

VIEW SHOWING LOCKOUT
HANDLE/CAM ASSEMBLY



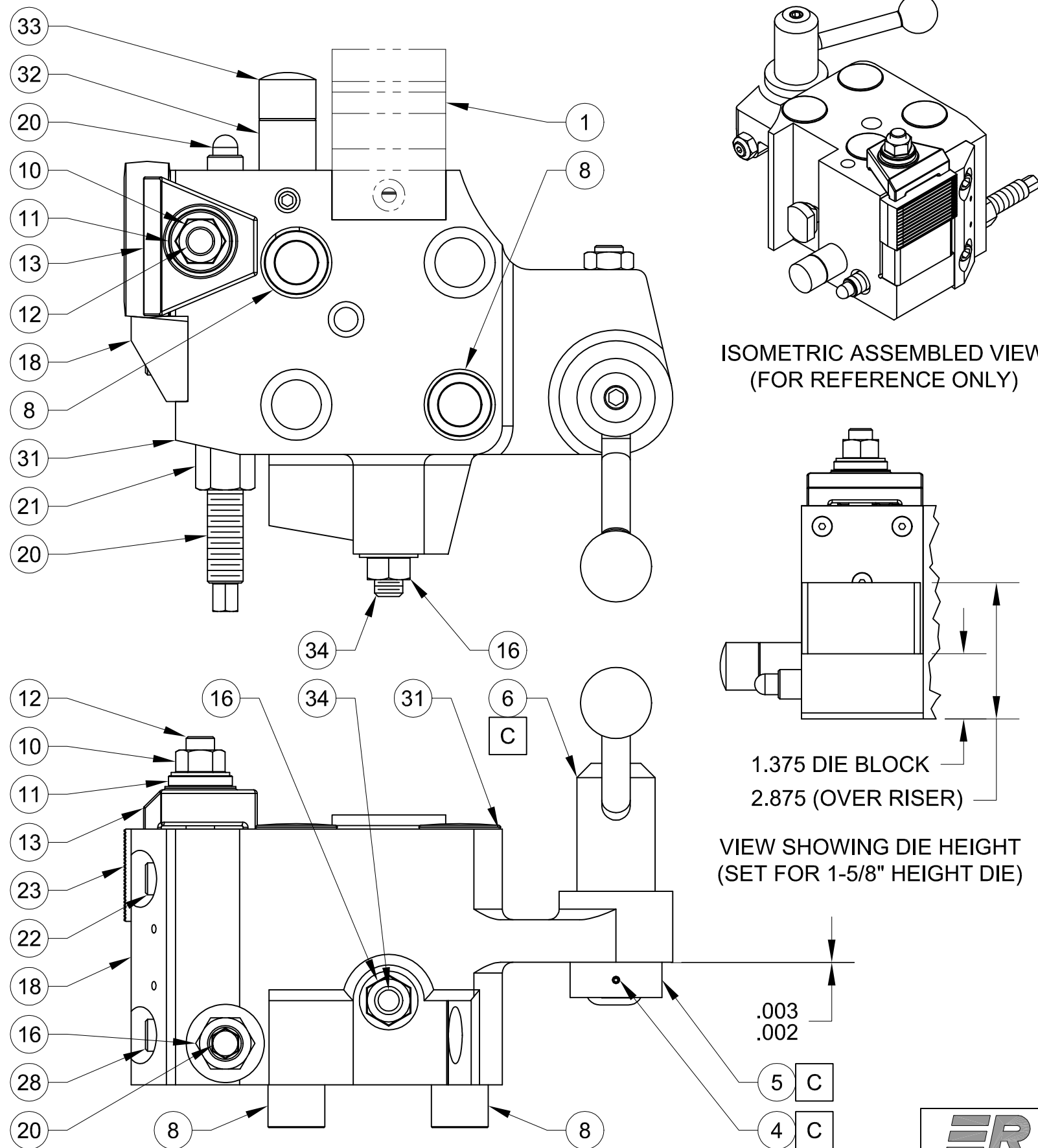
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PRIOR WRITTEN
CONSENT.

MACHINING		FABRICATION	
X	± .040	ALL	± .06
X.X	± .020	ANGULAR	2°
X.XX	± .010	ALL FINISHES	125mu
X.XXX	± .005	DEBURR ALL SHARP	CORNERS OR EDGES
ANGULAR	± 1/2°		

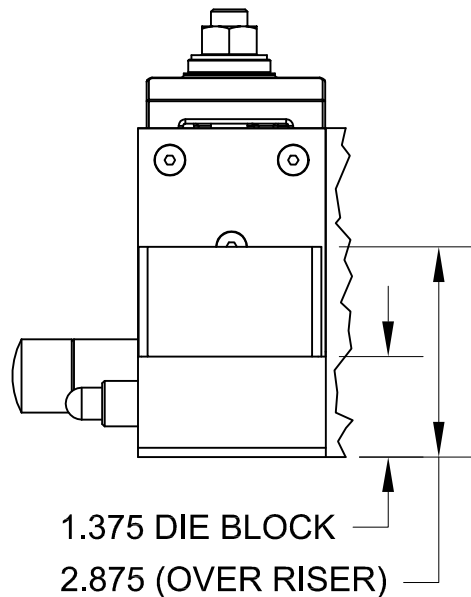
SCALE: 1:1
DRAWN BY: MLGATES
DATE: 24AUG18
CHECKED BY:
DATE:

TITLE: HARTFORD, 0-400 THD
ASSEMBLY, STATIONARY DIE BLOCK
SIZE: B SHEET: 1 OF 2 REV:
DWG NO: 319001710A

AUTOCAD DRAWING: FORM REVISION 13MAR12



ISOMETRIC ASSEMBLED VIEW
(FOR REFERENCE ONLY)



VIEW SHOWING DIE HEIGHT
(SET FOR 1-5/8" HEIGHT DIE)

ITEM	QTY	DESCRIPTION	LENGTH	UM	PART NUMBER	MATERIAL	TYP
1	REF	BRACKET, FRONT TRACK (RAIL)		EA	319012430		D
2	1	NUT, HEX THIN 1/2"-13 GRD5		EA	*94846A523	STEEL	P
3	1	SETSCREW, SPRING BALL 1/2"-13	1.5	EA	*91677A134	STEEL	P
4	1	PIN, SPRING ROLL 1/8" DIA	1.5	EA	*98296A887	STEEL	P
5	1	CAM, STARTER ARM LOCKOUT		EA	319001910		D
6	1	HANDLE, STARTER LEVER LOCKOUT		EA	319001000		D
7	1	SETSCREW, CUP POINT 1/2"-13	.625	EA	*91375A709	STEEL	P
8	2	BUSHING, STAT. DIE BLOCK LOCATING		EA	3190-2-P86		D
9	2	CAPSCREW, SOCKET HD 3/4"-10	3.50	EA	*90044A180	STEEL	P
10	1	NUT, STATIONARY DIE CLAMP		EA	3190-2-P123		D
11	1	WASHER, FLAT HARD HEAVY 1/2"		EA	*98099A033	STEEL	P
12	1	STUD, STATIONARY DIE CLAMP		EA	3190-2-P122		D
13	1	CLAMP, STATIONARY DIE TOP		EA	319008940		D
14	4	PLUG, STATIONARY DIE BLOCK		EA	3190-2-P140		D
15	2	CAPSCREW, SOCKET HD 3/4"-10	2.50	EA	*91251A845	STEEL	P
16	1	NUT, HEX FLANGE 1/2"-13		EA	*94902A104	STEEL	P
17	1	SETSCREW, CUP POINT 7/8"-9	1.0	EA	*91375A872	STEEL	P
18	1	STOP, STATIONARY DIE		EA	319000640		D
19	2	WASHER, FLAT HARD HEAVY 3/8"		EA	*98029A031	STEEL	P
20	1	STUD, STARTER ARM ADJUSTING		EA	319008240		D
21	1	NUT, STARTER ARM ADJUSTING STUD		EA	319009030		D
22	1	CAPSCREW, SOCKET HD 3/8"-16	.875	EA	*91251A623	STEEL	P
23	REF	DIE, STATIONARY (1-5/8", 1-1/4", 3/4")		EA		STEEL	P
24	REF	RISER, STATIONARY DIE (3/4" DIE)		EA	319000962		D
25	REF	RISER, STATIONARY DIE (1-1/4" DIE)		EA	319000961		D
26	2	CAPSCREW, SOCKET HD 1/4"-20	1.75	EA	*91251A548	STEEL	P
27	1	RISER, STATIONARY DIE (1-5/8" DIE)		EA	319000960		D
28	1	CAPSCREW, SOCKET HD 3/8"-16	.625	EA	*91251A621	STEEL	P
29	5	CAPSCREW, FLAT HD 10-24	.5	EA	*91253A242	STEEL	P
30	1	PLATE, STATIONARY DIE BACKING		EA	319000950		D
31	1	BLOCK, STATIONARY DIE		EA	319001710		D
32	1	ADAPTER, BUMPER		EA	319001860		D
33	1	BUMPER, STARTER ARM		EA	3190-2-P82		D
34	1	STUD, RAIL HEIGHT ADJUSTMENT		EA	3190-5-P30		D
		* PURCHASE FROM McMASTER-CARR					

- A ASSEMBLE USING REMOVABLE THREAD LOCKING COMPOUND (BLUE)
- B DIE RISERS ARE OPTIONAL (CUSTOMER MUST SPECIFY DIE HEIGHT)
- C USING LOCKOUT CAM (ITEM 5) AS A TEMPLATE, DRILL LOCKOUT HANDLE (ITEM 6) AS SHOWN. HANDLE SHOULD ROTATE FREELY AFTER ASSEMBLY.



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X.X, ±.020	ANGULAR 2°	CHECKED BY:
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X.XXX, ±.005	DEBURR ALL SHARP CORNERS OR EDGES	
ANGULAR ± 1/2°		

TITLE: HARTFORD, 0-400 THD ASSEMBLY, STATIONARY DIE BLOCK		
SIZE: B	SHEET: 2 OF 2	REV:
DWG NO: 319001710A		