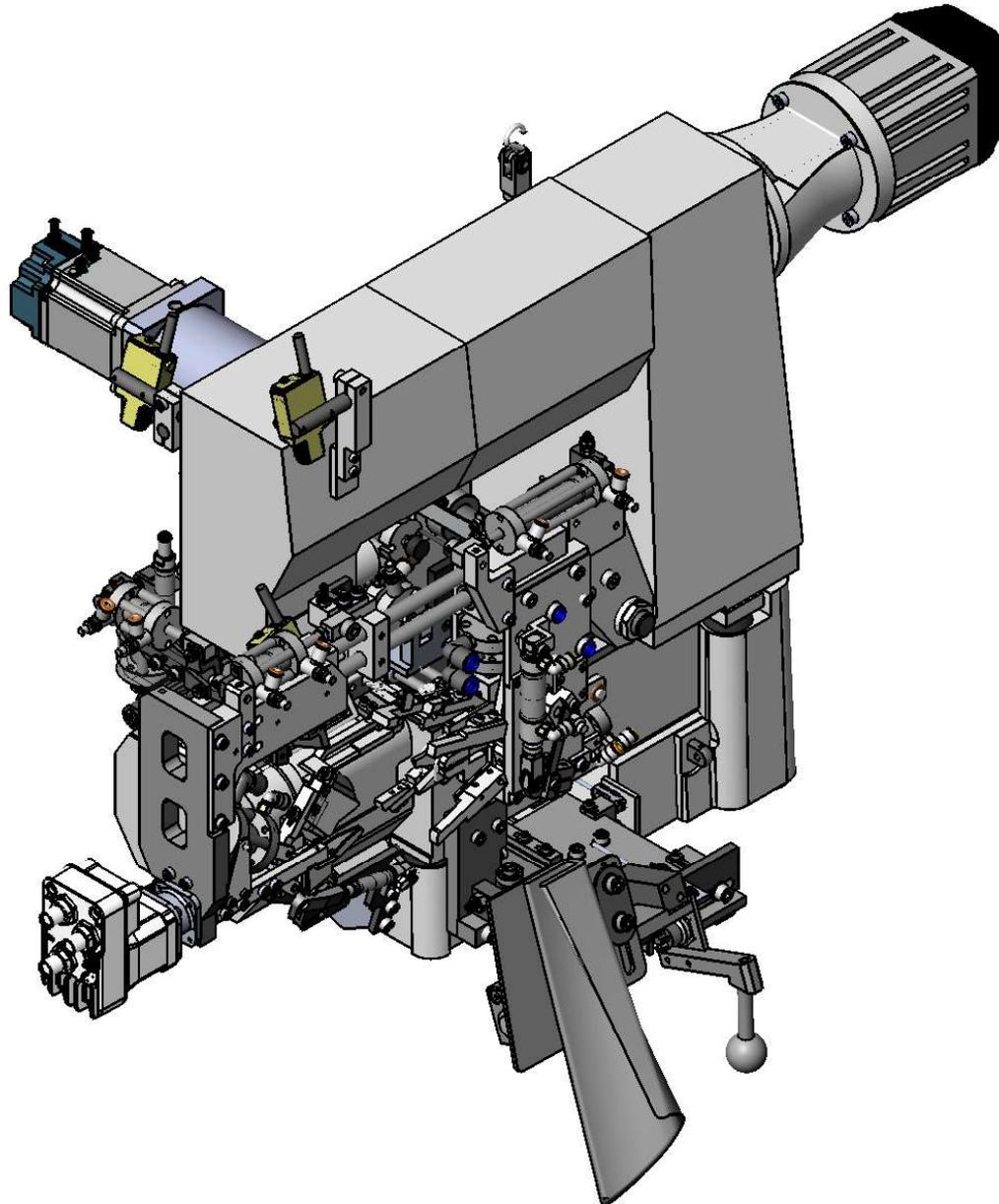
