


Item	Qty	Document #	Rev	Title	Comments
1	1	018-954-A000	NC	HPU	100 GAL 20 GPM
2	1	21-000-A001-04	NC	MACHINE ASSY	
3	1	21-120-A001-03	NC	FENCE	
4	1	21-120-A005	NC	FENCE	
5	1	21-850-A008	NC	PUSH BUTTON ASSY	
6	1	21-850-A009-01	NC	CABLE TRAY ASSY	
7	1	21-950-A013-04	NC	HYD BRIDGE	
8	1	21-960-A002	NC	GREASE PUMP ASSY	
9	1	HV CABINET RITTAL 3000mm	NC	HV CABINET RITTAL 3 BAY	1000-1000-1000 BAY
10	1	SCE 464919SDC		Console, Single Access Two Door	46.25H x 49.25W x 18.50D

NOTE:
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MACHINE #	M21-04	DATE	
DRAWN BY:	JerryW	04/09/21	
ENG. BY:	PC		
APP. BY:	CL		



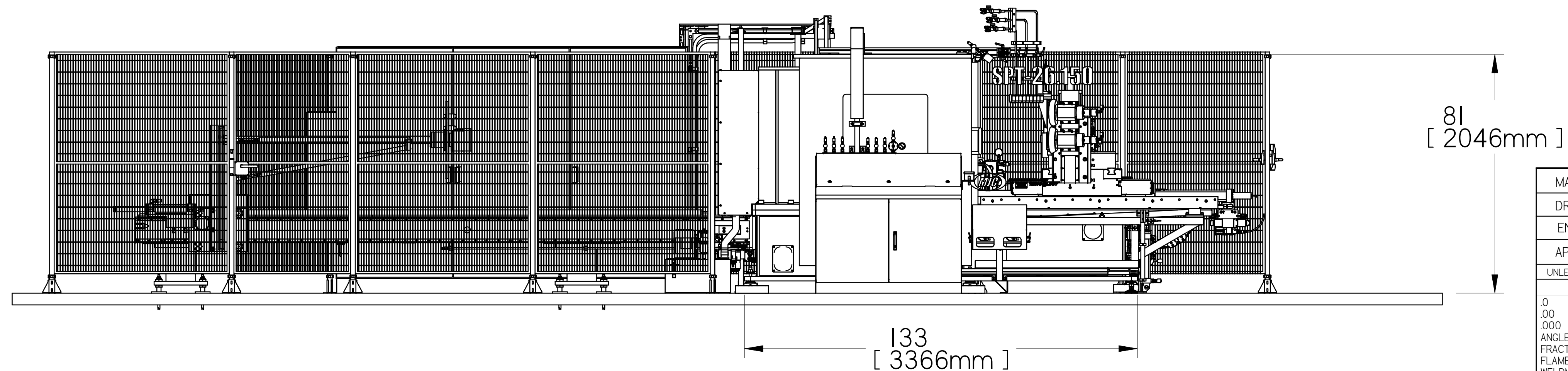
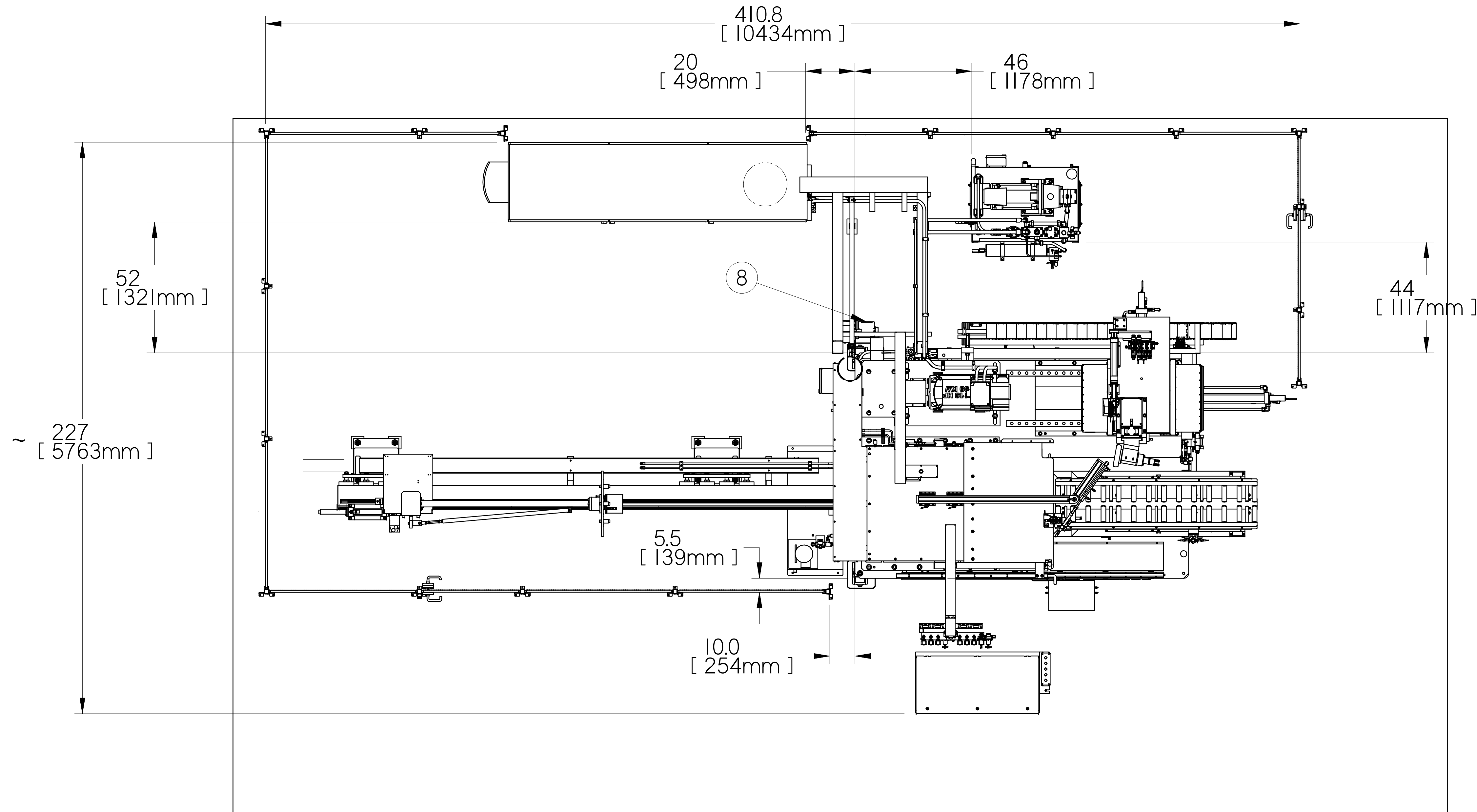
15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

INCH		METRIC	
0	± .1	0	± 2.5mm
.00	± .03	.0	± .75mm
.000	± .010	.00	± .25mm
ANGLES	± 30'	ANGLES	± 30'
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm

COUNTERSINK BOTTOM OF COUNTERBORE
 BREAK ALL SHARP EDGES, NO BURRS ALLOWED

Title MJC SPT-26.150 SPINNING MACHINE	REV. NC
Drawing. No. 21-000-A000-04	SHEET SHEET 1 OF 3
SIZE D	DO NOT SCALE



MACHINE #	M21-04	DATE	
DRAWN BY:	JerryW	04/09/21	
ENG. BY:	PC		
APP. BY:	CL		



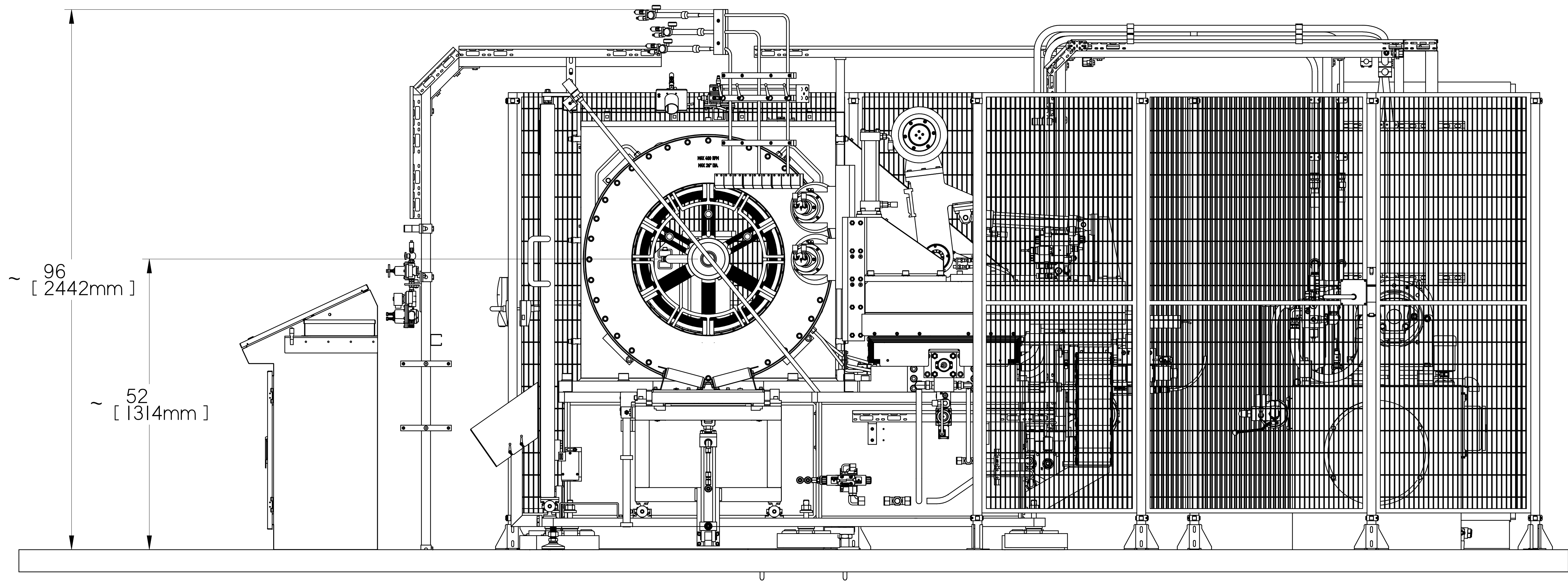
Title: **MJC SPT-26.150 SPINNING MACHINE**

INCH		METRIC	
0	± .1	0	± 2.5mm
.00	± .03	.0	± .75mm
.000	± .010	.00	± .25mm
ANGLES	± 30'	ANGLES	± 30'
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FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm

Drawing. No. **21-000-A000-04** REV. **NC**

COUNTERSINK BOTTOM OF COUNTERBORE
BREAK ALL SHARP EDGES, NO BURRS ALLOWED

SIZE **D** DO NOT SCALE SHEET SHEET 2 OF 3




MACHINE #	M21-04	DATE	
DRAWN BY:	JerryW	04/09/21	
ENG. BY:	PC		
APP. BY:	CL		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

INCH		METRIC	
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WELDMENTS	± 1/8	WELDMENTS	± 3mm

COUNTERSINK BOTTOM OF COUNTERBORE
BREAK ALL SHARP EDGES, NO BURRS ALLOWED



15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649

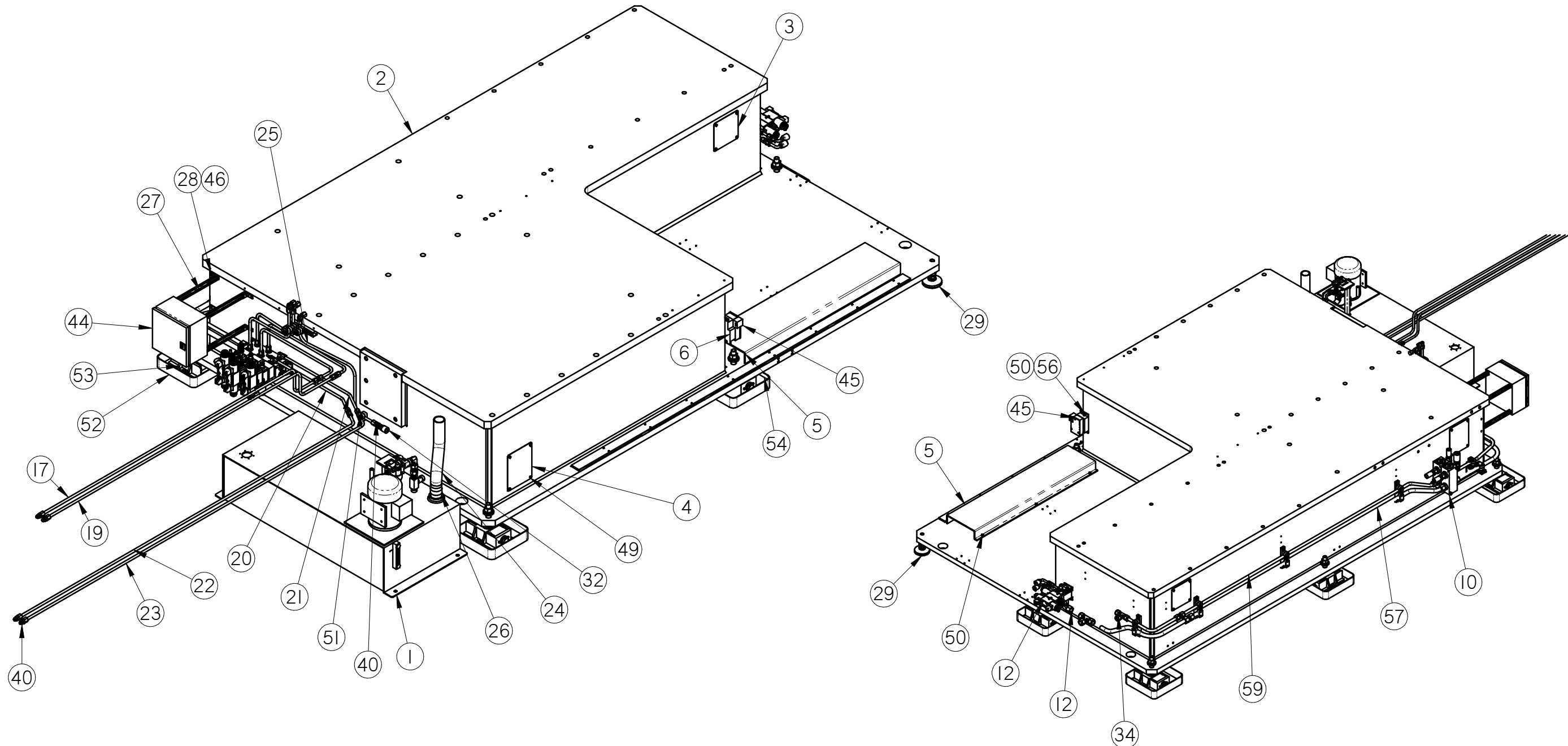
Title: **MJC SPT-26.150 SPINNING MACHINE**

Drawing. No. **21-000-A000-04**

REV. **NC**

SIZE **D** DO NOT SCALE SHEET **3** OF **3**

REV	DESCRIPTION	DATE	APP
NC			



LAST UPDATED 2/4/2022
TOTAL WEIGHT = 12770.7 lbm

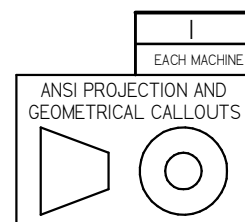
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DRAWN BY:	JerryW	04/12/21
ENG. BY:	PC	
APP. BY:	CL	



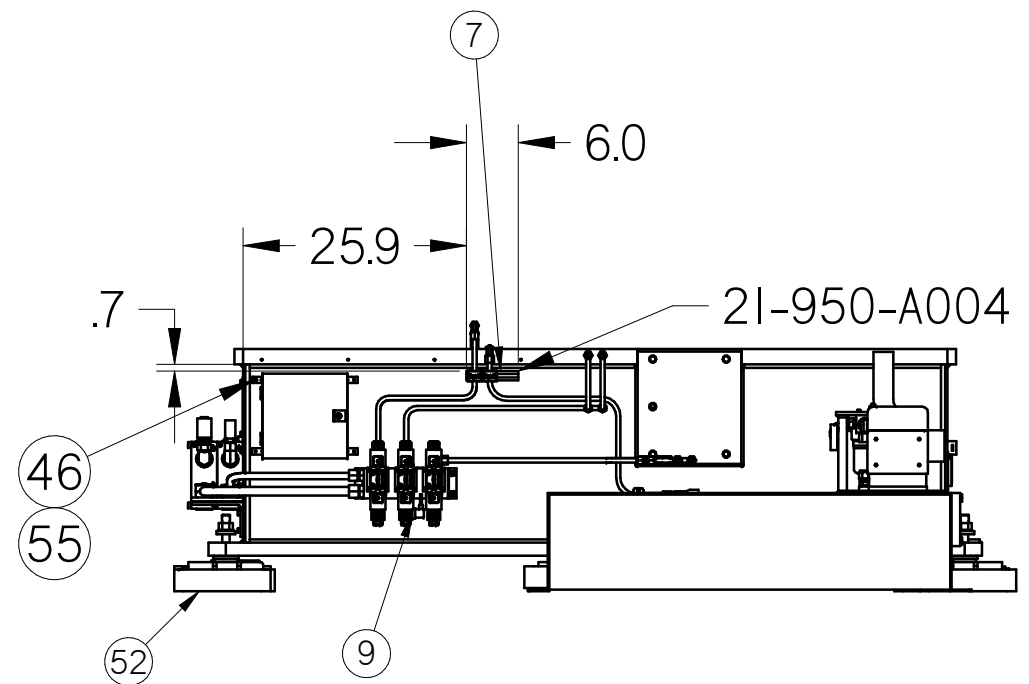
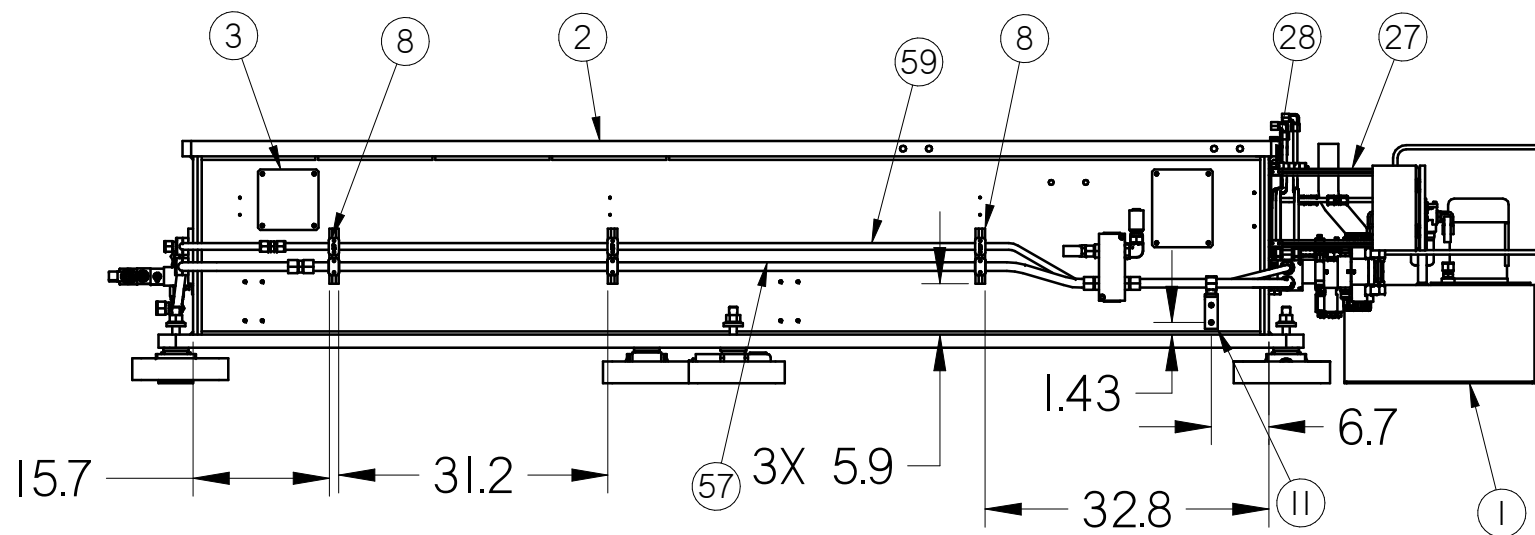
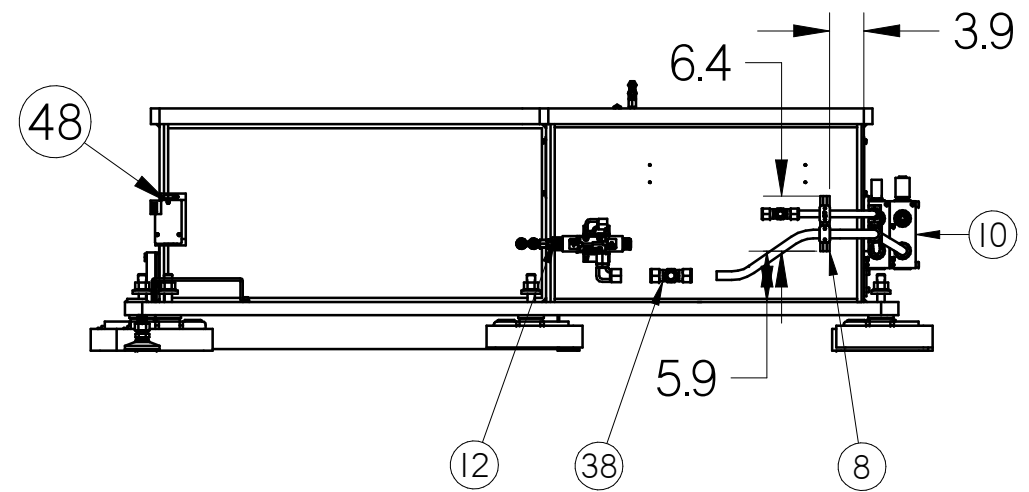
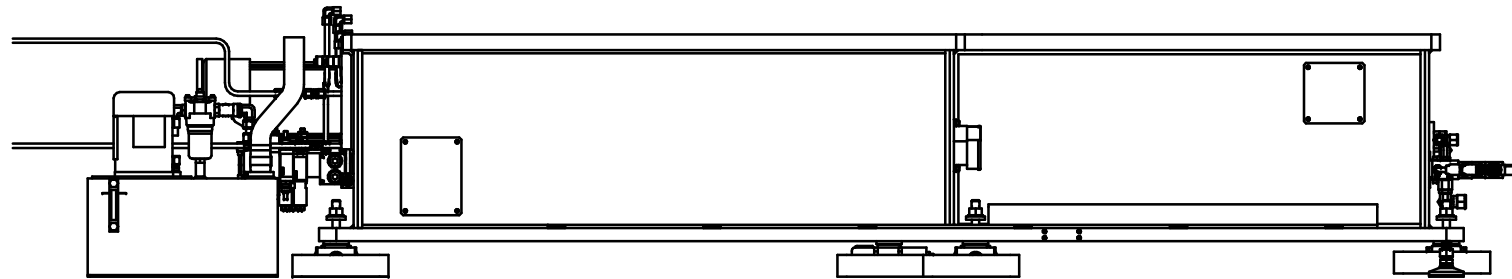
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES


	INCH	METRIC
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	± .010	± .25mm
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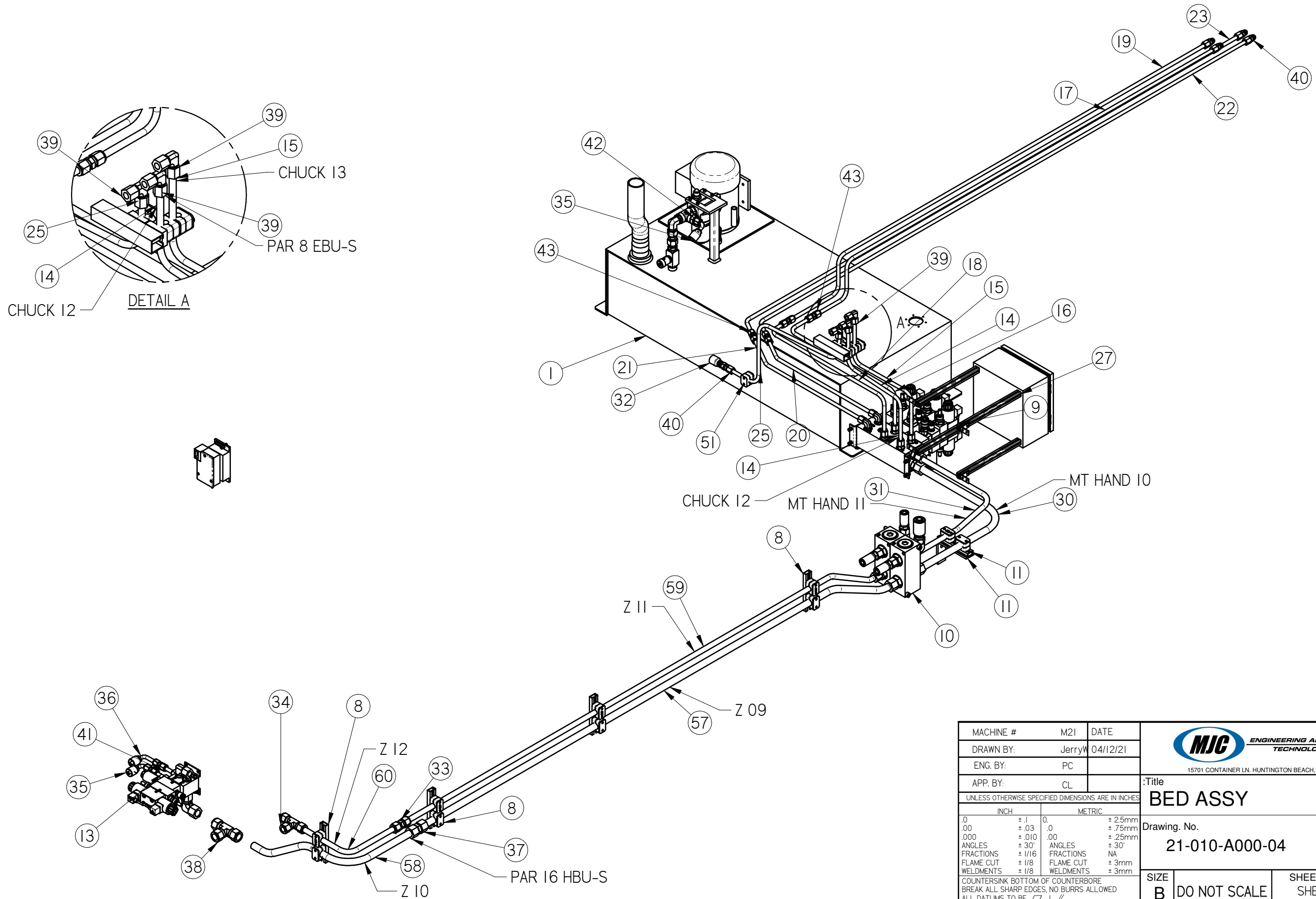
COUNTERSINK BOTTOM OF COUNTERBORE
BREAK ALL SHARP EDGES, NO BURRS ALLOWED
ALL DATUMS TO BE \square , \perp , \parallel
1/2" OR BETTER ON ALL MACHINED SURFACES




Title BED ASSY		REV. NC
Drawing. No. 21-010-A000-04		
SIZE B	DO NOT SCALE	SHEET SHEET 1 OF 4



MACHINE #	M21	DATE	 15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649	
DRAWN BY:	JerryW	04/12/21		
ENG. BY:	PC			
APP. BY:	CL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			Title	
			BED ASSY	
			Drawing No.	
			21-010-A000-04	
			SIZE	REV.
			B	NC
			SHEET	
			SHEET 2 OF 4	
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel			DO NOT SCALE	




MACHINE #	M21	DATE	 15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649	
DRAWN BY:	JerryW	04/12/21		
ENG. BY:	PC			
APP. BY:	CL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			Title	
			BED ASSY	
			Drawing No.	
			21-010-A000-04	
			REV.	
			NC	
			SIZE	SHEET
			B	DO NOT SCALE
			SHEET 3 OF 4	

INCH	METRIC
.0	±.1
.00	±.03
.000	±.010
ANGLES	± 30°
FRACTIONS	± 1/16
FLAME CUT	± 1/8
WELDMENTS	± 1/8
	± 2.5mm
	± .75mm
	± .25mm
	± 30°
	NA
	± 3mm
	± 3mm

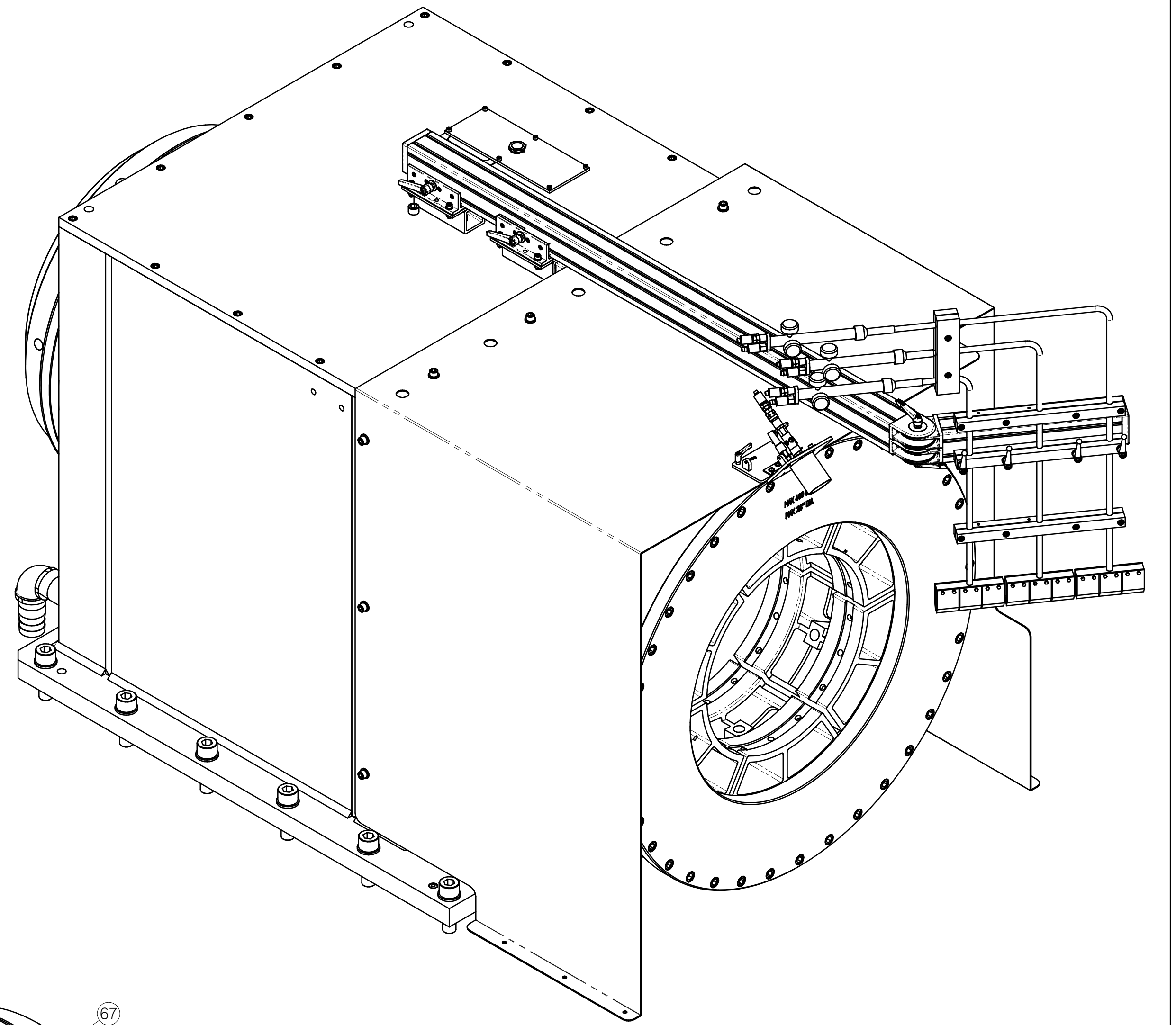
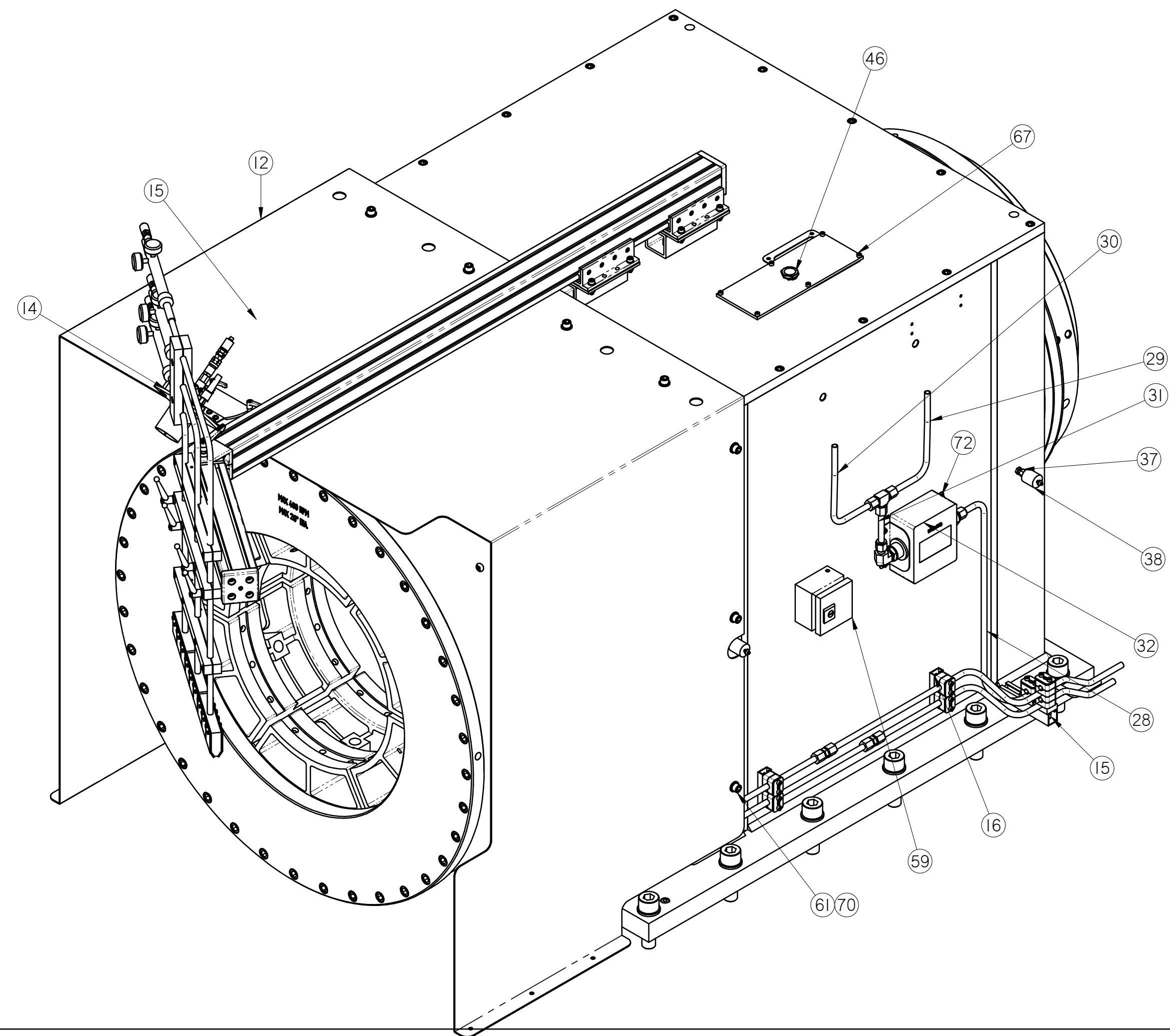
COUNTERSINK BOTTOM OF COUNTERBORE
 BREAK ALL SHARP EDGES, NO BURRS ALLOWED
 ALL DATUMS TO BE \square , \perp , \parallel

