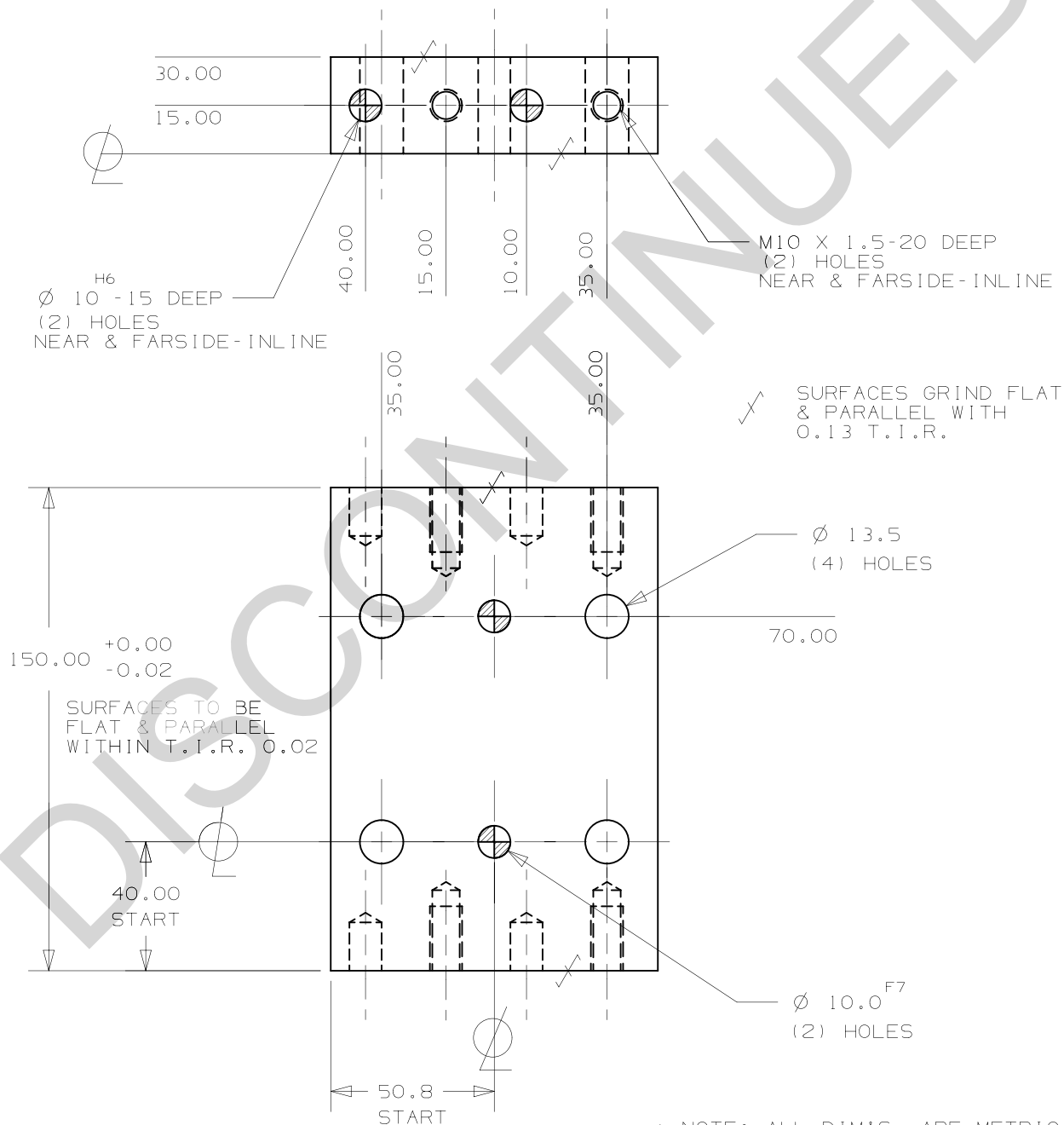
- 1 PLACE MACHINING ± 0.3
- 1 PLACE FABRICATION ± 1.5
- 2 PLACE ± 0.08 BETWEEN MACHINED SURFACES
- ± 0.03 BETWEEN SINGLE DOWEL AND HEEL SURFACE
- ± 0.03 BETWEEN DOWELS IN THE SAME PLANE
- ± 0.10 BETWEEN DOWELS IN DIFFERENT PLANES
- ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
 FOR PRESS FIT USE H6
 FOR SLIP FIT USE F7

DOWEL TOLERANCE
 m6

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

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



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

ADL0005 ARM

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

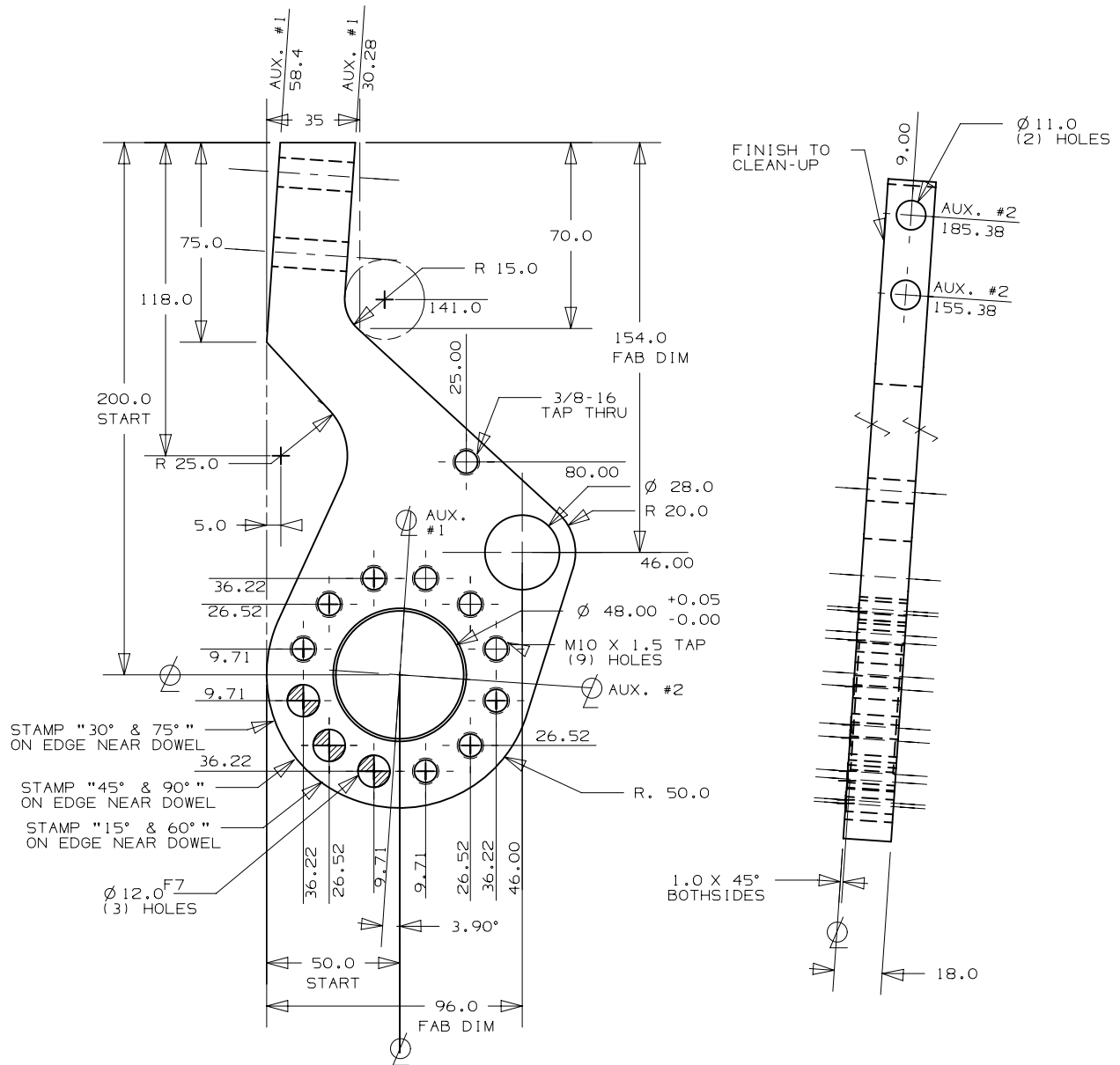
- UNLESS OTHERWISE SPECIFIED:
 MAXIMUM ALLOWABLE ROUGHNESS OF ALL:
 1 PLACE FINISH DIMENSIONS TO BE 6 MICRONS
 2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS
 3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS
- EXCEPT AS NOTED TOLERANCES SHALL BE:
 1 PLACE MACHINING ± 0.3
 1 PLACE FABRICATION ± 1.5
 2 PLACE ± 0.08 BETWEEN MACHINED SURFACES
 ± 0.03 BETWEEN SINGLE DOWEL AND HEEL SURFACE
 ± 0.03 BETWEEN DOWELS IN THE SAME PLANE
 ± 0.10 BETWEEN DOWELS IN DIFFERENT PLANES
 ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
 FOR PRESS FIT USE H6
 FOR SLIP FIT USE F7

DOWEL TOLERANCE
 m6

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

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



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

ADL0006 PLATE

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

UNLESS OTHERWISE SPECIFIED:
 MAXIMUM ALLOWABLE ROUGHNESS OF ALL:
 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:

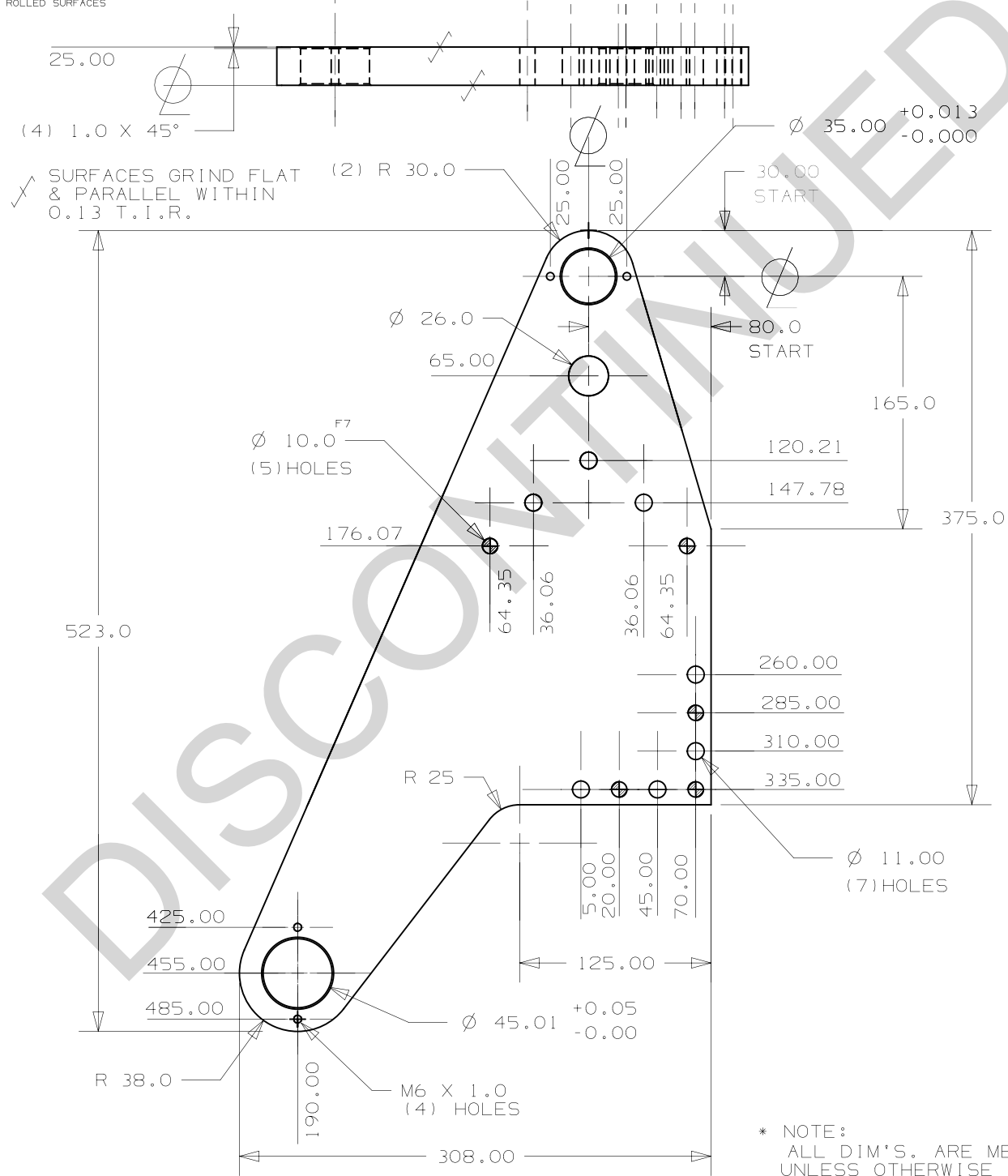
- 1 PLACE MACHINING ± 0.3
- 1 PLACE FABRICATION ± 1.5
- 2 PLACE
 - ± 0.08 BETWEEN MACHINED SURFACES
 - ± 0.03 BETWEEN SINGLE DOWEL AND HEEL SURFACE
 - ± 0.03 BETWEEN DOWELS IN THE SAME PLANE
 - ± 0.10 BETWEEN DOWELS IN DIFFERENT PLANES
 - ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
 FOR PRESS FIT USE H6
 FOR SLIP FIT USE F7

DOWEL TOLERANCE
 m6

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

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



ADL0007 LOCK KEEPER

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

UNLESS OTHERWISE SPECIFIED:

MAXIMUM ALLOWABLE ROUGHNESS OF ALL:

- 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:

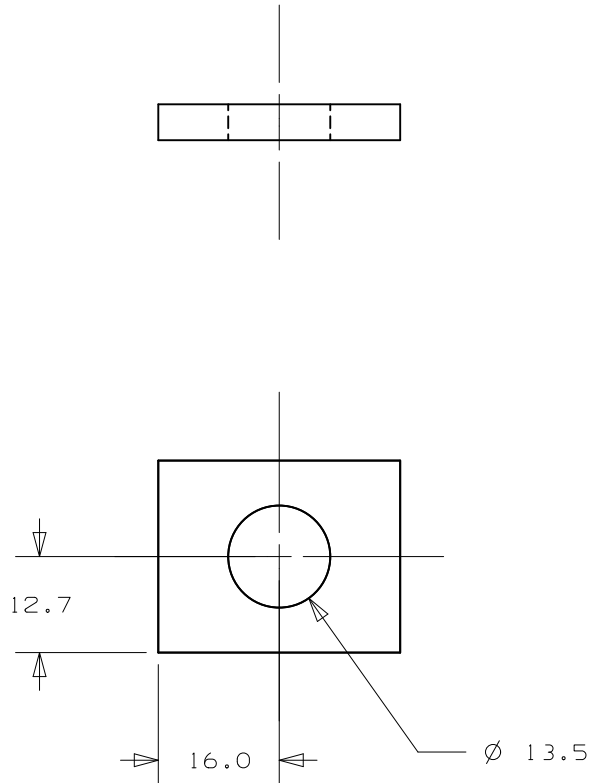
- 1 PLACE MACHINING ± 0.3
- 1 PLACE FABRICATION ± 1.5
- 2 PLACE ± 0.08 BETWEEN MACHINED SURFACES
- 2 PLACE ± 0.03 BETWEEN SINGLE DOWEL AND HEEL SURFACE
- 2 PLACE ± 0.03 BETWEEN DOWELS IN THE SAME PLANE
- 2 PLACE ± 0.10 BETWEEN DOWELS IN DIFFERENT PLANES
- 2 PLACE ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

DOWEL TOLERANCE
m6

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

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

UNLESS OTHERWISE SPECIFIED:

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- 2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS
- 3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS

EXCEPT AS NOTED TOLERANCES SHALL BE:

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- 1 PLACE FABRICATION ± 1.5
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- ± 0.03 BETWEEN DOWELS IN THE SAME PLANE
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- ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

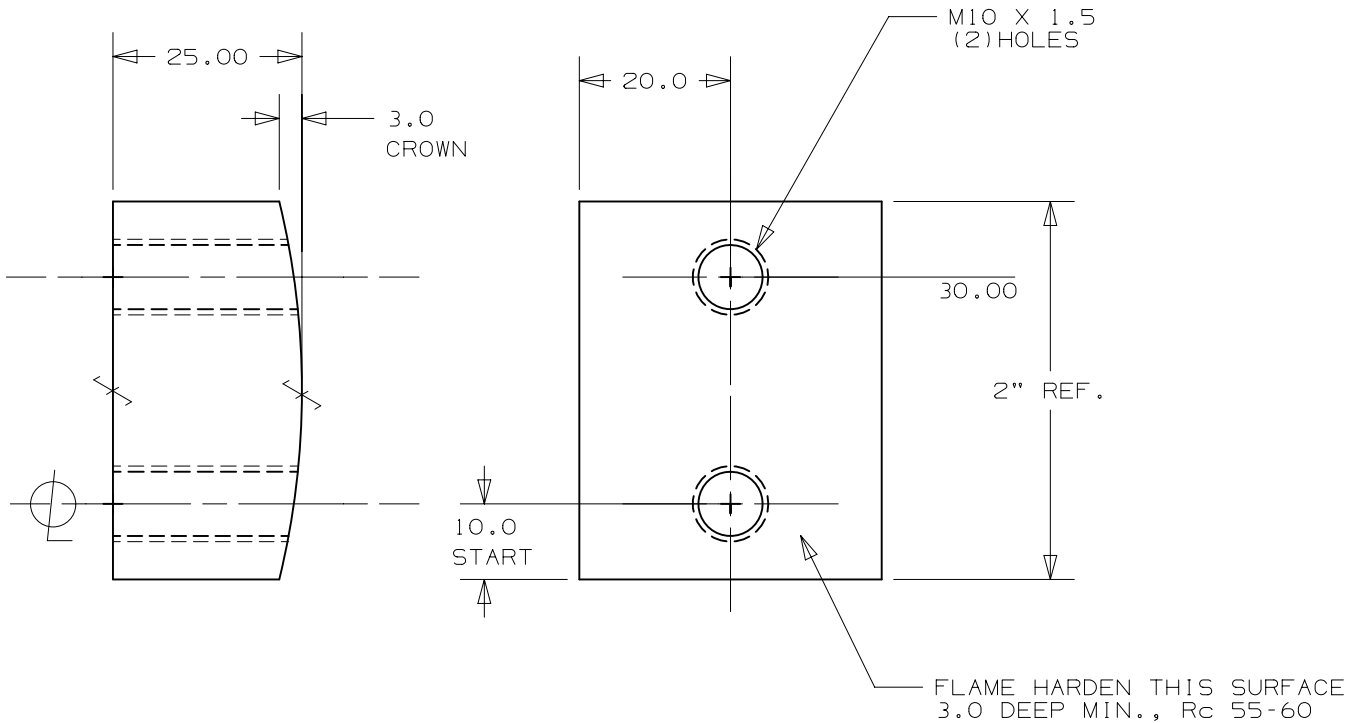
DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

