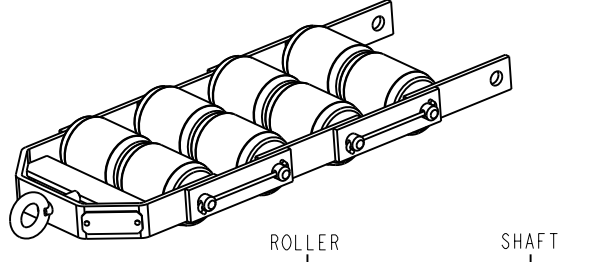
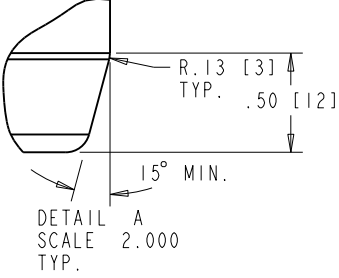
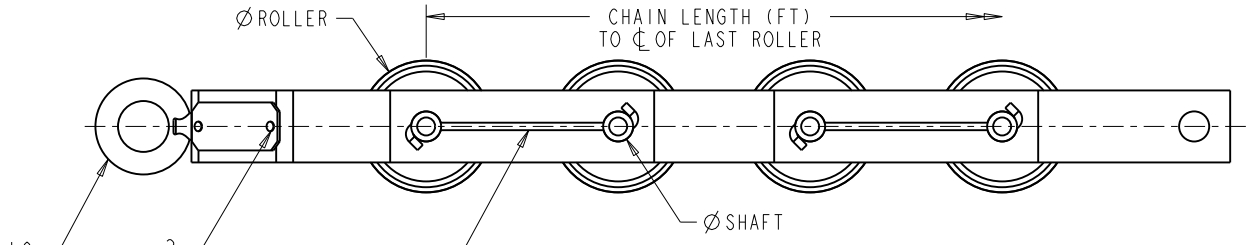
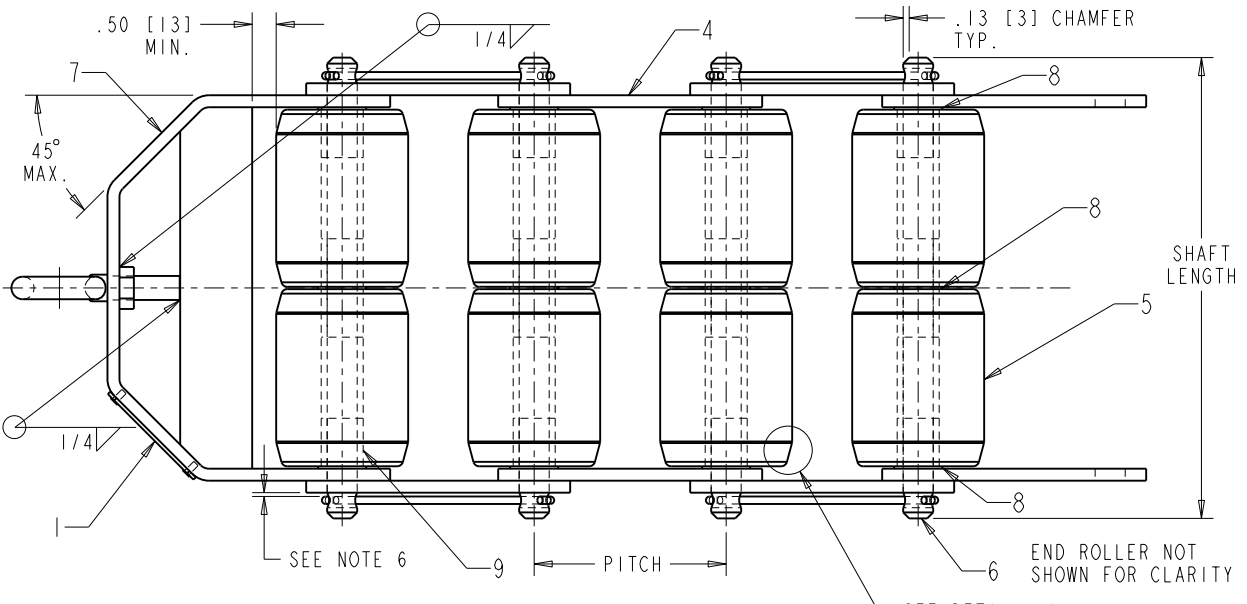


NOTES

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 $+ .005$ " [.13] / $+ .01$ [.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-14, MIN

ITEM NO.	LBS/FT	PITCH	DIA.	LENGTH	DIA.	LENGTH	LINK DIM.	PIN DIA.	BUSHING NO.
7MH71610J	40	4.0"	2.75"	3.69"	5/8"	9.60"	.25 x 1.5 x 5.5"	5/32"	B1014-8
7MH71610K	45	4.0"	2.875"	3.84"	5/8"	9.90"	.25 x 1.5 x 5.5"	5/32"	B1014-8
7MH71610L	50	4.0"	3.0"	3.95"	5/8"	10.12"	.25 x 1.5 x 5.5"	5/32"	B1014-8
7MH71610M	55	4.0"	3.0"	4.39"	5/8"	10.99"	.25 x 1.5 x 5.5"	5/32"	B1014-8
7MH71610N	60	6.0"	3.75"	4.49"	3/4"	11.27"	.25 x 2.0 x 8.0"	3/16"	B1216-9
7MH71610P	70	6.0"	4.0"	4.66"	3/4"	11.60"	.25 x 2.0 x 8.0"	3/16"	B1216-9
7MH71610Q	80	6.0"	4.0"	5.38"	3/4"	13.05"	.25 x 2.0 x 8.0"	3/16"	B1216-9
7MH71610R	90	6.0"	4.0"	6.11"	3/4"	14.50"	.25 x 2.0 x 8.0"	3/16"	B1216-9
7MH71610S	100	6.0"	4.50"	5.31"	7/8"	13.12"	.25 x 2.5 x 8.5"	3/16"	B1418-10

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

DIMENSIONS ARE IN INCHES
USE DIMENSIONS ONLY- DO NOT SCALE

THIRD ANGLE PROJECTION

PRODUCT GROUP: MASS DYNAMICS DATE: OCT 4, 2005 DRAWN: M. MORRISSEY CHECKED: A. HUIZINGA APPROVED: J. MARETT LOCATION: PETERBOROUGH SIEMENS MILLITRONICS INC PETERBOROUGH, ONTARIO CANADA FILE No: 2365052504	TOLERANCES UOS GENERAL TOL ± 0.06 HOLE TOL ± 0.01 ANGLES $\pm 0.5^\circ$	SCALE 1.0 SIZE C TITLE BUSHED DOUBLE ROLLER TEST CHAIN ASSEMBLY DRAWING DRAWING No: 23650525 REV 5 PLOT AT 1:1 SHEET 1 OF 1
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