Item	Qty	Rev	Document Number	Title	Comments	Item	Qty	Rev	Document Number	Title	Comments
41	2		PAR 8 XHBU-S	HYD FITTING, ADAPTER, 08MJ-08BT		1	1	01	001-950-B050	LUBE UNIT 03	40 GALLON RESERVOIR ASSY
42	1		PAR 8-12F50S-S	HYD FITTING, ADAPTER, 8MJ-12MORB		2	1	01	21-010-A001-04	BED WELD/MACHINE	
43	4		PAR 8HBU-S	HYD FITTING, COUPLING, 8 BT- 8 BT		3	2	NC	21-010-P002	COVER PLATE - BED	
44	1		RIT JB101006HC	ELECTRICAL BOX	10 X 10 X 6"	4	2	NC	21-010-P008	COVER PLATE - BED	
45	1		SCHM TZFS-24VDC	DOOR SWITCH	24VDC 1500N LOAD CAPACITY STRAIGHT KEY	5	1	NC	21-010-S001	STEP	
46	1		SHCS M5-0.80 X 15	SHCS	ZINC PLATED G 12.9	6	1	NC	21-050-P006-01	DOOR LOCK MOUNT	
47	5		SHCS M5-0.80 X 20	SHCS	ZINC PLATED G 12.9	7	1	NC	21-950-A004	HYD TUBE CLAMP ASSY	
48	3		SHCS M5-0.80 X 35	SHCS	ZINC PLATED G 12.9	8	4	NC	21-950-A005	HYD TUBE CLAMP ASSY	
49	16		SHCS M6-1.00 X 12	SHCS	ZINC PLATED G 12.9	9	1	01	21-950-A015-02	CHUCK/EJECTOR MANIFOLD	
50	7		SHCS M8-1.25 X 20	SHCS	ZINC PLATED G 12.9	10	1	NC	21-950-A016-01	HYD JUNCTION ASSY	
51	1		TUBE CLAMP .50"	TUBE CLAMP		11	1	NC	21-950-A022	HYD TUBE CLAMP ASSY	
52	6		UNI GROUT FORM 11X11X2.5	GROUT FORM	UNISORB GROUT FORM 11X11X2.5	12	1	01	21-950-A025-01	CONVEYOR MANIFOLD	
53	6		UNI RK 111 STE P	MACHINE FOOT	SPERICAL WASHER 8900LB RATING E=1.500"	13	2	NC	21TU-BD-01	HYD TUBE, -8	CUT TO: 3"
54	1		UNI V-100 EPOXY	GROUT FOR M21-01	UNISORB V-100 EPOXY 4X #22 V-100 KIT	14	1	NC	CHUCK 12	TUBE	
55	6		WASHER M5	WASHER	ZINC PLATED G 12.9	15	1	NC	CHUCK 13	TUBE	
56	2		WASHER M8	WASHER	ZINC PLATED G 12.9	16	1	NC	EJ 06	TUBING -08	
57	1	NC	Z 09	TUBE		17	1	NC	EJ 07	TUBE	
58	1	NC	Z 10	TUBE		18	1	NC	EJ 08	TUBE	
59	1	NC	Z 11	TUBE		19	1	NC	EJ 09	TUBE	
60	1	NC	Z 12	TUBE		20	1	NC	END STOP 04-03	TUBE	
						21	1	NC	END STOP 05-03	TUBE	
						22	1	NC	END STOP 06-03	TUBE	
						23	1	NC	END STOP 07-03	TUBE	
						24	1		H.S. DRAIN HOSE	DRAIN HOSE, 2" ID	
						25	1		HS LUBE 18	TUBE	
						26	1		MMC 5363K56	HOSE BARB 2.00	2" NPT
						27	4		MMC 5537T101 IFT	PROFILE 20x20, ALU	
						28	4		MMC 5537T344	BRACKET, 1-5/8" x 20mm, FROFILE 20,	
						29	1		MMC 6111K252	SWIVEL LEVELING MOUNT, 1"-8 x 3-1/2" THREAD	
						30	1	NC	MT HAND 10	TUBE	
						31	1	NC	MT HAND 11	TUBE	
						32	1		PAR 10643-8-8	HOSE END, 8FJ-8HOSE	
						33	1		PAR 12 HBU-S	HYD FITTING	12 TUBE 12 TUBE
						34	1		PAR 12 JBU-S	HYD FITTING	PAR 12 JBU
						35	2		PAR 13943-8-8	HYD FITTING, ELBOW SHORT, 08FJ-08HOSE	
						36	1		PAR 14143-8-8	HOSE END, ELBOW LONG, 08MJ-08HOSE	
						37	1		PAR 16 HBU-S	UNION	TUBE 16 TUBE 16
						38	1		PAR 16 JBU-S	HYD FITTING	TUBE 16 TEE
						39	3		PAR 8 EBU-S	ELBOW FITTING	PAR 8 EBU
						40	5		PAR 8 XHBU-S	HYD FITTING	ADAPTER -8 JIC TO -8 TUBE

MACHINE #	M21	DATE																																	
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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			 15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649																																
<table border="1"> <thead> <tr> <th colspan="2">INCH</th><th colspan="2">METRIC</th></tr> </thead> <tbody> <tr><td>.0</td><td>±.1</td><td>0.</td><td>± 2.5mm</td></tr> <tr><td>.00</td><td>±.03</td><td>.0</td><td>±.75mm</td></tr> <tr><td>.000</td><td>±.010</td><td>.00</td><td>±.25mm</td></tr> <tr><td>ANGLES</td><td>± 30'</td><td>ANGLES</td><td>± 30'</td></tr> <tr><td>FRACTIONS</td><td>± 1/16</td><td>FRACTIONS</td><td>NA</td></tr> <tr><td>FLAME CUT</td><td>± 1/8</td><td>FLAME CUT</td><td>± 3mm</td></tr> <tr><td>WELDMENTS</td><td>± 1/8</td><td>WELDMENTS</td><td>± 3mm</td></tr> </tbody> </table>				INCH		METRIC		.0	±.1	0.	± 2.5mm	.00	±.03	.0	±.75mm	.000	±.010	.00	±.25mm	ANGLES	± 30'	ANGLES	± 30'	FRACTIONS	± 1/16	FRACTIONS	NA	FLAME CUT	± 1/8	FLAME CUT	± 3mm	WELDMENTS	± 1/8	WELDMENTS	± 3mm
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COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel			Title BED ASSY																																
Drawing No. 21-010-A000-04		REV. NC																																	
SIZE B	DO NOT SCALE	SHEET SHEET 4 OF 4																																	

Item	Qty	Document Number	Rev	Title	Comments	Item	Qty	Document Number	Rev	Title	Comments
1	1	21-020-A001-02	NC	HEADSTOCK WELDMENT		57	2	PAR N400S	NC	NEEDLE VALVE	PARKER 1/4 IN INLINE NEEDLE VALVE
2	1	21-020-A002-03	NC	660MM CHUCK ASSY		58	4	RAM PAC 100mm X 2.2 INCH -8 PORTS	NC	BLOCK CYLINDER	100MM DIA X 2.200 STROKE RAM-PAC DRAWING # X801-1987
3	10	21-020-P012-01	NC	HEAT SHIELD SPACER		59	1	RIT JB040403HC		ELECTRICAL BOX	4 X 4 X 3"
4	1	21-020-P025-02	OI	MAIN SPINDLE- HS		60	6	SETS M16-2 X 80MM		SET SCREW	MMC 91390A197
5	1	21-020-P029-01	NC	SHEAVE- HS		61	10	SHCS M12-1.75 X 20		SHCS	ZINC PLATED G 12.9
6	1	21-020-P030	NC	LABYRINTH SEAL RING- HS		62	16	SHCS M12-1.75 X 30		SHCS	ZINC PLATED G 12.9
7	1	21-020-P031-02	NC	LOCK NUT- HS		63	1	SHCS M16-2.00 X 25		SHCS	ZINC PLATED G 12.9
8	1	21-020-P032	O3	FRONT SEAL RING- HS		64	6	SHCS M20-2.5 X 170		SHCS	ZINC PLATED G 12.9
9	1	21-020-P033	NC	KEY- SPINDLE		65	14	SHCS M30-3.50 X 100		SHCS	ZINC PLATED G 12.9
10	1	21-020-P039	O2	REAR SEAL RING- HS		66	8	SHCS M6-1.00 X 12		SHCS	ZINC PLATED G 12.9
11	1	21-020-P048	NC	ACCESS COVER		67	6	SHCS M6-1.00 X 16		SHCS	ZINC PLATED G 12.9
12	1	21-050-S002-02	O2	HEADSTOCK COVER		68	4	STAF SM 1095 PP DP-AS UW3K		TUBE CLAMP .375" SINGLE HOLE	
13	1	21-210-A001-02	O1	TORCH ASSEMBLY		69	2	TIM EE755285 - 755360 ASSEY 90030		TIMKEN TAPER ROLLER BEARING	TIMKEN EE755285 - 755360 ASSEY 90030 ID 28.500 OD 36.000 T 3.312 DYNAMIC RATING 77.400 LBF
14	1	21-210-A014	O1	IGNITOR MOUNT		70	10	WASHER M12		WASHER	ZINC PLATED G 12.9
15	1	21-950-A004	NC	HYD TUBE CLAMP ASSY		71	14	WASHER M30		WASHER	ZINC PLATED
16	2	21-950-A017	NC	HYD TUBE MOUNT		72	8	WASHER M6		WASHER	ZINC PLATED G 12.9

17	1	CHUCK 50	NC	TUBE	
18	1	CHUCK 51	NC	TUBE	
19	1	CHUCK 52	NC	TUBE	
20	1	CHUCK 53	NC	TUBE	
21	1	CHUCK 54	NC	TUBE	
22	1	CHUCK 55	NC	TUBE	
23	1	CHUCK 56	NC	TUBE	
24	1	CHUCK 57	NC	TUBE	
25	1	CHUCK TUBE 48	NC	TUBE	
26	1	CHUCK TUBE 49	NC	TUBE	
27	2	DP 20 X 80MM		DOWEL PIN DP 20 X 80MM	
28	1	HS. LUB I10	NC	TUBING -08	
29	1	HS. LUB I11	NC	TUBING -08	
30	1	HS. LUB I12	NC	TUBING -08	
31	1	HS. LUB I14	NC	TUBING -08, 8.2'LG	
32	1	HEDL H700A-010-F1		FLOW SWITCH, 1-10 GPM, -12 SAE	
33	1	HS LUBE 05	NC	TUBE	
34	1	HS LUBE 06	NC	TUBE	
35	1	HS LUBE 07	NC	TUBE	
36	1	HS LUBE 08	NC	TUBE	
37	2	IFM E30049		MALE CONNECTOR	
38	2	IFM TA3231		TEMP SENSOR	
39	1	LID GASKET		GASKET	CUT TO FIT FROM MMC 9402K82 OR SIMILAR ADHESE TO HEAD STOCK LID ONLY
40	1	MC 5738K5		MAGNET 2 X 2 X 1	MC 5738K5
41	1	MMC 44605K119		PIPE ELBOW, 2" NPT	2" NPT ELBOW
42	1	MMC 44615K199		SCH 40 BLACK PIPE	
43	1	MMC 4513K326		DRAIN PLUG	
44	1	MMC 5363K56		HOSE BARB 2.00	2" NPT
45	1	MMC 9023K81		GASKET	Oil-Resistant Buna-N Rubber Strip with Adhesive-Back, 1" x 36", 1/16" Thick
46	1	MMC 9933K13		BREATH VENT, 1" MNPT	
47	1	O-RING 704.11mm X 4.0mm		O RING	
48	2	O-RING 907.2mm X 4.0mm		O RING	
49	4	PAR 6 FBU-S		MALE CONNECTOR	1/4 NPT, 3/8 TUBE
50	1	PAR 6-6 CBU-S		90 DEG HYD FITT	PAR 6 6 CBU
51	2	PAR 8 F5BU-S		HYD FITTING	SAE 08 MFL 08
52	2	PAR 8 HBU-S		STRAIGHT FITTING	-8 TUBE
53	1	PAR 8 JBU-S		UNION TEE	-8 TUBE
54	6	PAR 8 R5BU-S		HYD FITTING	
55	1	PAR 8-12 C5BU-S		HYD FITTING, ELBOW, 08 BT - 12 MORB	
56	1	PAR 8-12 F5BU-S		HYD FITTING, CONNECTOR, 12 MORB - 08 BT	



NOTE: (UNLESS OTHERWISE SPECIFIED)
 LAST UPDATED 2/4/2022
 TOTAL WEIGHT = 14819.1 lbm
 I - SET UP .015" END PLAY.

MACHINE #	M21	DATE	
DRAWN BY:	BB	03/18/21	
ENG. BY:	PC		
APP. BY:	CL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
INCH		METRIC	
0	± .1	0	± 2.5mm
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ANGLES	± 30'	ANGLES	± 30'
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FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE Z, L, //			

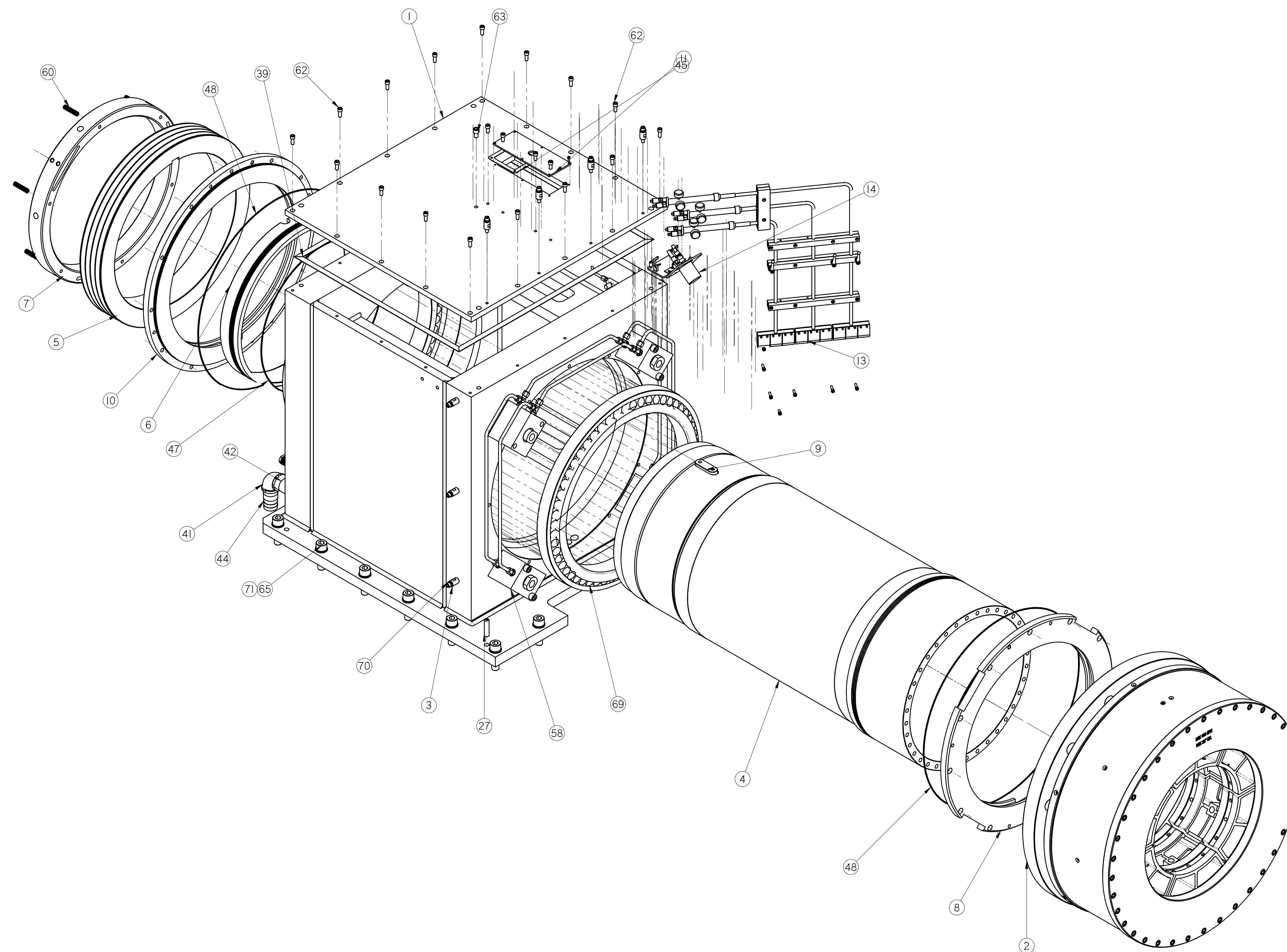
MJC ENGINEERING AND TECHNOLOGY, INC.
 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649


HEADSTOCK ASSY

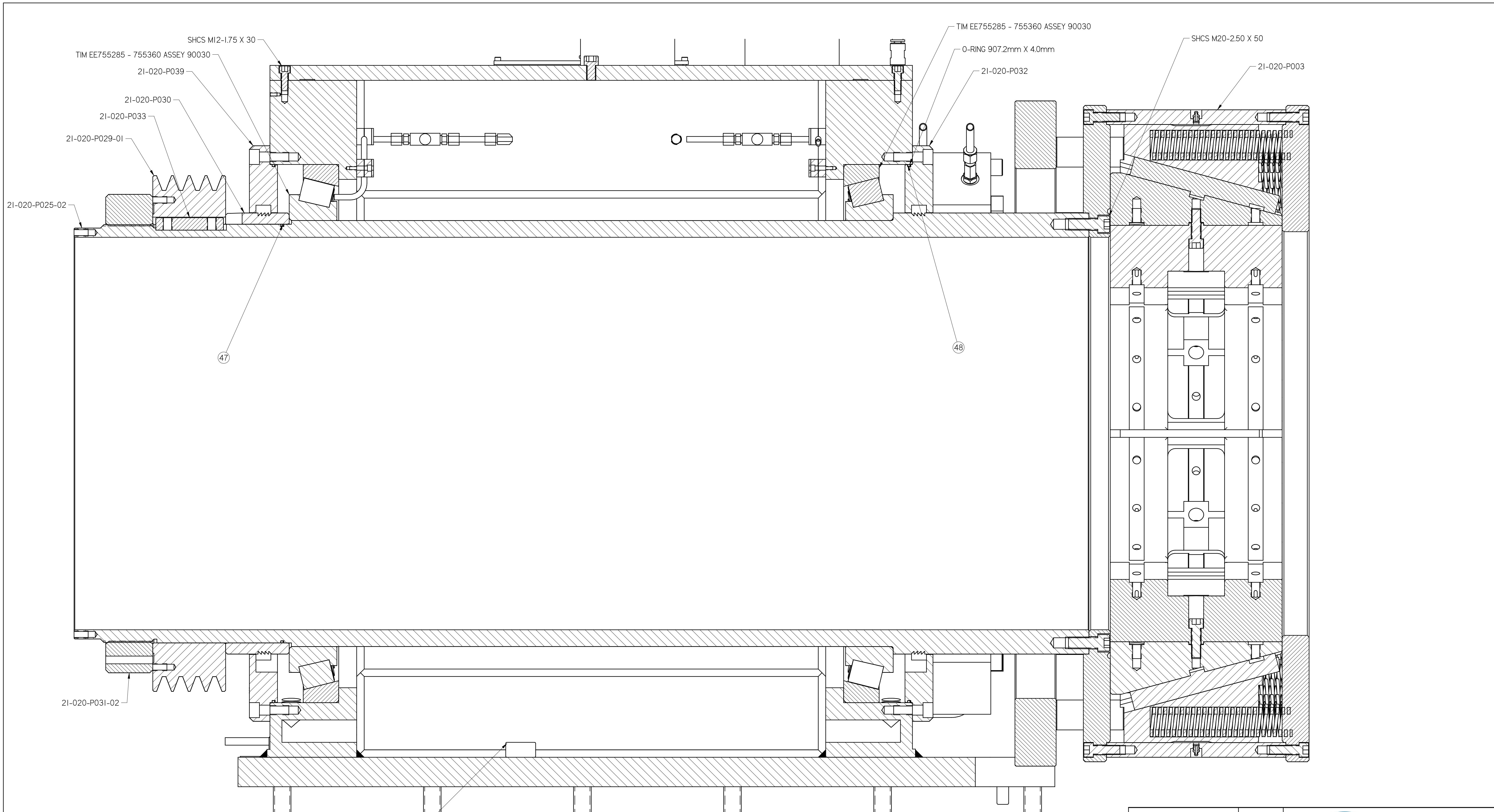
Drawing No. **21-020-A000-03**


REV. **01**

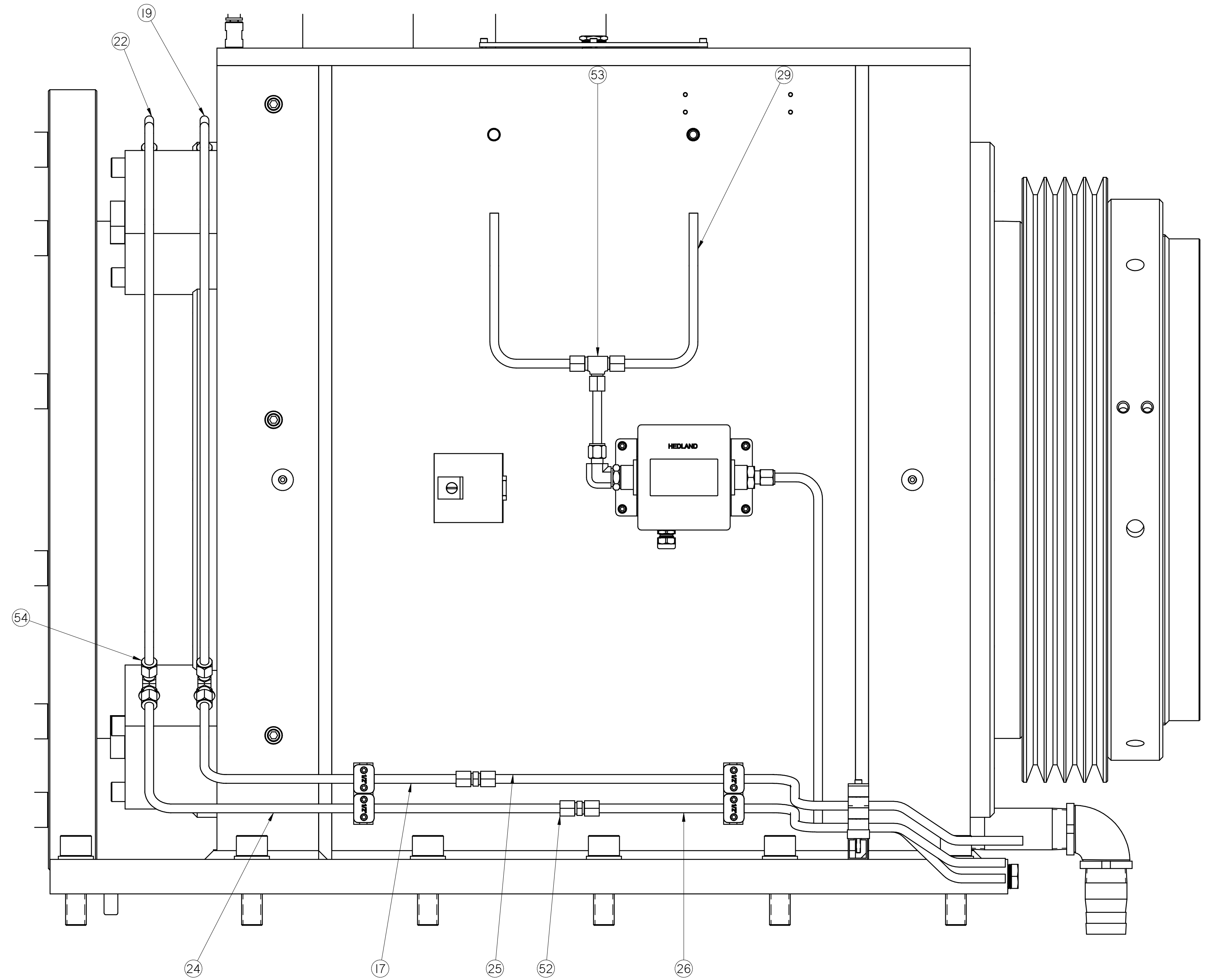
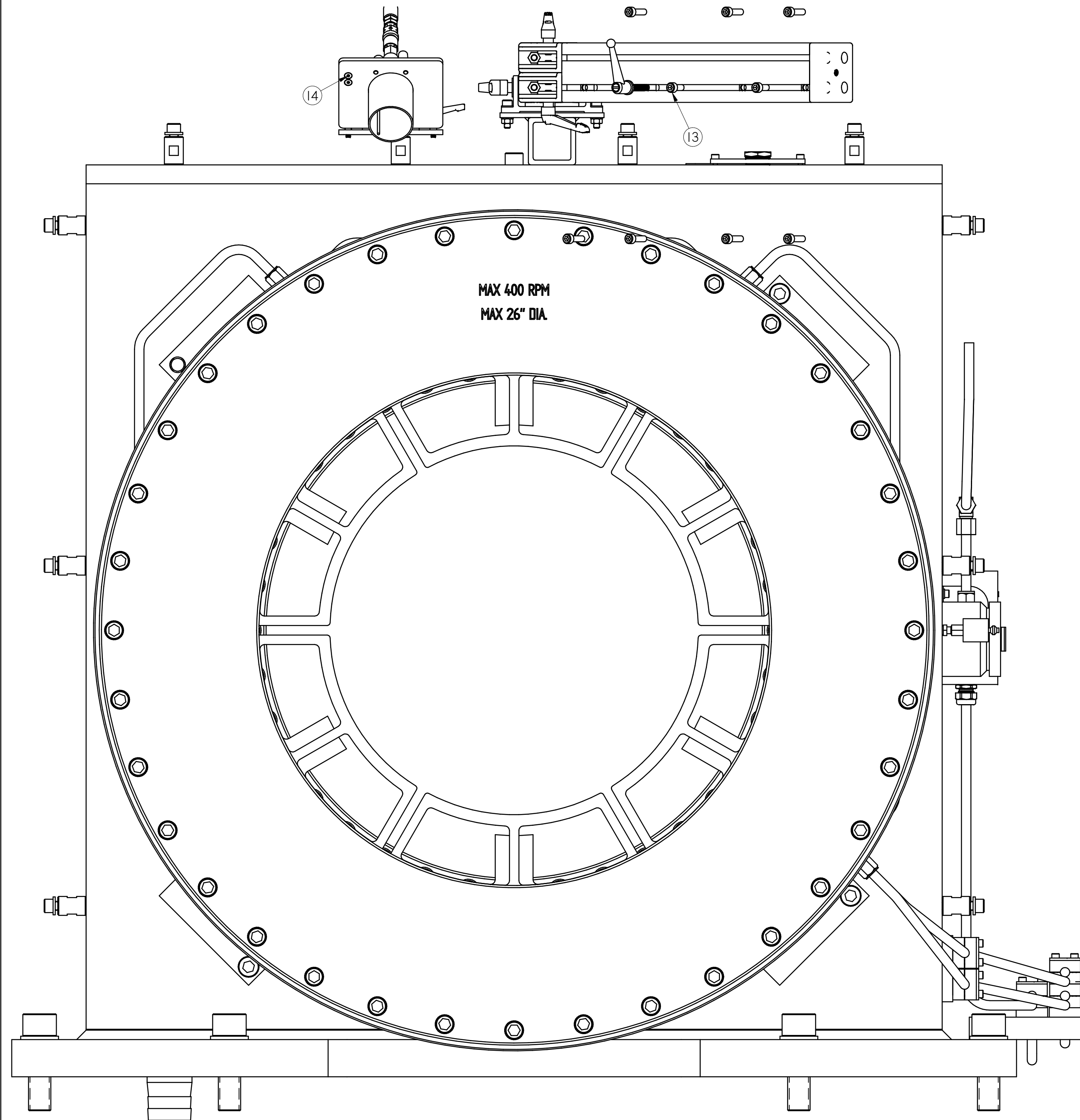
SIZE **D** DO NOT SCALE SHEET **1** OF **5**




MACHINE #	M21	DATE	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649																																	
DRAWN BY:	BB	03/18/21																																		
ENG. BY:	PC																																			
APP. BY:	CL		:Title																																	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			HEADSTOCK ASSY																																	
<table border="1"> <thead> <tr> <th colspan="2">INCH</th> <th colspan="2">METRIC</th> </tr> </thead> <tbody> <tr> <td>0</td> <td>± .1</td> <td>0</td> <td>± 2.5mm</td> </tr> <tr> <td>.00</td> <td>± .03</td> <td>.0</td> <td>± .75mm</td> </tr> <tr> <td>.000</td> <td>± .010</td> <td>.00</td> <td>± .25mm</td> </tr> <tr> <td>ANGLES</td> <td>± 30'</td> <td>ANGLES</td> <td>± 30'</td> </tr> <tr> <td>FRACTIONS</td> <td>± 1/16</td> <td>FRACTIONS</td> <td>NA</td> </tr> <tr> <td>FLAME CUT</td> <td>± 1/8</td> <td>FLAME CUT</td> <td>± 3mm</td> </tr> <tr> <td>WELDMENTS</td> <td>± 1/8</td> <td>WELDMENTS</td> <td>± 3mm</td> </tr> </tbody> </table>			INCH		METRIC		0	± .1	0	± 2.5mm	.00	± .03	.0	± .75mm	.000	± .010	.00	± .25mm	ANGLES	± 30'	ANGLES	± 30'	FRACTIONS	± 1/16	FRACTIONS	NA	FLAME CUT	± 1/8	FLAME CUT	± 3mm	WELDMENTS	± 1/8	WELDMENTS	± 3mm	Drawing. No.	
INCH		METRIC																																		
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.00	± .03	.0	± .75mm																																	
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COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \angle , \perp , \parallel			21-020-A000-03																																	
SIZE			SHEET																																	
D			DO NOT SCALE																																	
			SHEET 2 OF 5																																	
			REV. 01																																	