DOWEL TOLERANCE
m6

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



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

ADL0009 TRUNNION OFFSET

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

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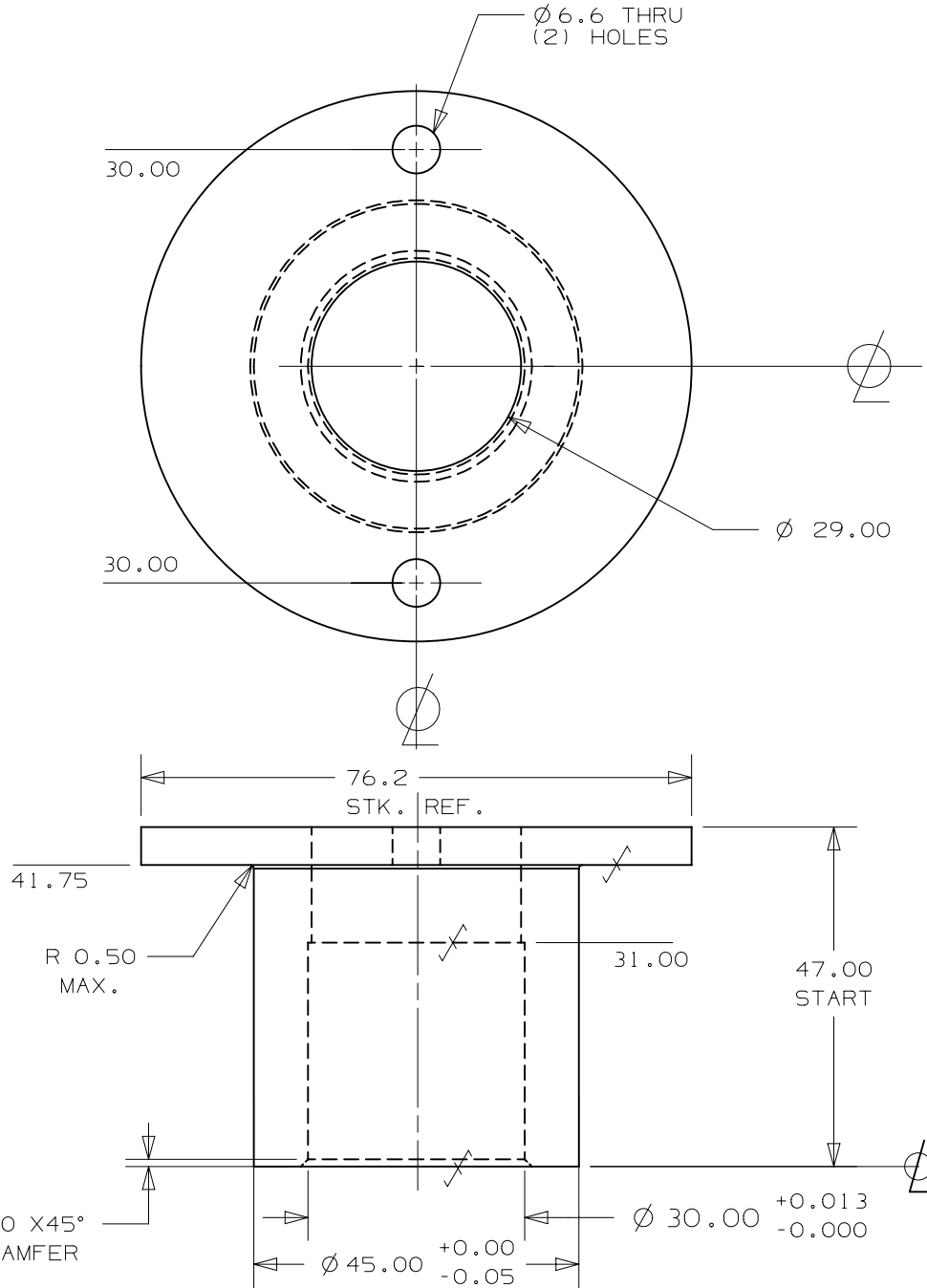
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- ± 0.03 BETWEEN DOWELS IN THE SAME PLANE
- ± 0.10 BETWEEN DOWELS IN DIFFERENT PLANES
- ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

DOWEL TOLERANCE
m6

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

STK: SAE 1020 HRS
3" x 50mm
APPROX wt. 0.45kg



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

ADL0011 PIVOT ARM

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

UNLESS OTHERWISE SPECIFIED:

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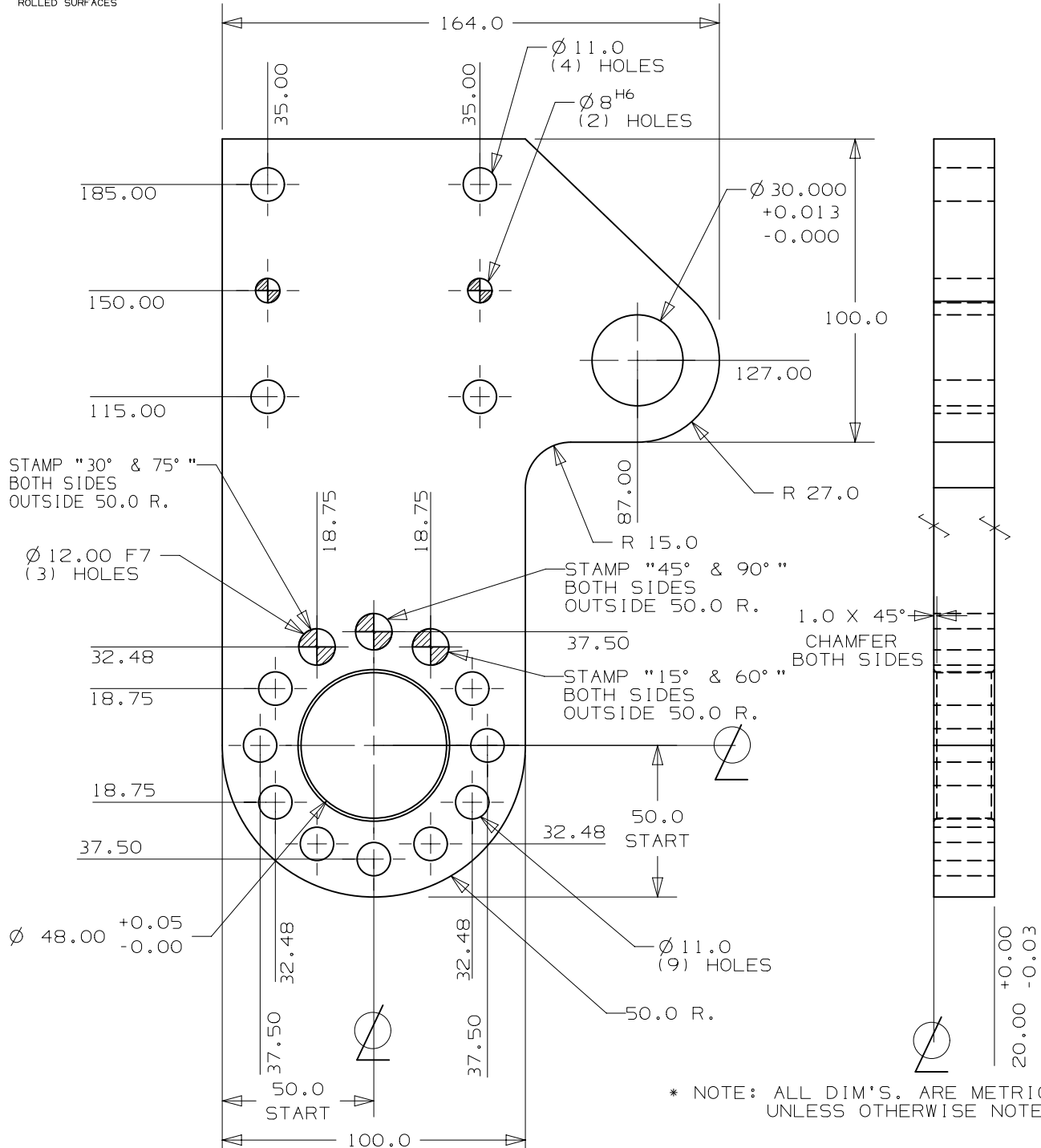
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- ± 0.03 BETWEEN DOWELS IN THE SAME PLANE
- ± 0.10 BETWEEN DOWELS IN DIFFERENT PLANES
- ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

DOWEL TOLERANCE
m6

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

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



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

ADL0012 ARM

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

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 2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS
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EXCEPT AS NOTED TOLERANCES SHALL BE:

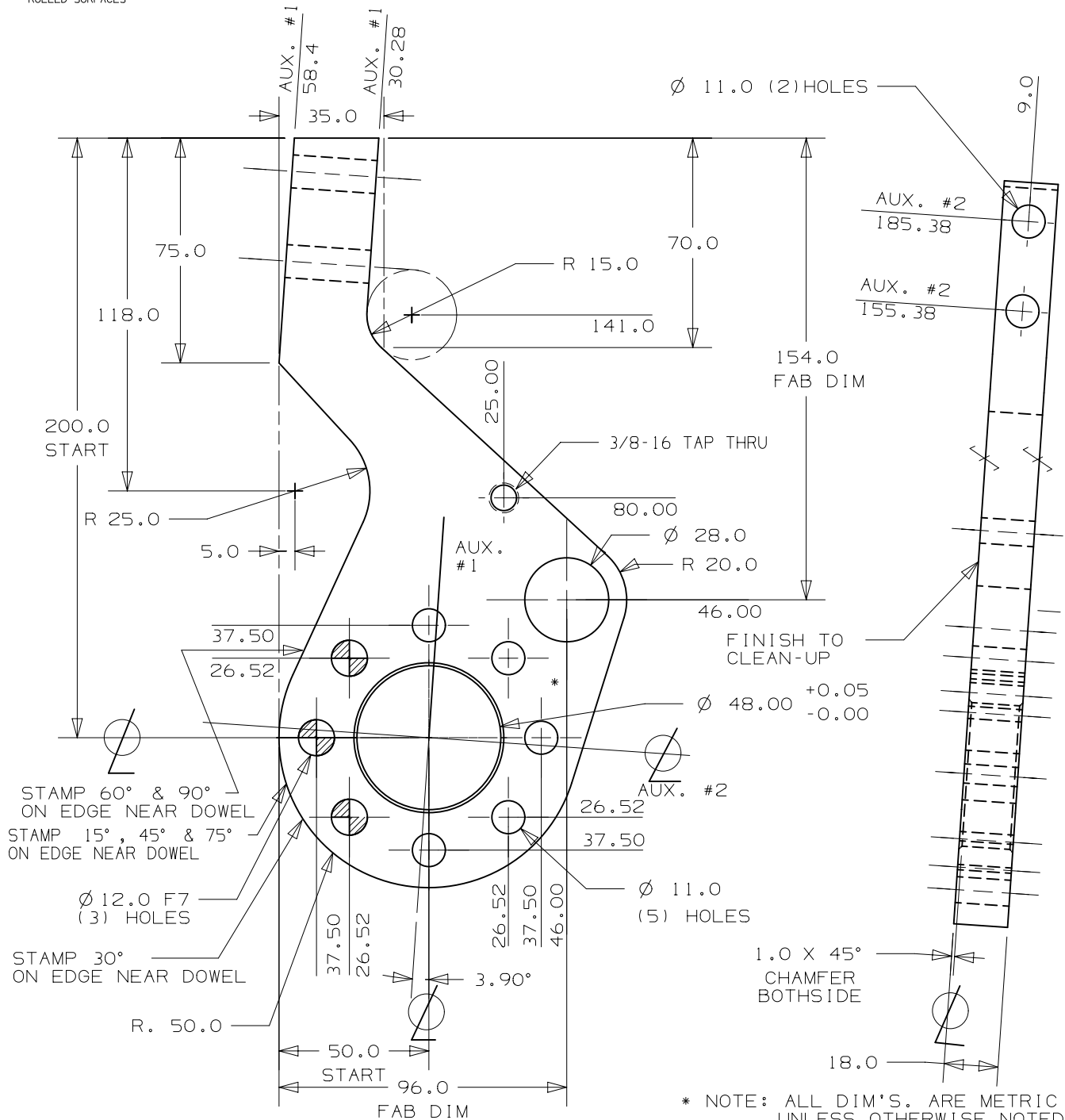
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 ±0.10 BETWEEN DOWELS IN DIFFERENT PLANES
 ±0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
 FOR PRESS FIT USE H6
 FOR SLIP FIT USE F7

DOWEL TOLERANCE
 m6

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

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



ADL0013 COVER

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

UNLESS OTHERWISE SPECIFIED:

MAXIMUM ALLOWABLE ROUGHNESS OF ALL:

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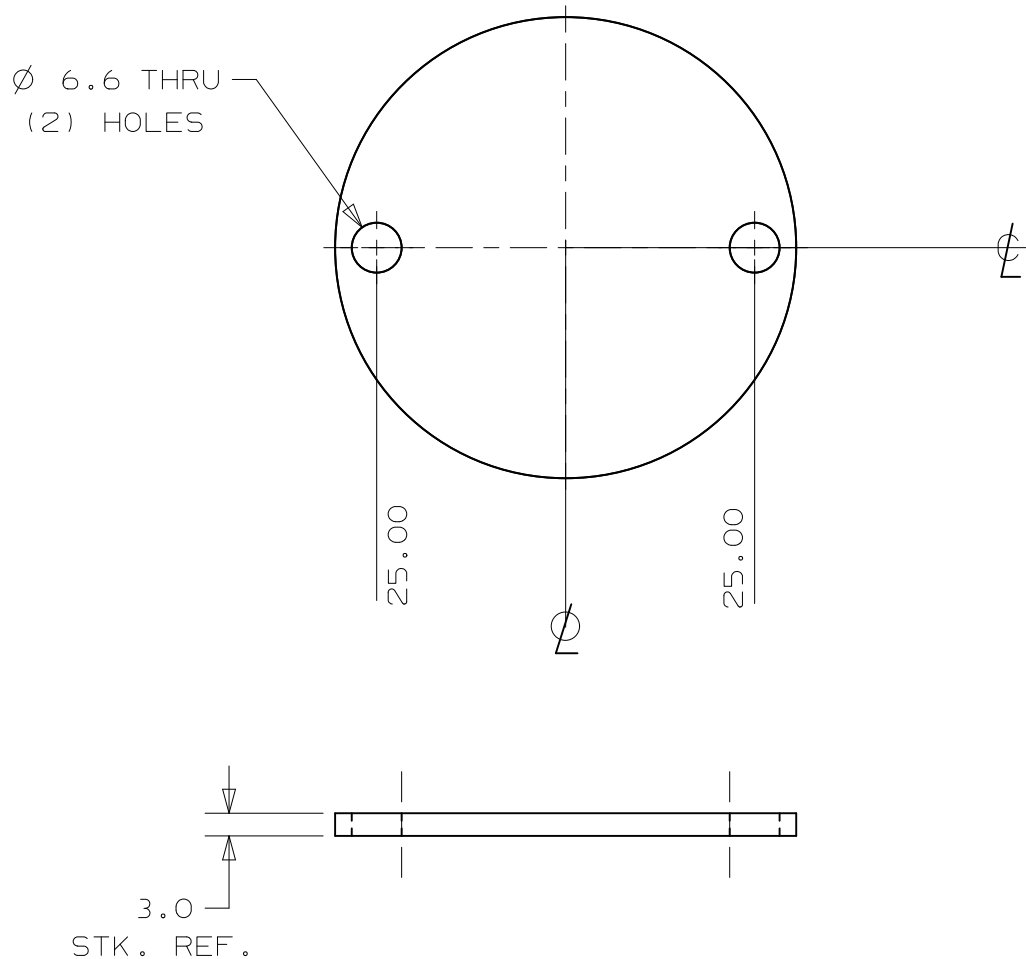
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- ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

DOWEL TOLERANCE
m6

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

STK: SAE 1020 HRS
2-3/8" DIA x 3mm
APPROX wt. 0.06kg



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

ADL0014 SHOCK BLOCK

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

UNLESS OTHERWISE SPECIFIED:

MAXIMUM ALLOWABLE ROUGHNESS OF ALL:

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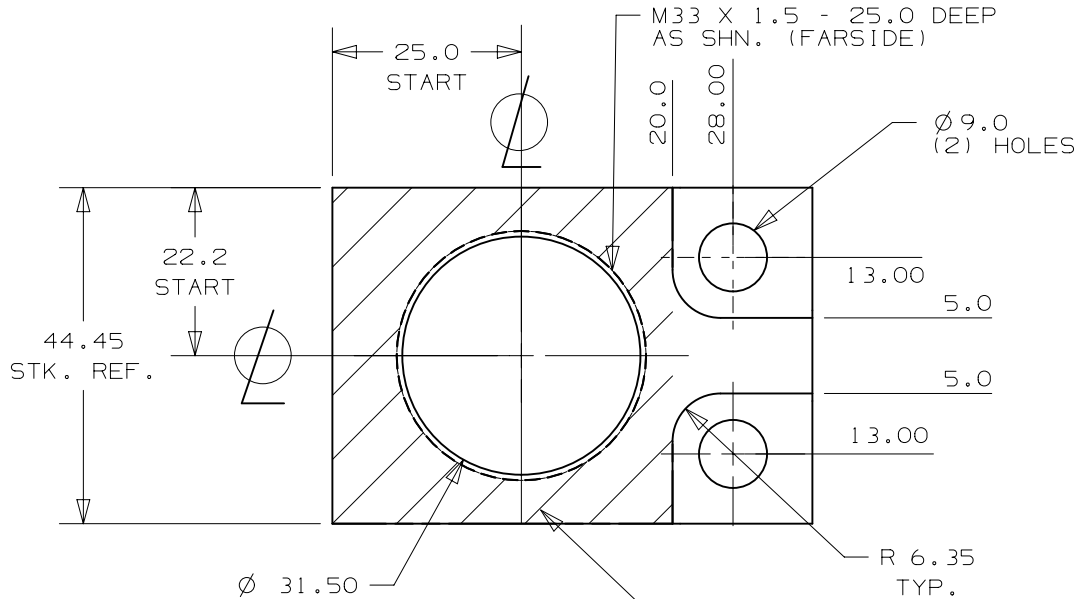
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- 2 PLACE
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DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

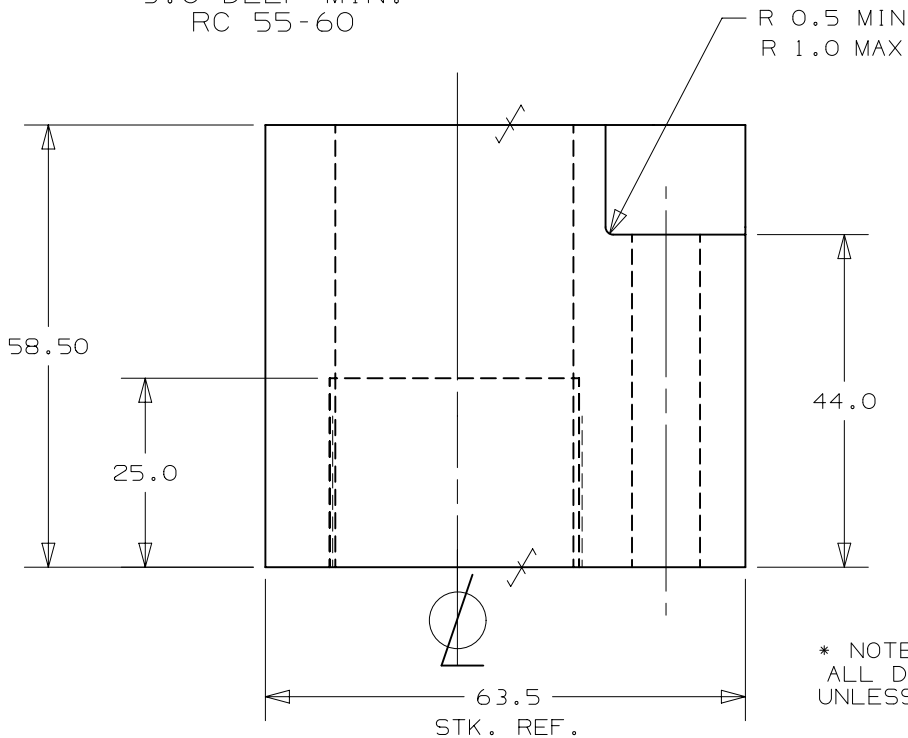
DOWEL TOLERANCE
m6

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

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



HARDEN CROSS-HATCHED SURFACE
3.0 DEEP MIN.
RC 55-60



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

ADL0015 CLEVIS

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

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- 3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS

EXCEPT AS NOTED TOLERANCES SHALL BE:

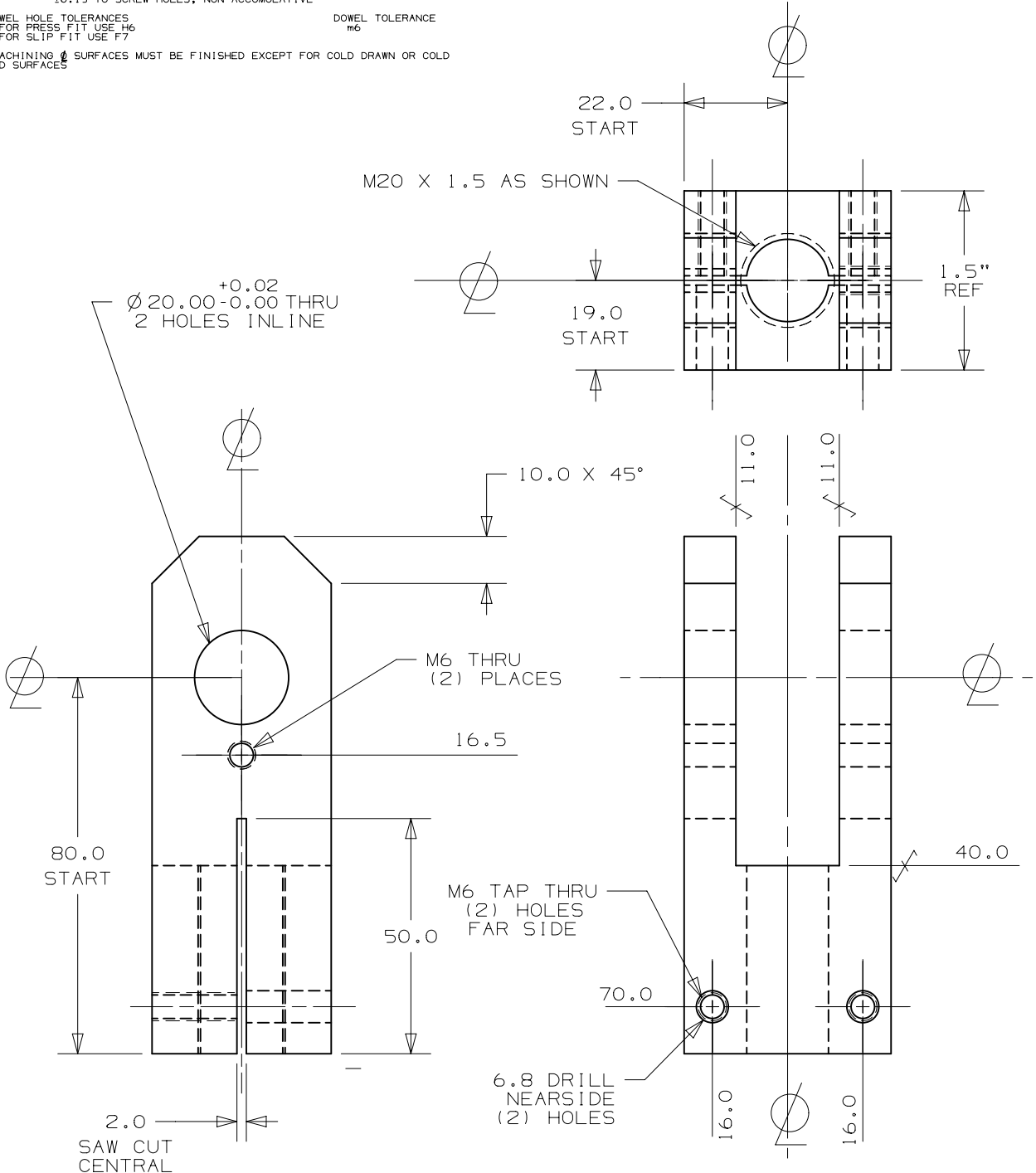
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- ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

DOWEL TOLERANCE
m6

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

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.

ADL0016 PIVOT HUB

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

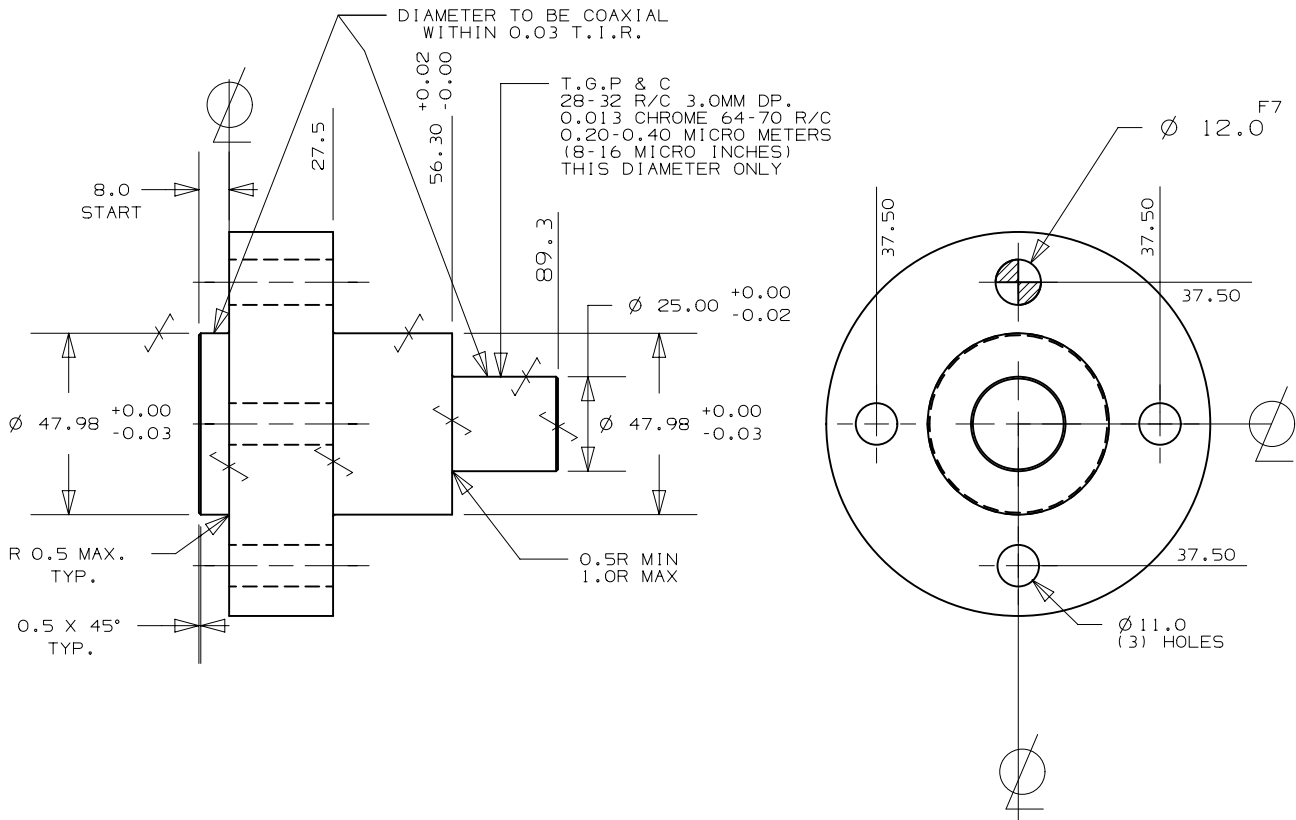
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 ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
 FOR PRESS FIT USE H6
 FOR SLIP FIT USE F7
 DOWEL TOLERANCE
 m6