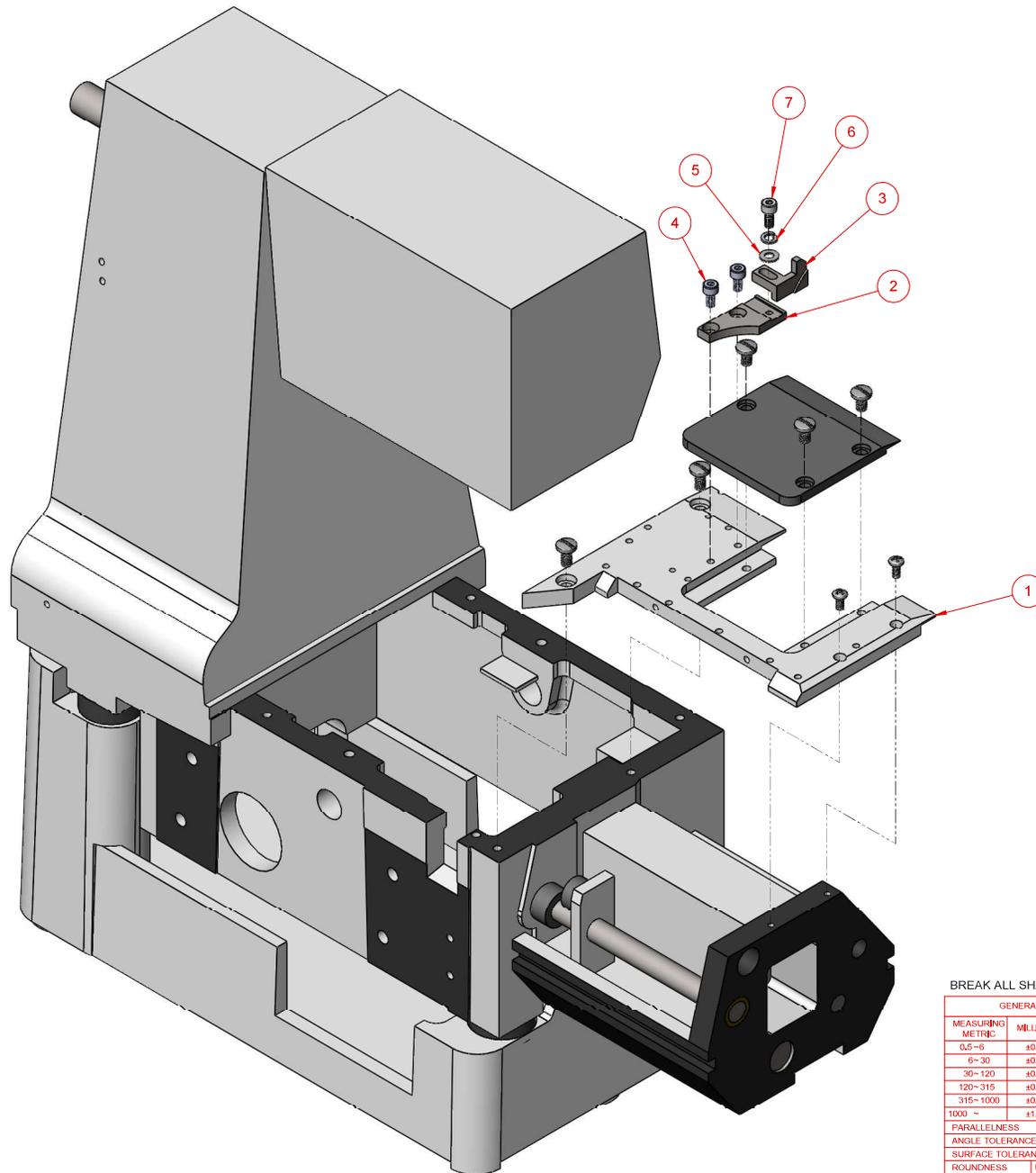