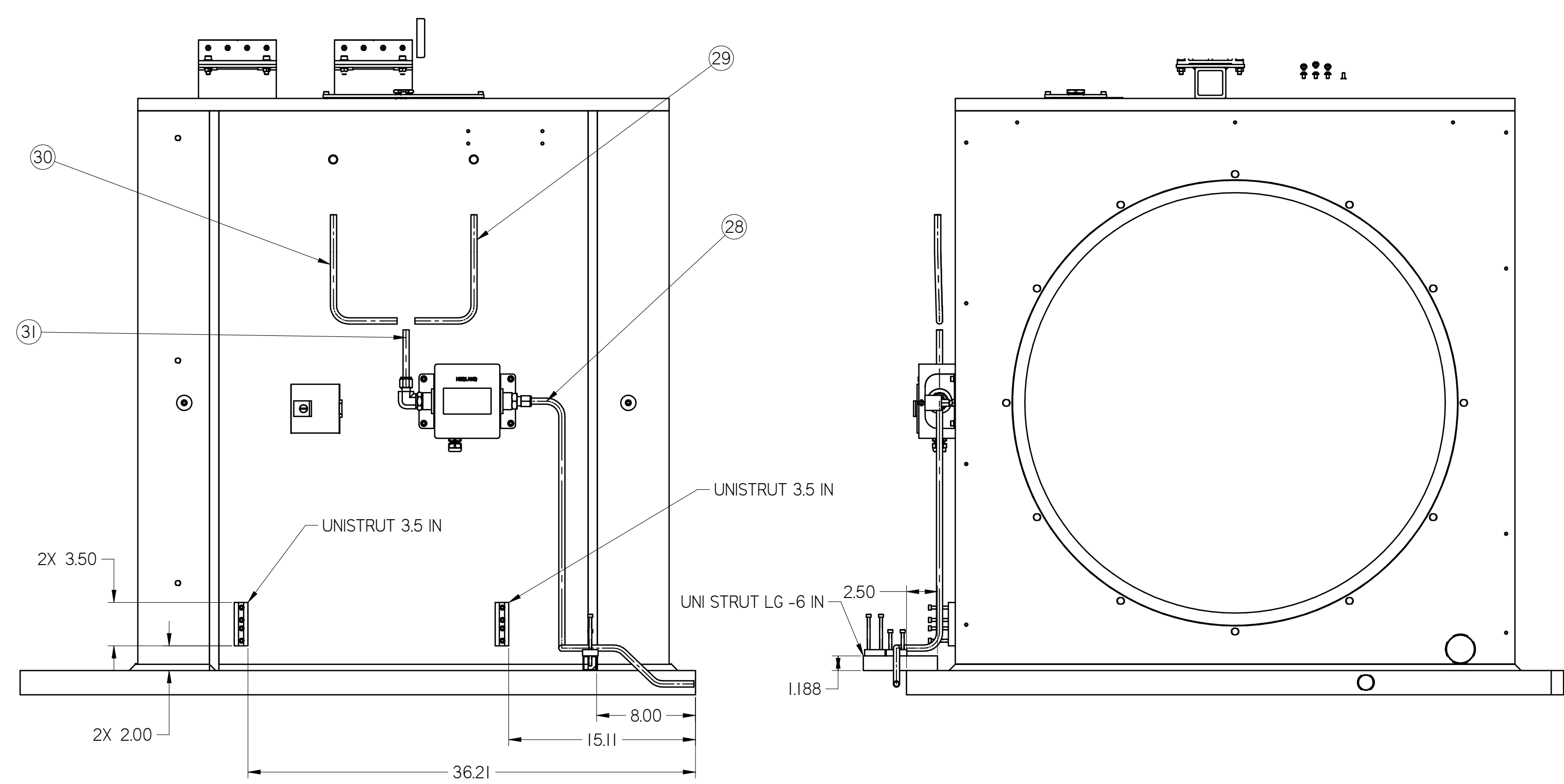
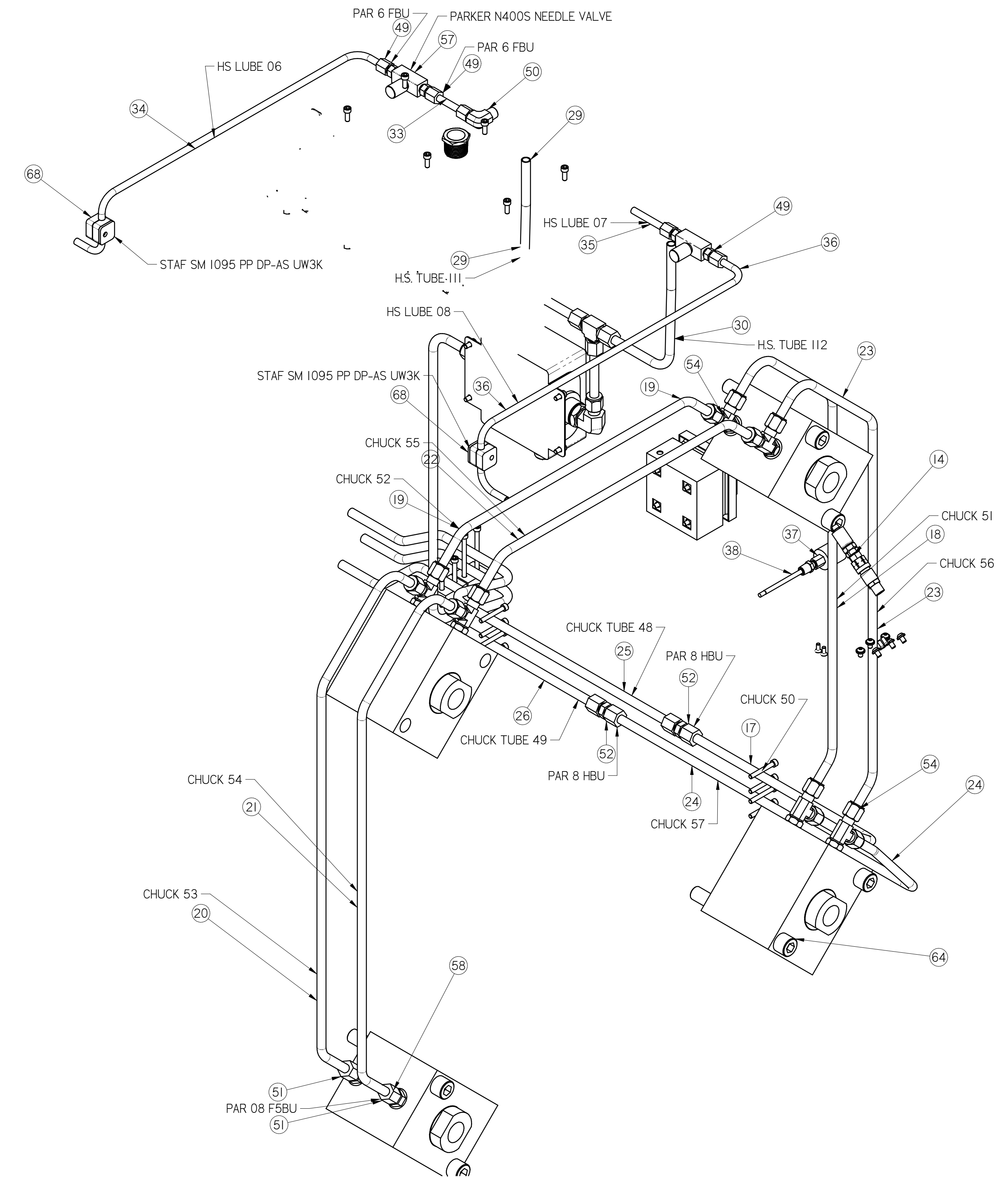
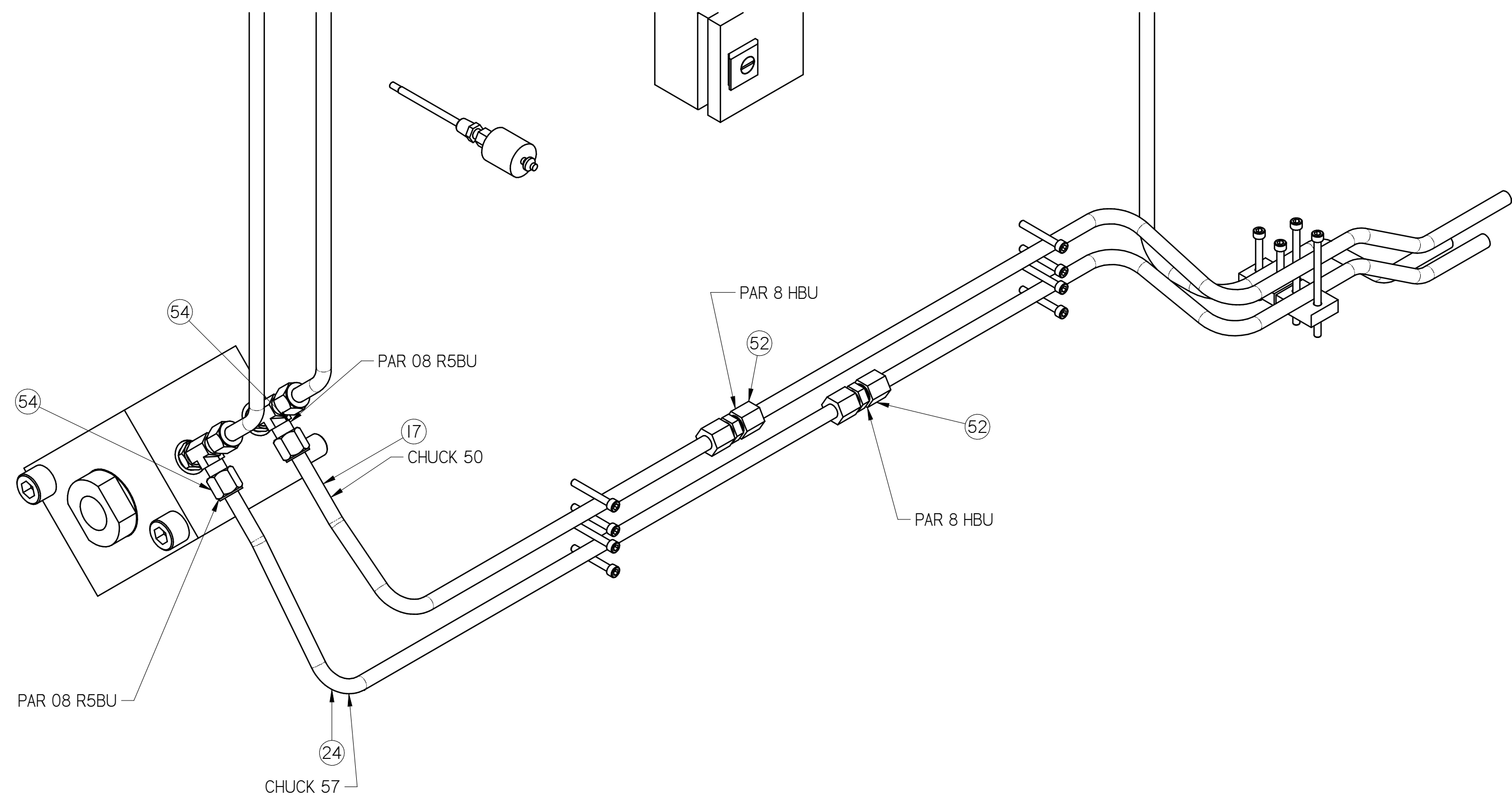
MACHINE #	M21	DATE	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649																																	
DRAWN BY:	BB	03/18/21																																		
ENG. BY:	PC																																			
APP. BY:	CL																																			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			:Title HEADSTOCK ASSY																																	
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INCH		METRIC																																		
0	± .1	0	± 2.5mm																																	
.00	± .03	.00	± .75mm																																	
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COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \angle , L, //			SIZE D	DO NOT SCALE	SHEET SHEET 3 OF 5																															
			REV.	01																																



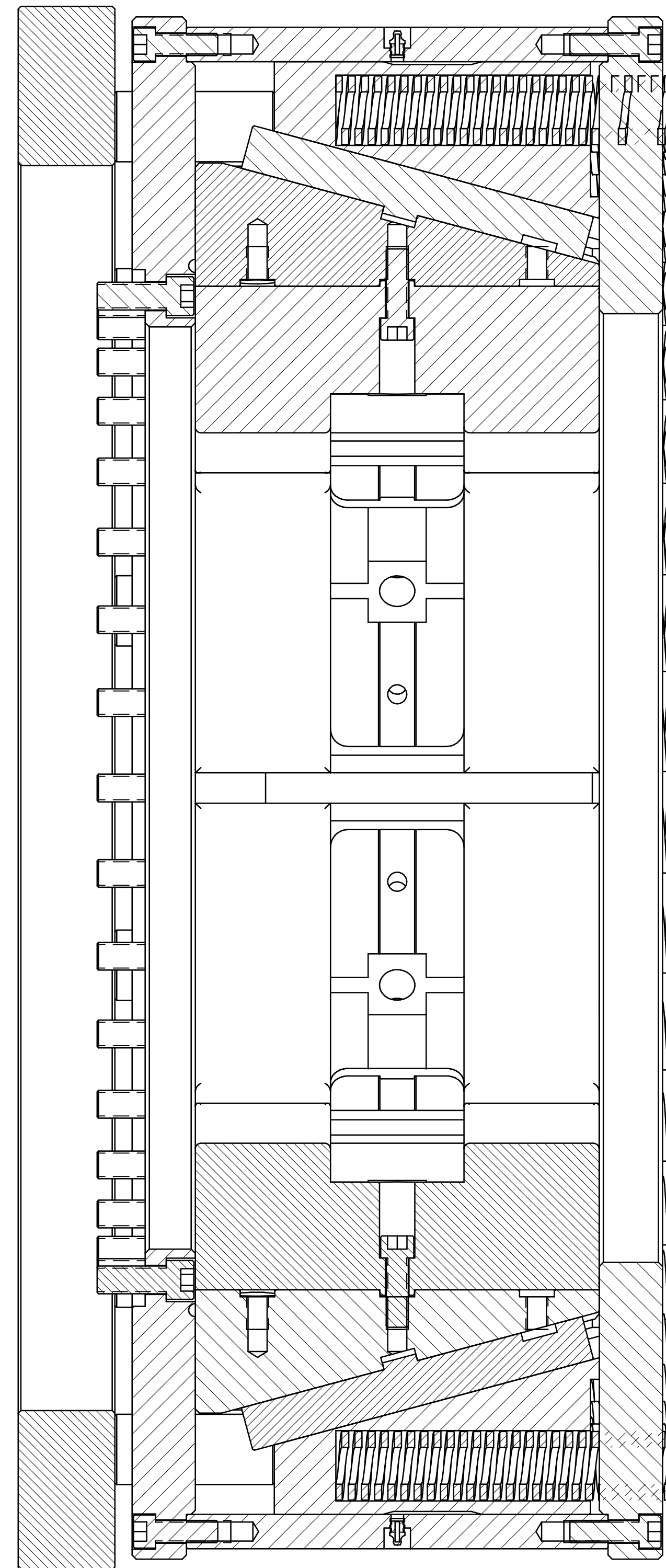
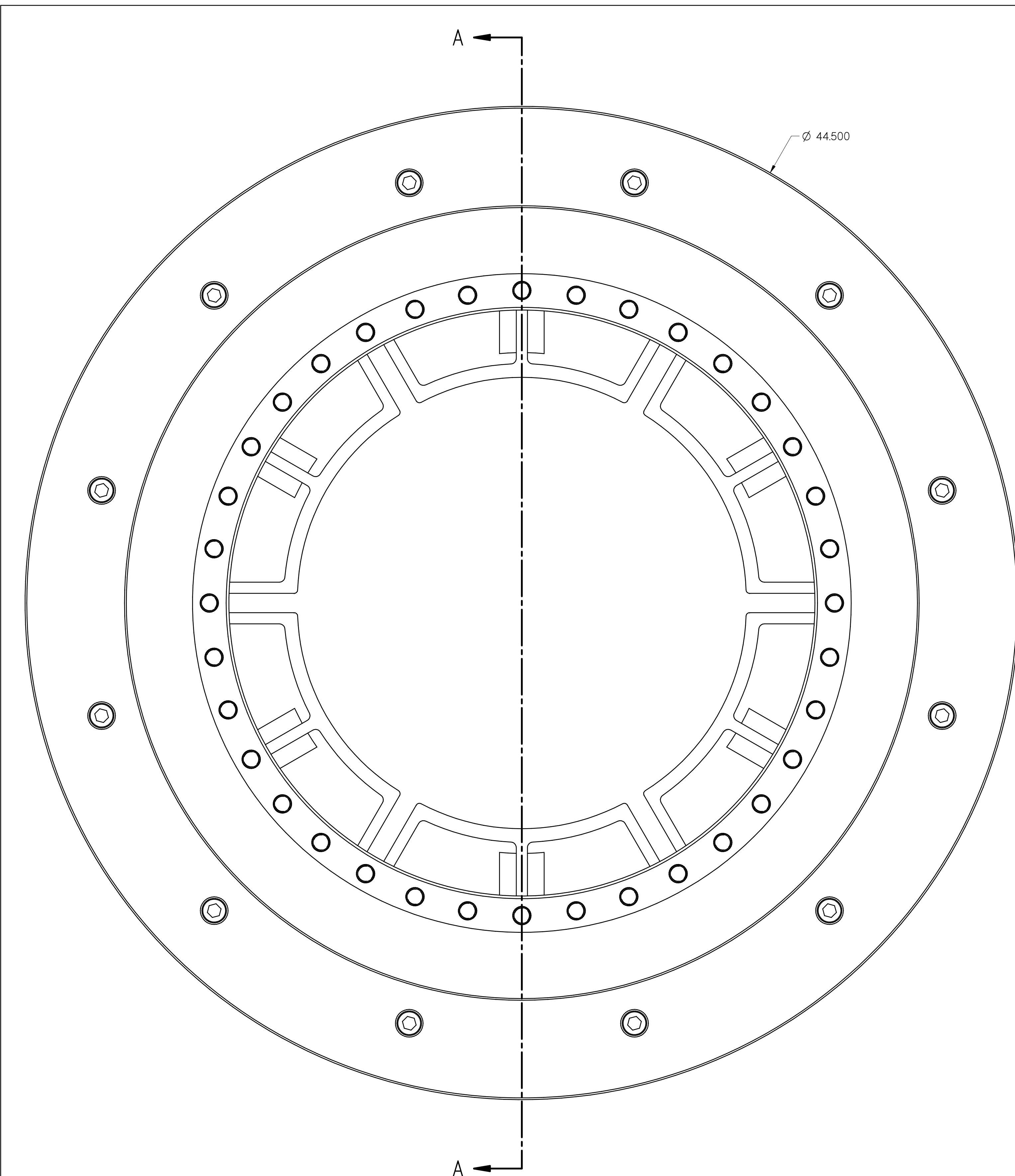
MACHINE #	M21	DATE	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649	
DRAWN BY:	BB	03/18/21		
ENG. BY:	PC			
APP. BY:	CL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			:Title	
			HEADSTOCK ASSY	
			Drawing. No.	
			21-020-A000-03	
			REV.	
			01	
			SIZE	SHEET
			D	4 OF 5
			DO NOT SCALE	

INCH		METRIC	
0	± .1	0	± 2.5mm
.00	± .03	.0	± .75mm
.000	± .010	.00	± .25mm
ANGLES	± 30'	ANGLES	± 30'
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm

COUNTERSINK BOTTOM OF COUNTERBORE
 BREAK ALL SHARP EDGES, NO BURRS ALLOWED
 ALL DATUMS TO BE \angle , L, //



MACHINE #	M21	DATE	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649	
DRAWN BY:	BB	03/18/21		
ENG. BY:	PC			
APP. BY:	CL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				
INCH		METRIC		
0	± .1	0	± 2.5mm	
.00	± .03	.0	± .75mm	
.000	± .010	.00	± .25mm	
ANGLES	± 30'	ANGLES	± 30'	
FRACTIONS	± 1/16	FRACTIONS	NA	
FLAME CUT	± 1/8	FLAME CUT	± 3mm	
WELDMENTS	± 1/8	WELDMENTS	± 3mm	
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE 7, 1, //				
:Title		HEADSTOCK ASSY		
Drawing No.		21-020-A000-03		
SIZE	D	DO NOT SCALE	SHEET	5 OF 5
				REV. 01



SECTION A-A

Item Number	Quantity	Document Number	Rev	Title	Comments
1	6	21-020-A003-03	NC	MASTER JAW ASSY	
2	1	21-020-P001	NC	FRONT PLATE- CHUCK	
3	1	21-020-P002	NC	BACK PLATE- CHUCK	
4	1	21-020-P003	NC	OUTER RING- CHUCK	
5	1	21-020-P004-02	NC	SPRING HOUSING- CHUCK	
6	1	21-020-P005	NC	PUSH RING- CHUCK	
7	12	21-020-P006	NC	PUSH PIN- CHUCK	
8	1	21-020-P010	NC	KEY- CHUCK	
9	42	DAN 9-3240-36		COMPRESSION SPRING	OD 2.000, ID 1.000, H 10.00 IDRAWN COMPRESSED .500" 19.500" LONG
10	15	MMC 1095K11		ZERK FITTING STR.	1/8 -27 NPT
11	36	SHCS M16-2.00 X 45		SHCS	ZINC PLATED G 12.9
12	36	SHCS M16-2.00 X 50		SHCS	ZINC PLATED G 12.9
13	12	SHCS M20-2.5 X 200		SHCS	ZINC PLATED G 12.9
14	36	SHCS M20-2.50 X 50		SHCS	ZINC PLATED G 12.9

MACHINE #	M21	DATE	
DRAWN BY:	JerryW	05/25/16	
ENG. BY:	PC		
APP. BY:	CL		



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

Title
660MM CHUCK ASSY

Drawing. No.
21-020-A002-03

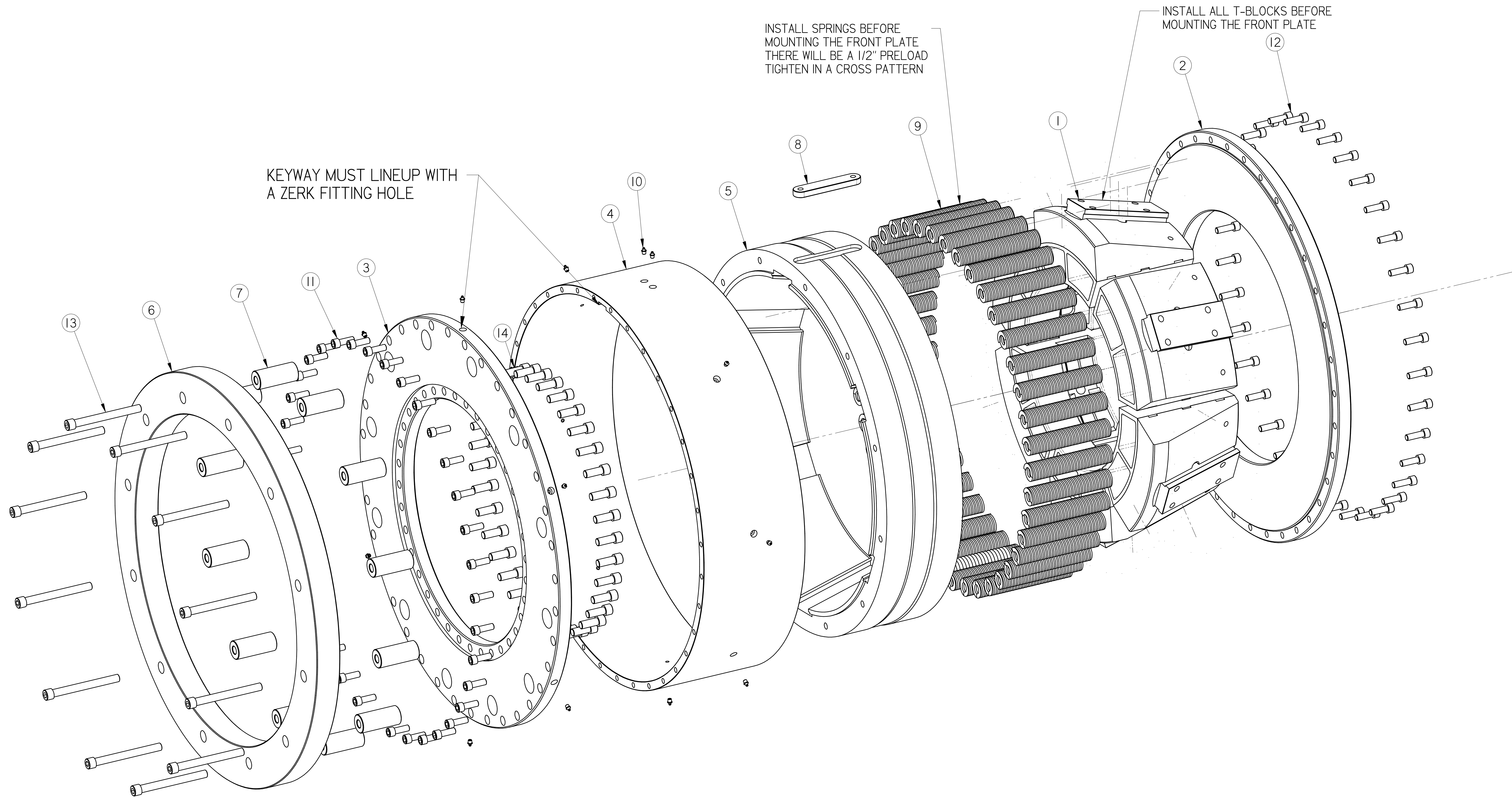
REV.
NC

INCH		METRIC	
0	± .1	0	± 2.5mm
.00	± .03	.0	± .75mm
.000	± .010	.00	± .25mm
ANGLES	± 30'	ANGLES	± 30'
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm

COUNTERSINK BOTTOM OF COUNTERBORE
BREAK ALL SHARP EDGES, NO BURRS ALLOWED
ALL DATUMS TO BE \angle , L, //

SIZE
D DO NOT SCALE

SHEET
SHEET 1 OF 3



KEYWAY MUST LINEUP WITH A ZERK FITTING HOLE

INSTALL SPRINGS BEFORE MOUNTING THE FRONT PLATE THERE WILL BE A 1/2" PRELOAD TIGHTEN IN A CROSS PATTERN

INSTALL ALL T-BLOCKS BEFORE MOUNTING THE FRONT PLATE

MACHINE #	M21	DATE
DRAWN BY:	JerryW	05/25/16
ENG. BY:	PC	
APP. BY:	CL	



Title
660MM CHUCK ASSY

INCH		METRIC	
0	± .1	0	± 2.5mm
.00	± .03	.0	± .75mm
.000	± .010	.00	± .25mm
ANGLES	± 30'	ANGLES	± 30'
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm

Drawing No.
21-020-A002-03

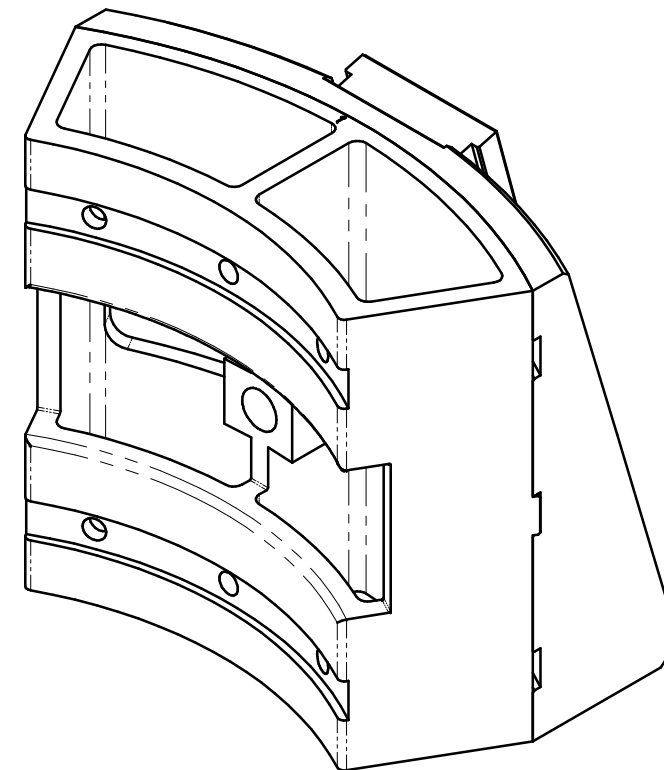
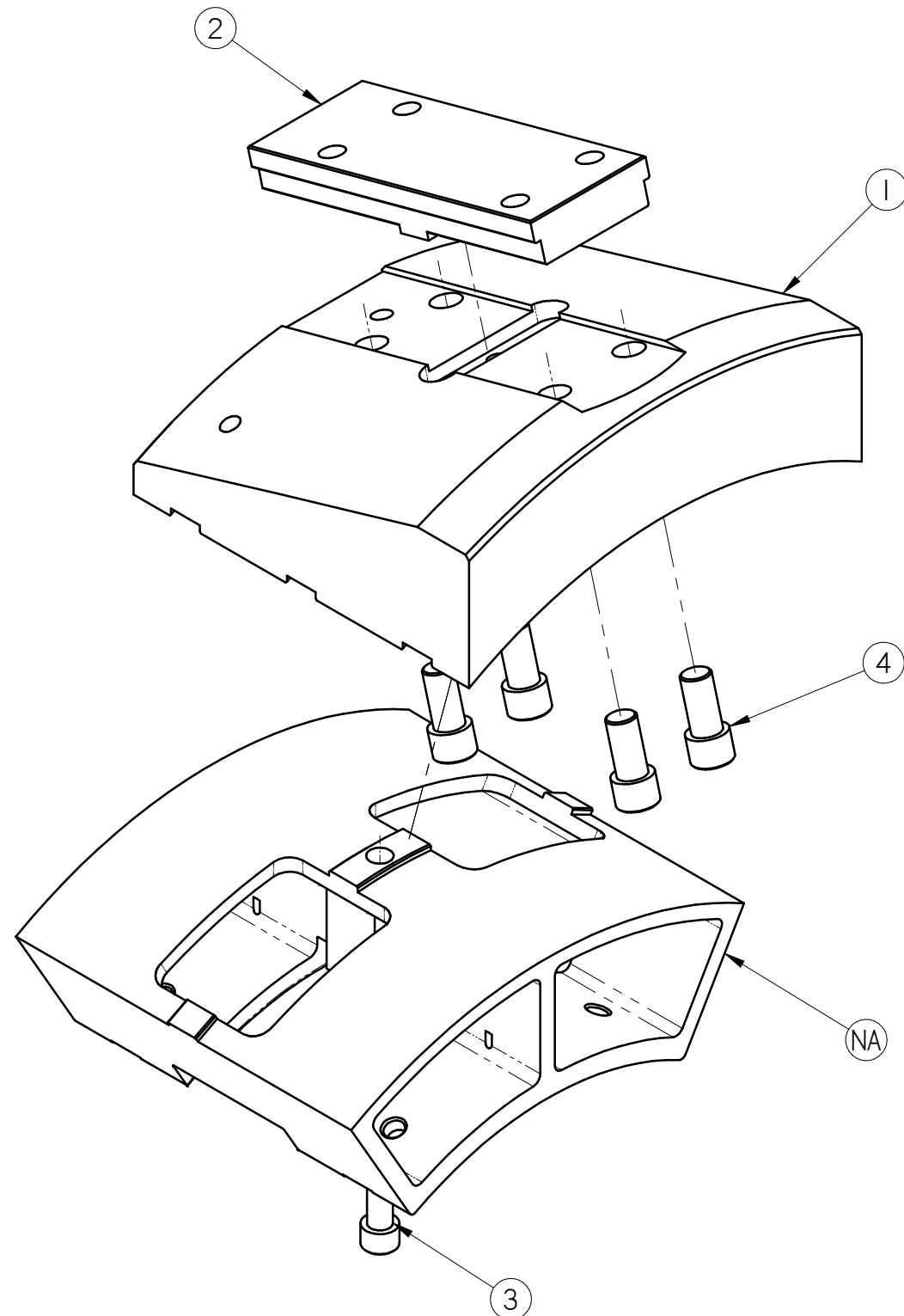
REV.
NC