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

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



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

ADL0018 SWITCH MTG BRKT

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

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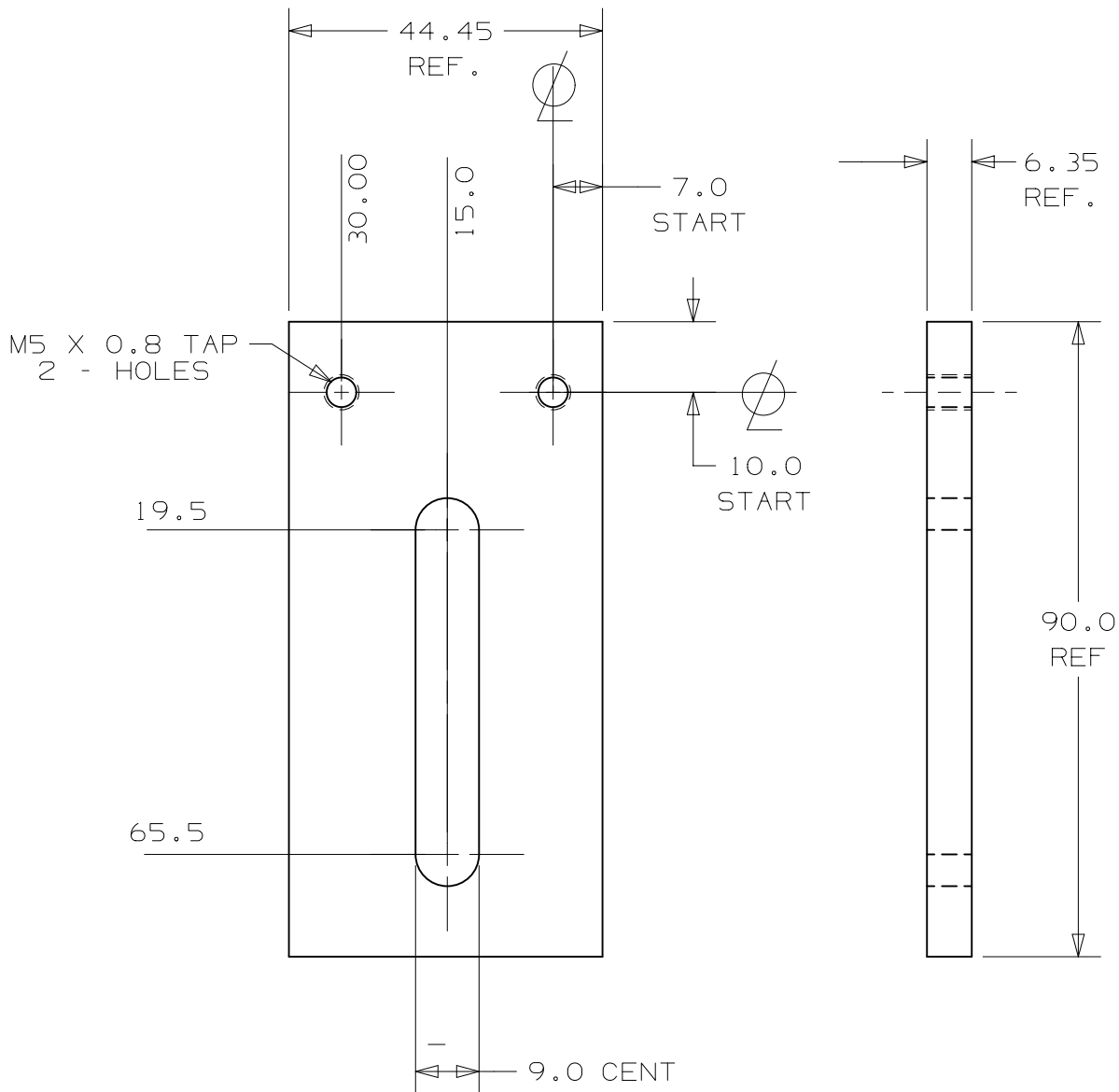
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 ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
 FOR PRESS FIT USE H6
 FOR SLIP FIT USE F7

DOWEL TOLERANCE
 m6

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

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



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

ADL0020 KEEPER

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

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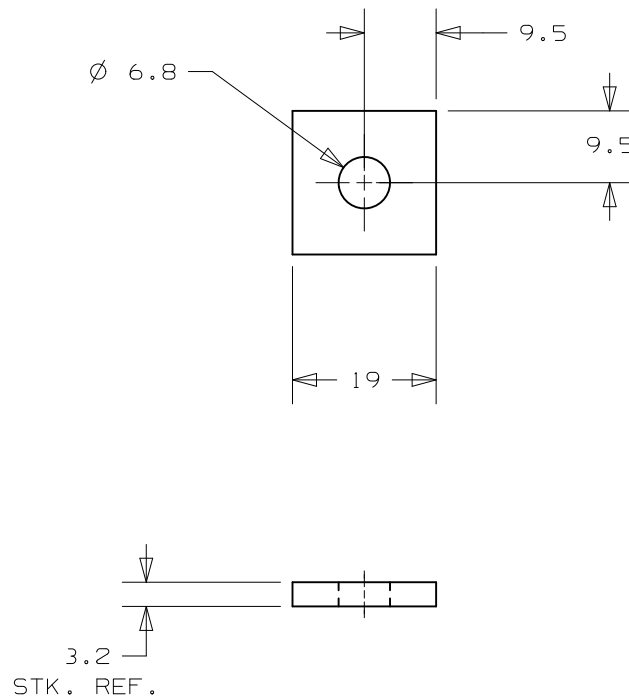
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- 2 PLACE
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 - ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

DOWEL TOLERANCE
m6

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

STK: SAE 1018 CRS
1/8" x 3/4" x 19mm
APPROX wt. 0.01kg



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

ADL0021 COVER

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

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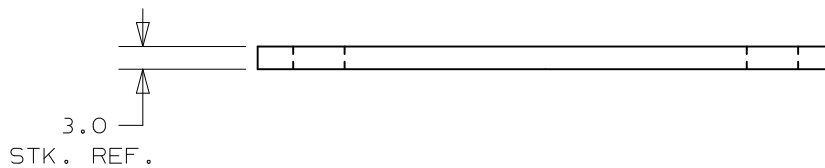
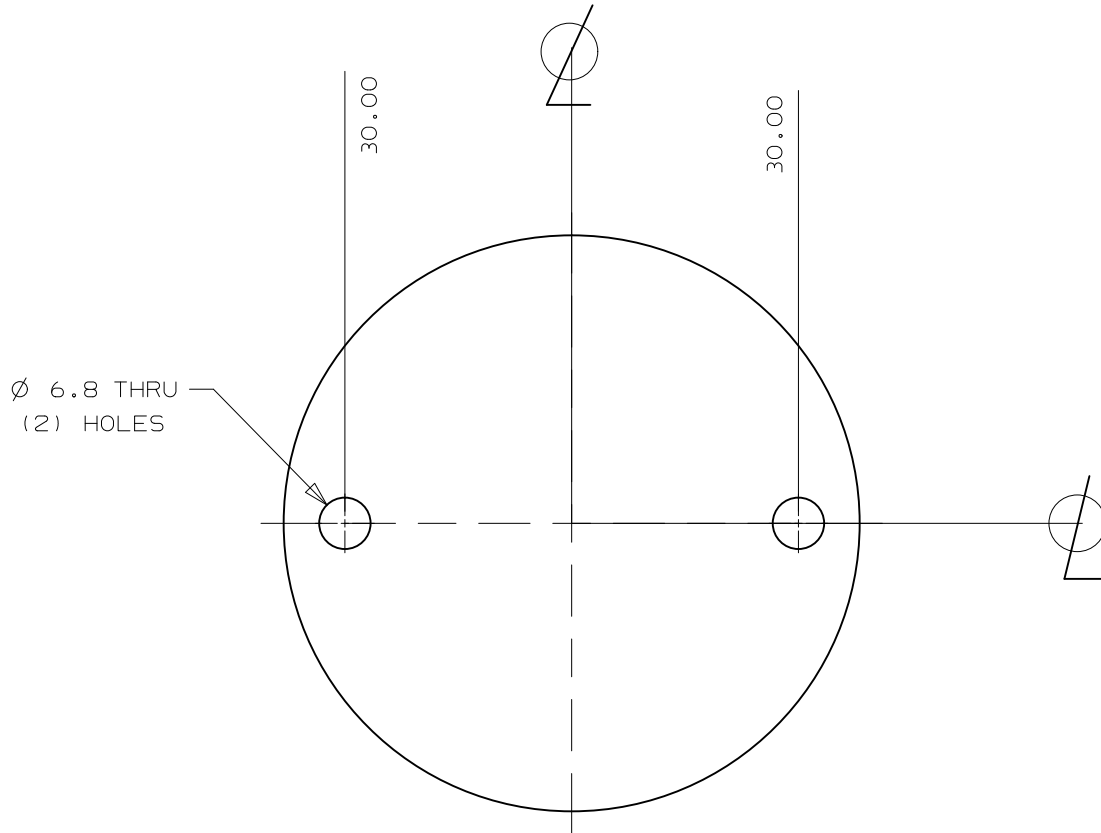
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 - ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

DOWEL TOLERANCE
m6

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

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

GLOBAL STANDARD COMPONENTS



09/06/12

METRIC DETAIL TOLERANCES

NOTE:

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EXCEPT AS NOTED TOLERANCES SHALL BE:

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 - ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

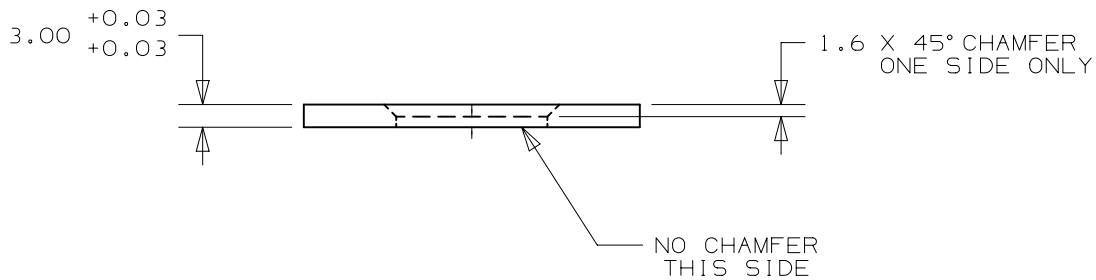
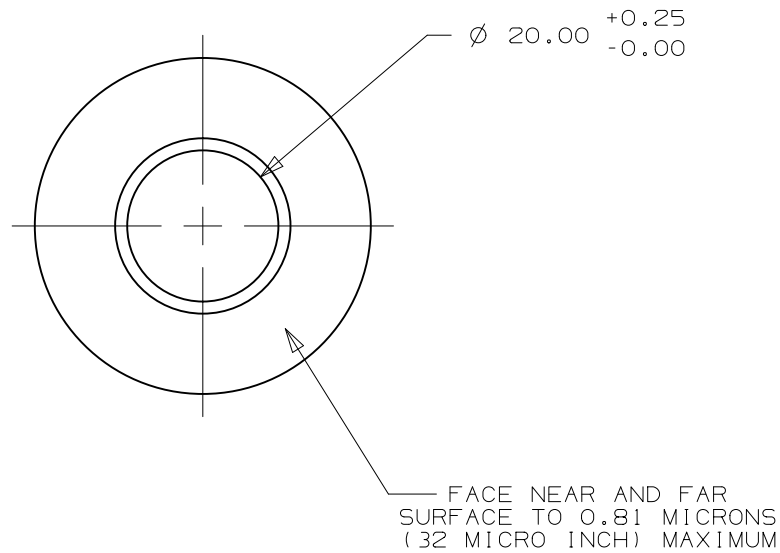
DOWEL TOLERANCE
m6

