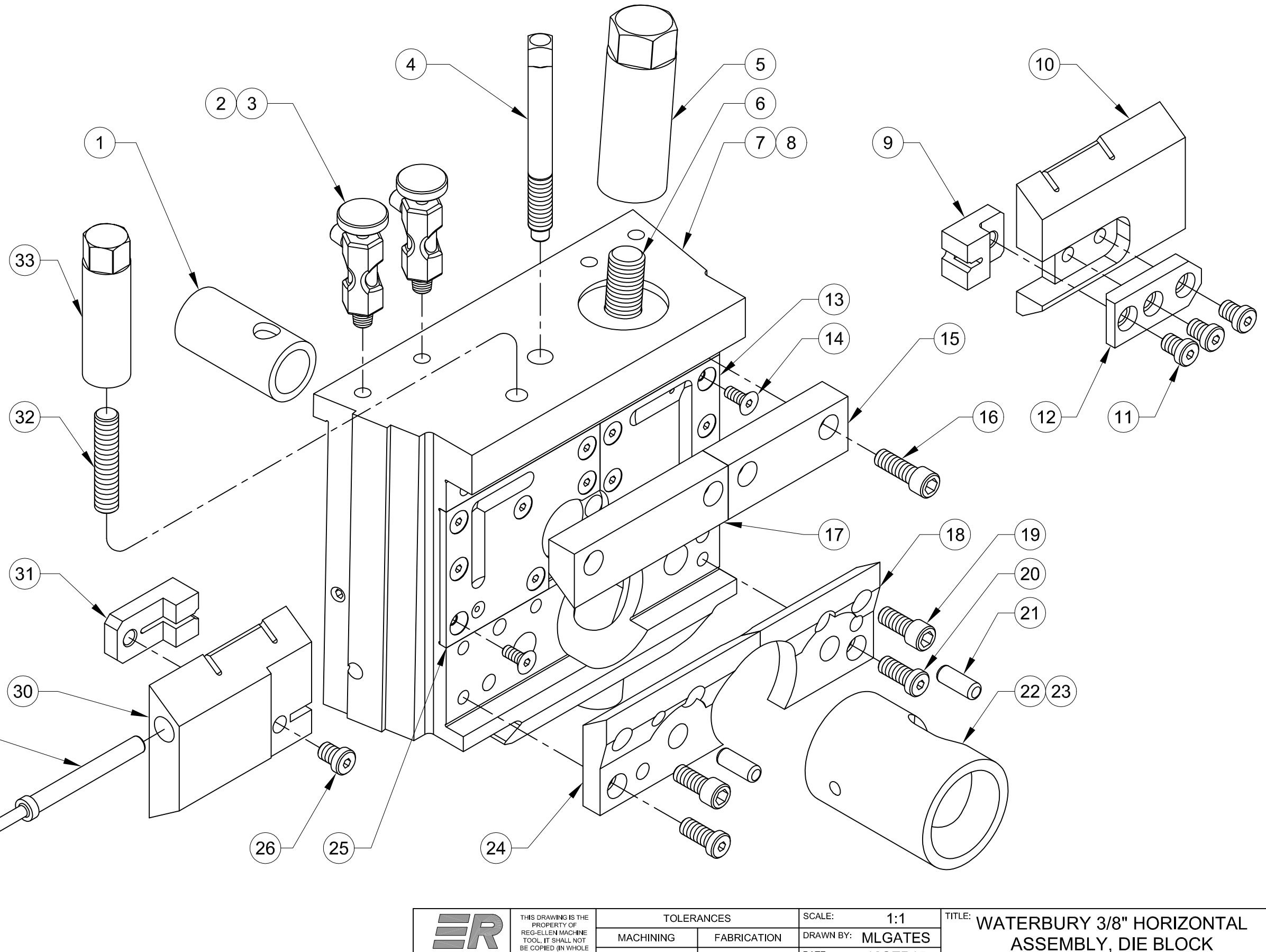


ASSEMBLED ISOMETRIC VIEW
(FOR REFERENCE ONLY)