COUNTERSINK BOTTOM OF COUNTERBORE
BREAK ALL SHARP EDGES, NO BURRS ALLOWED
ALL DATUMS TO BE \angle , L, //

SIZE
D DO NOT SCALE

SHEET
SHEET 2 OF 3

REV	DESCRIPTION	DATE	APP
01	CALLOUT WITHOUT JAWS	7/6/21	JW



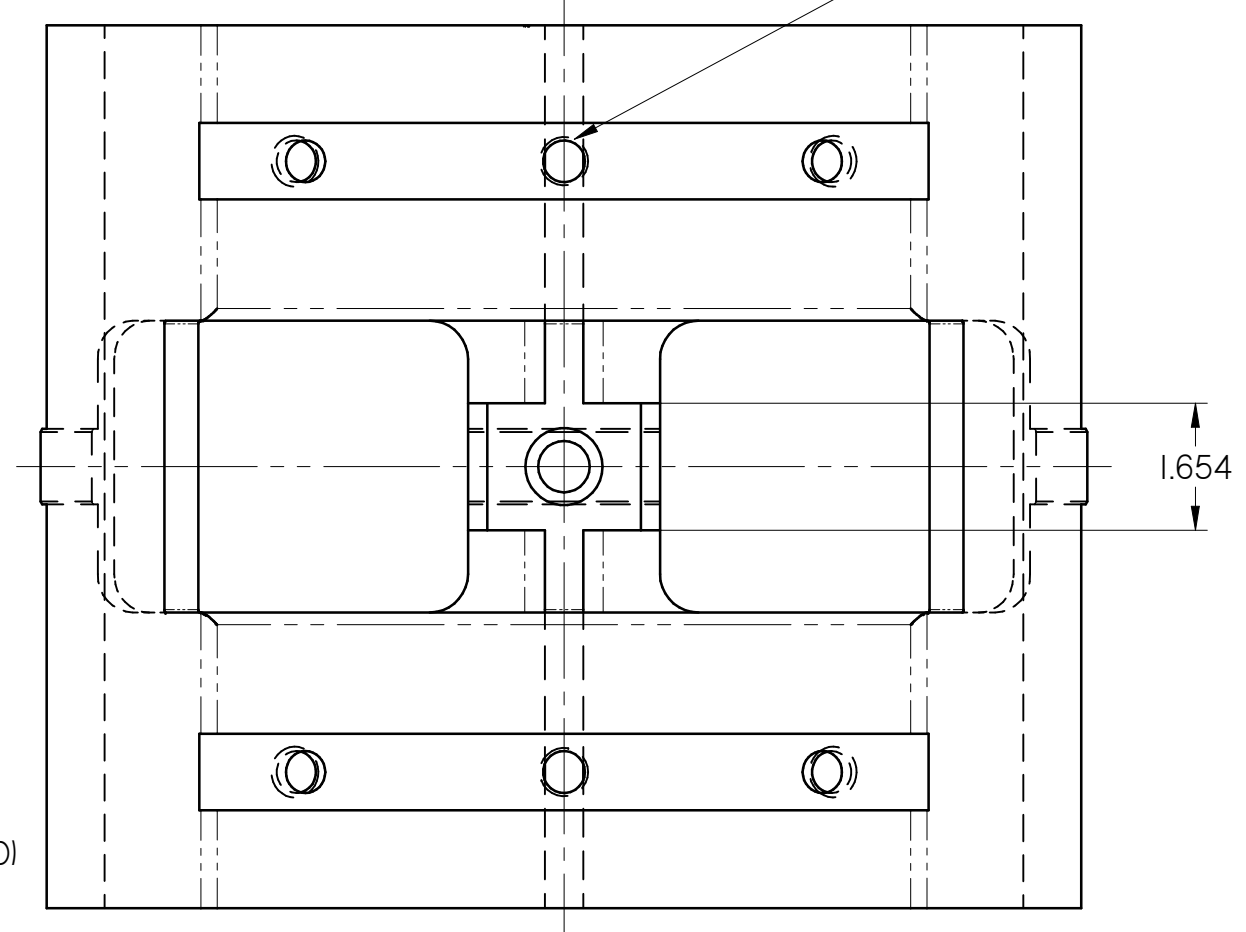
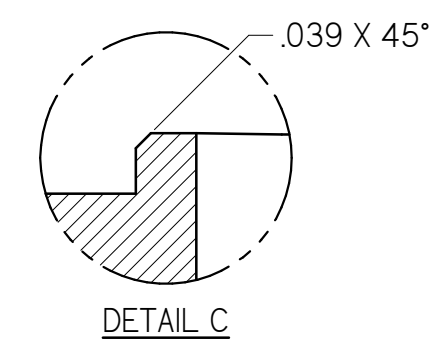
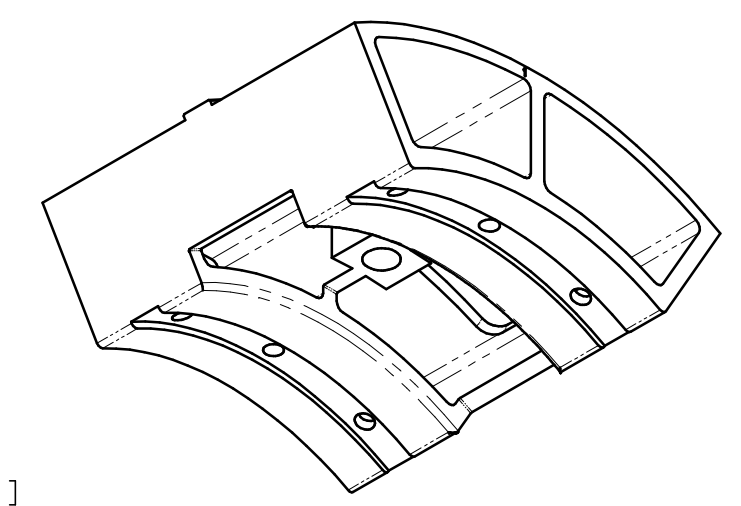
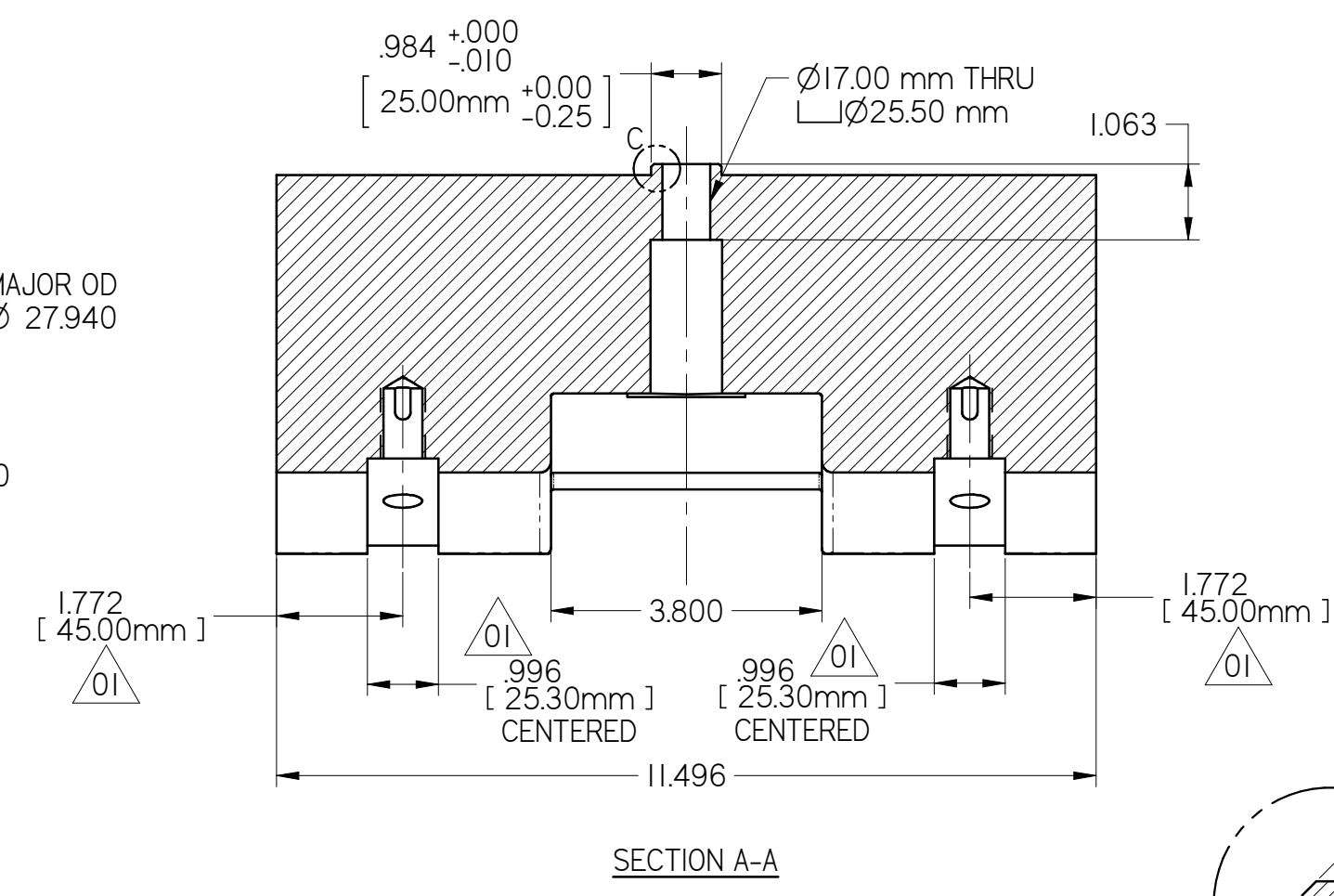
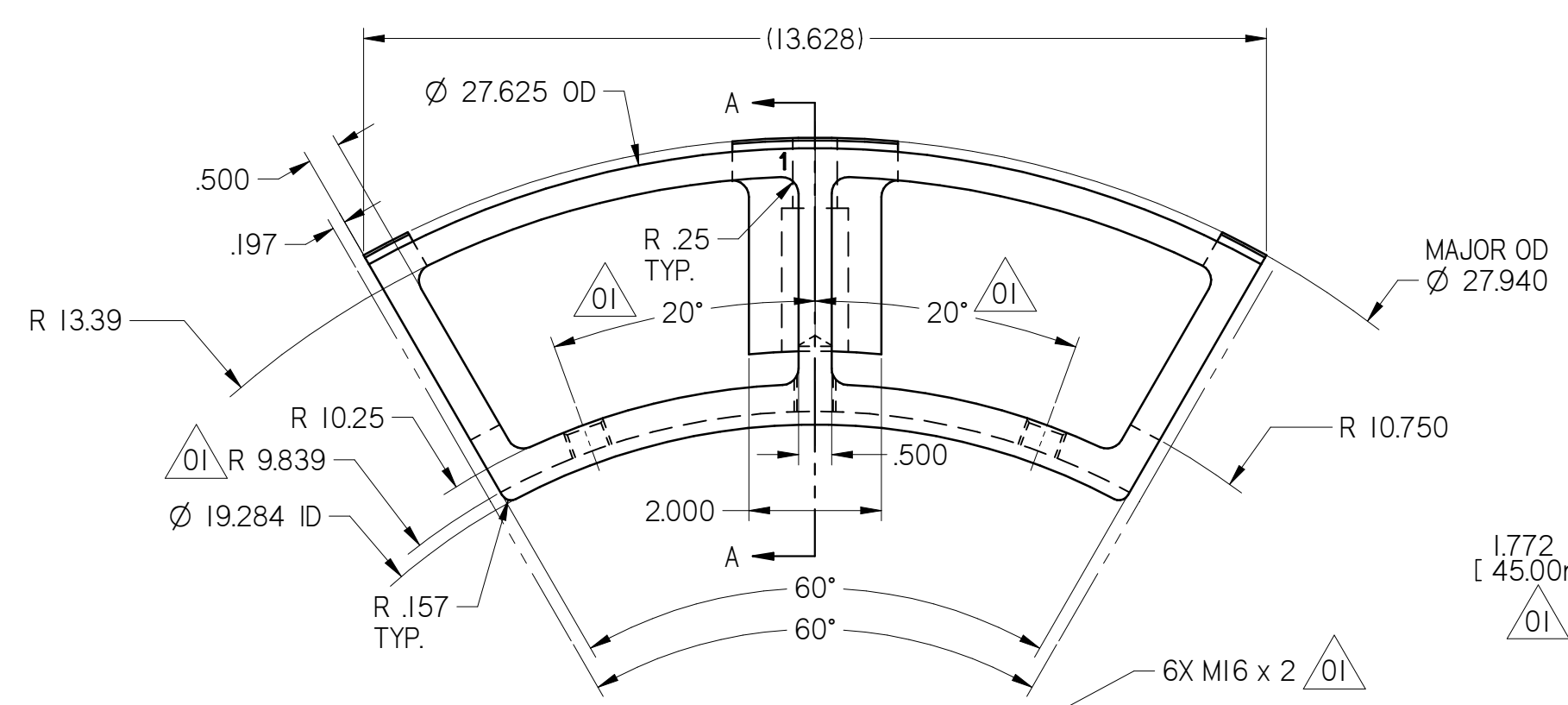
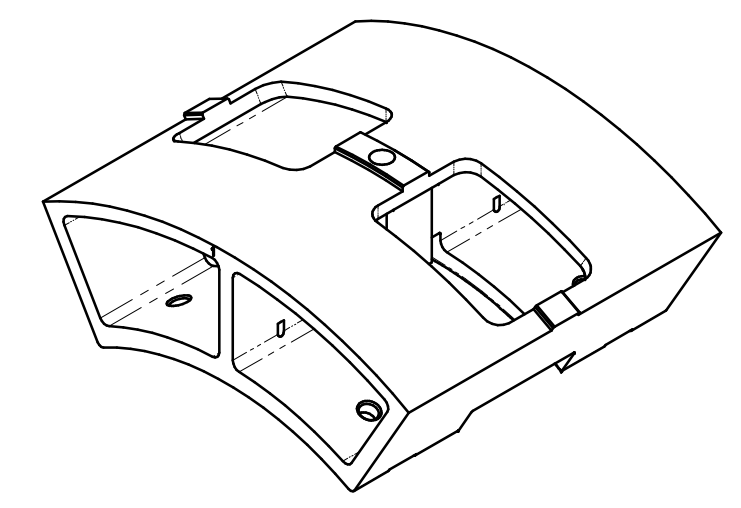
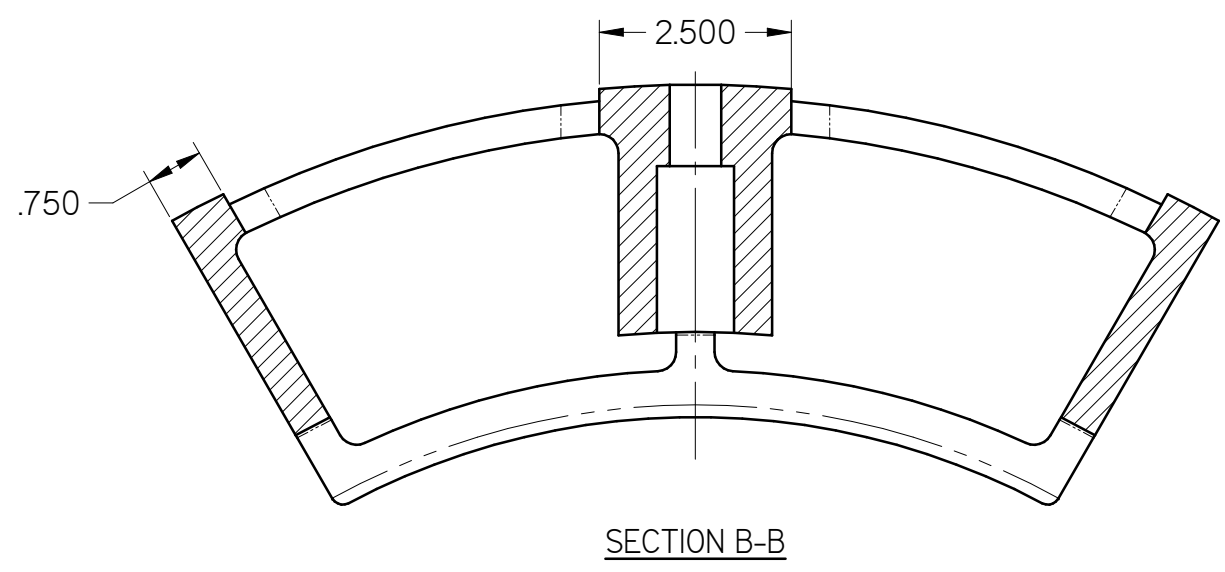
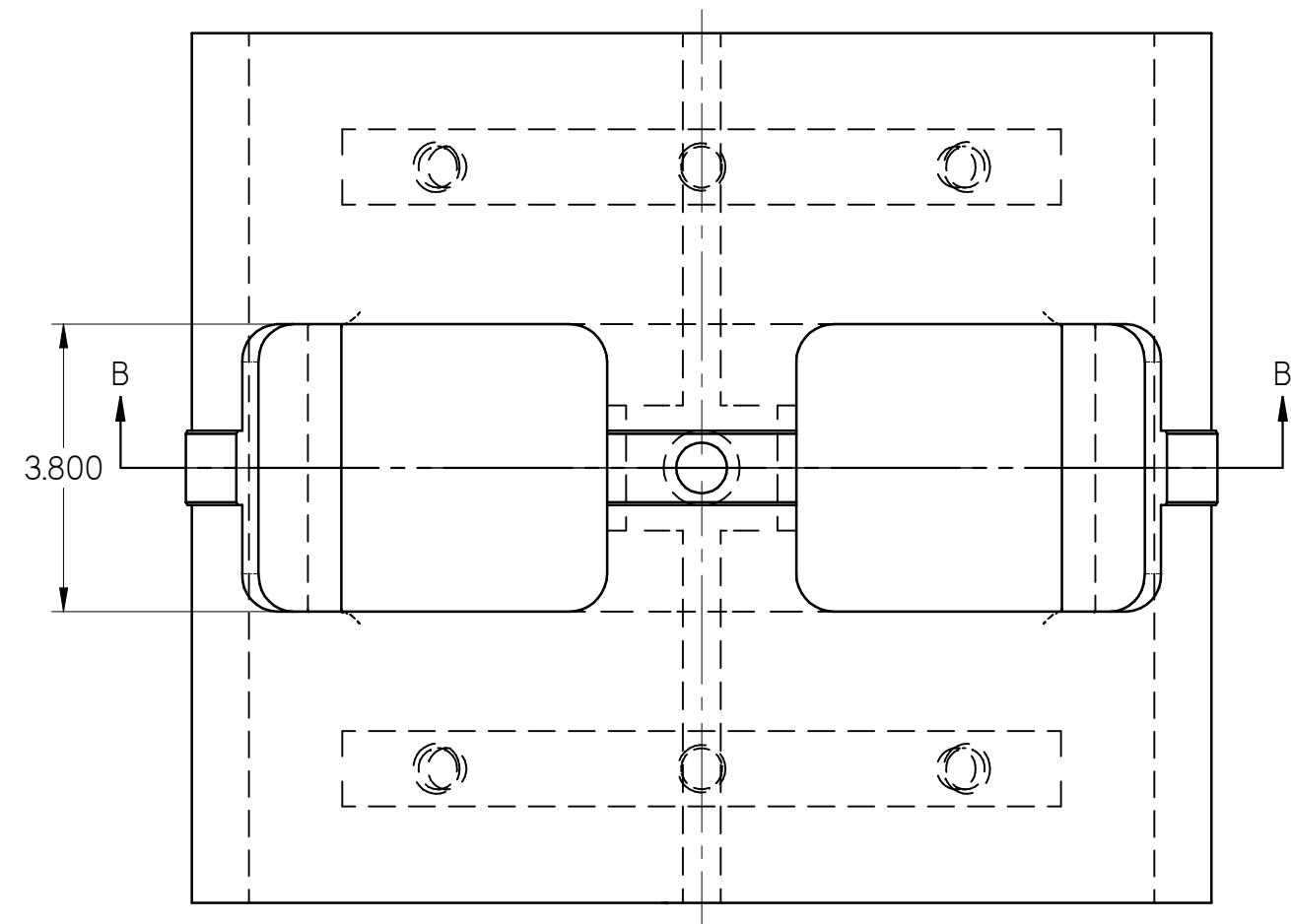
Item #	Qty	Rev	Document Number	Title	Comments
1	1	NC	21-020-P007-02	MASTER JAW- CHUCK	
2	1	NC	21-020-P008-01	T-BLOCK- CHUCK	
3	1		SHCS M16-2.00 X 50	SHCS	ZINC PLATED G 12.9
4	4		SHCS M20-2.5 X 40	SHCS	ZINC PLATED G 12.9

MACHINE #	M21	DATE	
DRAWN BY:	perc	03/18/21	
ENG. BY:	PC		
APP. BY:	CL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
INCH		METRIC	
.0	±.1	0.	± 2.5mm
.00	±.03	.0	±.75mm
.000	±.010	.00	±.25mm
ANGLES	± 30°	ANGLES	± 30°
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel			
:Title			REV.
MASTER JAW ASSY			01
Drawing No.		SHEET	
21-020-A003-03		SHEET 1 OF 1	
SIZE	DO NOT SCALE		
B			



15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649

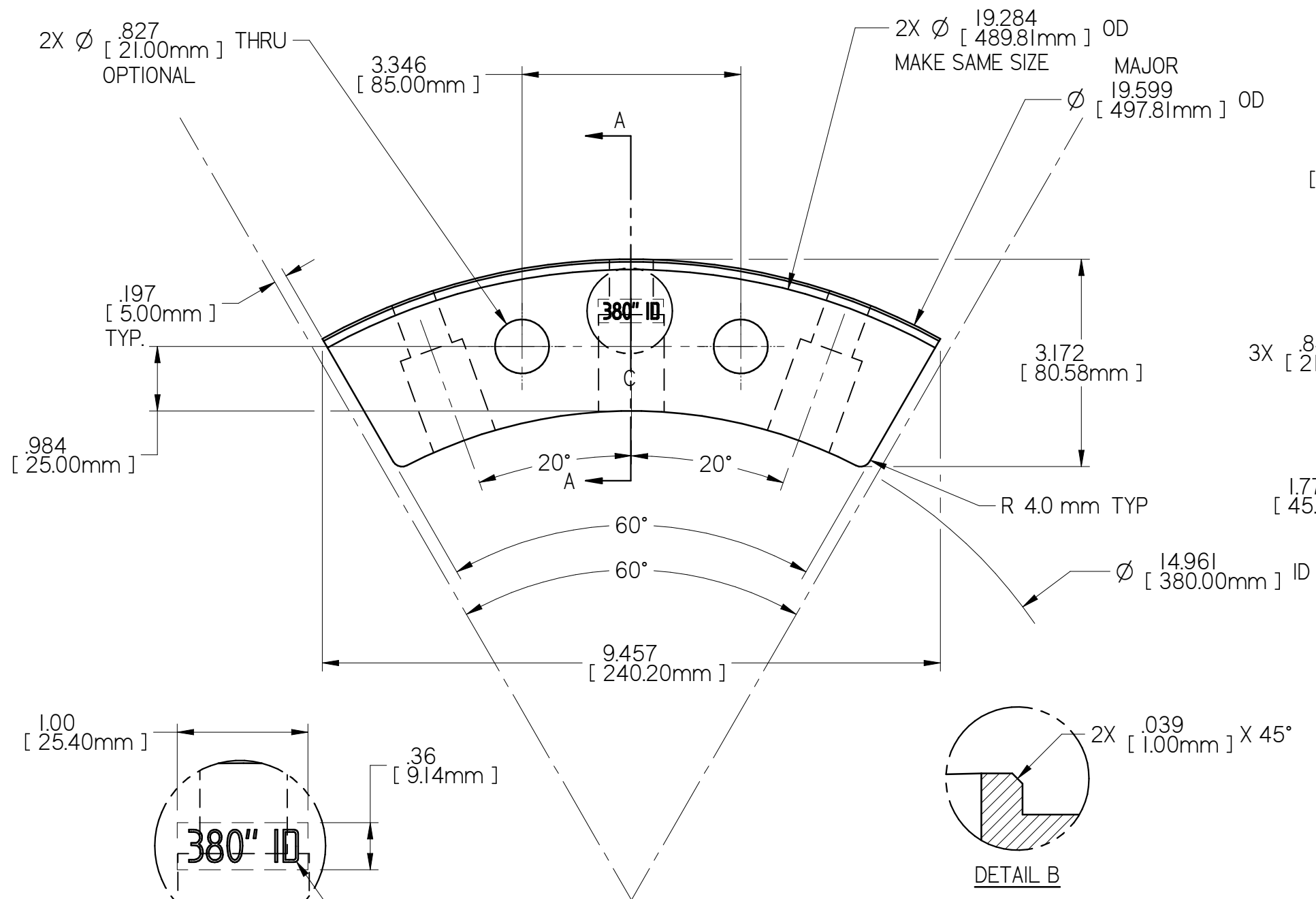
REV	DESCRIPTION	DATE	APP
01	ADDED 2 GROOVES AND 6 HOLES	11-24-21	PC



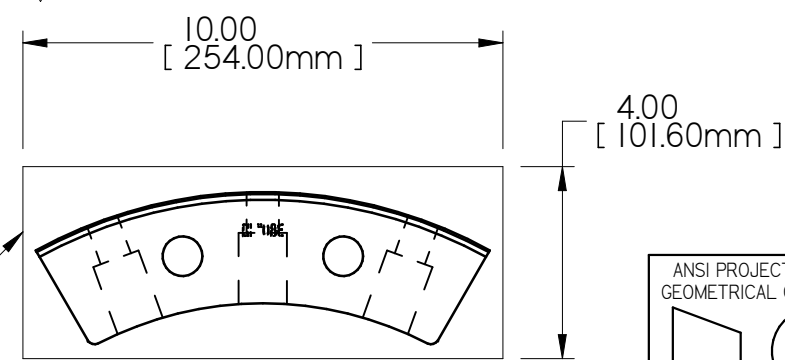
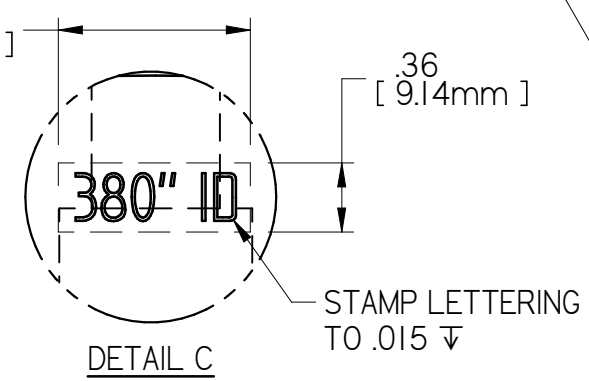
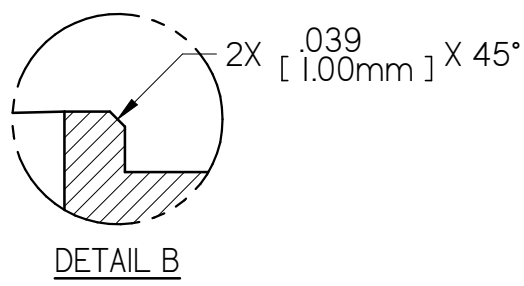
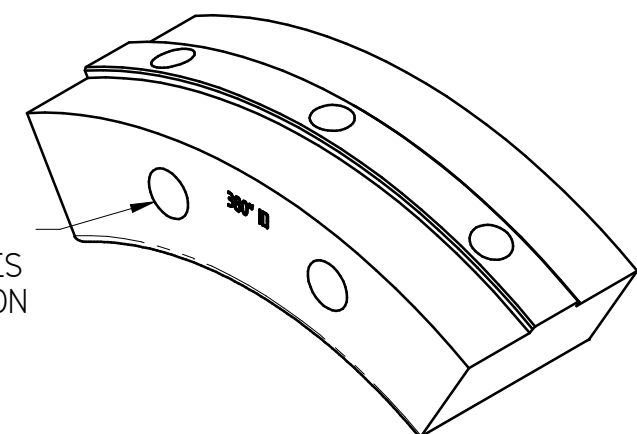
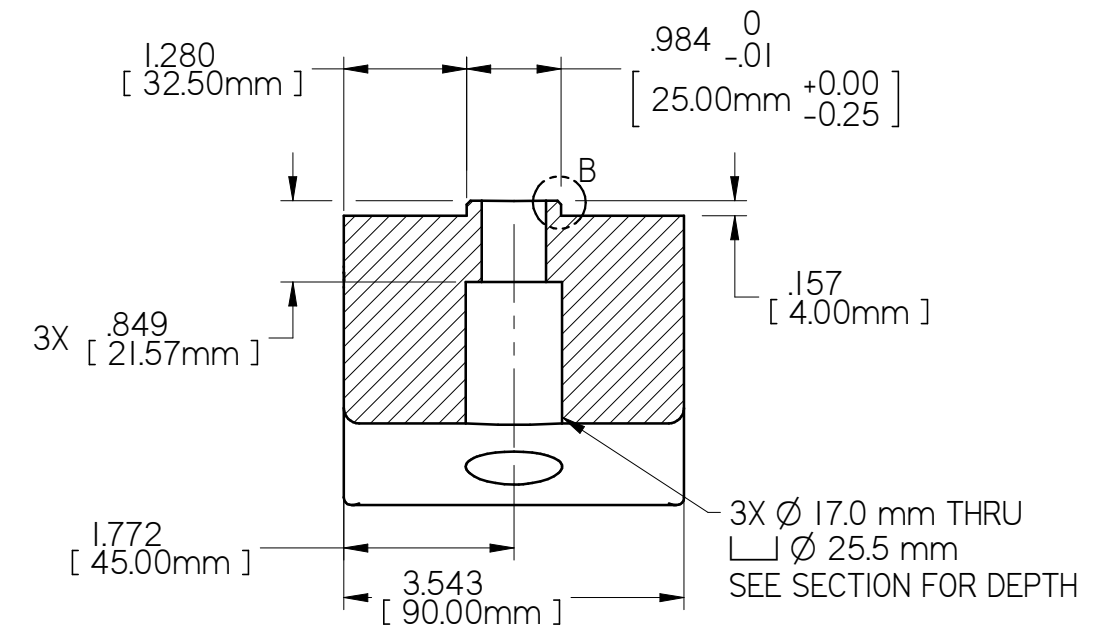
NOTE: (UNLESS OTHERWISE SPECIFIED)
 LAST UPDATED 11/24/2021
 TOTAL WEIGHT = 14.9 lbm
 1 - KELLER MILLED
 2 - STAMP ID SIZE APPROX. WHERE SHOWN.

MATERIAL:	Aluminum, 6061-T6	MACHINE #	M21	DATE	03/18/21	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649	Title 19.284" JAW																																			
DRAWN BY:	JerryW	ENG. BY:	PC	APP. BY:	CL			Drawing. No. 21-020-P009-02	REV. 01																																	
TREATMENT:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	<table border="1"> <tr> <th colspan="2">INCH</th> <th colspan="2">METRIC</th> </tr> <tr> <td>.0</td> <td>± .1</td> <td>0.</td> <td>± 2.5mm</td> </tr> <tr> <td>.00</td> <td>± .03</td> <td>.0</td> <td>± .75mm</td> </tr> <tr> <td>.000</td> <td>± .010</td> <td>.00</td> <td>± .25mm</td> </tr> <tr> <td>ANGLES</td> <td>± 30'</td> <td>ANGLES</td> <td>± 30'</td> </tr> <tr> <td>FRACTIONS</td> <td>± 1/16</td> <td>FRACTIONS</td> <td>NA</td> </tr> <tr> <td>FLAME CUT</td> <td>± 1/8</td> <td>FLAME CUT</td> <td>± 3mm</td> </tr> <tr> <td>WELDMENTS</td> <td>± 1/8</td> <td>WELDMENTS</td> <td>± 3mm</td> </tr> </table>								INCH		METRIC		.0	± .1	0.	± 2.5mm	.00	± .03	.0	± .75mm	.000	± .010	.00	± .25mm	ANGLES	± 30'	ANGLES	± 30'	FRACTIONS	± 1/16	FRACTIONS	NA	FLAME CUT	± 1/8	FLAME CUT	± 3mm	WELDMENTS	± 1/8	WELDMENTS	± 3mm	SIZE C
INCH		METRIC																																								
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.00	± .03	.0	± .75mm																																							
.000	± .010	.00	± .25mm																																							
ANGLES	± 30'	ANGLES	± 30'																																							
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FLAME CUT	± 1/8	FLAME CUT	± 3mm																																							
WELDMENTS	± 1/8	WELDMENTS	± 3mm																																							
FINISH:	COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel $\frac{1}{25}$ OR BETTER ON ALL MACHINED SURFACES	6	EACH MACHINE																																							

REV	DESCRIPTION	DATE	APP

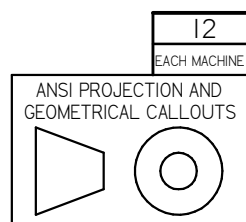


SECTION A-A

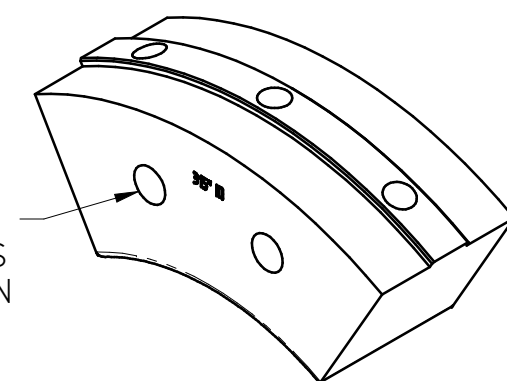
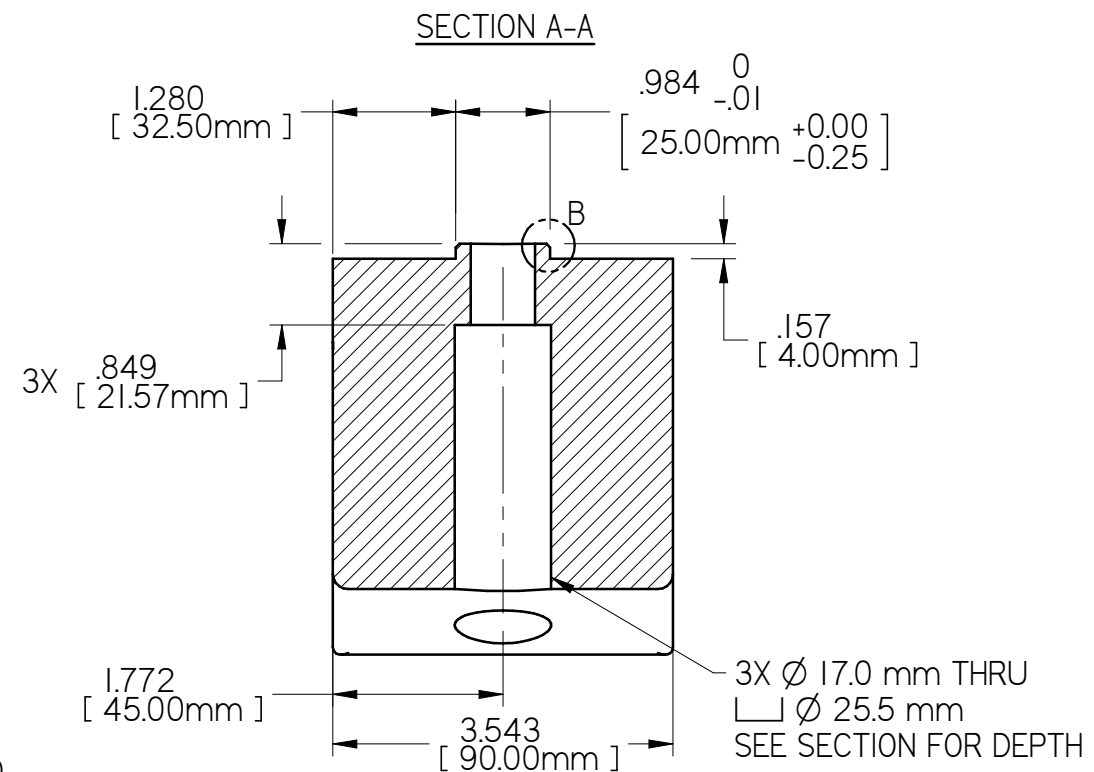
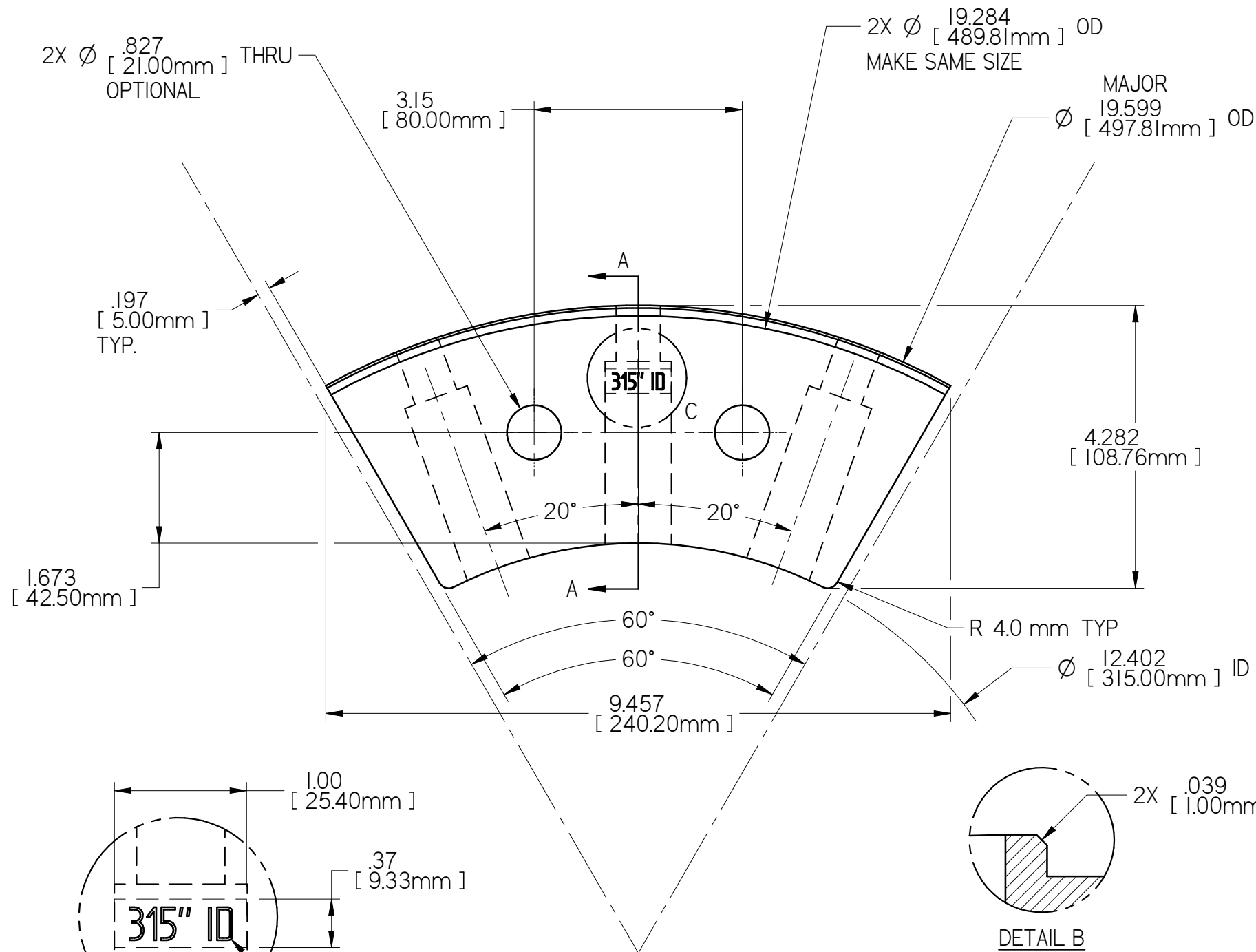


NOTE: (UNLESS OTHERWISE SPECIFIED)
 LAST UPDATED 12/15/2021
 TOTAL WEIGHT = 5.8 lbm
 1 - KELLER MILLED
 2- STAMP ID SIZE APPROX. WHERE SHOWN

MATERIAL: Aluminum, 6061-T6	MACHINE # M21	DATE 11/24/21	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649																															
TREATMENT:	DRAWN BY: albert	APP. BY: CL																																
FINISH:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES:																																	
	<table border="1"> <thead> <tr> <th>INCH</th> <th>METRIC</th> </tr> </thead> <tbody> <tr> <td>.0</td> <td>±.1</td> </tr> <tr> <td>.00</td> <td>±.03</td> </tr> <tr> <td>.000</td> <td>±.010</td> </tr> <tr> <td>ANGLES</td> <td>± 30'</td> </tr> <tr> <td>FRACTIONS</td> <td>± 1/16</td> </tr> <tr> <td>FLAME CUT</td> <td>± 1/8</td> </tr> <tr> <td>WELDMENTS</td> <td>± 1/8</td> </tr> </tbody> </table>	INCH		METRIC	.0	±.1	.00	±.03	.000	±.010	ANGLES	± 30'	FRACTIONS	± 1/16	FLAME CUT	± 1/8	WELDMENTS	± 1/8	<table border="1"> <thead> <tr> <th>METRIC</th> <th>INCHES</th> </tr> </thead> <tbody> <tr> <td>± 2.5mm</td> <td>0.</td> </tr> <tr> <td>± .75mm</td> <td>.00</td> </tr> <tr> <td>± .25mm</td> <td>.00</td> </tr> <tr> <td>± 30'</td> <td>± 30'</td> </tr> <tr> <td>NA</td> <td>NA</td> </tr> <tr> <td>± 3mm</td> <td>± 3mm</td> </tr> <tr> <td>± 3mm</td> <td>± 3mm</td> </tr> </tbody> </table>	METRIC	INCHES	± 2.5mm	0.	± .75mm	.00	± .25mm	.00	± 30'	± 30'	NA	NA	± 3mm	± 3mm	± 3mm
INCH	METRIC																																	
.0	±.1																																	
.00	±.03																																	
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METRIC	INCHES																																	
± 2.5mm	0.																																	
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± 30'	± 30'																																	
NA	NA																																	
± 3mm	± 3mm																																	
± 3mm	± 3mm																																	
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel $\sqrt{}$ OR BETTER ON ALL MACHINED SURFACES			Title 380MM" JAW																															
Drawing No. 21-020-P010-02		REV. 01	SHEET SHEET 1 OF 1																															
SIZE B	DO NOT SCALE																																	



REV	DESCRIPTION	DATE	APP



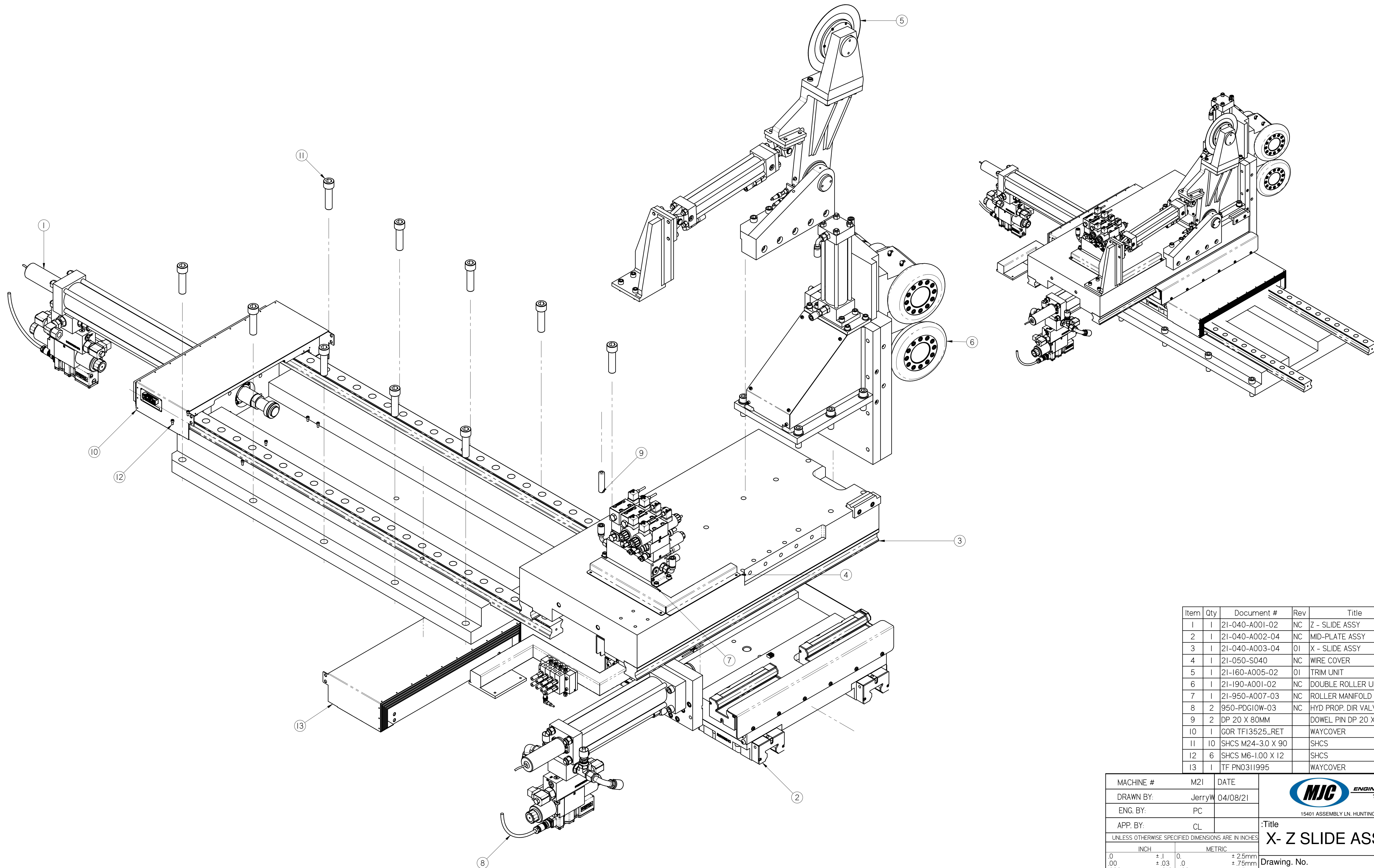
NOTE: (UNLESS OTHERWISE SPECIFIED)
 LAST UPDATED 11/29/2021
 TOTAL WEIGHT = 8.5 lbm
 1 - KELLER MILLED
 2- STAMP ID SIZE APPROX. WHERE SHOWN