GTN1828 ASSEMBLY GUIDE





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012789A	THROAT PLATE BASE (W10-4A)	1
2	G012811	PLATE, SMALL MOUNT (W10-4E)	1
3	G012812	ANGLE, ADJUSTABLE (W10-4EB)	1
4	GSSC408	M4 X 8 SHCS	2
5	GWFO400	FLAT WASHER M4	1
6	GWLO400	LW M4	1
7	GSSC410	SHCS M4 X 10	1

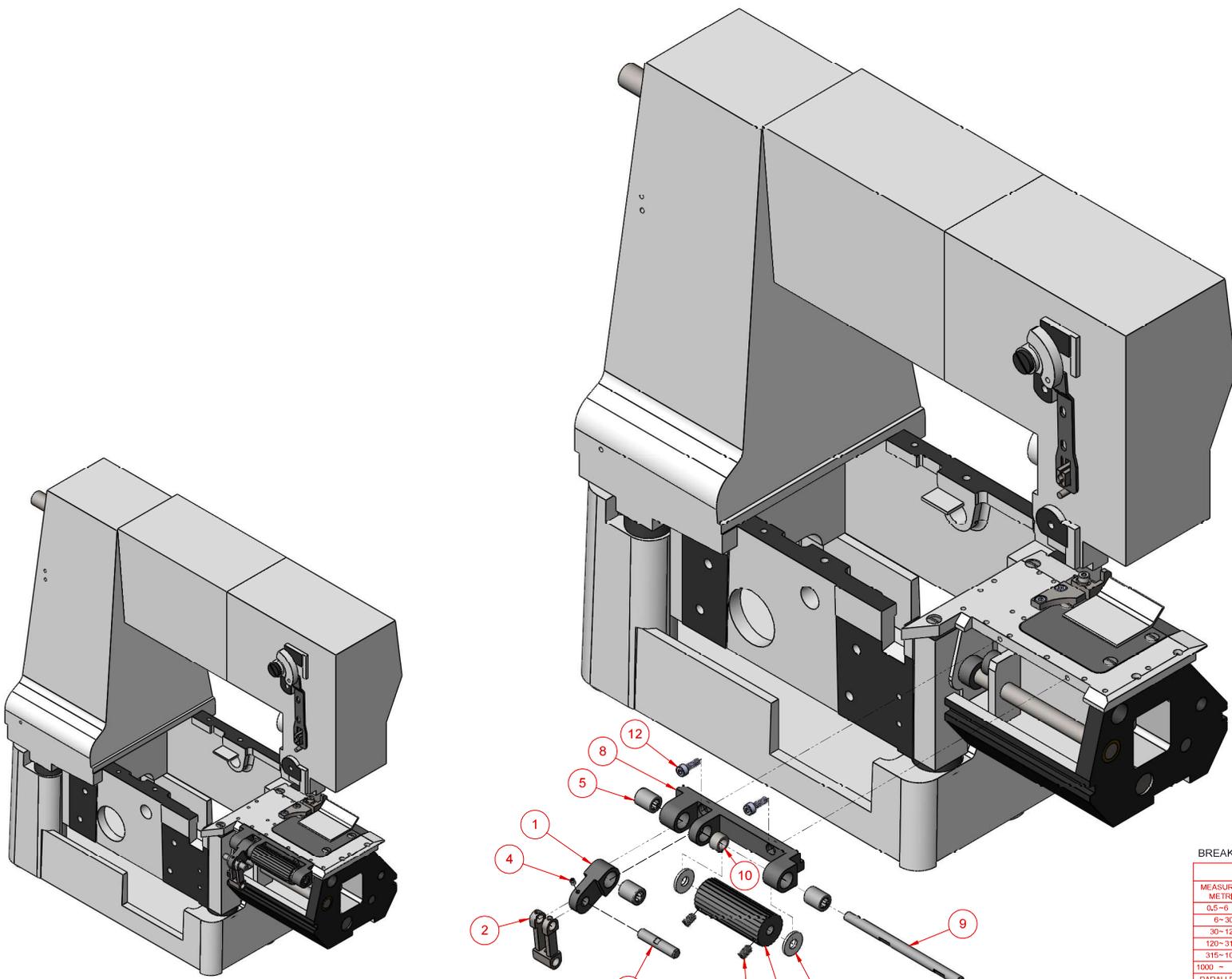
Tracking No. V005445

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Int.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6-30	±0.2	±0.25	±0.5	Heat T'mnt.		Modif.No.	GTN1828
30-120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120-315	±0.5	±0.6	±1.0			Customer	CARRIART
315-1000	±0.8	±1.1	±1.5	Material		Part No.	G013316EX1
1000 =	±1.2	±1.8	-			Asly No.	G013312
PARALLELNESS			1/100	Part Name		Date	3/17/15
ANGLE TOLERANCE			1/100	Assy Name		Scale	1:1 Size 11" D"
SURFACE TOLERANCE			0.2/100	Drawn By	Checked By	Approved	
ROUNDNESS			UNDER 30% TOLERANCE	TZ			
SURFACE FINISH NOT TO EXCEED			UNLESS OTHERWISE SPECIFIED				

DATE	REV.	DESCRIPTION	INT.
REVISIONS			

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012801	CRANK (W10-4C)	1
2	G012800	JOINT (W10-4CB)	1
3	G012802	SHORT PIN W FLATS (W1-1A-1B)	1
4	GSSS304	SET SCRW M3 X 4	1
5	2489K28	ONE-WAY BEARING (W11-1A-1B)	3
6	G012803	GEAR (W10-4D)	1
7	GSSS508	M5 X .8 SHSS, 8MM LONG	2
8	G012804	PLATE, MOUNTING (W10-4DB)	1
9	G012805	LONG PIN W FLATS (W11-1A-1D)	1
10	G012809	ROLLER BEARING (W11-1A-1E)	1
11	7421K1	THRUST WASHER (W11-1A-1F)	2
12	GSSC412	M4 X 12 SHCS	2



