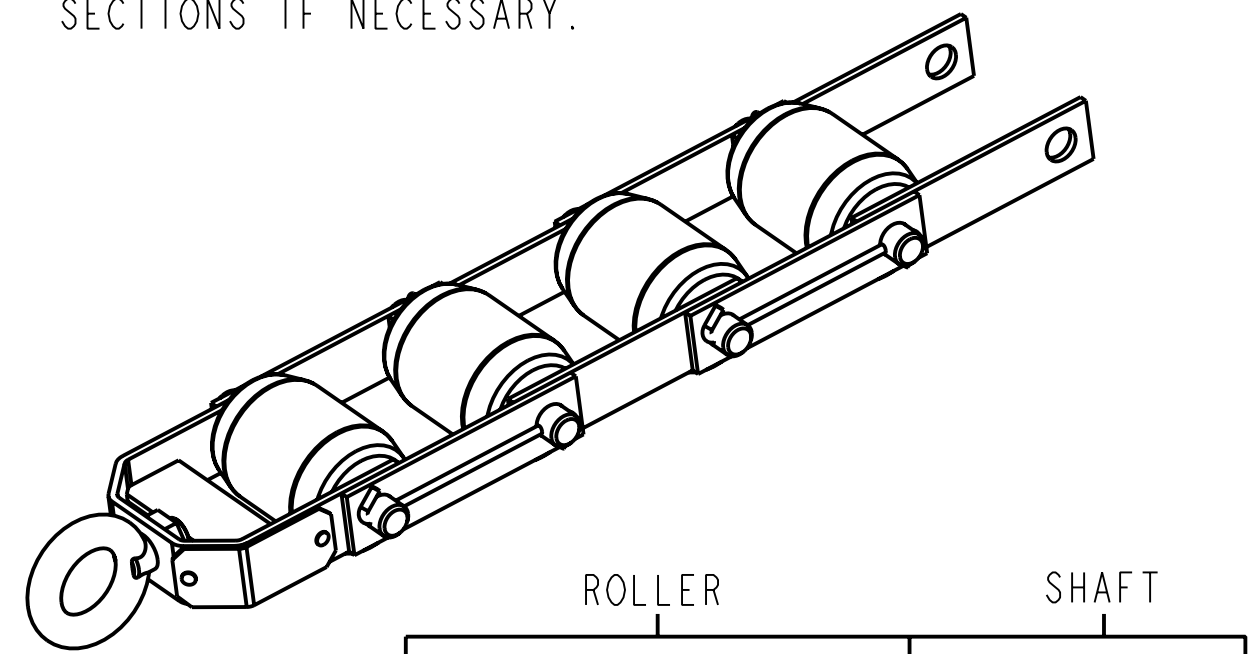
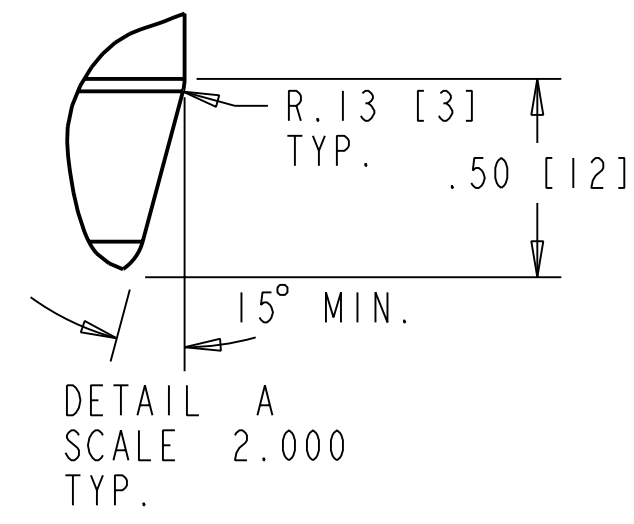
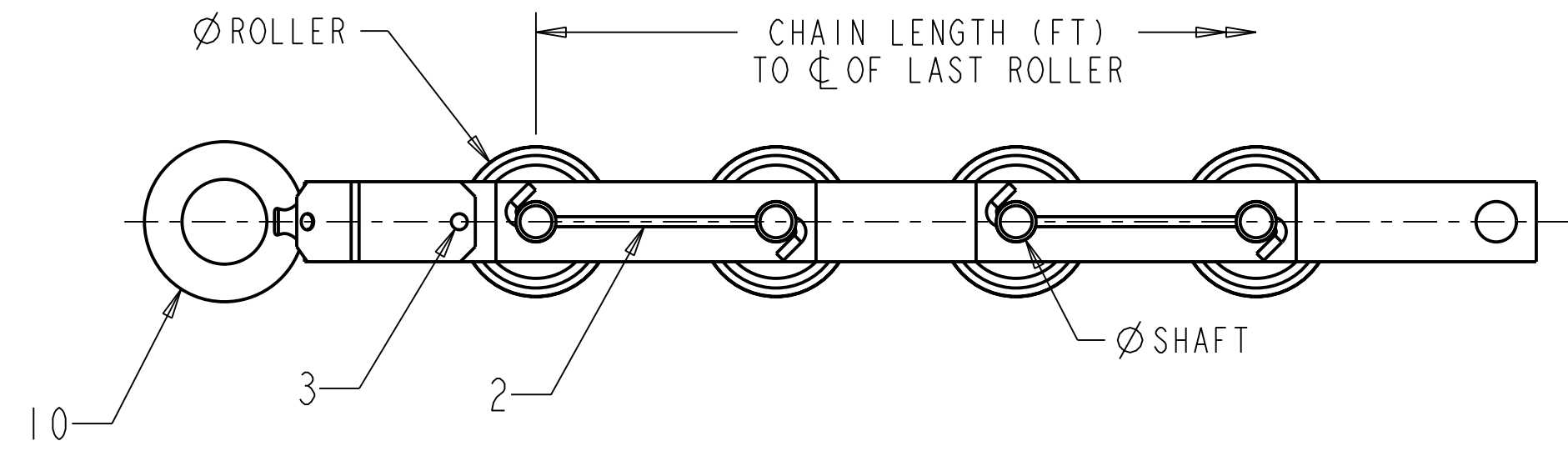
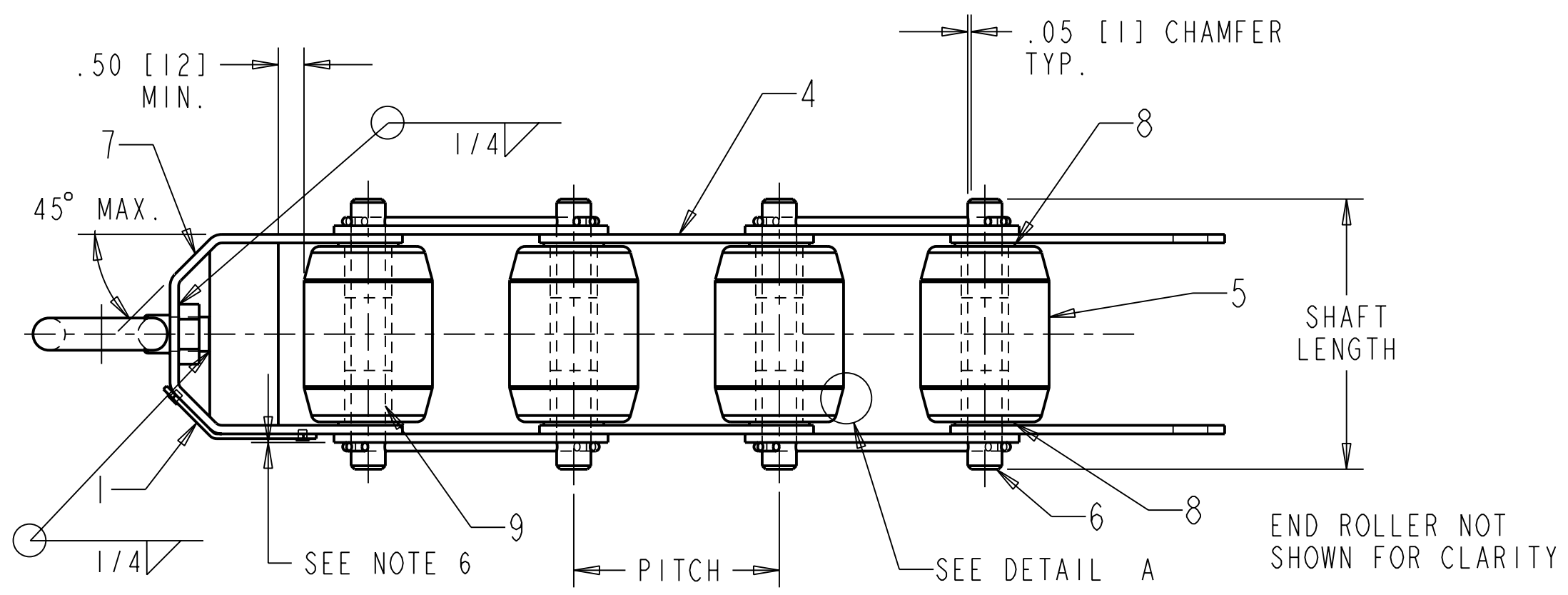