MAKE FROM RECT. BLOCK

12 EACH MACHINE

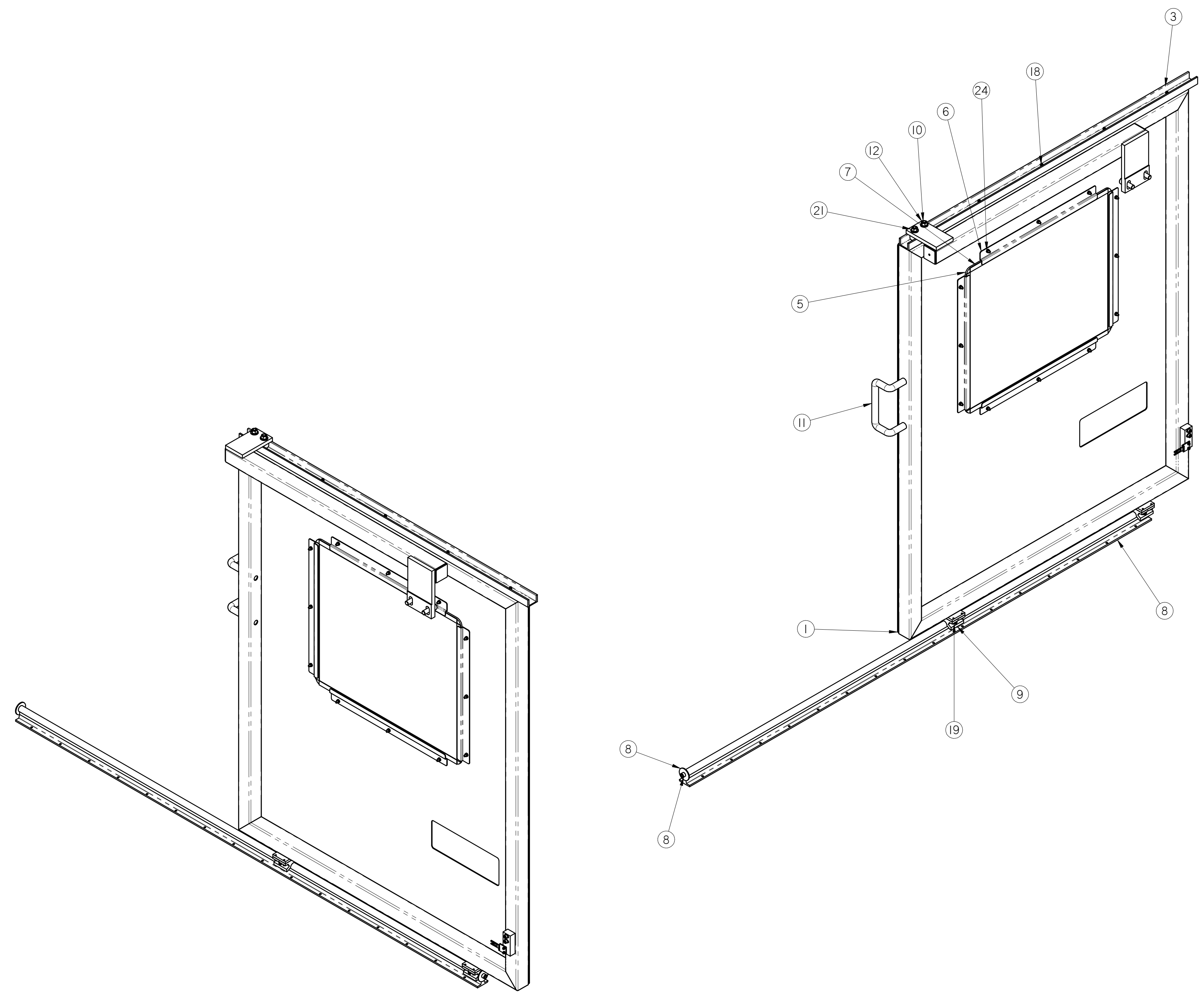
ANSI PROJECTION AND GEOMETRICAL CALLOUTS

MATERIAL:	Aluminum, 6061-T6	MACHINE #	M21	DATE	11/29/21	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649	Title 315MM" JAW																																
DRAWN BY:	alberto	ENG. BY:	PC	APP. BY:	CL			Drawing. No.	REV.																														
TREATMENT:		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES						21-020-P013-02	01																														
FINISH:		<table border="1"> <thead> <tr> <th colspan="2">INCH</th> <th colspan="2">METRIC</th> </tr> </thead> <tbody> <tr> <td>.0</td> <td>\pm .1</td> <td>0</td> <td>\pm 2.5mm</td> </tr> <tr> <td>.00</td> <td>\pm .03</td> <td>.0</td> <td>\pm .75mm</td> </tr> <tr> <td>.000</td> <td>\pm .010</td> <td>.00</td> <td>\pm .25mm</td> </tr> <tr> <td>ANGLES</td> <td>\pm 30'</td> <td>ANGLES</td> <td>\pm 30'</td> </tr> <tr> <td>FRACTIONS</td> <td>\pm 1/16</td> <td>FRACTIONS</td> <td>NA</td> </tr> <tr> <td>FLAME CUT</td> <td>\pm 1/8</td> <td>FLAME CUT</td> <td>\pm 3mm</td> </tr> <tr> <td>WELDMENTS</td> <td>\pm 1/8</td> <td>WELDMENTS</td> <td>\pm 3mm</td> </tr> </tbody> </table>						INCH		METRIC		.0	\pm .1	0	\pm 2.5mm	.00	\pm .03	.0	\pm .75mm	.000	\pm .010	.00	\pm .25mm	ANGLES	\pm 30'	ANGLES	\pm 30'	FRACTIONS	\pm 1/16	FRACTIONS	NA	FLAME CUT	\pm 1/8	FLAME CUT	\pm 3mm	WELDMENTS	\pm 1/8	WELDMENTS	\pm 3mm
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WELDMENTS	\pm 1/8	WELDMENTS	\pm 3mm																																				
						B	DO NOT SCALE	1 OF 1																															



Item	Qty	Document #	Rev	Title	Material
1	1	21-040-A001-02	NC	Z - SLIDE ASSY	
2	1	21-040-A002-04	NC	MID-PLATE ASSY	
3	1	21-040-A003-04	01	X - SLIDE ASSY	
4	1	21-050-S040	NC	WIRE COVER	14 GAUGE STEEL
5	1	21-160-A005-02	01	TRIM UNIT	
6	1	21-190-A001-02	NC	DOUBLE ROLLER UNIT	
7	1	21-950-A007-03	NC	ROLLER MANIFOLD	
8	2	950-PDG10W-03	NC	HYD PROP. DIR VALVE	
9	2	DP 20 X 80MM		DOWEL PIN DP 20 X 80MM	Steel
10	1	GOR TF13525_RET		WAYCOVER	
11	10	SHCS M24-3.0 X 90		SHCS	GRADE 12.9
12	6	SHCS M6-1.00 X 12		SHCS	Steel
13	1	TF PN0311995		WAYCOVER	

MACHINE #	M21	DATE																																	
DRAWN BY:	JerryW	04/08/21																																	
ENG. BY:	PC																																		
APP. BY:	CL																																		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649																																
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COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \angle , \perp , \parallel			Drawing. No. 21-040-A000-04																																
SIZE D		DO NOT SCALE	SHEET 1 OF 1																																



Item Number	Quantity	Document Number	Rev	Title	Comments
1	1	21-050-A004-01	01	DOOR WELDMENT	
2'	1	21-050-A005	NC	DOOR BRACKET	
3	1	21-050-P001	NC	U-CHANNEL	MMC 1630T47 5 FT AL
4'	1	21-050-P007-01	NC	BRACKET, DOOR LOCK	
5	1	21-050-P008	NC	SAFETY GLASS	TEMPERED GLASS
6	4	21-050-S023	NC	GLASS RETAINER	
7	1	CORK GASKET		.062 x .750	MMC 94545K37 -100'
8	1	LEE SA-16 96"LG ES16x2		BEARING RAIL ASSY, -16, CTL 96", Y=3", W/ END STOPS	
9	2	LEE SPB-16-OPN		PILLOW BLOCK	LEE LINEAR 1 INCH
10	2	MMC 3647K16		CAM ROLLER, ECCENTRIC, 1-3/8	
11	1	MMC 5245A9		HANDLE, 90 DEGREE OFFSET, 8", ALU	
12	2	NUT H .500-20		HEX NUT	ZINC PLATED HEX NUT .500-20
13'	12	NUT H M6-1		NUT	
14'	1	SCHM TZ/CO		DOOR KEY	
15"	2	SHCS .250-20 X .750		SHCS	ZINC PLATED
16"	2	SHCS M16-2.00 X 45		SHCS	ZINC PLATED G 12.9
17"	2	SHCS M4-.70 X 14		SHCS	ZINC PLATED G 12.9
18	10	SHCS M5-.80 X 12		SHCS	ZINC PLATED G 12.9
19	8	SHCS M5-.80 X 15		SHCS	ZINC PLATED G 12.9
20"	2	SHCS M8-1.25 X 30		SHCS	ZINC PLATED G 12.9
21	2	WASHER .500		WASHER	ZINC PLATED G 12.9
22"	2	WASHER M16		WASHER	ZINC PLATED G 12.9
23"	10	WASHER M5		WASHER	ZINC PLATED G 12.9
24	12	WASHER M6		WASHER	ZINC PLATED G 12.9
25"	2	WASHER M8		WASHER	ZINC PLATED G 12.9

MACHINE # M21 DATE
 DRAWN BY: JerryW 03/18/21
 ENG. BY: PC
 APP. BY: CL



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

INCH		METRIC	
0	± .1	0	± 2.5mm
.00	± .03	.0	± .75mm
.000	± .010	.00	± .25mm
ANGLES	± 30'	ANGLES	± 30'
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm

COUNTERSINK BOTTOM OF COUNTERBORE
 BREAK ALL SHARP EDGES, NO BURRS ALLOWED
 ALL DATUMS TO BE Z7, L, //

Title
DOOR ASSY

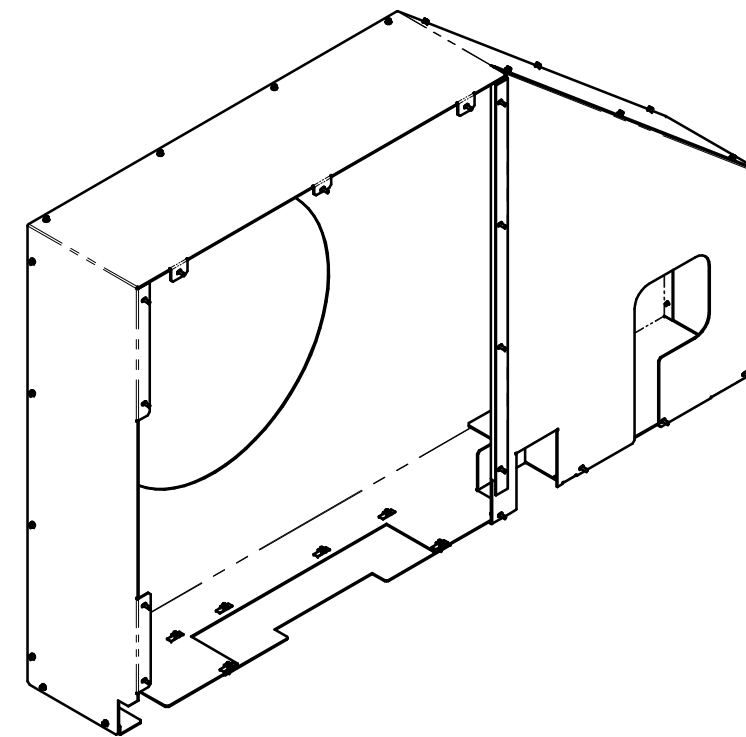
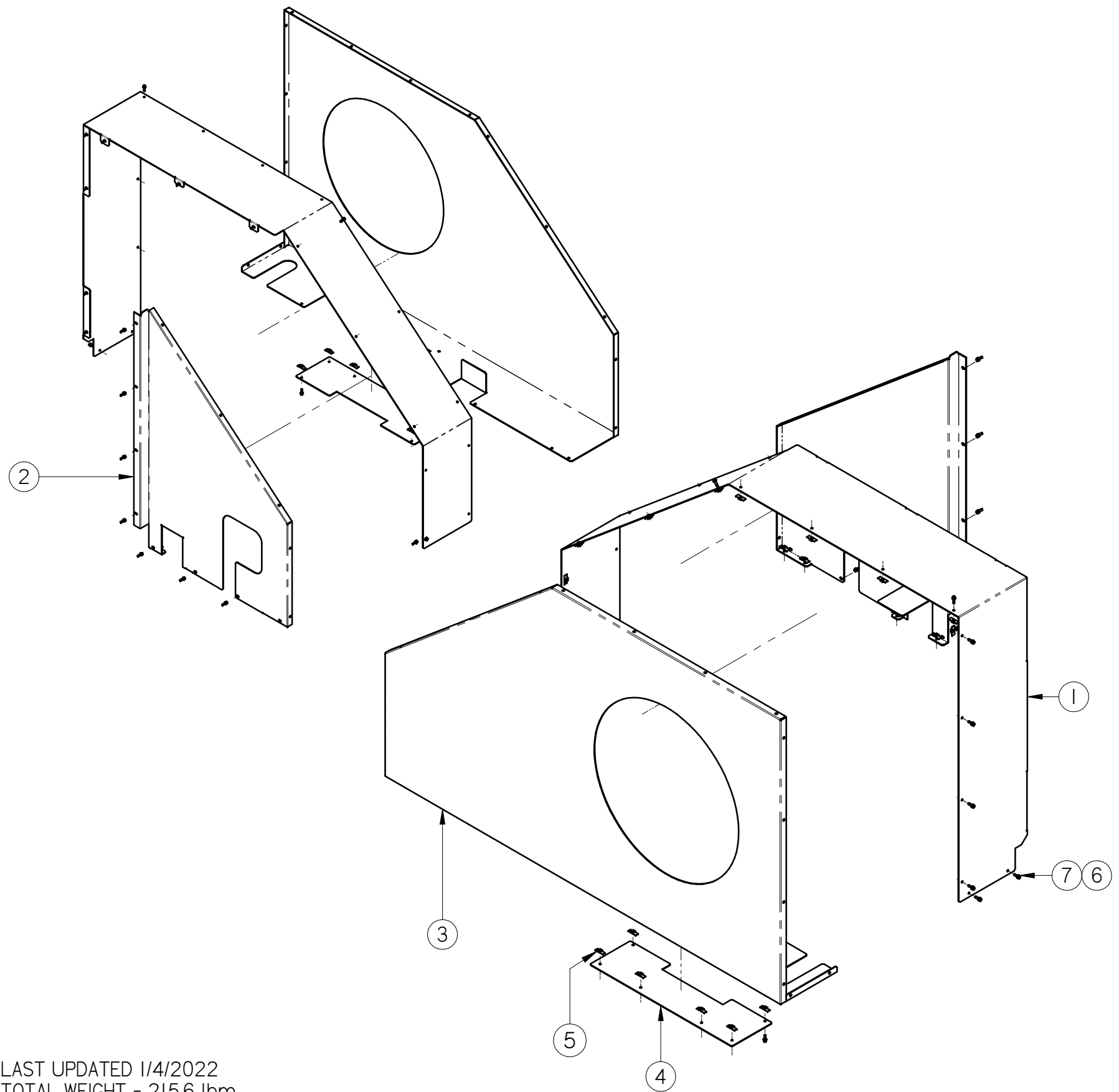
Drawing. No.
21-050-A001-03

REV. 01

SIZE D DO NOT SCALE SHEET 1 OF 1

1
 EACH MACHINE

REV	DESCRIPTION	DATE	APP
NC			



Item	Qty	Document #	Rev	Title	Comments
1	1	21-050-S020-01	01	OUTER COVER	
2	1	21-050-S021-01	01	INNER COVER	
3	1	21-050-S022-01	NC	FRONT COVER	
4	1	21-050-S024	NC	BELT COVER DOOR	
5	30	NUT W M6-1 RETAINER		WELD NUT	MMC# 90955A101
6	45	SHCS M6-1.00 X 20		SHCS	ZINC PLATED G 12.9
7	45	WASHER M6		WASHER	ZINC PLATED G 12.9

MACHINE #	M21	DATE	
DRAWN BY:	kaif	03/18/21	
ENG. BY:	PC		
APP. BY:	CL		



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

21-000-A001-05	1
BELONGS TO	EACH MACHINE
ANSI PROJECTION AND GEOMETRICAL CALLOUTS	

INCH		METRIC	
.0	±.1	0.	± 2.5mm
.00	±.03	.0	±.75mm
.000	±.010	.00	±.25mm
ANGLES	± 30'	ANGLES	± 30'
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm

COUNTERSINK BOTTOM OF COUNTERBORE
BREAK ALL SHARP EDGES, NO BURRS ALLOWED
R25 OR BETTER ON ALL MACHINED SURFACES

Title
BELT COVER

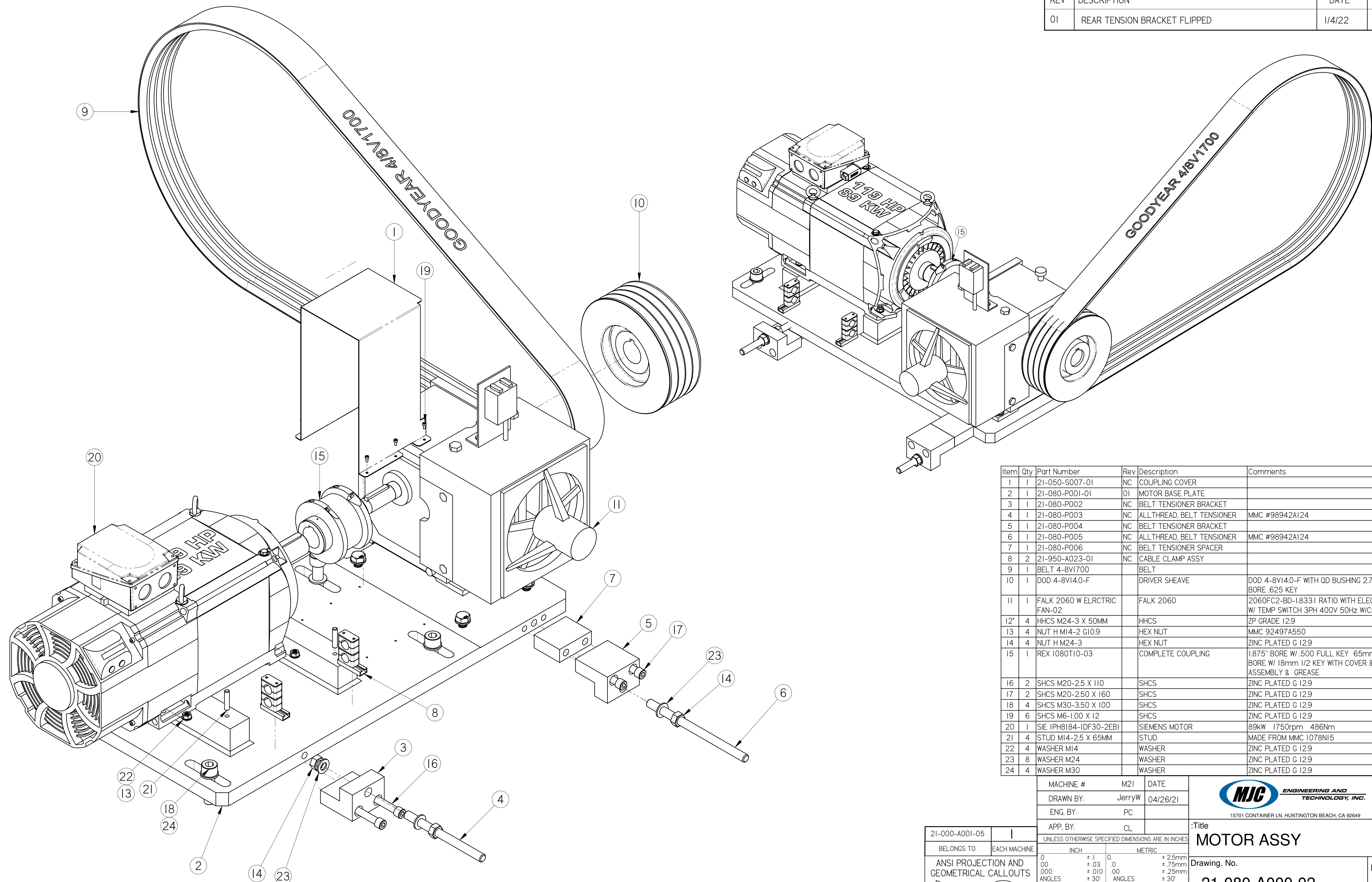
Drawing No.
21-050-A002-02

REV. 01

SIZE B DO NOT SCALE SHEET SHEET 1 OF 1

LAST UPDATED 1/4/2022
TOTAL WEIGHT = 215.6 lbm

REV	DESCRIPTION	DATE	APP
01	REAR TENSION BRACKET FLIPPED	1/4/22	DR



Item	Qty	Part Number	Rev	Description	Comments
1	1	21-050-S007-01	NC	COUPLING COVER	
2	1	21-080-P001-01	01	MOTOR BASE PLATE	
3	1	21-080-P002	NC	BELT TENSIONER BRACKET	
4	1	21-080-P003	NC	ALLTHREAD, BELT TENSIONER	MMC #98942A124
5	1	21-080-P004	NC	BELT TENSIONER BRACKET	
6	1	21-080-P005	NC	ALLTHREAD, BELT TENSIONER	MMC #98942A124
7	1	21-080-P006	NC	BELT TENSIONER SPACER	
8	2	21-950-A023-01	NC	CABLE CLAMP ASSY	
9	1	BELT 4-8V1700		BELT	
10	1	DOD 4-8V14.0-F		DRIVER SHEAVE	DOD 4-8V14.0-F WITH OD BUSHING 2.750 BORE .625 KEY
11	1	FALK 2060 W ELRCTRIC FAN-02		FALK 2060	2060FC2-BD-1.833:1 RATIO WITH ELECT FAN W/ TEMP SWITCH 3PH 400V 50Hz WICE
12	4	HHCS M24-3 X 50MM		HHCS	ZP GRADE I2.9
13	4	NUT H M14-2 G10.9		HEX NUT	MMC 92497A550
14	4	NUT H M24-3		HEX NUT	ZINC PLATED G 12.9
15	1	REX 1080T10-03		COMPLETE COUPLING	1.875" BORE W/ .500 FULL KEY .65mm BORE W/ 18mm 1/2 KEY WITH COVER & GRID ASSEMBLY & GREASE
16	2	SHCS M20-2.5 X 110		SHCS	ZINC PLATED G 12.9
17	2	SHCS M20-2.50 X 160		SHCS	ZINC PLATED G 12.9
18	4	SHCS M30-3.50 X 100		SHCS	ZINC PLATED G 12.9
19	6	SHCS M6-1.00 X 12		SHCS	ZINC PLATED G 12.9
20	1	SIE IPH8184-IDF30-2EB1		SIEMENS MOTOR	89kW 1750rpm 486Nm
21	4	STUD M14-2.5 X 65MM		STUD	MADE FROM MMC 1078N15
22	4	WASHER M14		WASHER	ZINC PLATED G 12.9
23	8	WASHER M24		WASHER	ZINC PLATED G 12.9
24	4	WASHER M30		WASHER	ZINC PLATED G 12.9

MACHINE #	M21	DATE	
DRAWN BY:	JerryW	04/26/21	
ENG. BY:	PC		
APP. BY:	CL		

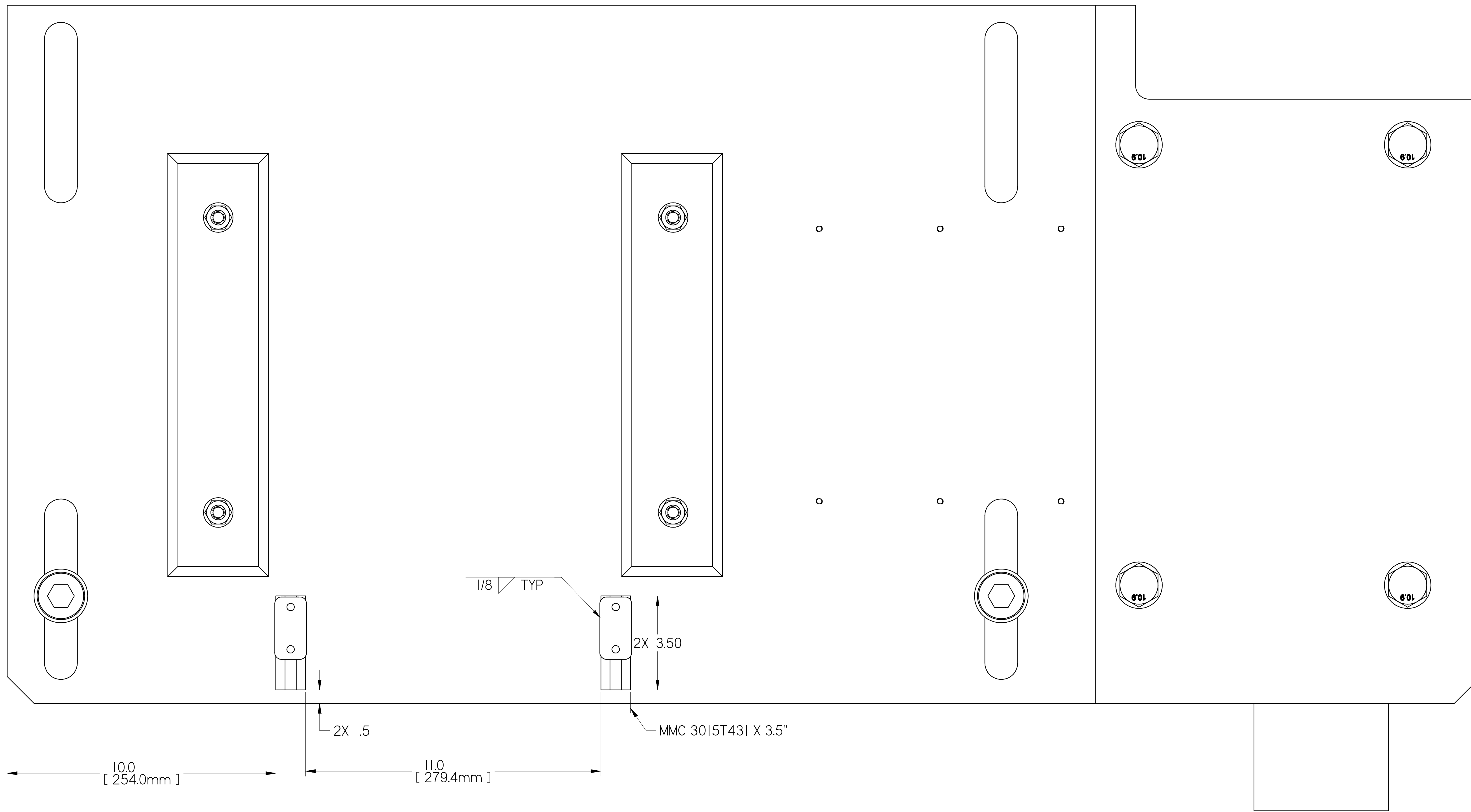


21-000-A001-05	1
BELONGS TO	EACH MACHINE
ANSI PROJECTION AND GEOMETRICAL CALLOUTS	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
INCH	METRIC
0	± 2.5mm
.00	± .03
.000	± .010
ANGLES	± 30'
FRACTIONS	± 1/16
FLAME CUT	± 1/8
WELDMENTS	± 1/8
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE Z7, L, //	

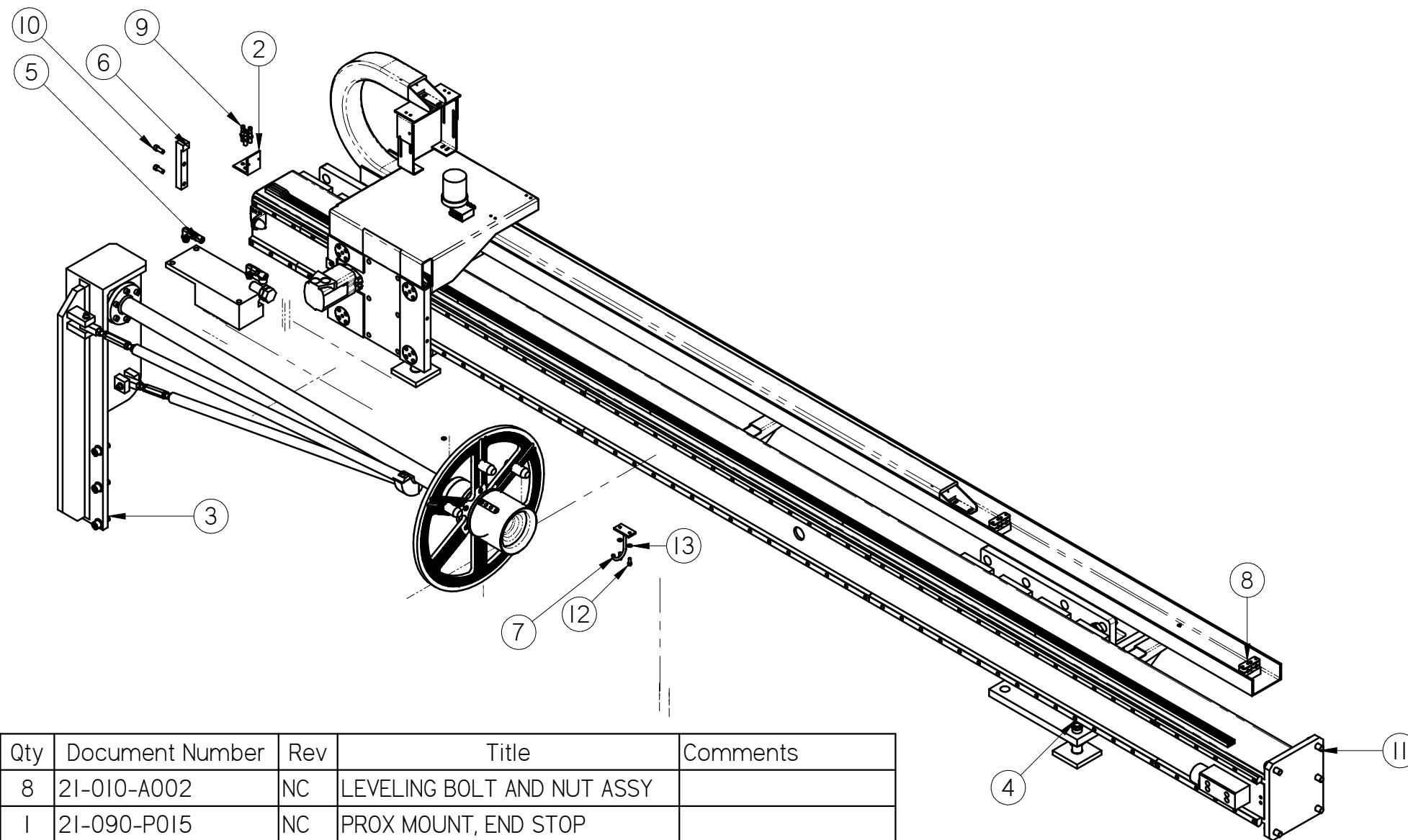
Title		
MOTOR ASSY		
Drawing No.		REV.
21-080-A000-02		01
SIZE	DO NOT SCALE	SHEET
D		SHEET 1 OF 2

SEE PAGE 2 FOR UNISTRUT LOCATION



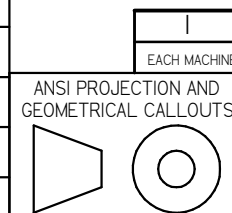
MACHINE #	M21	DATE	
DRAWN BY:	JerryW	04/26/21	
ENG. BY:	PC		
APP. BY:	CL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
	INCH		METRIC
0	±.1	0	± 2.5mm
.00	±.03	.0	± 7.5mm
.000	±.010	.00	± 2.5mm
ANGLES	± 30'	ANGLES	± 30'
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel R OR BETTER ON ALL MACHINED SURFACES			
		15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649	
Title			REV.
MOTOR ASSY			01
Drawing No.		21-080-A000-02	
SIZE	DO NOT SCALE	SHEET 2 OF 2	

REV	DESCRIPTION	DATE	APP
NC			



Item	Qty	Document Number	Rev	Title	Comments
1*	8	21-010-A002	NC	LEVELING BOLT AND NUT ASSY	
2	1	21-090-P015	NC	PROX MOUNT, END STOP	
3	1	21-110-A003-02	NC	EJECTOR ARM ASSY	
4	1	21-110-A006-01	NC	GUDEL EJECTOR EP-4	
5	1	21-110-A009-01	NC	HYD ENDSTOP	
6	1	21-110-P015	NC	BUMP PAD	
7	2	21-110-P080	NC	HOSE HANGER	
8	5	21-950-A008	NC	HYD TUBE CLAMP ASSY	
9	3	AMI AP 3H		PROX SWITCH	
10	2	SHCS M12-1.75 X 30		SHCS	ZINC PLATED G 12.9
11	5	SHCS M20-2.5 X 50		SHCS	ZINC PLATED G 12.9
12	4	SHCS M8-1.25 X 20		SHCS	ZINC PLATED G 12.9
13	4	WASHER M8		WASHER	ZINC PLATED G 12.9