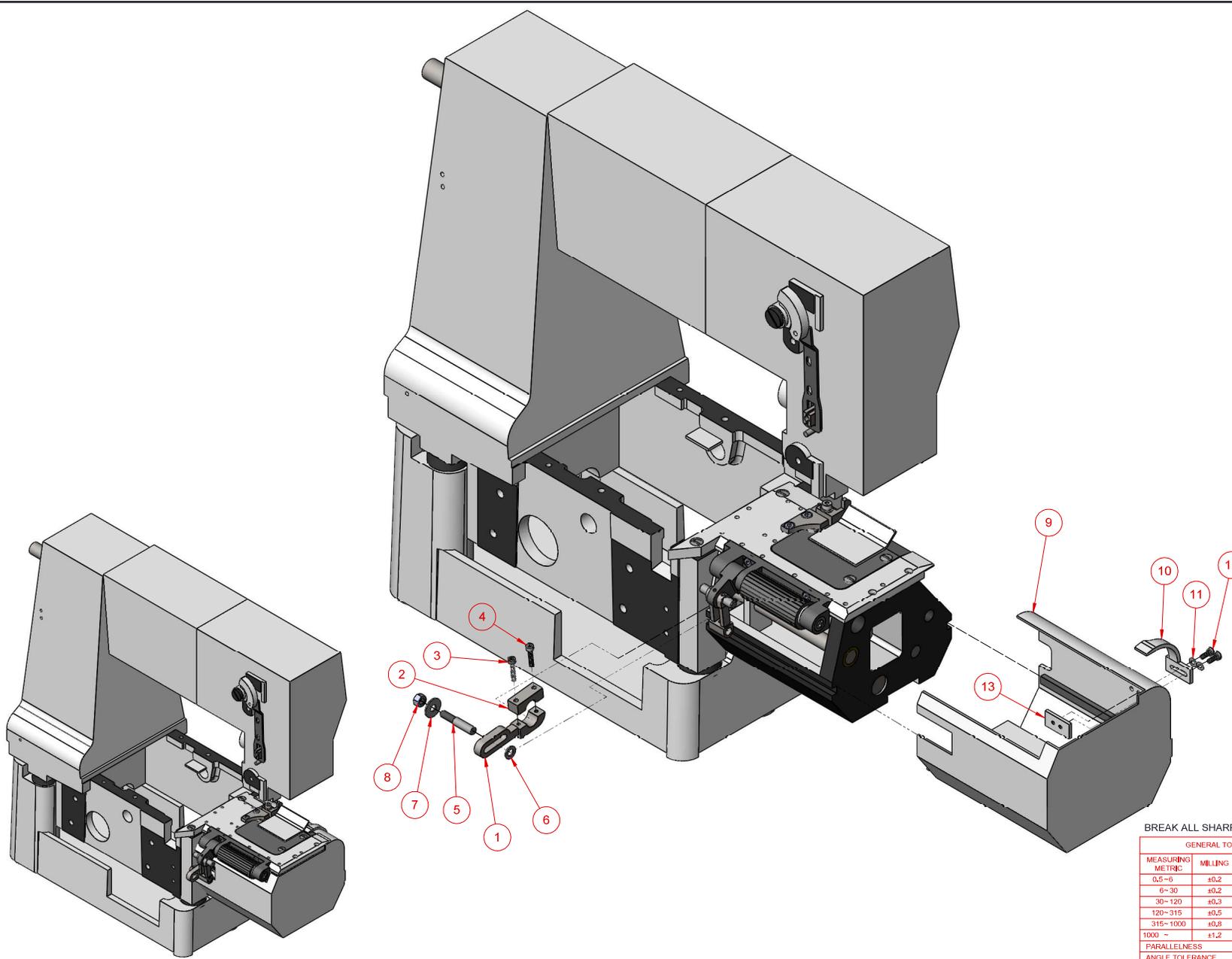
DATE	REV.	DESCRIPTION	INE.
REVISIONS			

GENERAL TOLERANCE		Date	Rev.No.	Revisions	Int.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING		
0.5-6	±0.2	±0.2	±0.4	Hardness	Hard.Dpth.
6-30	±0.2	±0.25	±0.5	Heat T'mnt.	Modif.No.
30-120	±0.3	±0.45	±0.7	Finish	Machine No.
120-315	±0.5	±0.6	±1.0	Material	Customer
315-1000	±0.8	±1.1	±1.5	Part No.	G013316EX2
1000 -	±1.2	±1.8	-	Assy No.	G013312
PARALLELNESS			1/100	Part Name	Date
ANGLE TOLERANCE			1/100	Assy Name	3/17/15
SURFACE TOLERANCE			0.2/100	Scale	1:1
ROUNDSNESS			UNDER 30% TOLERANCE	Drawn By	Checked By
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED	Approved	
NOT TO EXCEED				TZ	

Tracking No. V005445



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012798	SUPPORT, BOTTOM SLOTTED (W10-4B)	1
2	G012799	SUPPORT, TOP (W10-4BB)	1
3	GSSC318	SHCS M3 X 18	1
4	GSSC316	SHCS M3 X 16	1
5	G012797A	ROD, THREADED (11A)	1
6	GWFO500	M5 FW	1
7	GWFO501	M5 FW (OD 15mm)	1
8	GN00500	NUT, M5 HEX	1
9	G013850	COVER (W10-6A)	1
10	G013860	GUIDE, COVER (W10-4F)	1
11	GWFO300	FW M3	2
12	GSSC308	SHCS M3 x 8	2
13	G014043	DBL NUT	1