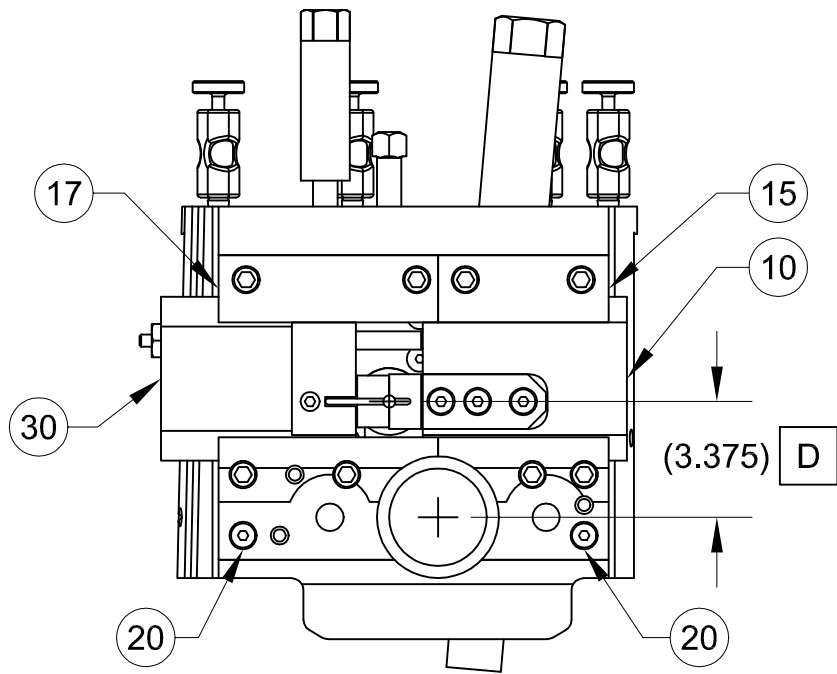
THIS DRAWING IS THE PROPERTY OF REG-ELLEN MACHINE TOOL. IT SHALL NOT BE COPIED (IN WHOLE OR IN PART), FOR MANUFACTURE OR OTHERWISE DISCLOSED WITHOUT PRIOR WRITTEN CONSENT.

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

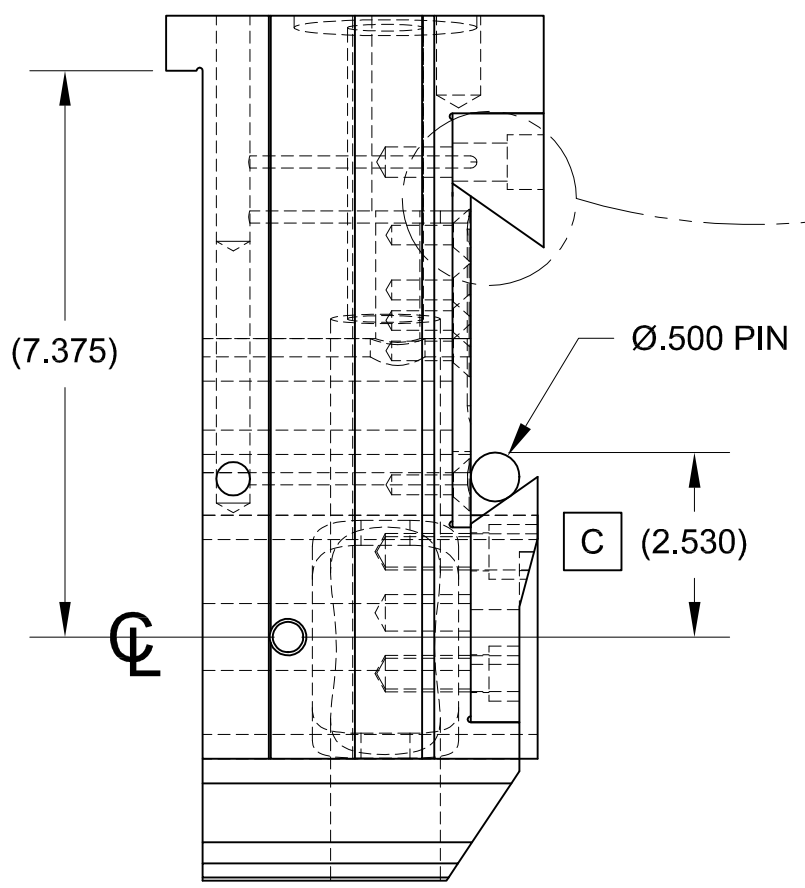
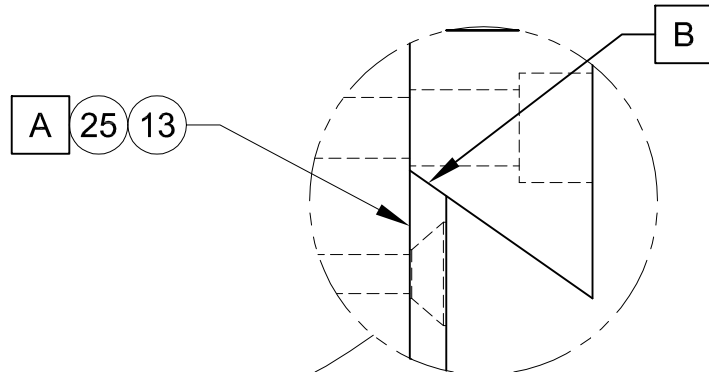
SCALE: 1:1
DRAWN BY: MLGATES
DATE: 12SEP15
CHECKED BY:
DATE:

TITLE: WATERBURY 3/8" HORIZONTAL ASSEMBLY, DIE BLOCK		
SIZE: B	SHEET: 1 OF 1	REV:
DWG NO: 753316100A		

AUTOCAD DRAWING: FORM REVISION 13MAR12



- A** FIT LINERS (ITEMS 13, 25) SO THAT THEY ARE FLUSH OR SLIGHTLY HIGHER THAN THE RECESS IN THE DIE BLOCK.
- B** WATCH FOR INTERFERENCE. MODIFY THE GIBS (ITEMS 17, 15, 18, 24) OR THE LINERS (ITEMS 13, 25), IF NECESSARY, TO ENSURE THAT THE GIBS FIT FLAT TO THE DIE BLOCK.
- C** GRIND DOVETAIL ON THE LOWER GIBS TO 2.530 DIM, AS SHOWN OVER A .500 DIA. PIN.