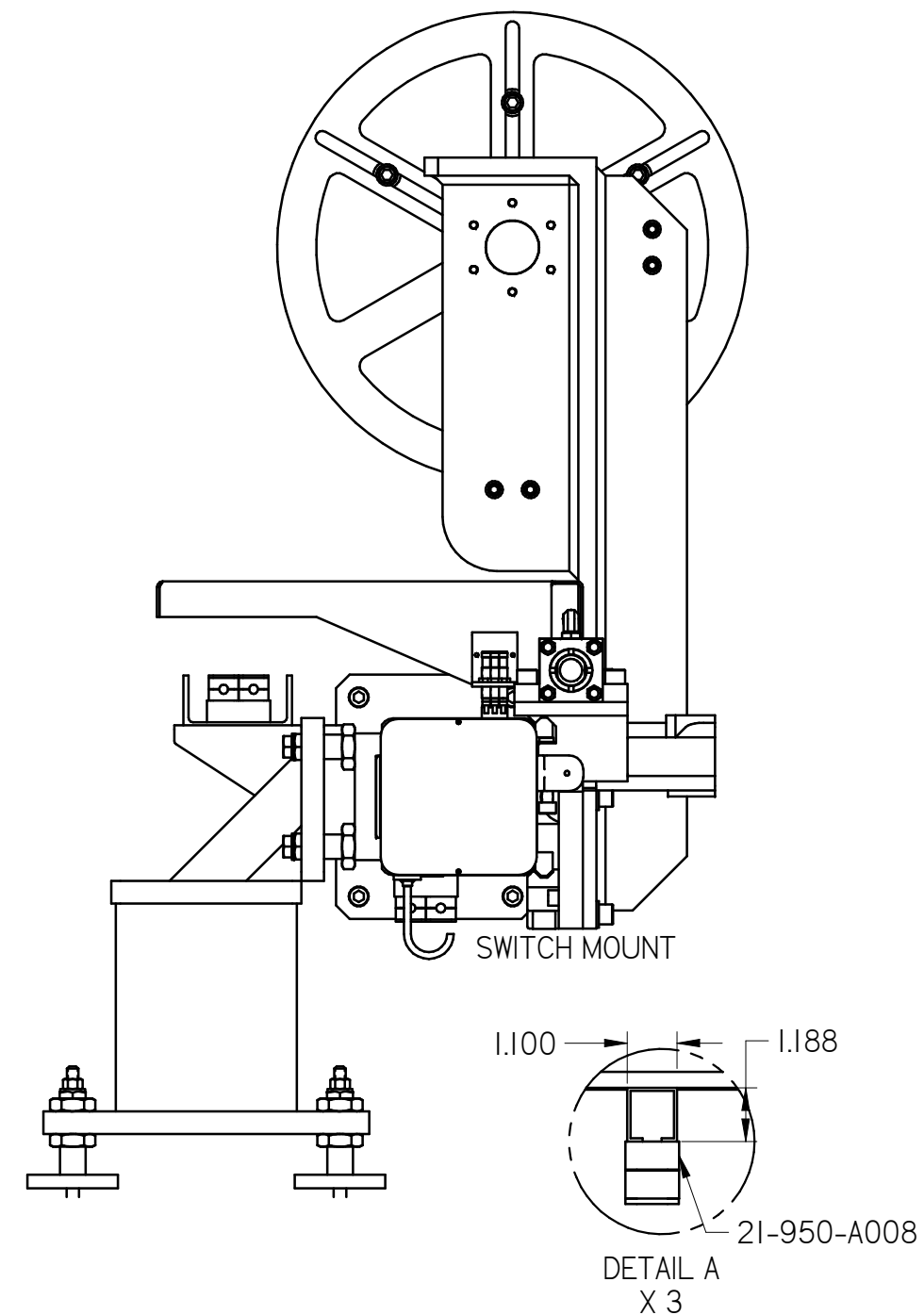
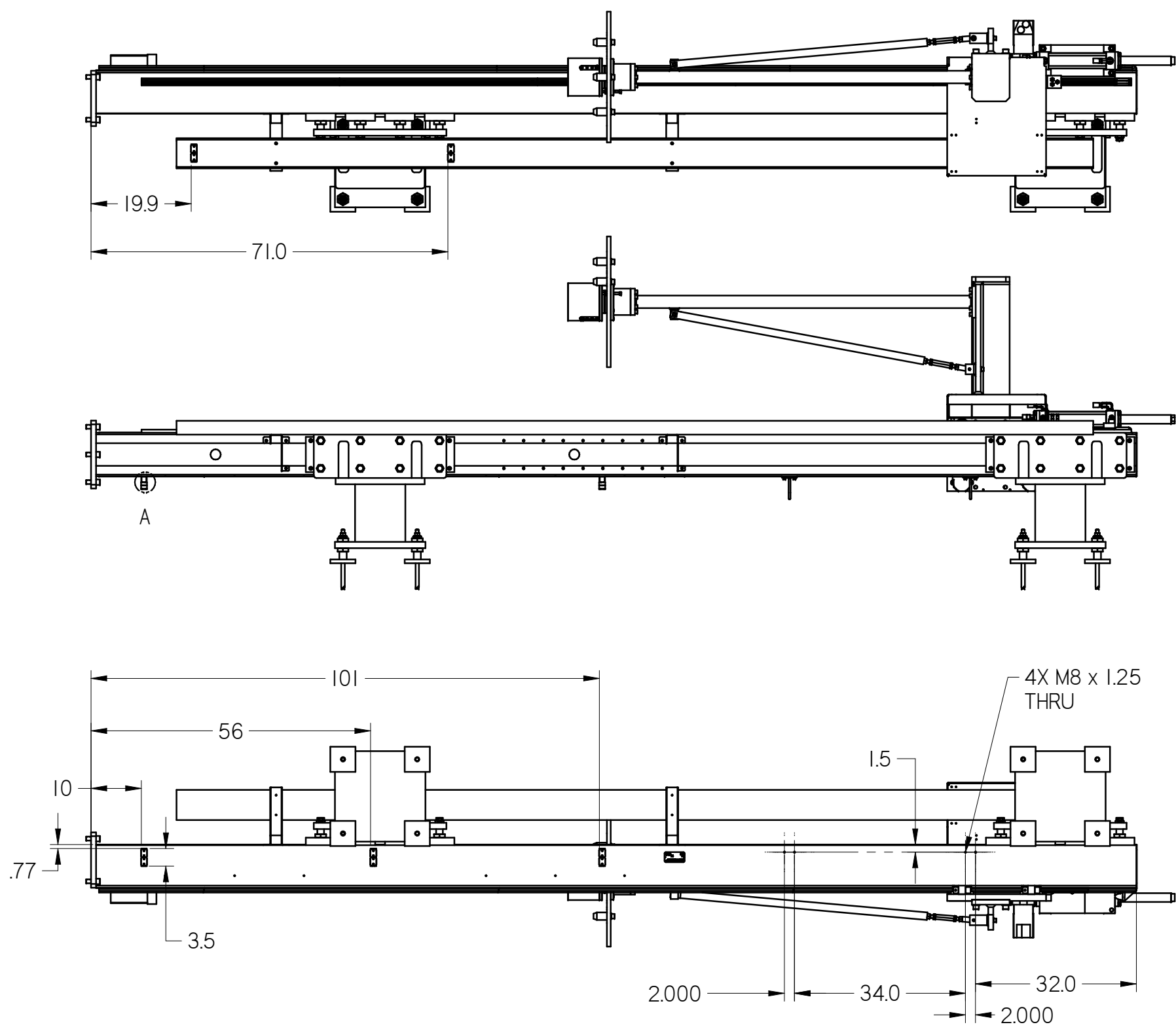
LAST UPDATED 2/4/2022
TOTAL WEIGHT = 2686.5 lbm




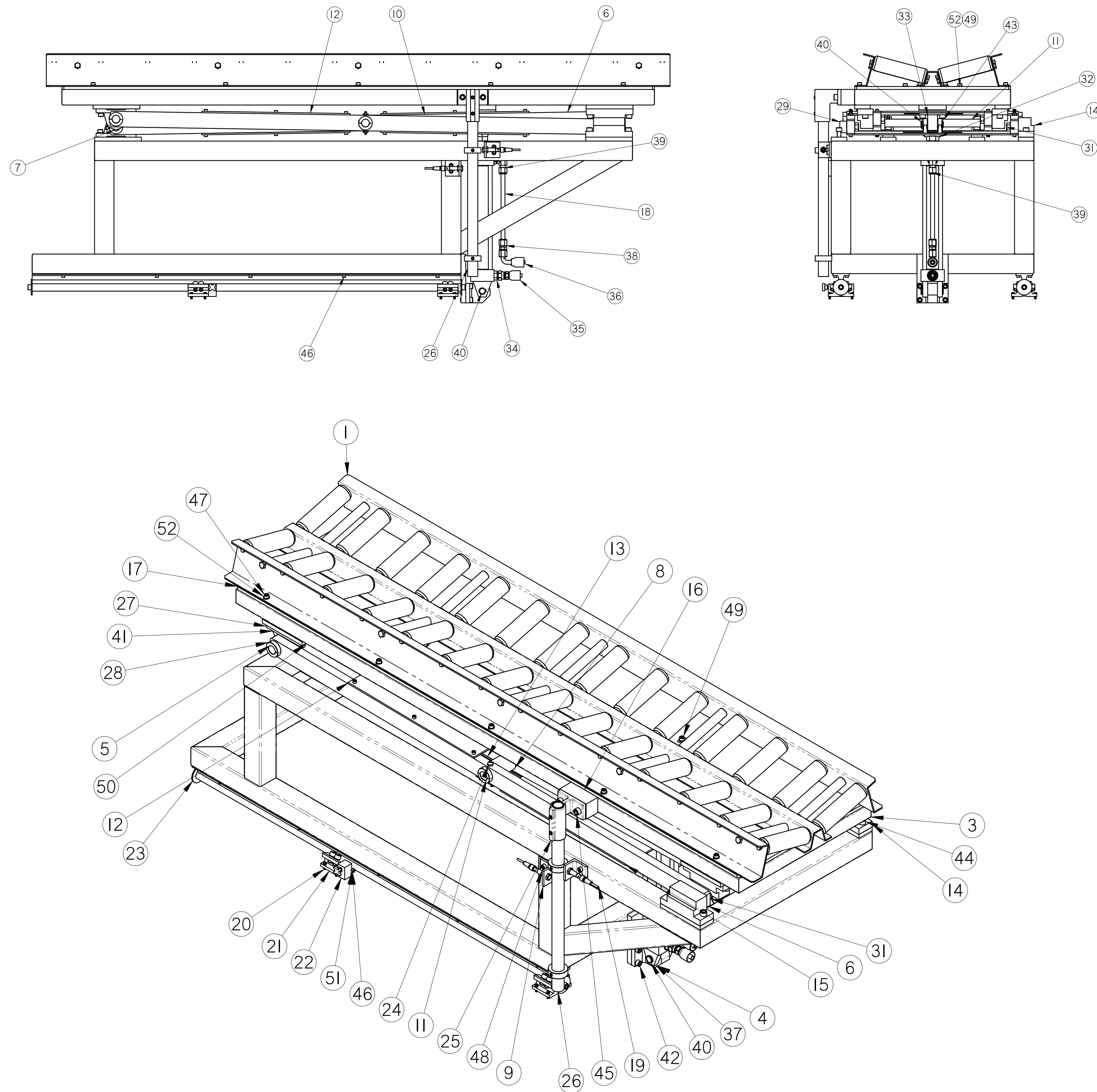
MACHINE #	M21	DATE	
DRAWN BY:	BB	03/18/21	
ENG. BY:	PC		
APP. BY:	CL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
INCH		METRIC	
.0	±.1	0.	±.25mm
.00	±.03	.0	±.75mm
.000	±.010	.00	±.25mm
ANGLES	± 30'	ANGLES	± 30'
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel $\sqrt{\text{R}}$ OR BETTER ON ALL MACHINED SURFACES			
Title		EJECTOR UNIT	
Drawing No.		21-110-A002-03	
REV.	NC	SIZE	B
SHEET		DO NOT SCALE	
SHEET 1 OF 2			



15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649



MACHINE #	M21	DATE	 15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649																																	
DRAWN BY:	BB	03/18/21																																		
ENG. BY:	PC																																			
APP. BY:	CL																																			
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			EJECTOR UNIT																																	
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.00	±.03	.0	±.75mm																																	
.000	±.010	.00	±.25mm																																	
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			21-110-A002-03																																	
			REV.	NC																																
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel			SIZE	SHEET																																
			B	DO NOT SCALE																																
			SHEET 2 OF 2																																	



Item Number	Quantity	Document Number	Rev	Title	Comments
1	1	21-110-A042	NC	CONVEYOR ASSY	
2	1	21-110-A044	NC	FRAME, CONVEYOR	
3	1	21-110-A045	NC	CONVEYOR TOP FRAME	
4	1	21-110-P007-01	NC	PIVOT BLOCK	
5	2	21-110-P013-01	NC	SHAFT	SEE DRAWING 21-110-P022
6	4	21-110-P021-01	NC	SUPPORT ARM	
7	1	21-110-P022	NC	SHAFT	MADE FROM MMC 5947K66 (48")
8	2	21-110-P025-01	NC	SPACER	
9	2	21-110-P026	01	PROX BRACKET	
10	1	21-110-P029-02	NC	CROSS BRACE INNER	
11	1	21-110-P032-01	NC	SHAFT	SEE DRAWING 21-110-P022
12	1	21-110-P033-02	NC	CROSS BRACE	
13	1	21-110-P034	NC	CROSS BRACE	
14	4	21-110-P077	01	CAM BLOCK	
15	1	21-110-P078-01	NC	CROSS BRACE	
16	1	21-110-P141	NC	SPACER, FLAT BAR 1.5 X 2 CRS	
17	1	21-110-P142	NC	BASE PLATE, CONVEYOR	
18	1	21TU-MH-01		HYD TUBE, -8	CUT TO: 10"
19	2	AUT AMI AP 3H		PROX SWITCH	
20	16	HHCS M5-0.8 X 16MM	HHCS,		M5-0.8 X16MM, ZINC
21	4	LEE DPB-16-OPEN		PILLOW BLOCK, DOUBLE ROLLER, 1"	LEE LINEAR
22	1	LEE LOCK-16		LINEAR CARRIAGE LOCK, -16	
23	2	LEE SA-16 55'LG ESI6x2		BEARING RAIL ASSY, -16, CTL 55", Y=3", W/ END STOPS	CTL 55.00", Y=3.00"
24	4	MMC 1095K31		ZERK FITTING	1/4 -18 NPT
25	1	MMC 4698T72		RAIL FITTING, SLIP-ON, 1" PIPE, ALU	
26	1	MMC 4699T34 2FT		PIPE, 1-1/4 SCH40, 2 FT, ALU, YELLOW PAINT	
27	4	MMC 636IK370		PILLOW BLOCK	1" SHAFT 1.312" CENTER
28	8	MMC 6435KI80		CLAMPING COLLAR	1.0"
29	4	MMC 646IK49		CAM ROLLER	1-1.50" Roller THREAD: 5/8"-18
30	2	MMC 9414T250		SHAFT COLAR, 1-5/16" ID, W/SET SCREW	OPEN ID TO DIA 1.34"
31	4	NUT H .625-18		HEX NUT	ZINC PLATED G 8
32	1	PAR 050942000		ROD CLEVIS, 3/4-16, .750 PIN	
33	1	PAR 0959810075		EYE BRACKET, 3/4" PIN	
34	1	PAR 10 F50X-S		HYD FITTING, ADAPTER, 10MJ-10MORB, 5000PSI	
35	1	PAR 10643-10-8		HOSE END, STRAIGHT, 10 FJ-08 HOSE	
36	1	PAR 13943-8-8		HYD FITTING, ELBOW SHORT, 08FJ-08HOSE	
37	1	PAR 2.00BB2HLT14A12.000	NC	HYD CYL, 2H, 2"BORE 1"ROD 12"STK,CLEVIS MOUNT	
38	1	PAR 8 XHBU-S		HYD FITTING, ADAPTER, 08MJ-08BT	
39	1	PAR 8-10 C5BU-S		HYD FITTING, ELBOW, 10MORB-08BT	
40	2	PAR 856640075		PIVOT PIN 3/4"	.75 X 2.867
41	8	SHCS M10-1.50 X 25	SHCS		ZINC PLATED G 12.9
42	4	SHCS M10-1.50 X 30	SHCS		ZINC PLATED G 12.9
43	4	SHCS M12-1.75 X 30	SHCS		ZINC PLATED G 12.9
44	8	SHCS M12-1.75 X 35	SHCS		ZINC PLATED G 12.9
45	2	SHCS M12-1.75 X 65	SHCS		ZINC PLATED G 12.9
46	45	SHCS M6-1.00 X 15	SHCS		ZINC PLATED G 12.9
47	16	SHCS M8-1.25 X 12	SHCS		ZINC PLATED G 12.9
48	4	SHCS M8-1.25 X 15	SHCS		ZINC PLATED G 12.9
49	8	SHCS M8-1.25 X 20	SHCS		ZINC PLATED G 12.9
50	8	WASHER M10	WASHER		ZINC PLATED G 12.9
51	1	WASHER M6	WASHER		ZINC PLATED G 12.9
52	24	WASHER M8	WASHER		ZINC PLATED G 12.9

MACHINE #	M21	DATE	
DRAWN BY:	JERRYW	03/18/21	
ENG. BY:	PC		
APP. BY:	CL		

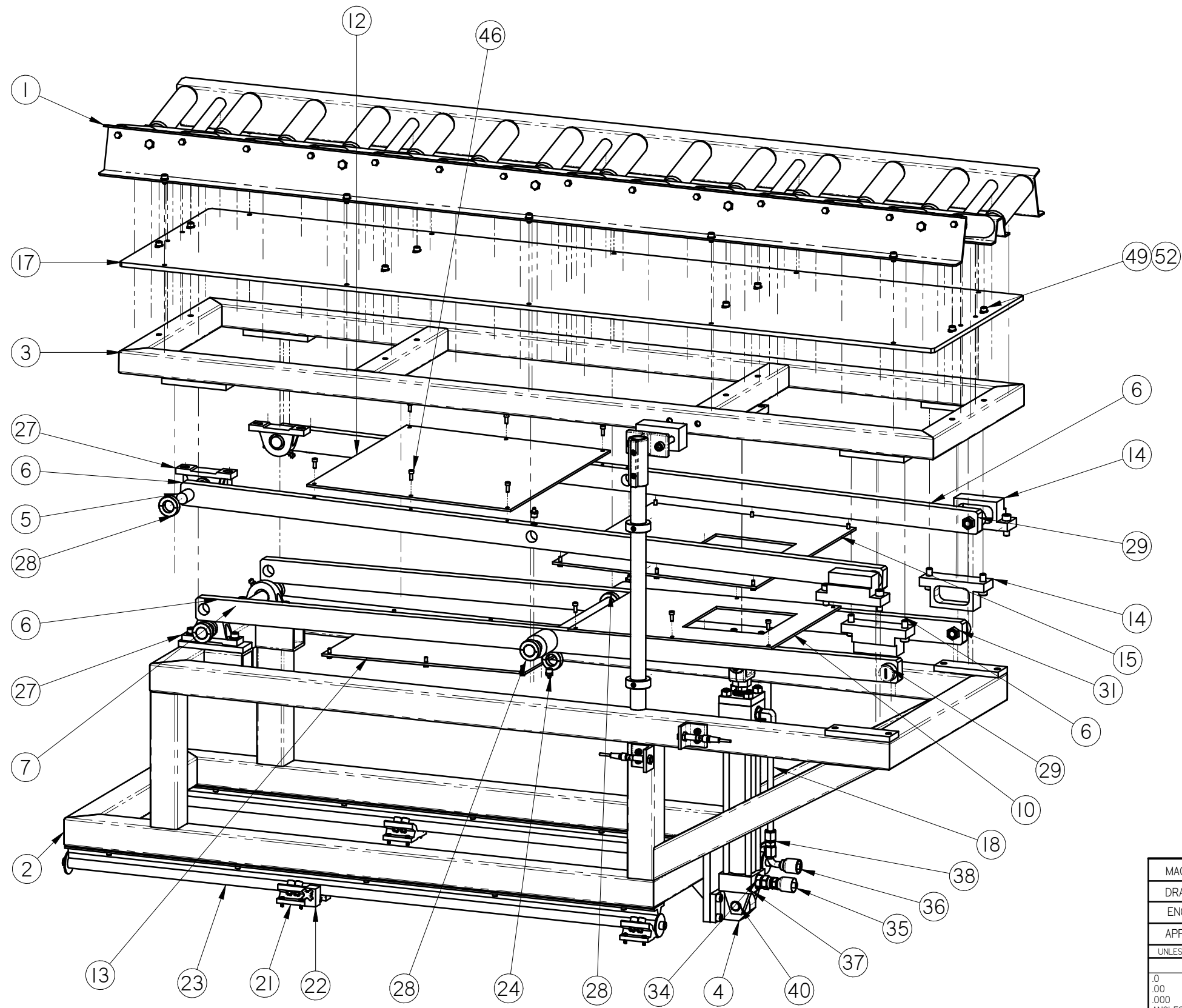



Title CONVEYOR LOCATION. ASSY	
Drawing No. 21-110-A020-03	REV. 01
SIZE D	SHEET SHEET 1 OF 2

INCH		METRIC	
0	± .1	0	± 2.5mm
.00	± .03	.0	± .75mm
.000	± .010	.00	± .25mm
ANGLES	± 30'	ANGLES	± 30'
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm

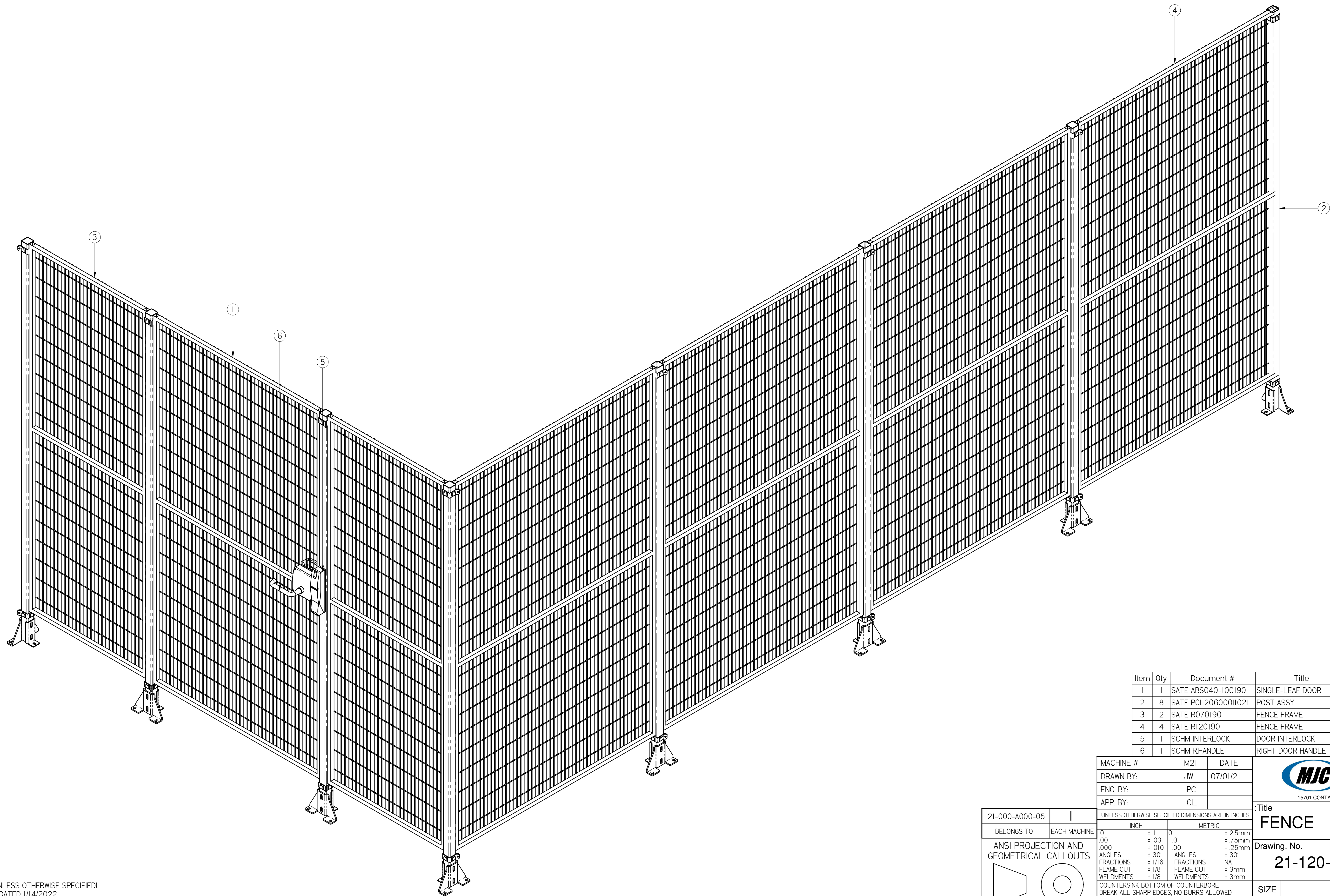
1
EACH MACHINE

COUNTERSINK BOTTOM OF COUNTERBORE
BREAK ALL SHARP EDGES, NO BURRS ALLOWED
ALL DATUMS TO BE Z7, L, //



MACHINE #	M21	DATE	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649	
DRAWN BY:	JERRYW	03/18/21		
ENG. BY:	PC			
APP. BY:	CL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			Title	
			CONVEYOR LOCATION. ASSY	
			Drawing No.	
			21-110-A020-03	
			REV.	
			01	
Error: No reference BELONGS TO EACH MACHINE			SIZE B	DO NOT SCALE
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel			SHEET SHEET 2 OF 2	

REV	DESCRIPTION	DATE	APP
NC			



Item	Qty	Document #	Title	Comments
1	1	SATE ABS040-100190	SINGLE-LEAF DOOR	BASIC 1900 X 1000 W/ HARDWARE
2	8	SATE POL20600011021	POST ASSY	2060 POST WITH HARDWARE
3	2	SATE R070190	FENCE FRAME	20MM FRAME 1900 X 700
4	4	SATE R120190	FENCE FRAME	20MM FRAME 1900 X 1200
5	1	SCHM INTERLOCK	DOOR INTERLOCK	AZM200-ST2-T-IP2P
6	1	SCHM RHANDLE	RIGHT DOOR HANDLE	AZ/AZM200-B30-RTAG1P1

MACHINE #	M21	DATE
DRAWN BY:	JW	07/01/21
ENG. BY:	PC	
APP. BY:	CL	



15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649

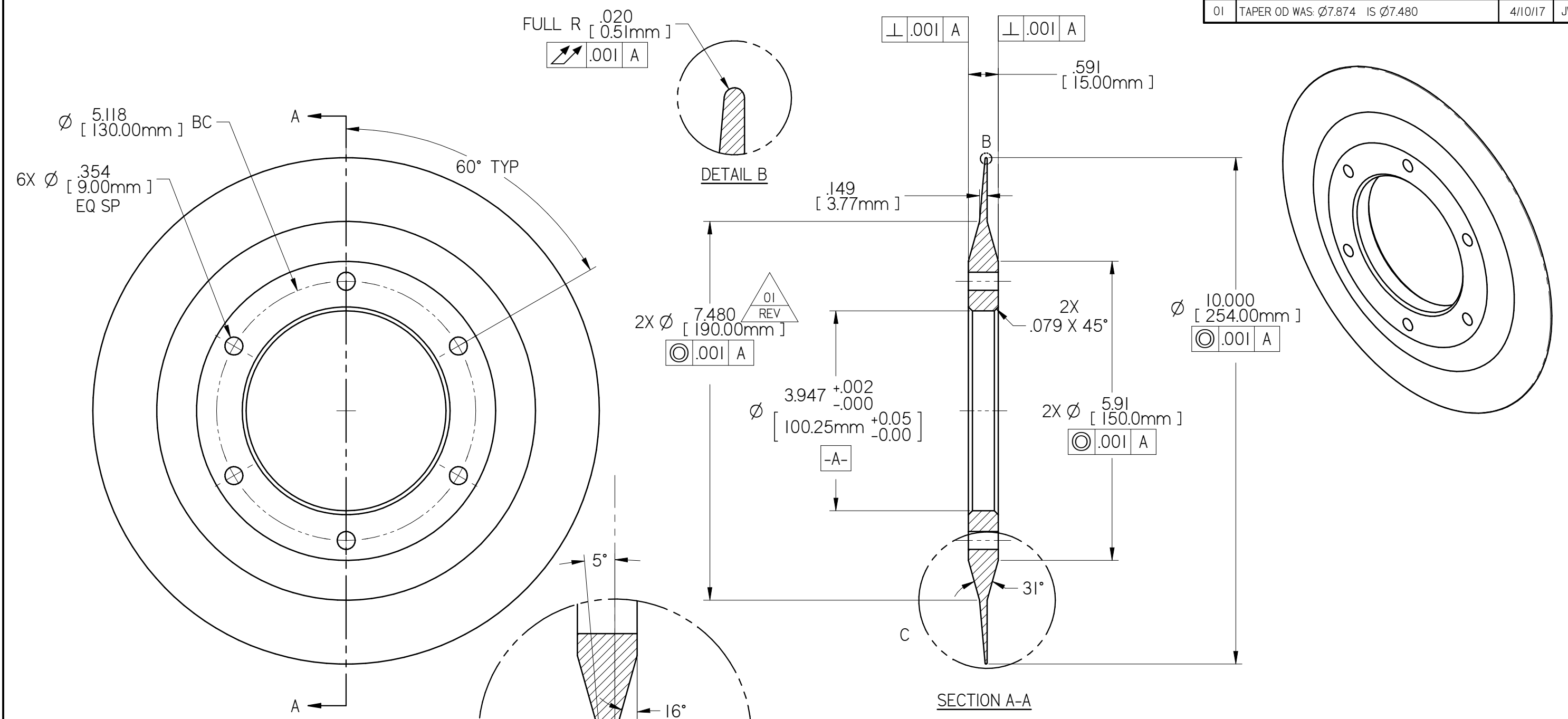
21-000-A000-05	1
BELONGS TO	EACH MACHINE
ANSI PROJECTION AND GEOMETRICAL CALLOUTS	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
INCH	METRIC
0	± 2.5mm
± .03	± 0.75mm
± .010	± .25mm
± .000	± .00
± 30'	± 30'
FRACTIONS	NA
FLAME CUT	± 3mm
WELDMENTS	± 3mm

Title FENCE		REV. NC
Drawing No. 21-120-A005		
SIZE D	DO NOT SCALE	SHEET SHEET 1 OF 1

NOTE: (UNLESS OTHERWISE SPECIFIED)
LAST UPDATED 1/14/2022
TOTAL WEIGHT = 386.8 lbm

REV	DESCRIPTION	DATE	APP
01	TAPER OD WAS: Ø7.874 IS Ø7.480	4/10/17	JW

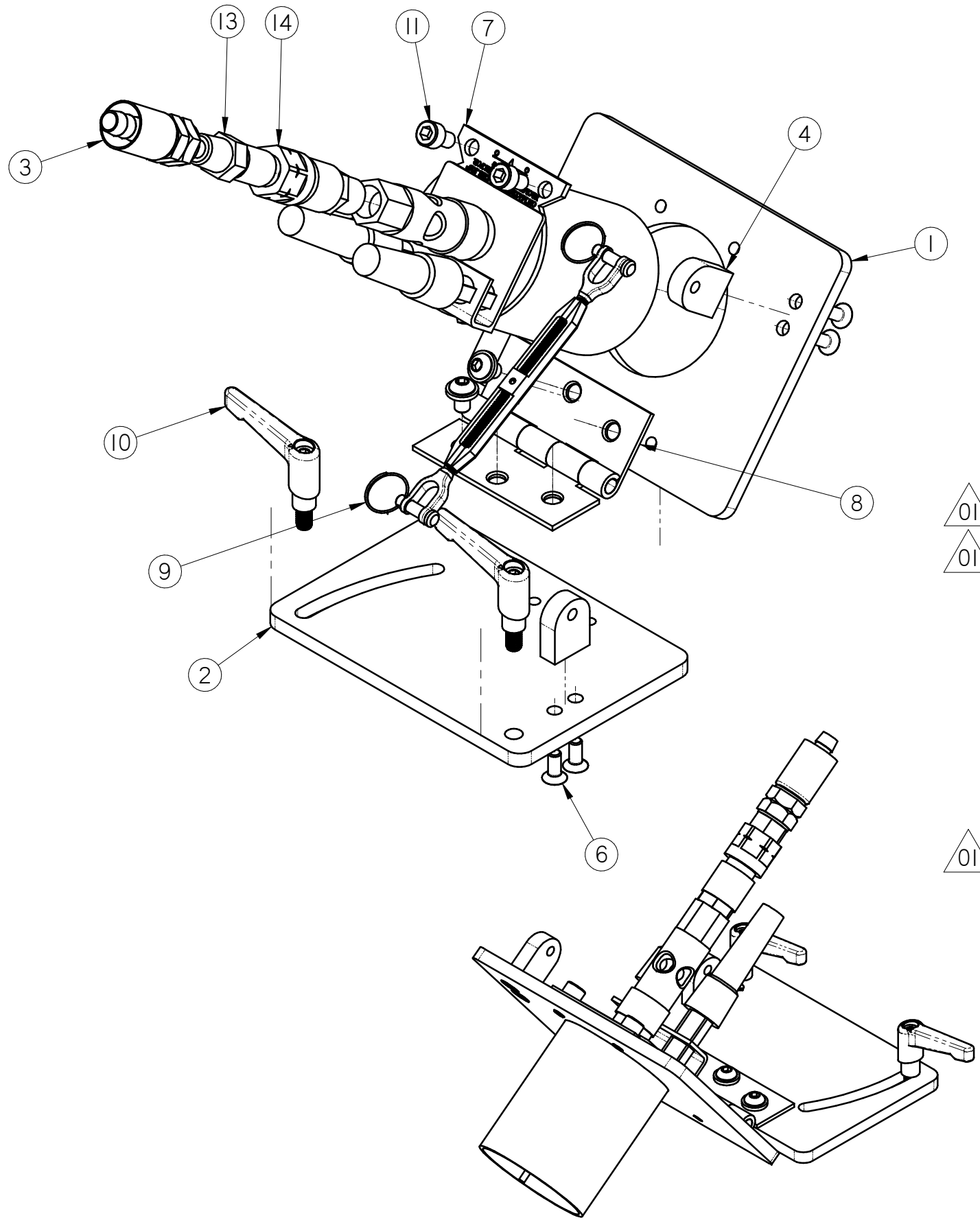


ATTN:
THE 5° IS TO ONE SIDE ONLY!
OTHER SIDE IS FLAT AND PARALLEL TO -B-

NOTE: (UNLESS OTHERWISE SPECIFIED)
LAST UPDATED 9/21/2021
TOTAL WEIGHT = 5.1 lbm
I - BREAK ALL SHARP EDGES

MATERIAL: CPM9V	MACHINE # M21	DATE 03/18/21	 15701 CONTAINER LN. HUNTINGTON BEACH, CA 92649	Title BLADE																																
TREATMENT:	DRAWN BY: JerryW	ENG. BY: PC		Drawing No. 21-160-P020-01																																
FINISH: GRIND	APP. BY: CL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES:		REV. 01	SHEET SHEET 1 OF 1																															
ANSI PROJECTION AND GEOMETRICAL CALLOUTS	APPROXIMATE DIMENSIONS:	<table border="1"> <thead> <tr> <th colspan="2">INCH</th> <th colspan="2">METRIC</th> </tr> </thead> <tbody> <tr> <td>.0</td> <td>±.1</td> <td>0.</td> <td>±.25mm</td> </tr> <tr> <td>.00</td> <td>±.03</td> <td>.0</td> <td>±.75mm</td> </tr> <tr> <td>.000</td> <td>±.010</td> <td>.00</td> <td>±.25mm</td> </tr> <tr> <td>ANGLES</td> <td>±.30'</td> <td>ANGLES</td> <td>±.30'</td> </tr> <tr> <td>FRACTIONS</td> <td>±.1/16</td> <td>FRACTIONS</td> <td>NA</td> </tr> <tr> <td>FLAME CUT</td> <td>±.1/8</td> <td>FLAME CUT</td> <td>±.3mm</td> </tr> <tr> <td>WELDMENTS</td> <td>±.1/8</td> <td>WELDMENTS</td> <td>±.3mm</td> </tr> </tbody> </table>		INCH		METRIC		.0	±.1	0.	±.25mm	.00	±.03	.0	±.75mm	.000	±.010	.00	±.25mm	ANGLES	±.30'	ANGLES	±.30'	FRACTIONS	±.1/16	FRACTIONS	NA	FLAME CUT	±.1/8	FLAME CUT	±.3mm	WELDMENTS	±.1/8	WELDMENTS	±.3mm	SIZE B
INCH		METRIC																																		
.0	±.1	0.	±.25mm																																	
.00	±.03	.0	±.75mm																																	
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FRACTIONS	±.1/16	FRACTIONS	NA																																	
FLAME CUT	±.1/8	FLAME CUT	±.3mm																																	
WELDMENTS	±.1/8	WELDMENTS	±.3mm																																	