- NOTES
1. DIMENSIONS IN INCHES [mm]
 2. GENERAL TOLERANCES ± 0.06 ,
HOLE DIA. TOLERANCES ± 0.01 ,
UNLESS OTHERWISE SPECIFIED.
 3. MATERIAL: MILD STEEL UNLESS OTHERWISE NOTED.
 4. FINISH: GRIND OFF SHARP
CORNERS AND CLEAN ALL SURFACES
 5. PAINT: NONE
- FABRICATION:
6. SHAFT (ITEM 6) SHOULD BE AN EASY SLIDING
FIT. TRANSVERSE MOVEMENT OF SHAFT SHOULD
BE LIMITED TO $+0.005$ " [.13] / $+0.01$ [.25], CUMULATIVE.
FINAL ASSEMBLY SHOULD ENSURE LEAST PRACTICAL
PLAY. ROLLERS SHOULD ROTATE SMOOTHLY.
 7. BUSHINGS TO BE PRESS FIT IN.
 8. ALL PARTS SUPPLIED BY FABRICATOR.
- INSPECTION:
9. WEIGH THE CHAIN WITH SHACKLES REMOVED ON A
"WEIGHTS & MEASURES" CERTIFIED SCALE WITH
A MINIMUM RESOLUTION OF 0.5 LBS. LINKS AT .01 LBS.
 10. MEASURE THE LENGTH OF THE TEST CHAIN FROM THE
CENTER LINES OF THE LAST ROLLERS WHILE THE TEST
CHAIN IS FULLY STRETCHED ON A FLAT SURFACE.
 11. MEASURE THE LENGTH OF THE TEST CHAIN FROM THE
CENTER LINES OF THE LAST ROLLERS WHILE THE TEST
CHAIN IS FULLY COMPRESSED ON A FLAT SURFACE.
 12. THE CHAIN SHOULD APPEAR AS SHOWN, AND MAY BE 1
PITCH LONGER THEN STATED ON THE PURCHASE ORDER.
 13. FORM 2-306 MUST BE COMPLETED AND SENT FOR
APPROVAL FROM APPLICATION ENGINEERING.
 14. STAMP BRASS PLATE PER RETURNED FORM 2-306 AND
FASTEN TO SHACKLE WITH RIVETS.
- SHIPMENT:
15. PRIOR TO SHIPMENT SOAK TEST CHAIN IN A RUST
INHIBITOR. WRAP IN PLASTIC SHEETING.
 16. PACK AND SHIP THE CHAIN IN WOODEN CRATE(S) IN
SECTIONS IF NECESSARY.