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

STK: CDA93200/SAE 660 BRONZE

1-3/4" DIA x 4.0mm

APPROX wt. 0.03kg



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

ADL0023 MOUNTING PLATE

GLOBAL STANDARD COMPONENTS



05/31/16

METRIC DETAIL TOLERANCES

NOTE:

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DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

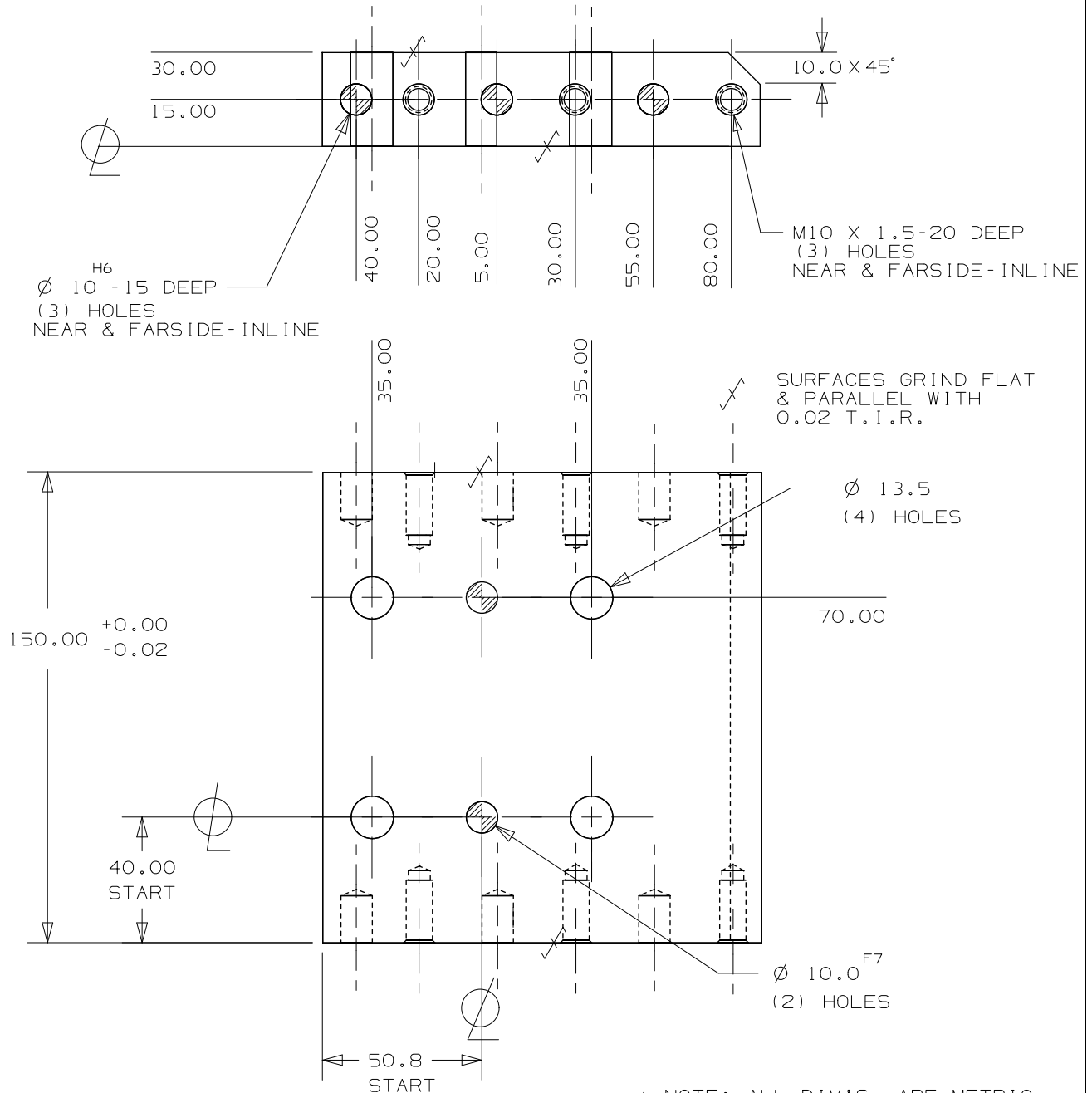
DOWEL TOLERANCE
m6

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

STK: ASTM A36

1-1/2" x 5-1/2" x 156mm

APPROX wt. 5kg



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

ADL0024 PLATE

GLOBAL STANDARD COMPONENTS



05/31/16

METRIC DETAIL TOLERANCES

NOTE:

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EXCEPT AS NOTED TOLERANCES SHALL BE:

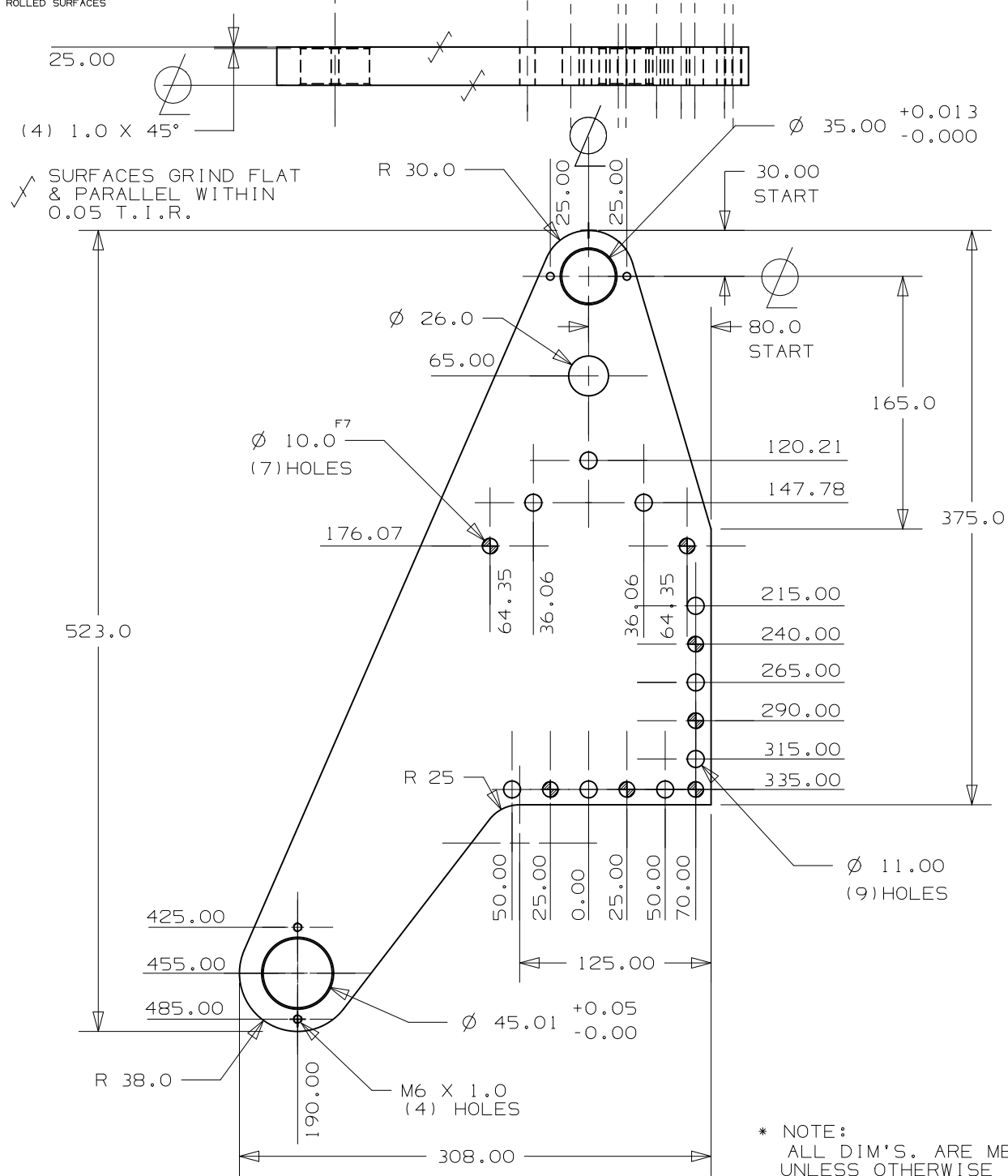
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- ± 0.13 TO SCREW HOLES, NON ACCUMULATIVE