REV	DESCRIPTION	DATE	APP
01	REMOVE WELD, ADDED HARDWARE	10/19/21	KF



01
01
01

Item	Qty	Document Number	Rev	Title	Comments
1	1	21-050-S012	01	PILOT HEAT SHIELD	
2	1	21-050-S018	01	PILOT HEAT SHIELD	
3	1	21-210-A026	NC	HOSE END ASSEMBLY GAS	WESTERN T-7328, -20-A, -8,
4	2	21-210-P026	01	TURNBUCKLE MOUNT	
5*	6	BHCS M6-1.00 X 10		BHCS	ZINK PLATED
6	4	FHCS M5 X 12		FHCS M5 X 12	ZINC PLATED G 12.9
7	1	KR0 84228020 ZAI TN		IGNITOR	WITH 1/4 NPT INLET
8	1	MMC 1798A210		HINGE	
9	1	MMC 30315T611		TURNBUCKLE	2.5" MAX TRAVEL
10	2	MMC 6610K32		HANDLE, SAFETY ADJUSTABLE, M6x1	
11	2	SHCS M6-1.00 X 10		SHCS	ZINC PLATED G 12.9
12*	6	WASHER M6		WASHER	ZINC PLATED G 12.9
13	1	WEST 33		GAS FITT B-33 LH FUEL	WESTERN 1/4 TO B SIZE LH ADAPT
14	1	WEST FA-3CV		FLASH ARRESTOR,	1/4"FNPT TO 1/4"MNPT

MACHINE #	M21	DATE	
DRAWN BY:	BB	03/18/21	
ENG. BY:	PC		
APP. BY:	CL		

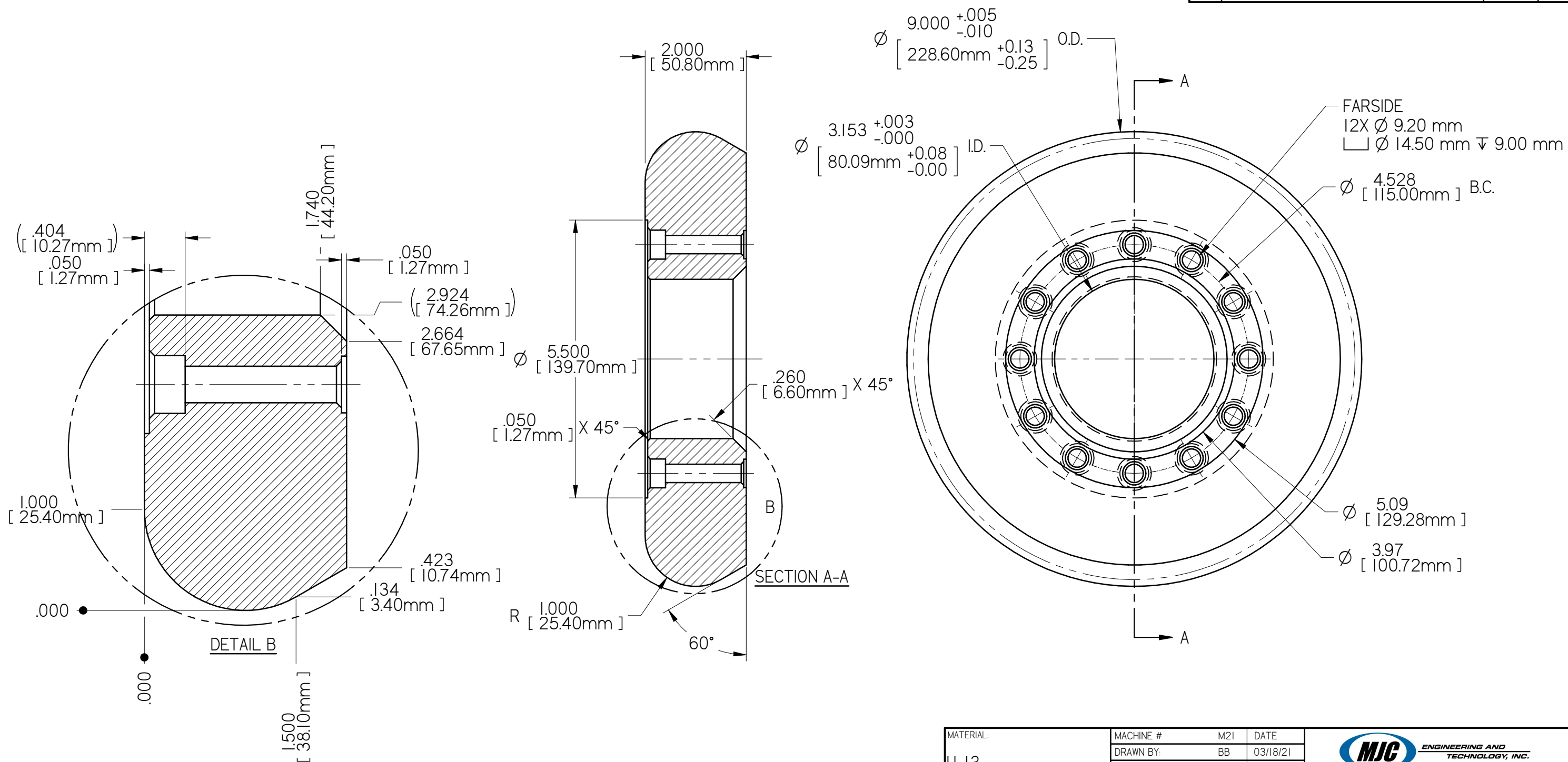


UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
INCH	METRIC		
.0	±.1	0.	± 2.5mm
.00	±.03	.0	±.75mm
.000	±.010	.00	±.25mm
ANGLES	± 30°	ANGLES	± 30°
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm

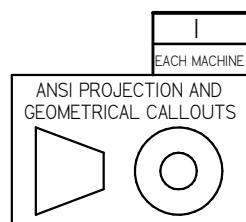
Title	
IGNITOR MOUNT	
Drawing. No.	REV.
21-210-A014	01

I EACH MACHINE	COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel	SIZE B	DO NOT SCALE	SHEET SHEET 1 OF 1
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REV	DESCRIPTION	DATE	APP
NC			

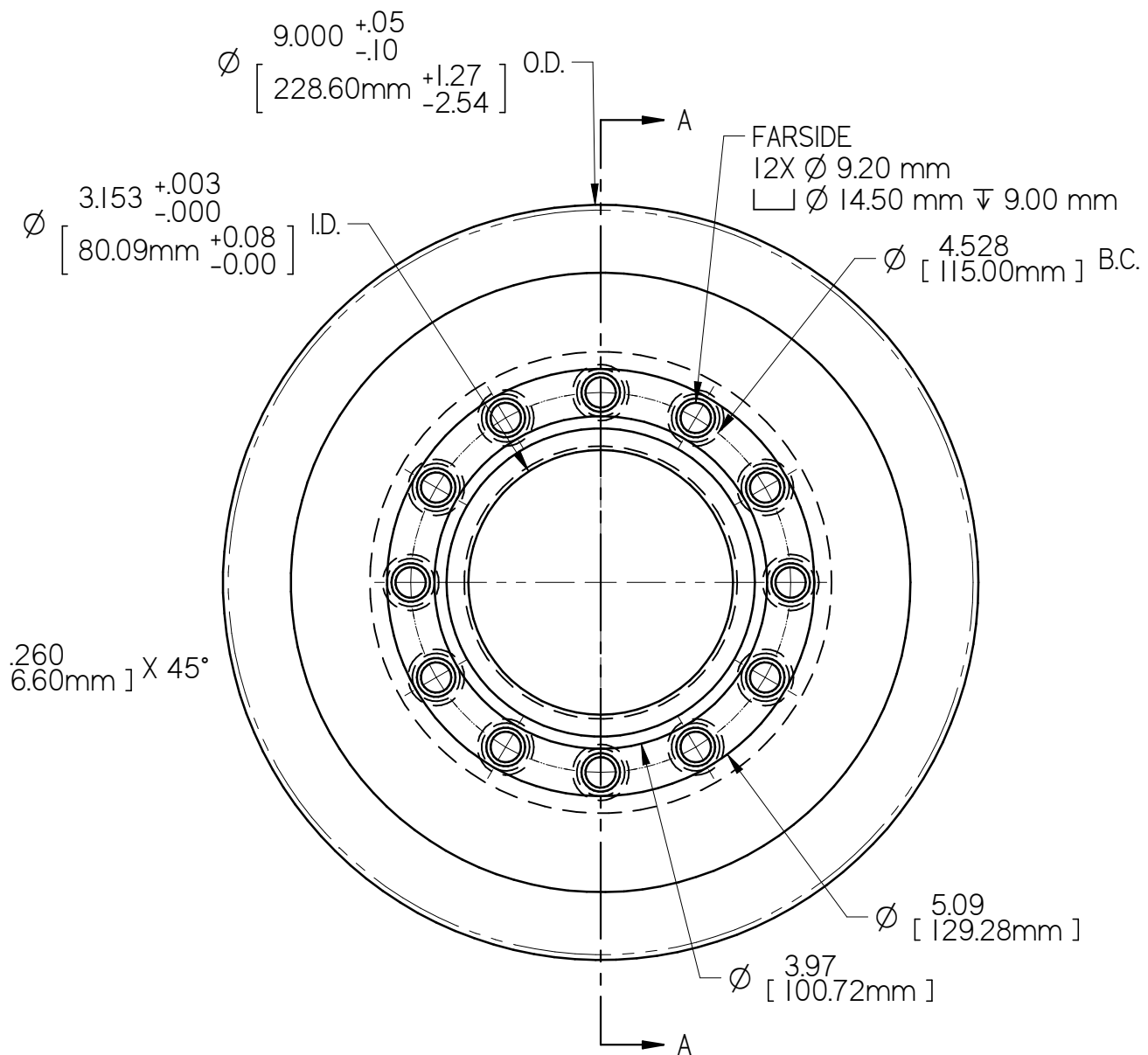
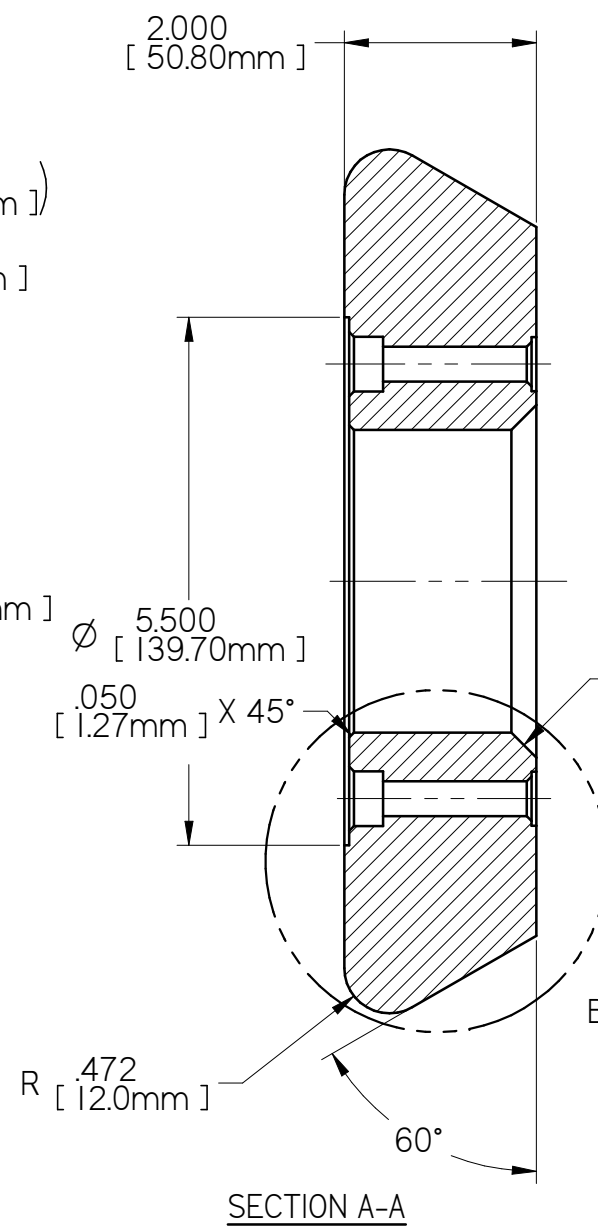
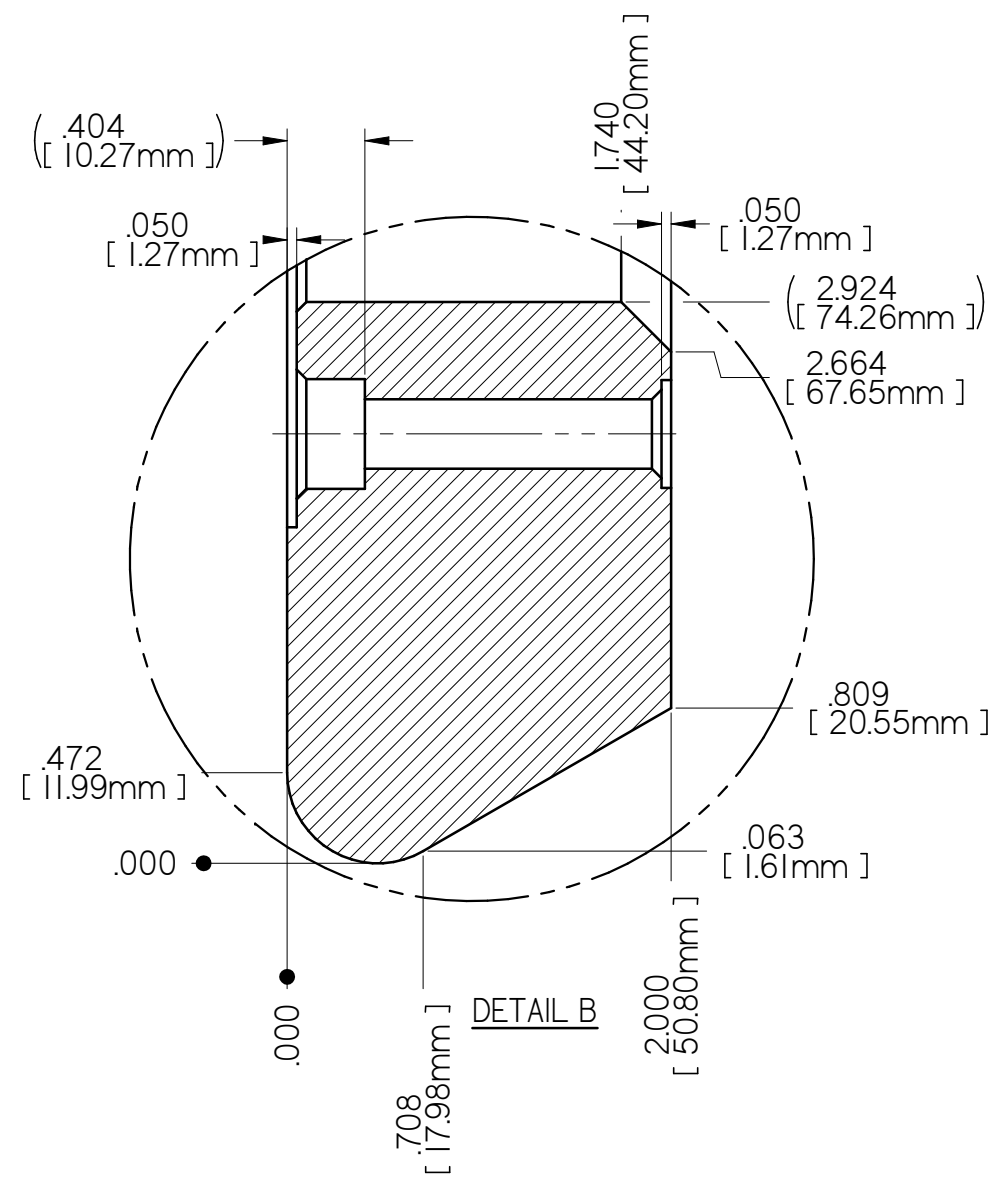


NOTE: (UNLESS OTHERWISE SPECIFIED)
 LAST UPDATED 10/1/2021
 TOTAL WEIGHT = 27.4 lbm
 1 - ROUGH MACHINE
 2- STRESS RELIEVE
 3- HEAT TREAT
 4- FINAL MACHINE, T.I.R. = .003"

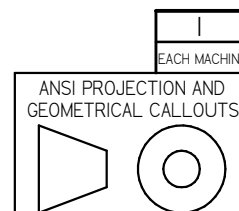


MATERIAL: H-13	MACHINE # M21	DATE 03/18/21	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649																																
TREATMENT: STRESS RELIEVE HEAT TREAT 50-54RC	DRAWN BY: BB	ENG. BY: PC																																	
FINISH:	APP. BY: CL																																		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES:			Title ROLLER R 1" R																																
<table border="1"> <thead> <tr> <th colspan="2">INCH</th> <th colspan="2">METRIC</th> </tr> </thead> <tbody> <tr> <td>.0</td> <td>±.1</td> <td>0</td> <td>±.25mm</td> </tr> <tr> <td>.00</td> <td>±.03</td> <td>.0</td> <td>±.75mm</td> </tr> <tr> <td>.000</td> <td>±.010</td> <td>.00</td> <td>±.25mm</td> </tr> <tr> <td>ANGLES</td> <td>± 30'</td> <td>ANGLES</td> <td>± 30'</td> </tr> <tr> <td>FRACTIONS</td> <td>± 1/16</td> <td>FRACTIONS</td> <td>NA</td> </tr> <tr> <td>FLAME CUT</td> <td>± 1/8</td> <td>FLAME CUT</td> <td>± 3mm</td> </tr> <tr> <td>WELDMENTS</td> <td>± 1/8</td> <td>WELDMENTS</td> <td>± 3mm</td> </tr> </tbody> </table>			INCH		METRIC		.0	±.1	0	±.25mm	.00	±.03	.0	±.75mm	.000	±.010	.00	±.25mm	ANGLES	± 30'	ANGLES	± 30'	FRACTIONS	± 1/16	FRACTIONS	NA	FLAME CUT	± 1/8	FLAME CUT	± 3mm	WELDMENTS	± 1/8	WELDMENTS	± 3mm	Drawing No. 21-300-P001
INCH		METRIC																																	
.0	±.1	0	±.25mm																																
.00	±.03	.0	±.75mm																																
.000	±.010	.00	±.25mm																																
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COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE $\square, \perp, \parallel$ $\sqrt{2}$ OR BETTER ON ALL MACHINED SURFACES			REV. NC																																
SIZE B			SHEET DO NOT SCALE SHEET 1 OF 1																																

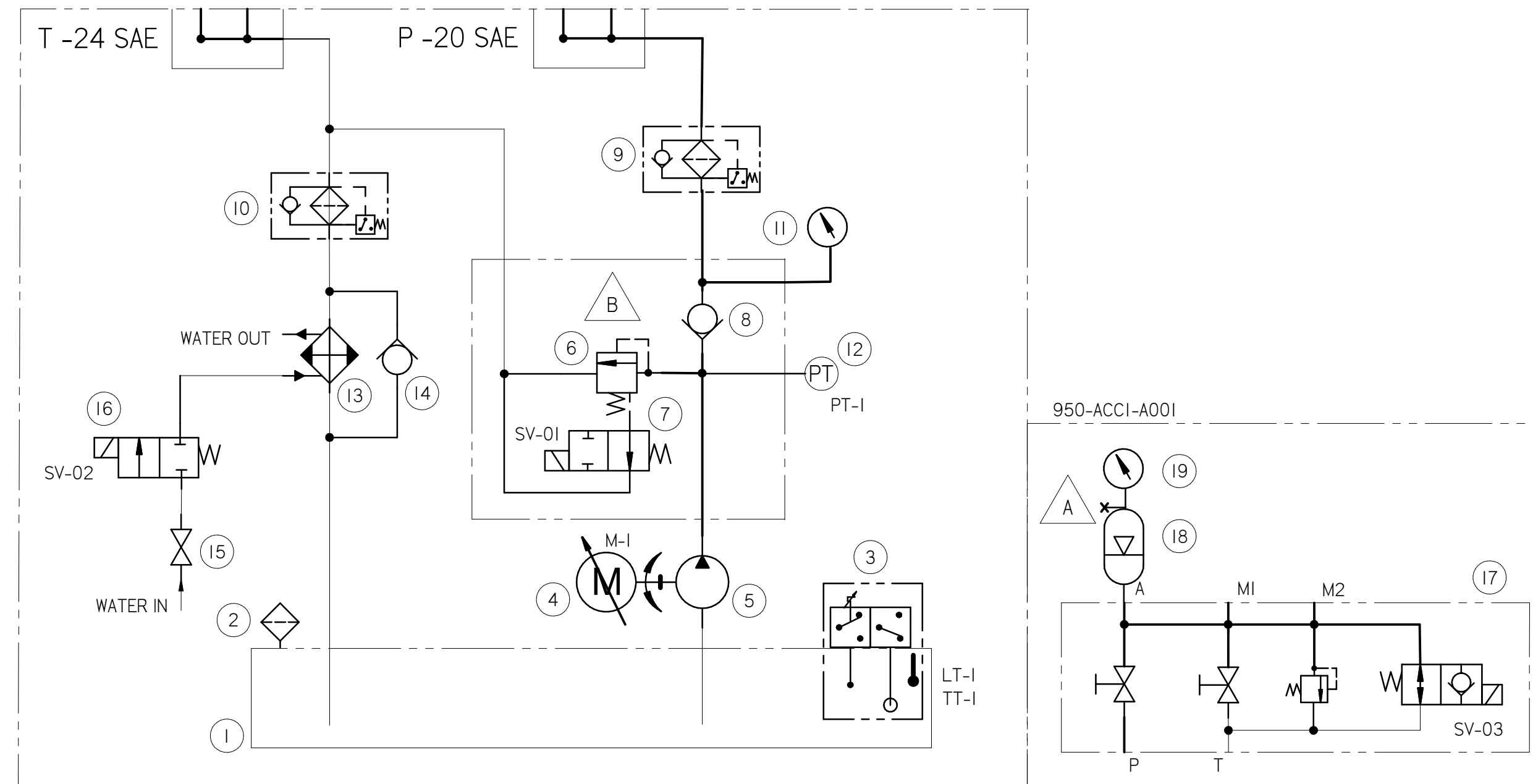
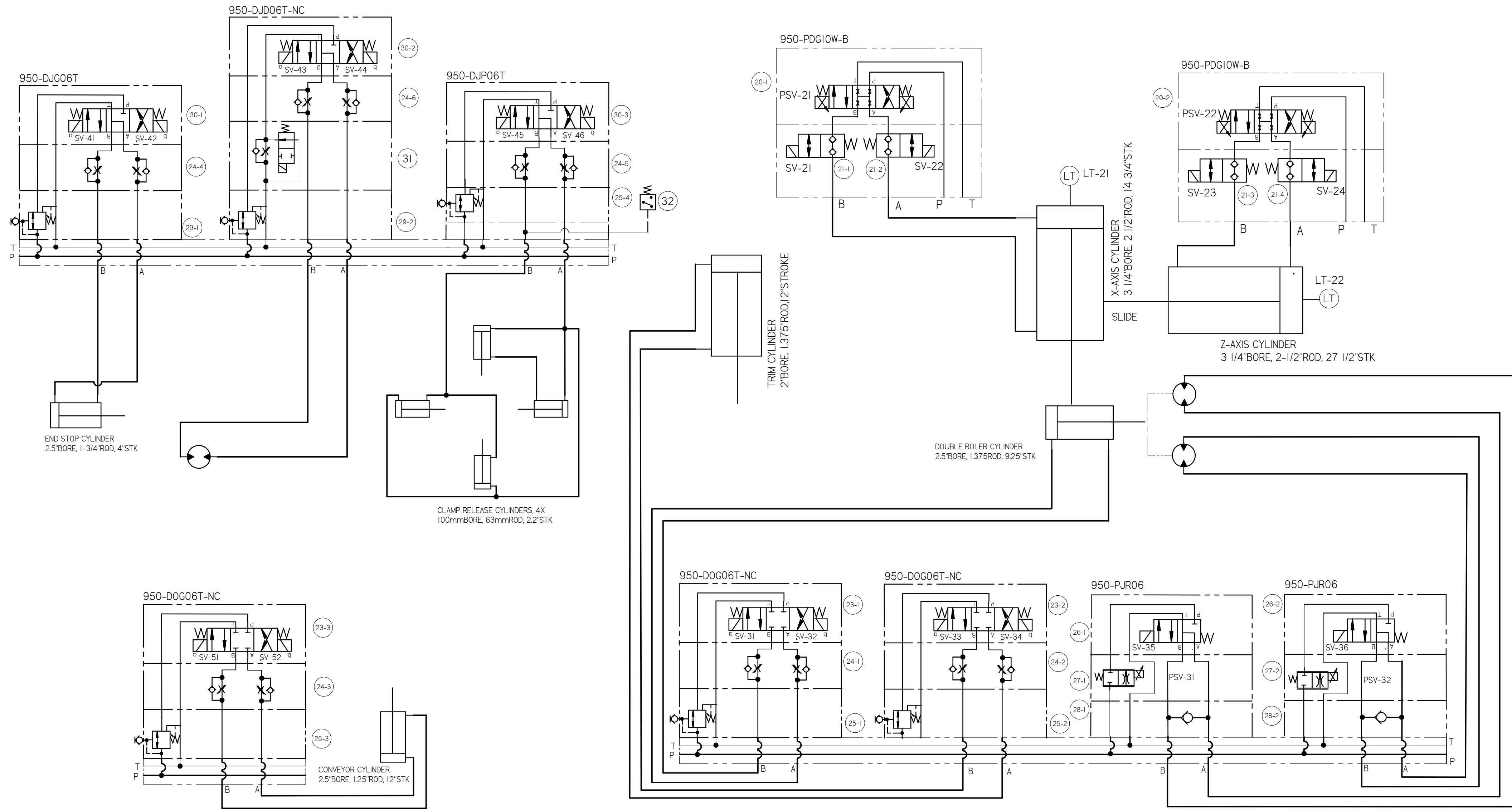
REV	DESCRIPTION	DATE	APP
NC			



NOTE: (UNLESS OTHERWISE SPECIFIED)
 LAST UPDATED 10/1/2021
 TOTAL WEIGHT = 25.6 lbm
 1 - ROUGH MACHINE
 2- STRESS RELIEVE
 3- HEAT TREAT
 4- FINAL MACHINE, T.I.R. = .003"



MATERIAL: H-13	MACHINE # M21	DATE 07/06/21	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649																																
TREATMENT: STRESS RELIEVE HEAT TREAT 50-54RC	DRAWN BY: JWANG	ENG. BY: PC																																	
FINISH:	APP. BY: CL																																		
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES																																		
	<table border="1"> <thead> <tr> <th colspan="2">INCH</th> <th colspan="2">METRIC</th> </tr> </thead> <tbody> <tr> <td>.0</td> <td>±.1</td> <td>0</td> <td>± 2.5mm</td> </tr> <tr> <td>.00</td> <td>±.03</td> <td>.0</td> <td>±.75mm</td> </tr> <tr> <td>.000</td> <td>±.010</td> <td>.00</td> <td>±.25mm</td> </tr> <tr> <td>ANGLES</td> <td>± 30'</td> <td>ANGLES</td> <td>± 30'</td> </tr> <tr> <td>FRACTIONS</td> <td>± 1/16</td> <td>FRACTIONS</td> <td>NA</td> </tr> <tr> <td>FLAME CUT</td> <td>± 1/8</td> <td>FLAME CUT</td> <td>± 3mm</td> </tr> <tr> <td>WELDMENTS</td> <td>± 1/8</td> <td>WELDMENTS</td> <td>± 3mm</td> </tr> </tbody> </table>		INCH		METRIC		.0	±.1	0	± 2.5mm	.00	±.03	.0	±.75mm	.000	±.010	.00	±.25mm	ANGLES	± 30'	ANGLES	± 30'	FRACTIONS	± 1/16	FRACTIONS	NA	FLAME CUT	± 1/8	FLAME CUT	± 3mm	WELDMENTS	± 1/8	WELDMENTS	± 3mm	Title ROLLER R .472"
INCH		METRIC																																	
.0	±.1	0	± 2.5mm																																
.00	±.03	.0	±.75mm																																
.000	±.010	.00	±.25mm																																
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FLAME CUT	± 1/8	FLAME CUT	± 3mm																																
WELDMENTS	± 1/8	WELDMENTS	± 3mm																																
	Drawing No. 21-300-P007		REV. NC																																
	SIZE B	DO NOT SCALE	SHEET SHEET 1 OF 1																																



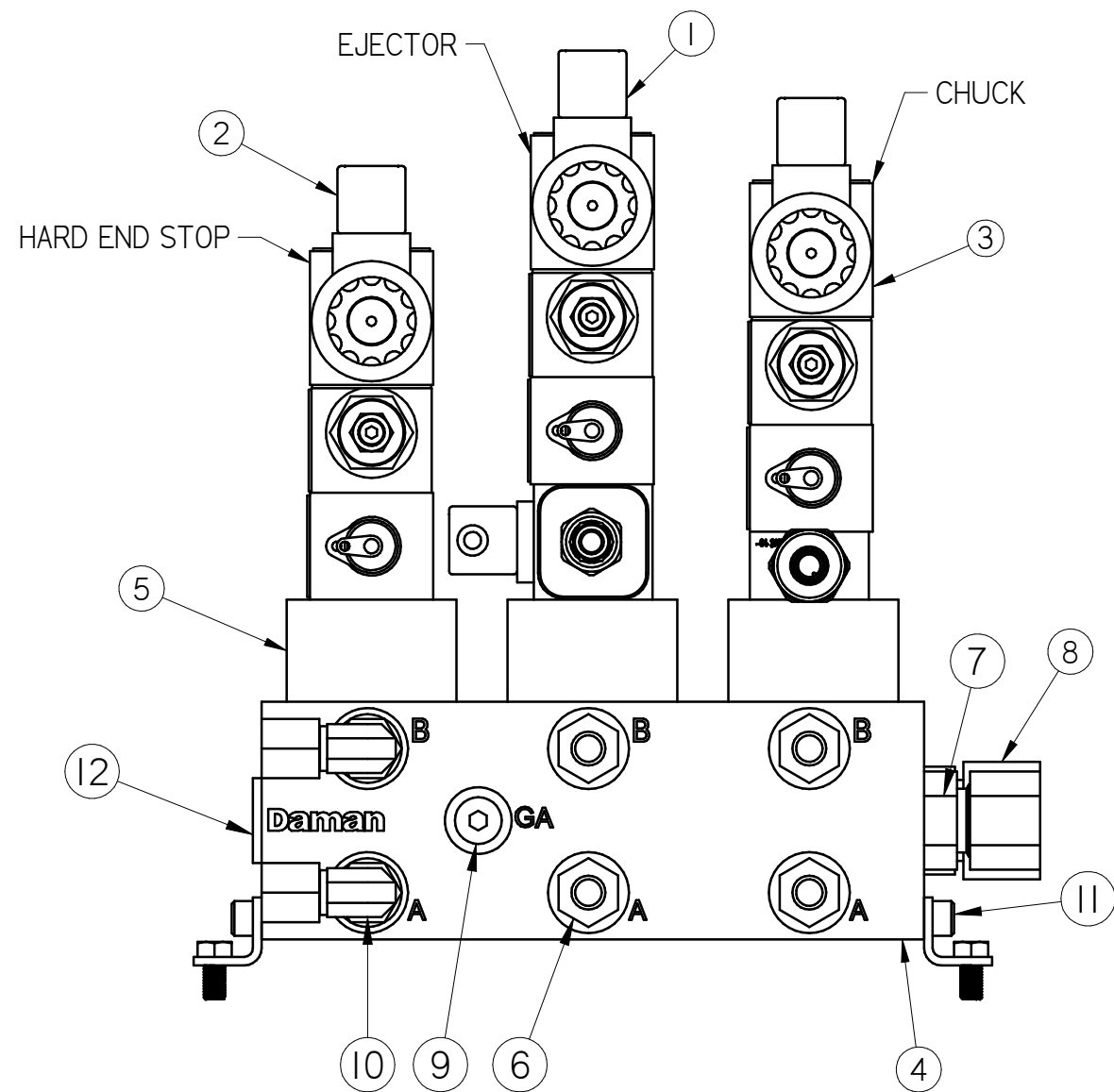
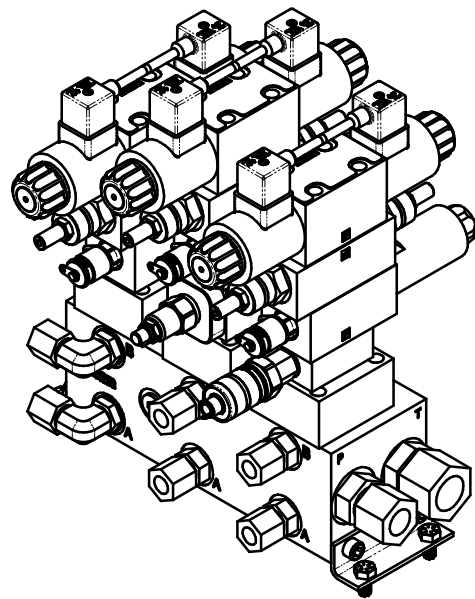
BILL OF MATERIAL				
TEM	QTY	PART NUMBER	DESCRIPTION	MFG.
1	1	018-954-A001	RESERVOIR 150 GALLON	
2	1	934332T	8.1 TRICEPTOR AIR BREATH	PARKER
3	1	NVT-E50-2NT-MI2	LEVEL / TEMP SENSOR, 0-10VDC	KTR
4	1	IPH8137-IUF02-ILCI	ELEC. MOTOR, 22KW, 400V	SIEMENS
5	1	PCAP 5-40 101	HYD PUMP, GEAR, 40CC, 210BAR, 3000RPM	VOITH
6	1	A06H3PZN	HYD VALVE, CART, RELIEF, VENTABLE C16-3S	PARKER
7	1	GSL081NR	HYD VALVE, POPPET, 2-WAY, N/O	PARKER
8	1	CVH161P	HYD VALVE, CART, CHECK, C16-2, 5000/20	PARKER
9	1	WPF310QE2KS161	HYD FILTER, 10 MIC, 6000PSI, SAE-16	PARKER
9a		941037Q	REPLACEMENT ELEMENT	PARKER
10	1	40CN210QE2KS244	HYD FILTER, 10 MIC, 800PSI, W/ELE IND	PARKER
10a		936601Q	REPLACEMENT ELEMENT	PARKER
11	1	SPG063-03000-05-S-N 04	HYD GAUGE, DUAL, 63mm, 0-3K, BOT 1/4	STAUFF
12	1	PX9021	HYD PRES TRAN, 0-250BAR, 1/4"NPT	FM
13	1	TAK/T2342	HEAT EXCHANGER, 2-PASS,	KTR
14	1	TH-1000-16F0-05	THERMAL BYPASS	PARKER
15	1	XV500P-8	BALL VALVE, 1/2"	PARKER
16	1	I2F24C2148A3FPH80	SOLENOID VALVE, 24VDC	PARKER
17	1	SBAT20EIT1-210TLI	SAFTY VALVE	PARKER
18	1	ACPI0AA4000EIKTE	ACCUM 4 LITER	PARKER
19	1	G-2140-GXB-3000	HYD GAUGE, DUAL, 2.5", 0-3K, BOT 1/4	VALLEY
20	2	D3FCE50UB9NB03	PROP DIR VALVE, D05, 60LPM@5BAR	PARKER
21	4	GS068000N	POPPET SOL. VALVE, 2P2W, NC, 3K	PARKER
23	3	D1VW001CNJW	DIR. VALVE, 3P4W, D03, N/C, 24VDC	PARKER
24	6	FM2DDSN	HYD VALVE, FLOW CONT, SAND, D03, A&B	PARKER
25	4	PRDM2PP21SNS	PRESSURE REDUCE VALVE, D03, 210BAR	PARKER
26	2	D1VW004KNJW	DIR. VALVE, 2/4, D03, A-B-T, 24VDC	PARKER
27	2	FPCC-XCN2B24V	PROP FLOW CONT, .25-7GPM, T-13A	SUN
28	2	CXDA-XCN	CHECK VALVE, CART, 20GPM	SUN
29	2	PRDM2PP16SNN	PRESSURE REDUCE VALVE, D03, 44-2320PSI	PARKER
30	3	D1VW004CNJW	DIR. VALVE, 3P4W, D03, A-B-T, 24VDC	PARKER
31	1	X2CNLCN-HA-224	HYD CART, D03, RAPID & FLOW CON ON P/T	SUN
32	1	PK6220	PRESSURE SWITCH, 20-400BAR, 1/4"NPT	FM