ITEM NO.	DESCRIPTION
1	BRASS PLATE 14GA. 1"X2-33/64"
2	PIN 304 SS BAR
3	RIVET, SPAE-NAUR RVT-2008
4	TEST CHAIN LINK, CRS
5	TEST CHAIN ROLLER, MS
6	TEST CHAIN SHAFT, CRS
7	TEST CHAIN SHACKLE, MS
8	FLAT WASHER, SAE ZINC PL.
9	BUSHING, BOSTON OIL-IMP
10	EYE-BOLT, SPAE-NAUR EYB-12, MIN

ITEM NO.	LBS/FT	PITCH	DIA.	LENGTH	DIA.	LENGTH	LINK DIM.	PIN DIA.	BUSHING NO.
7MH71610A	5	6.0"	1.875"	2.56"	1/2"	3.94"	.125 x 1 x 7.0"	1/8"	B811-6
7MH71610B	7.5	6.0"	2.0"	3.73"	1/2"	5.11"	.125 x 1 x 7.0"	1/8"	B811-6
7MH71610C	10	4.0"	2.125"	2.90"	1/2"	4.28"	.125 x 1.25 x 5.25"	1/8"	B811-6
7MH71610D	15	4.0"	2.25"	4.00"	9/16"	5.41"	.125 x 1.5 x 5.5"	1/8"	B912-6
7MH71610E	20	4.0"	2.5"	4.52"	9/16"	5.93"	.125 x 1.5 x 5.5"	1/8"	B912-6
7MH71610F	25	4.0"	2.75"	4.50"	9/16"	6.16"	.1875 x 1.5 x 5.5"	1/8"	B912-6
7MH71610G	30	4.0"	2.875"	5.06"	5/8"	6.90"	.1875 x 1.5 x 5.5"	5/32"	B1014-8
7MH71610H	35	4.0"	3.0"	5.50"	5/8"	7.34"	.1875 x 1.5 x 5.5"	5/32"	B1014-8

LENGTH DIMENSIONS PROVIDED ON PURCHASE ORDER. Z ORDER CODE, LENGTH PROVIDED IN FEET.

03 UPDATE TO NEW MLFB NUMBERS MM MM MAR 04/08
 02 UPDATE TO PRO-E DRAWING MM JM OCT 04/05

DIMENSIONS ARE IN INCHES
 USE DIMENSIONS ONLY- DO NOT SCALE

Rev Description Drw Appr Date

THIRD ANGLE PROJECTION

PRODUCT GROUP: MASS DYNAMICS
 DATE: OCT 4, 2005
 DRAWN: M. MORRISSEY

TOLERANCES: UOS
 GENERAL TOL ± 0.06
 HOLE TOL ± 0.01
 ANGLES $\pm 0.5^\circ$

SCALE 1.0
 SIZE C

CHECKED: A. HUIZINGA
 APPROVED: J. MARETT
 LOCATION: PETERBOROUGH

TITLE: BUSHED SINGLE ROLLER TEST CHAIN ASSEMBLY DRAWING

SIEMENS MILLTRONICS
 PROCESS INSTRUMENTS INC
 PETERBOROUGH, ONTARIO CANADA

DRAWING No 23650685
 REV 3

FILE No 2365068503
 PLOT AT 1:1
 SHEET 1 OF 1

-FOR INTERNAL USE ONLY-