DOWEL HOLE TOLERANCES
 FOR PRESS FIT USE H6
 FOR SLIP FIT USE F7


DOWEL TOLERANCE
 m6


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


STK: ASTM A36
 1-1/4" x 308mm x 523mm
 APPROX wt. 14kg
 THERMAL STRESS RELIEVE



DESCRIPTION (FILL OUT ON SHEET ONE ONLY)										UNIT B.O.M.		TOOL NO.				(SHOWN)		BOM PAGE				
DROP AWAY LEAF ASSEMBLY - 80MM BORE																(OPPOSITE)		1 OF 4				
CUSTOMER NAAMS			PROGRAM			DESIGN SOURCE NAAMS			BUILD SOURCE			UNIT NO. ADL100				OPPOSITE UNIT		SHOWN UNIT		SOURCE	DATE RELEASED BY	SERVICE
CUSTOMER DETAIL NO.	SUPPLIER DETAIL NO.	SUB-DETAIL	REVISION LEVEL	SHN. ON L/O SHT.	NAME	MATERIAL	SPECIFICATIONS AND/OR			OPP.	SHN.	OPP.	SHN.	FAB	FINAL							
							<input type="checkbox"/> ONE MAKES TWO <input type="checkbox"/> CUT TO LAYOUT															
ASP350				2	SPACER	STD	NAAMS				2		2	P								
ASA9000				2	SWITCH ADAPTER	STD	NAAMS				2		2	P								
					BRACKET PLATE																	
ACL0505				2	CLEVIS PIN	STD	NAAMS				1		1	M								
ACL0512				6	BEARING	STD	NAAMS				2		2	P								
ACL0515				6	BEARING	STD	NAAMS 20 ID X 30 OD X 20 LG				1		1	P								
ACL0516				6	BEARING	STD	NAAMS 25 ID X 35 OD X 25 LG				2		2	P								
ADP2550B				6	THRUST WASHER	STD	NAAMS				2		2	P								
ADP700				1	THRUST WASHER	S.S.	NAAMS 29 ID X 50 OD X 2MM THK				4		4	P								
ADL0001				1	ANGLE BRACKET	STL. ANGLE	5" X 5" X 3/4" X 156MM				1		1	M								
ADL0003				1	MOUNTING PLATE	1020 HRS	1 1/2" X 4" X 156MM				0		0	M								
CHG LTR	DATE	REVISIONS / REASONS FOR					PROJECT MGR.					DESIGN SUPV.										
A	05/31/17	DETAIL ADL0003 DISCONTINUED & REMOVED, WAS 1 REQ'D. - G.B.					MR					REM										
							SOURCE LEGEND					HI-SPOT										
							M - MAKE ITEM P - PURCHASE ITEM APPROVAL REQUIRED FOR SUBSTITUTION M/P - MAKE ITEM CONTAINING PURCHASE ITEM(S) F - FURNISHED BY CUSTOMER NC - NUMERICAL CONTROLLED MACHINING					CHECKER										
												CB										
												DESIGNER										
												REM										

DESCRIPTION (FILL OUT ON SHEET ONE ONLY)										UNIT B.O.M.		TOOL NO.				(SHOWN)		BOM PAGE				
DROP AWAY LEAF ASSEMBLY - 80MM BORE																(OPPOSITE)		2 OF 4				
CUSTOMER NAAMS			PROGRAM			DESIGN SOURCE NAAMS			BUILD SOURCE			UNIT NO. ADL100				OPPOSITE UNIT		SHOWN UNIT		SOURCE	DATE RELEASED BY	SERVICE
CUSTOMER DETAIL NO.	SUPPLIER DETAIL NO.	SUB-DETAIL	REVISION LEVEL	SHN. ON L/O SHT.	NAME	MATERIAL	SPECIFICATIONS AND/OR			OPP.	SHN.	OPP.	SHN.	M	FAB	FINAL						
							<input type="checkbox"/> ONE MAKES TWO <input type="checkbox"/> CUT TO LAYOUT															
ADL0005				1	ARM	ASTM A36	3/4" X 5" X 250MM				1		1	M								
ADL0006				1	PLATE	ASTM A36	1 1/4 X 308MM X 523MM				0		0	M								
ADL0007				1	LOCK KEEPER	1020 HRS	3/16" X 1" X 32MM				2		2	M								
ADL0008				1	STOP BLOCK	1060 HRS	1 1/4" X 2" X 40MM				2		2	M								
ADL0009				2	TRUNNION OFFSET	1020 HRS	3" X DIA. X 50MM				2		2	M								
ADL0011				2	PIVOT ARM	ASTM A36	1" X 7" X 250MM				1		1	M								
ADL0012				1	ARM	ASTM A36	3/4" X 5" X 250MM				1		1	M								
ADL00013				2	COVER	1020 HRS	2 3/8" DIA. X 3MM LG.				2		2	M								
ADL0014				2	SHOCK BLOCK	1060 HRS	1 3/4" X 2 1/2" X 65MM				2		2	M								
ADL0015				2	CLEVIS	4140 HRS	1 1/2" X 1 3/4" X 100MM				1		1	M								
CHG LTR	DATE	REVISIONS / REASONS FOR					PROJECT MGR.				DESIGN SUPV.											
A	05/31/17	DETAIL ADL0006 DISCONTINUED & REMOVED, WAS 2 REQ'D. - G.B.					MR				REM											
							SOURCE LEGEND				HI-SPOT											
							M - MAKE ITEM P - PURCHASE ITEM APPROVAL REQUIRED FOR SUBSTITUTION M/P - MAKE ITEM CONTAINING PURCHASE ITEM(S) F - FURNISHED BY CUSTOMER NC - NUMERICAL CONTROLLED MACHINING				CHECKER											
											CB											
											DESIGNER											
											REM											

DESCRIPTION (FILL OUT ON SHEET ONE ONLY)					UNIT B.O.M.	TOOL NO.	(SHOWN)				BOM PAGE			
DROP AWAY LEAF ASSEMBLY - 80MM BORE							(OPPOSITE)				3 OF 4			
CUSTOMER NAAMS		PROGRAM		DESIGN SOURCE	NAAMS	BUILD SOURCE	UNIT NO. ADL100		OPPOSITE UNIT	SHOWN UNIT	SOURCE	DATE RELEASED BY	SERVICE	
CUSTOMER DETAIL NO.	SUPPLIER DETAIL NO.	SUB-DETAIL	REVISION LEVEL	SHN. ON L/O SHT.	NAME	MATERIAL	SPECIFICATIONS AND/OR		OPP.	SHN.				OPP.
							<input type="checkbox"/> ONE MAKES TWO <input type="checkbox"/> CUT TO LAYOUT							
ADL0016				2	PIVOT HUB	4140 HRS	4" DIA. X 98MM			2		2	M	
ADL0018				2	SWITCH MTG. BRACKE	1020 HRS	1/4" X 1-3/4" X 90MM			2		2	M	
ADL0020				2	KEEPER	1018 CRS	1/8" X 3/4" X 19MM			1		1	M	
ADL0021				2	COVER	1020 HRS	3" DIA. X 3.0MM			2		2	M	
ADL0022				6	THRUST WASHER	660 BRONZE	1 3/4" DIA. X 3.0MM			2		2	M	
DIA 10 X 30MM LG.					PULL DOWEL	STD	F911030			4		4	P	
DIA 10 X 40MM LG					PULL DOWEL	STD	F911040			4		4	P	
DIA 12 X 120MM LG					PULL DOWEL	STD	F911212			1		1	P	
M6 X 1.0 x 12MM LG.					S.H.C.S.	STD	F010608			5		5	P	
M6x1.0 X 20MM LG.					S.H.C.S.	STD	F010610			4		4	P	
CHG LTR	DATE	REVISIONS / REASONS FOR				PROJECT MGR. MR			DESIGN SUPV. REM					
						SOURCE LEGEND			HI-SPOT					
						M - MAKE ITEM P - PURCHASE ITEM APPROVAL REQUIRED FOR SUBSTITUTION M/P - MAKE ITEM CONTAINING PURCHASE ITEM(S) F - FURNISHED BY CUSTOMER NC - NUMERICAL CONTROLLED MACHINING			CHECKER CB					
									DESIGNER REM					

DESCRIPTION (FILL OUT ON SHEET ONE ONLY)						UNIT B.O.M.		(SHOWN)				BOM PAGE						
DROP AWAY LEAF ASSEMBLY - 80MM BORE						TOOL NO.		(OPPOSITE)				4 OF 4						
CUSTOMER NAAMS		PROGRAM		DESIGN SOURCE NAAMS		BUILD SOURCE		UNIT NO. ADL100				OPPOSITE UNIT		SHOWN UNIT		SOURCE	DATE RELEASED	SERVICE
CUSTOMER DETAIL NO.	SUPPLIER DETAIL NO.	SUB- DETAIL	REVISION LEVEL	SHN. ON L/O SHT.	NAME	MATERIAL	SPECIFICATIONS AND/OR		OPP.	SHN.	OPP.	SHN.	SOURCE	DATE RELEASED BY		SERVICE		
							<input type="checkbox"/> ONE MAKES TWO	<input type="checkbox"/> CUT TO LAYOUT						FAB	FINAL			
M6x1.0 X 40MM LG.					S.H.C.S.	STD	F010614			2		2	P					
M8x1.25 X 25MM LG.					S.H.C.S.	STD	F010811			4		4	P					
M8x1.25 X 60MM LG.					S.H.C.S.	STD	F010818			4		4	P					
M10x1.5 X 45MM LG.					S.H.C.S.	STD	F011015			4		4	P					
M10x1.5 X 120MM LG.					S.H.C.S.	STD	F011026B			3		3	P					
M10x1.5 X 40MM LG.					S.H.C.S.	STD	F011014			10		10	P					
ADL0023				1	MOUNTING PLATE	ASTM A36	1 1/2" X 5 1/2" X 156MM			1		1	M					
ADL0024				1	PLATE	ASTM A36	1 1/4" X 308MM X 523MM			2		2	M					
CHG LTR	DATE	REVISIONS / REASONS FOR				PROJECT MGR.				DESIGN SUPV.								
A	05/31/17	DETAILS ADL0023 & ADL0024 ADDED. - G.B.				MR				REM								
						SOURCE LEGEND				HI-SPOT								
						M - MAKE ITEM P - PURCHASE ITEM APPROVAL REQUIRED FOR SUBSTITUTION M/P - MAKE ITEM CONTAINING PURCHASE ITEM(S) F - FURNISHED BY CUSTOMER NC - NUMERICAL CONTROLLED MACHINING				CHECKER								
										CB								
										DESIGNER								
										REM								