MACHINE #	M21-04	DATE																																	
DRAWN BY:	JERRYW	9/11/2016																																	
ENG. BY:	JERRYW																																		
APP. BY:	CL																																		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		:Title																																	
		HYDRAULIC SCHEMATIC																																	
<table border="1"> <thead> <tr> <th>INCH</th> <th>METRIC</th> </tr> </thead> <tbody> <tr><td>0</td><td>± 1</td></tr> <tr><td>.00</td><td>± .03</td></tr> <tr><td>.000</td><td>± .010</td></tr> <tr><td>ANGLES</td><td>± 30'</td></tr> <tr><td>FRACTIONS</td><td>± 1/16</td></tr> <tr><td>FLAME CUT</td><td>± 1/8</td></tr> <tr><td>WELDMENTS</td><td>± 1/8</td></tr> </tbody> </table>		INCH	METRIC	0	± 1	.00	± .03	.000	± .010	ANGLES	± 30'	FRACTIONS	± 1/16	FLAME CUT	± 1/8	WELDMENTS	± 1/8	<table border="1"> <thead> <tr> <th>METRIC</th> <th>INCH</th> </tr> </thead> <tbody> <tr><td>± 2.5mm</td><td>± .1</td></tr> <tr><td>± .75mm</td><td>± .03</td></tr> <tr><td>± .25mm</td><td>± .010</td></tr> <tr><td>± 30'</td><td>± 30'</td></tr> <tr><td>NA</td><td>NA</td></tr> <tr><td>± 3mm</td><td>± 1/8</td></tr> <tr><td>± 3mm</td><td>± 1/8</td></tr> </tbody> </table>		METRIC	INCH	± 2.5mm	± .1	± .75mm	± .03	± .25mm	± .010	± 30'	± 30'	NA	NA	± 3mm	± 1/8	± 3mm	± 1/8
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COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE Z, L, //		Drawing. No. 21-900-04 REV. NC																																	
SIZE D DO NOT SCALE		SHEET 1 OF 1																																	

NOTES:
 1. SYSTEM PRESSURE: 140 BAR
 2. PRESSURE SET UP:
 A. SET @ 100 BAR PRE-CHARGE
 B. SET @ 160 BAR SAFETY PRESSURE

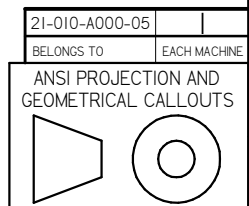
018-954-A000

REV	DESCRIPTION	DATE	APP
NC			



Item #	Qty	Rev	Document Number	Title
1	1	NC	950-DJD06T-NC	DIR. STACK, D03, A-B-T, DOUBE SPEED, W/TEST POINT
2	1	NC	950-DJG06T	HYD. DIR. VALVE STACK
3	1	01	950-DJP06T	DIR. STACK, D03, A-B-T, W/PRESS SW ON B & FLOW CONT, 8~210BAR
4	1		DAM AD05P033S	MANIFOLD
5	3		DAMAN ADAPTER AD03D05VAAB	ADAPTER
6	4		PAR 08 F5BU	HYD FITT
7	1		PAR 12 F5BU-S	HYD FITTING
8	1		PAR 16-12 F5BU-S	FITTING
9	1		PAR 6 HP50N	SAE HEX PLUG
10	2		PAR 8 C5BU-S	ELBOW FITTING
11	4		SHCS M8-1.25 X 12	SHCS
12	2		TOM 6408 12 HHP	HEX PLUG

LAST UPDATED 12/23/2021
TOTAL WEIGHT = 90.3 lbm



MACHINE #	M21	DATE	
DRAWN BY:	JerryW	03/18/21	
ENG. BY:	PC		
APP. BY:	CL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
INCH		METRIC	
.0	±.1	0.	±.25mm
.00	±.03	.0	±.75mm
.000	±.010	.00	±.25mm
ANGLES	±.30'	ANGLES	±.30'
FRACTIONS	±.1/16	FRACTIONS	NA
FLAME CUT	±.1/8	FLAME CUT	±.3mm
WELDMENTS	±.1/8	WELDMENTS	±.3mm
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel $\sqrt{\text{R}}$ OR BETTER ON ALL MACHINED SURFACES			



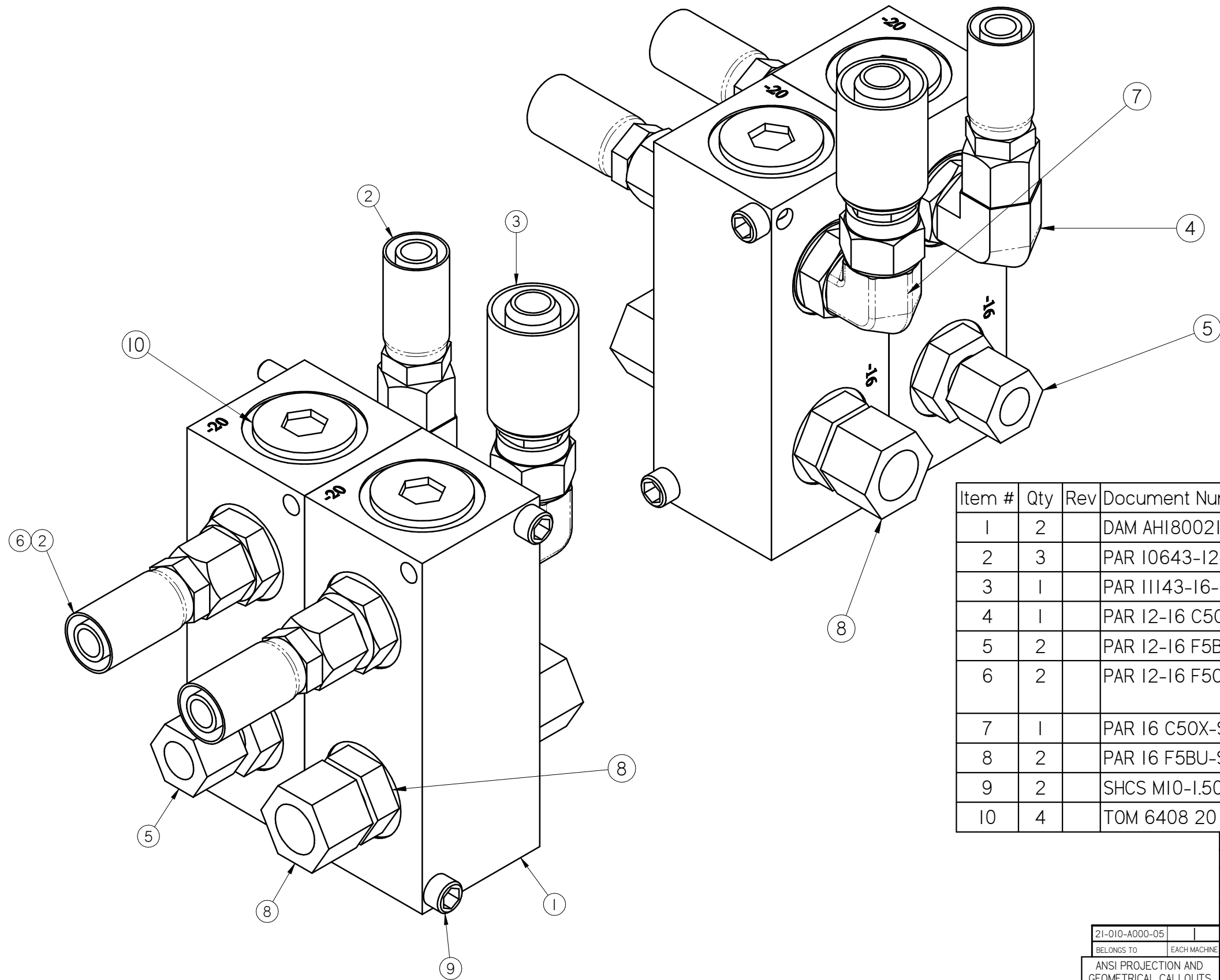
15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649

Title
CHUCK/EJECTOR MANIFOLD

Drawing No. **21-950-A015-02**


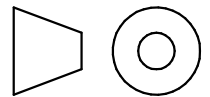
REV. **01**
SIZE **B** DO NOT SCALE SHEET **1** OF **1**

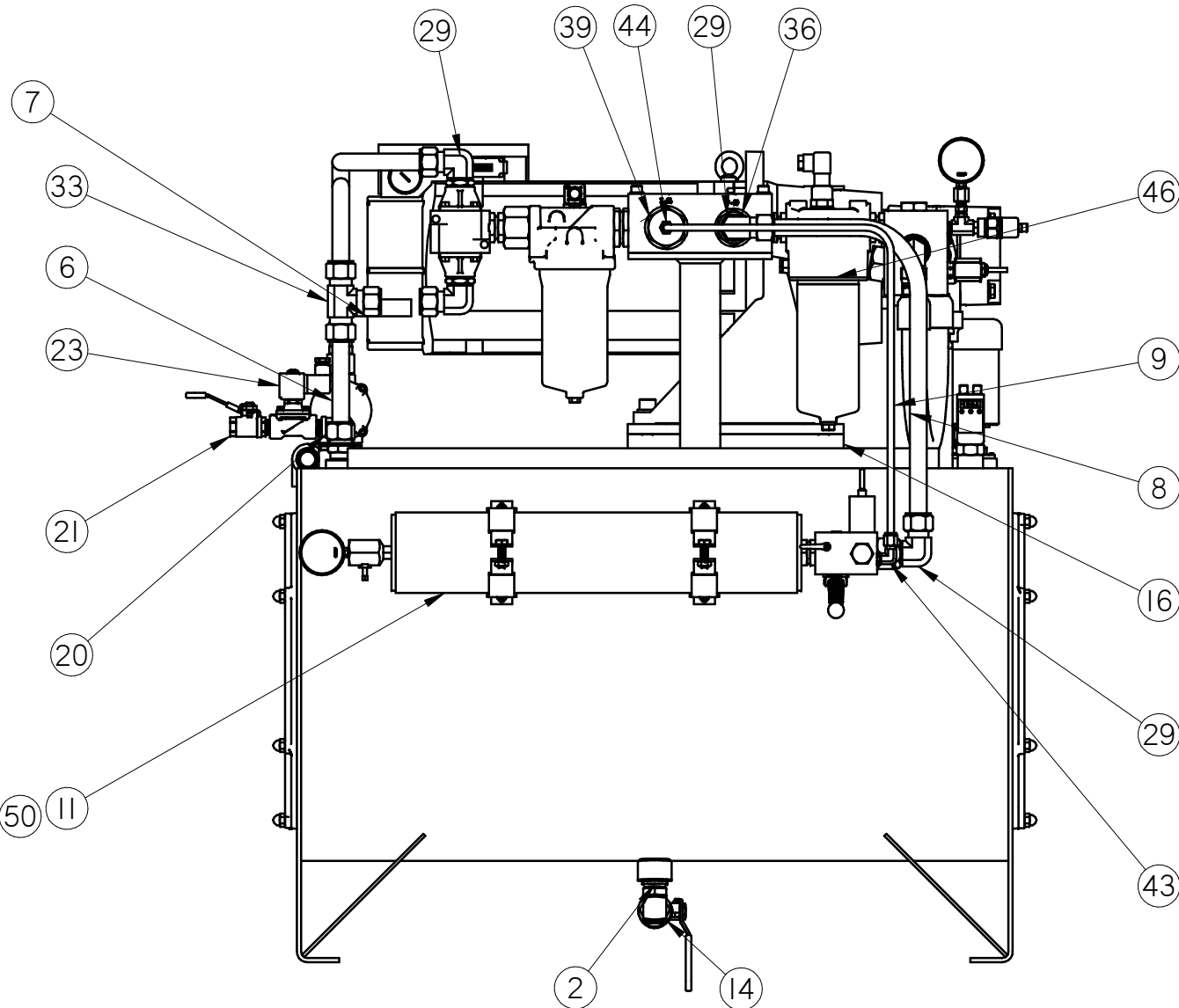
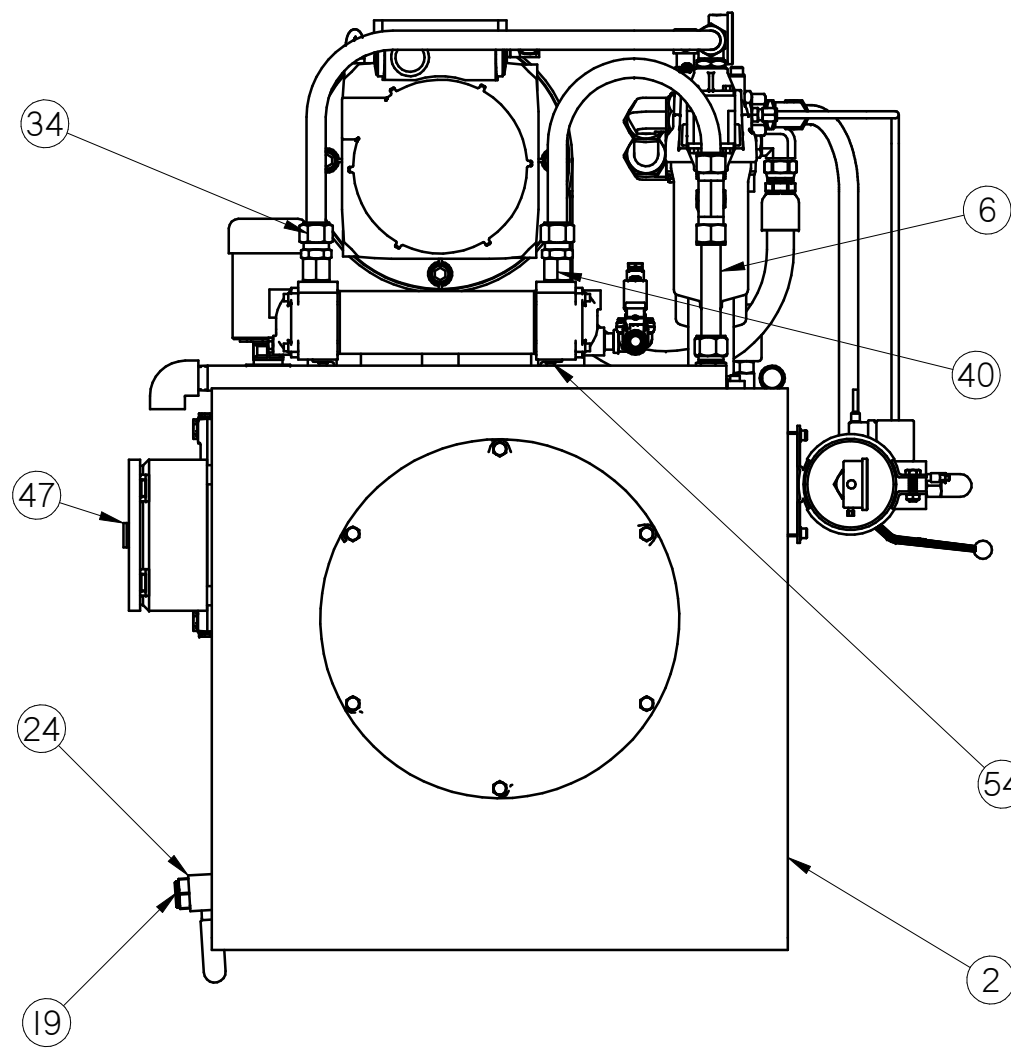
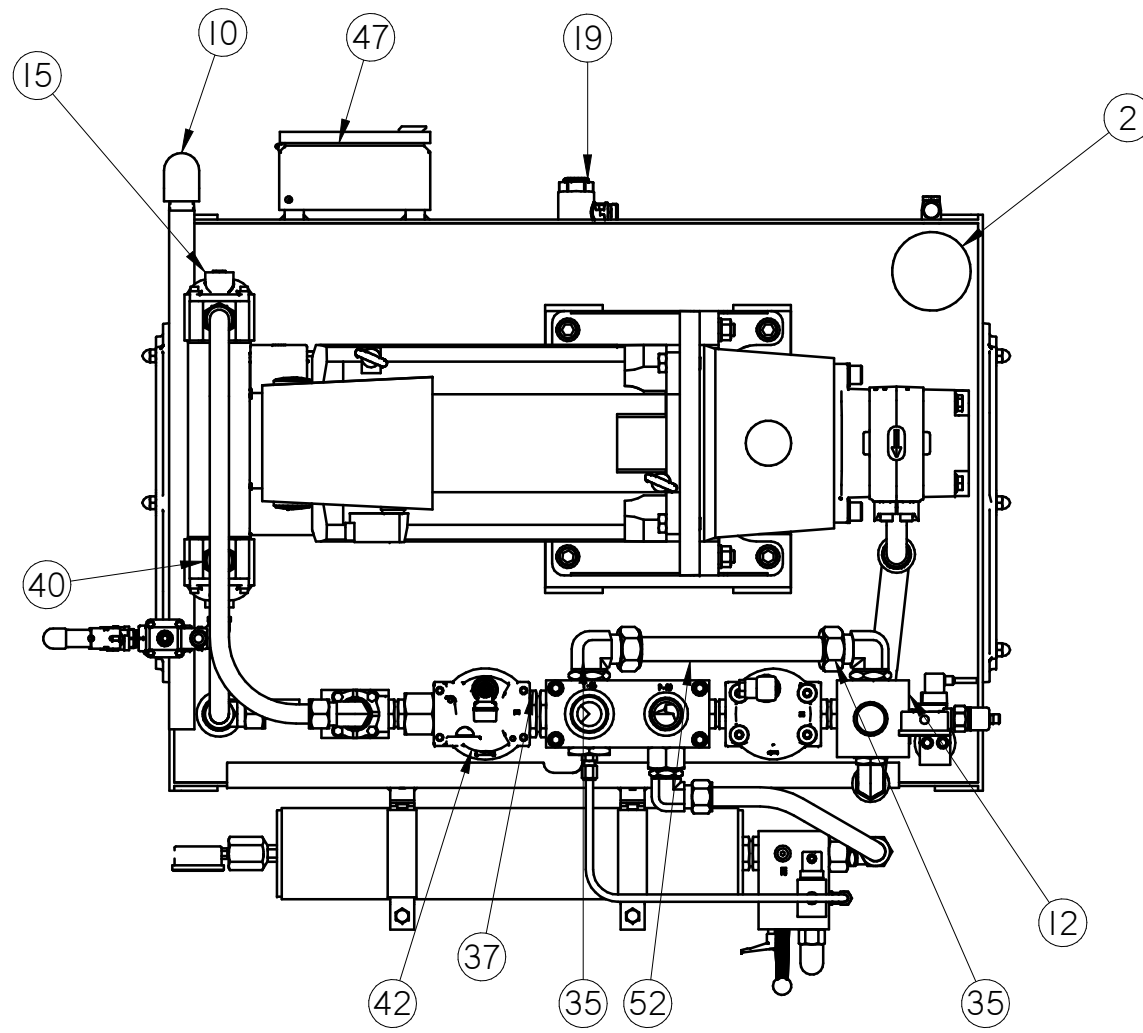
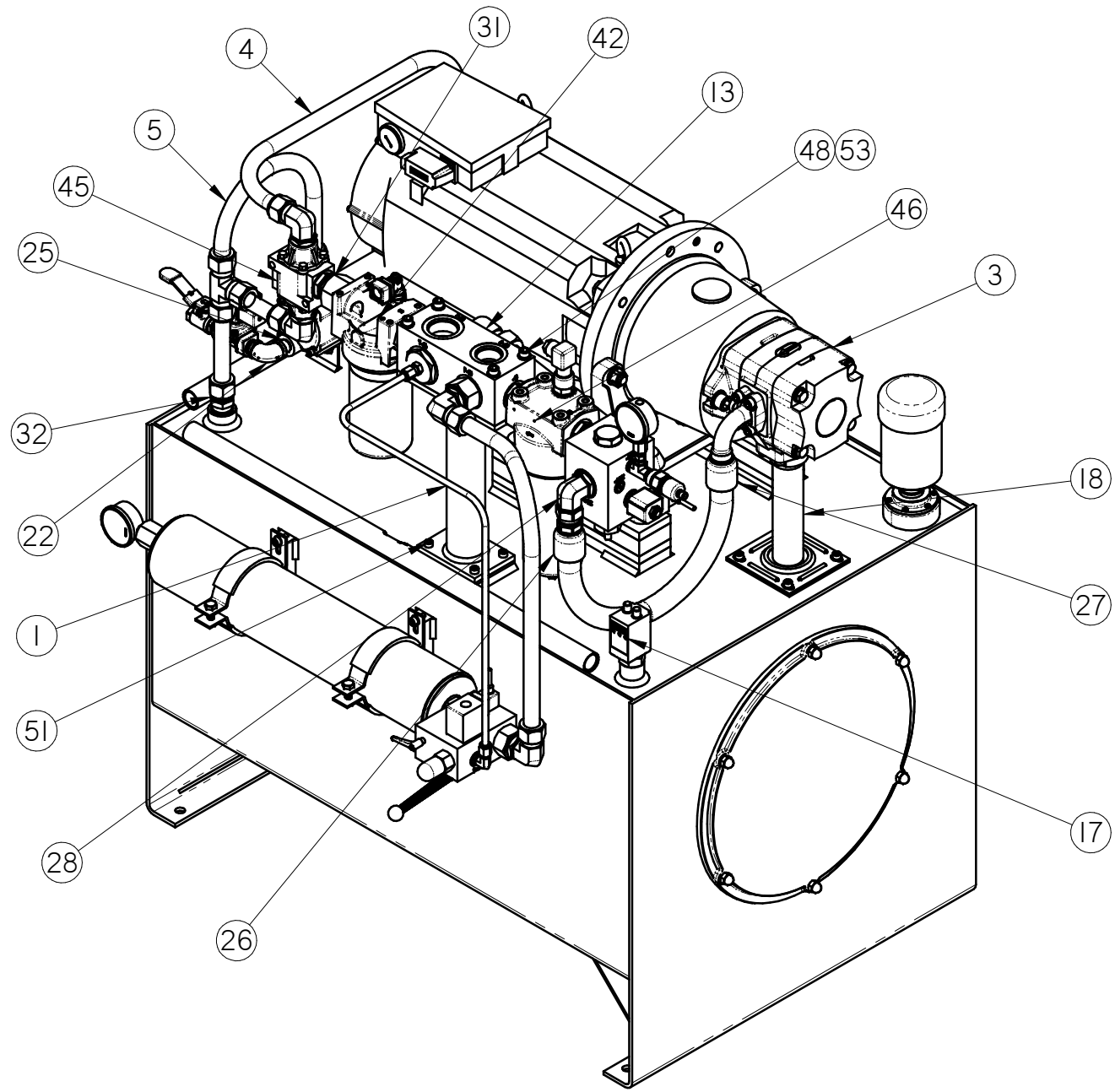
REV	DESCRIPTION	DATE	APP
NC			



Item #	Qty	Rev	Document Number	Title	Comments
1	2		DAM AH1800216S	HEADER BLOCK	180 DEG. 2 STATION -16
2	3		PAR 10643-12-12	HOSE END STRAIGHT	-8 HOSE -8 JIC
3	1		PAR 11143-16-16	FERULOK HOSE END	16 TUBE 16 HOSE
4	1		PAR 12-16 C50X-S	ELBOW, 16MORB-12MJ-90	
5	2		PAR 12-16 F5BU-S	HYD FITT	PAR 12 16 F5BU
6	2		PAR 12-16 F50X-S	HYD FITTING, ADAPTER, 12MJ-160RB	
7	1		PAR 16 C50X-S	ELBOW, 16MORB-16MJ-90	
8	2		PAR 16 F5BU-S	HYD FITT	
9	2		SHCS M10-1.50 X 170	SHCS	ZINC PLATED G 12.9
10	4		TOM 6408 20 HHP	HEX PLUG	

LAST UPDATED 1/10/2022
TOTAL WEIGHT = 39.0 lbm

MACHINE #	M21	DATE	
DRAWN BY:	JerryW	04/12/21	
ENG. BY:	PC		
APP. BY:	CL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
INCH		METRIC	
.0	±.1	0.	± 2.5mm
.00	±.03	.0	±.75mm
.000	±.010	.00	±.25mm
ANGLES	± 30°	ANGLES	± 30°
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm
COUNTERSINK BOTTOM OF COUNTERBORE BREAK ALL SHARP EDGES, NO BURRS ALLOWED ALL DATUMS TO BE \square , \perp , \parallel \sqrt{R} OR BETTER ON ALL MACHINED SURFACES			
21-010-A000-05		Title	
BELONGS TO EACH MACHINE		 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649 HYD JUNCTION ASSY	
ANSI PROJECTION AND GEOMETRICAL CALLOUTS		Drawing No.	
		21-950-A016-01	
		SIZE	REV.
		B	NC
		DO NOT SCALE	SHEET 1 OF 1



Item	Qty	Part Number	Description
1	1	004-954-A002	BRACKET, MANIFOLD
2	1	018-954-A001	RESERVOIR, 100 GALLON
3	1	018-954-A002	PUMP ASSY
4	1	018-954-T001	HYD TUBING -16
5	1	018-954-T002	HYD TUBING -16
6	1	018-954-T003	HYD TUBING -16
7	1	018-954-T004	HYD TUBING -16
8	1	15-954-T010	HYD TUBING, -16
9	1	15-954-T011	HYD TUBING, -6
10	1	IFP DARK GRAY PVC ELBOW	PLASTIC ELBOW CONNECTOR, 1 NPTF ELBOW
11	1	950-ACCI-A004	ACCU ASSY, 4 L.
12	1	954-A001-04	VALVES ASSY, HPU
13	1	954-PI00	MANIFOLD, HPU P/T
14	1	BRE 6806-16-16-NWO-S	HYD FITTING - ELBOW
15	1	KTR 140020342100	WATER/OIL COOLER, TAK/T2342
16	2	KTR 213500900000	DAMPING ROD, DSFS 350
17	1	KTR 263500020000	HYD LEVEL/TEMP SENSOR
18	1	LDI SCH40150TM27	PIPE, 1-1/2SCH40, 27" LG, TRIMED
19	1	MMC 44605K667	PLUG
20	1	MMC 4549K571	PIPE NIPPLE, CLOSE, 1/2", GAL
21	1	MMC 4629K43	BALL VALVE, 1/2" MALE/FEMALE,
22	1	MMC 4638K133	ELBOW, 1/2", #150, GAL
23	1	MMC 4711K732	SOLENOID VALVE, 1/2" NC, BRASS, DIN 24VDC
24	1	MMC 47865K25	BALL VALVE
25	1	MMC 4859K301	PIPE NIPPLE, 1/2NPT-1/2BSPT, 1-1/2"LG, GAL
26	1	PAR 10643-16-16	HOSE FITTING, 16FJ-16HOSE
27	1	PAR 11943-16-16	HOSE END, ELBOW, 16CODE61-16HOSE
28	1	PAR 16 C50X-S	HYD FITTING - ELBOW
29	4	PAR 16 C5BU-S	HYD FITTING - ELBOW
30'	2	PAR 16 F50HA0-S	HYD FITTING - STRAIGHT
31	1	PAR 16 F50HA0-S	HYD FITTING, STRAIGHT
32	1	PAR 16 FBUS-S	HYD FITTING - CONNECTOR
33	1	PAR 16 JBUS-S	TEE, 16BT-16BT-16BT
34	2	PAR 16-12 F5BU-S	FITTING
35	2	PAR 20 C5BU-S	HYD FITTING - ELBOW
36	1	PAR 20-16 F50G5-S	HYD FITTING - REDUCER
37	1	PAR 24 F50HA0-S	HYD FITTING - UNION
38"	1	PAR 24-16 F50G5-S	HYD FITTING, REDUCER
39	1	PAR 24-6 F50G5-S	HYD FITTING - ADAPTER
40	2	PAR 3/4-12 F40HG5-S	ADAPTER, 12MBSPP-12FORB
41"	1	PAR 387TC-16	HOSE -16, CUT LG 24"
42	1	PAR 40CN220QEBE2KS244	HYD FILTER
43	1	PAR 6 C5BU-S	HYD FITTING, ELBOW
44	1	PAR 6 F5BU-S	HYD FITTING
45	1	PAR TH-1000-16F0-05	HYD VALVE, THERMAL BYPASS, -16SAE
46	1	PAR WPF310QEBE2KS161	HYD FILTER
47	1	RIT JB080804HC	ELECT BOX
48	4	SHCS M10-1.50 X 100	SHCS
49"	4	SHCS M16-2.00 X 30	SHCS

MACHINE #	STD	DATE
DRAWN BY:	JerryW	04/05/21
ENG. BY:	JerryW	
APP. BY:	CL	



15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649

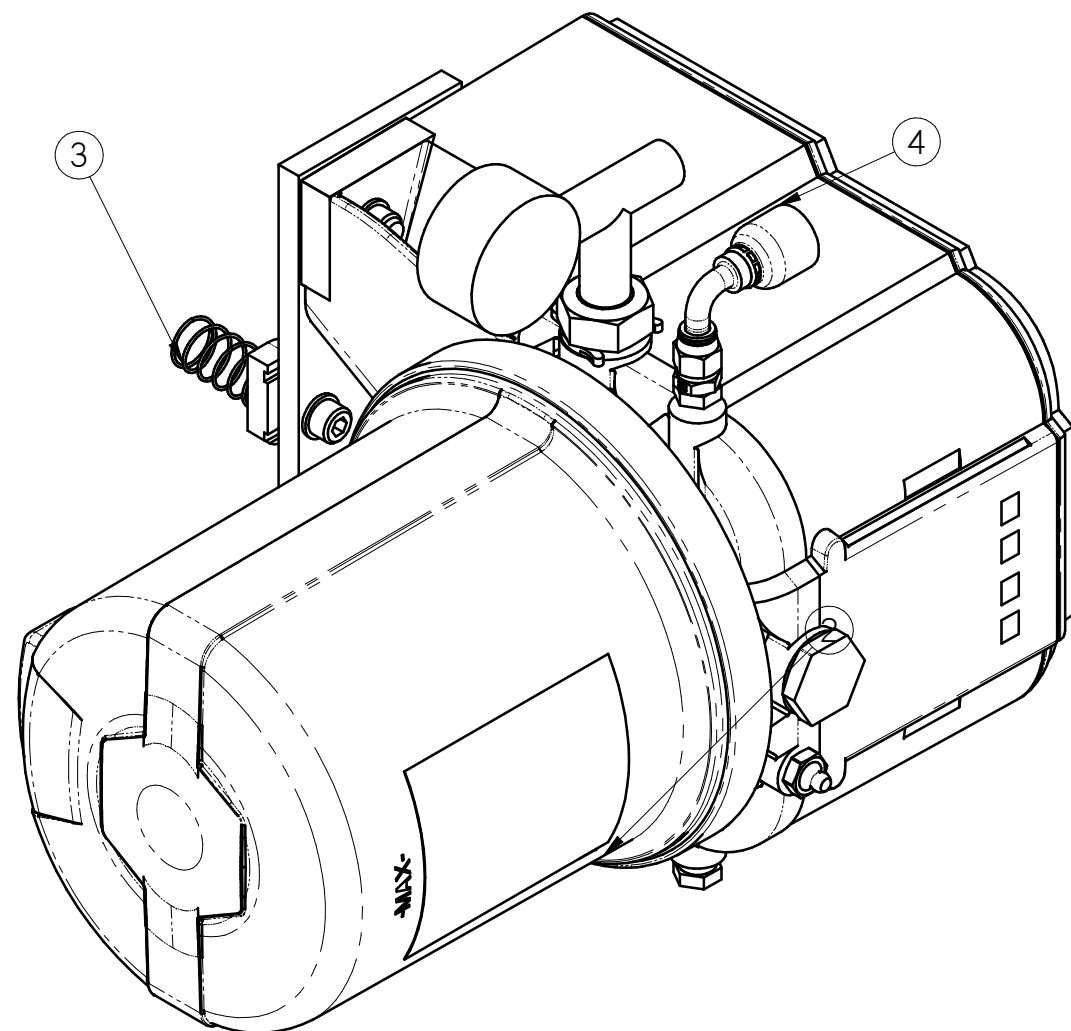
Title	
HPU	
Drawing. No.	REV.
018-954-A000	NC
SIZE	SHEET
C	DO NOT SCALE SHEET 1 OF 1

Item	Qty	Part Number	Description
50	4	SHCS M6-1.00 X 16	SHCS
51	4	SHCS M8-1.25 X 18	SHCS
52	1	TUBING 20-4	HYD TUBING, -20
53	4	WASHER M10	WASHER
54	4	WASHER M6	WASHER

INCH		METRIC	
.0	± .1	.0	± 2.5mm
.00	± .03	.0	± .75mm
.000	± .010	.00	± .25mm
ANGLES	± 30'	ANGLES	± 30'
FRACTIONS	± 1/16	FRACTIONS	NA
FLAME CUT	± 1/8	FLAME CUT	± 3mm
WELDMENTS	± 1/8	WELDMENTS	± 3mm


COUNTERSINK BOTTOM OF COUNTERBORE
BREAK ALL SHARP EDGES, NO BURRS ALLOWED
ALL DATUMS TO BE \square , \perp , \parallel

REV	DESCRIPTION	DATE	APP
NC			



Item	Qty	Document #	Rev	Title	Comments
1	1	21-960-P001	NC	GREASE PUMP MOUNT	
2	1	GRAC 96GI82-F		GREASE PUMP	2L WITH GAUGE AND AUTO RELIEF
3	2	MMC 3259T52		STRUT CHANNEL NUT	M8
4	1	PAR 13943-4-4		ELBOW HOSE END 04FJ-04HOSE-90	
5	1	PAR 4 FTX-S		HYD FITTING, 1/4 NPT-04MJ	
6	4	SHCS M8-1.25 X 25		SHCS	ZINC PLATED G 12.9
7	4	WASHER M8		WASHER	ZINC PLATED G 12.9

LAST UPDATED 2/4/2022
TOTAL WEIGHT = 5.1 lbm

MACHINE #	DATE	 15401 ASSEMBLY LN. HUNTINGTON BEACH, CA 92649																																
DRAWN BY: JerryW	04/15/21																																	
ENG. BY: JerryW																																		
APP. BY: PC																																		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		Title: GREASE PUMP ASSY																																
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INCH		METRIC																																
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BELONGS TO	EACH MACHINE																																	
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