- D** GRIND THE CUTOFF SLIDE (ITEM 30) AND THE CUTOFF RETURN SLIDE (ITEM 10) SO THE KNIFE CENTERLINE IS MAINTAINED WITH THE QUILL CENTERLINE.
- E** GRIND THE UPPER GIBS (ITEMS 17,15) TO ALLOW .002/.003 SLIDE CLEARANCE.
- F** AFTER FITTING LOWER GIBS (ITEMS 24,18) PIN IN PLACE.

ITEM	QTY	DESCRIPTION	LENGTH	UM	PART NUMBER	MATERIAL	TYP
1	1	SLEEVE, QUILL		EA	753313100		D
2	4	OILER, DRIP		EA	1137K3	BRASS	P
		PURCHASE FROM McMASTER-CARR					
3	4	NIPPLE 1/8 PIPE	.75	EA	4568K111	BRASS	P
		PURCHASE FROM McMASTER-CARR					
4	1	SCREW, QUILL LOCK		EA	753313030		D
5	1	NUT, DRAWBOLT		EA	753313040		D
6	1	DRAWBOLT		EA	753313090		D
7	1	DIEBLOCK		EA	753316100		F
8	2	PLUG, 1/8 PIPE		EA	9171K251	BRASS	P
		PURCHASE FROM McMASTER-CARR					
9	REF	KNIFE, RETURN		EA	RERTK60200		D
10	1	SLIDE, CUTOFF RETURN		EA	753313200		D
11	3	CAPSCREW, 1/2"-13 LOWHEAD SOC	.687	EA	92220A261	STEEL	P
		PURCHASE FROM McMASTER-CARR					
12	1	PLATE, BACKING		EA	753313220		D
13	1	LINER, RIGHT		EA	753313160		D
14	13	CAPSCREW, 5/16"-18 FLATHEAD	.75	EA	91253A581	STEEL	P
		PURCHASE FROM McMASTER-CARR					
15	1	GIB, UPPER RIGHT		EA	753313120		D
16	4	CAPSCREW, 1/2"-13 IND HEX	1.75	EA	91251A718	STEEL	P
		PURCHASE FROM McMASTER-CARR					
17	1	GIB, UPPER LEFT		EA	753313110		D
18	1	GIB, LOWER RIGHT		EA	753313190		D
19	4	CAPSCREW, 1/2"-13 IND HEX	1.0	EA	91251A712	STEEL	P
		PURCHASE FROM McMASTER-CARR					
20	2	CAPSCREW, 1/2"-13 LOWHEAD SOC	1.0	EA	92220A261	STEEL	P
		PURCHASE FROM McMASTER-CARR					
21	2	PIN, 1/2" DOWEL	1.25	EA	98381A714	STEEL	P
		PURCHASE FROM McMASTER-CARR					
22	1	SLEEVE, DIE		EA	752913170		D
23	2	PIN, 3/8" DOWEL	.875	EA	98381A354	STEEL	P
		PURCHASE FROM McMASTER-CARR					
24	1	GIB, LOWER LEFT		EA	753313180		D
25	1	LINER, LEFT		EA	753313150		D
26	1	CAPSCREW, 1/2"-13 LOWHEAD SOC	1.0	EA	92220A261	STEEL	P
		PURCHASE FROM McMASTER-CARR					
27	1	BUSHING, STOP ROD		EA	753313340		D
28	1	SPRING, STOP ROD		EA	753313130		D
29	1	ROD, STOP		EA	753313140		D
30	1	SLIDE, CUTOFF		EA	753313210		D
31	REF	KNIFE, CUTOFF		EA	RECOK60200C		D
32	1	STUD, WIRE STOP HOLDDOWN		EA	753313310		D
33	1	NUT, WIRE STOP HOLDDOWN		EA	753313330		D



THIS DRAWING IS THE PROPERTY OF REG-ELLEN MACHINE TOOL. IT SHALL NOT BE COPIED (IN WHOLE OR IN PART), FOR MANUFACTURE OR OTHERWISE DISCLOSED WITHOUT PRIOR WRITTEN CONSENT.

TOLERANCES	
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: 12SEP15
 CHECKED BY:
 DATE:

TITLE: WATERBURY 3/8" HORIZONTAL ASSEMBLY, DIE BLOCK
 SIZE: B SHEET: 1 OF 1 REV:
 DWG NO: 753316100A

AUTOCAD DRAWING: FORM REVISION 13MAR12