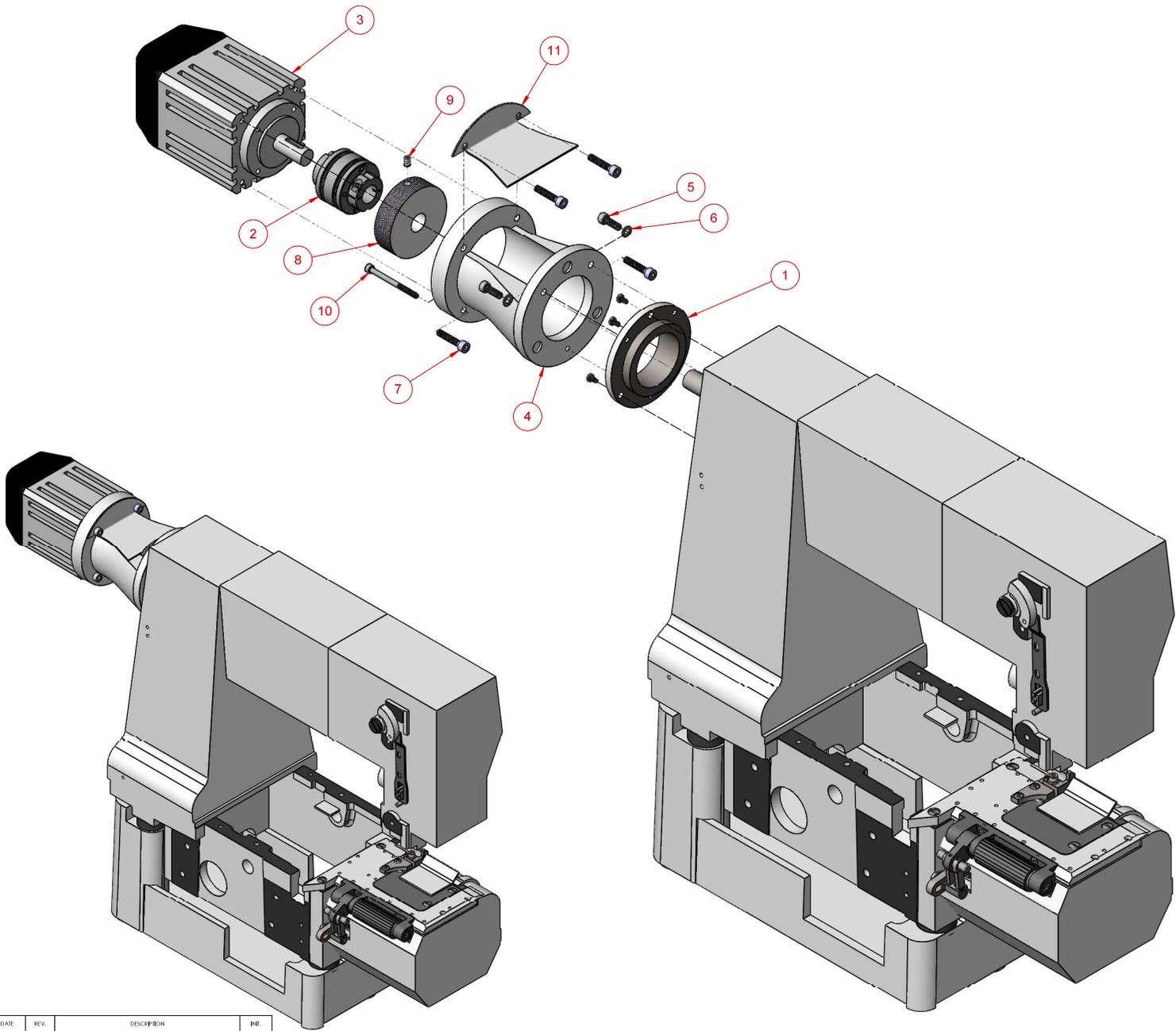


DATE	REV.	DESCRIPTION	INE.
REVISIONS			

GENERAL TOLERANCE				Date		Rev.No.		Revisions		Int.	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness		Hard.Dpth.		Modif.No.		GTN1828	
0.5-6	±0.2	±0.2	±0.4	Heat T'mnt.				Machine No.		302U201B	
6-30	±0.2	±0.25	±0.5	Finish				Customer		CARPART	
30-120	±0.3	±0.45	±0.7	Material				Part No.		G013916EX3	
120-315	±0.5	±0.6	±1.0					Ass'y No.		G013912	
315-1000	±0.8	±1.1	±1.5	Part/ Assy Name				Date		3/17/15	
1000 =	±1.2	±1.8	-					Scale	1:1	Size : " D"	
PARALLELNESS											
ANGLE TOLERANCE											
SURFACE TOLERANCE											
ROUNDNESS											
SURFACE FINISH											
NOT TO EXCEED											

Tracking No. V005445





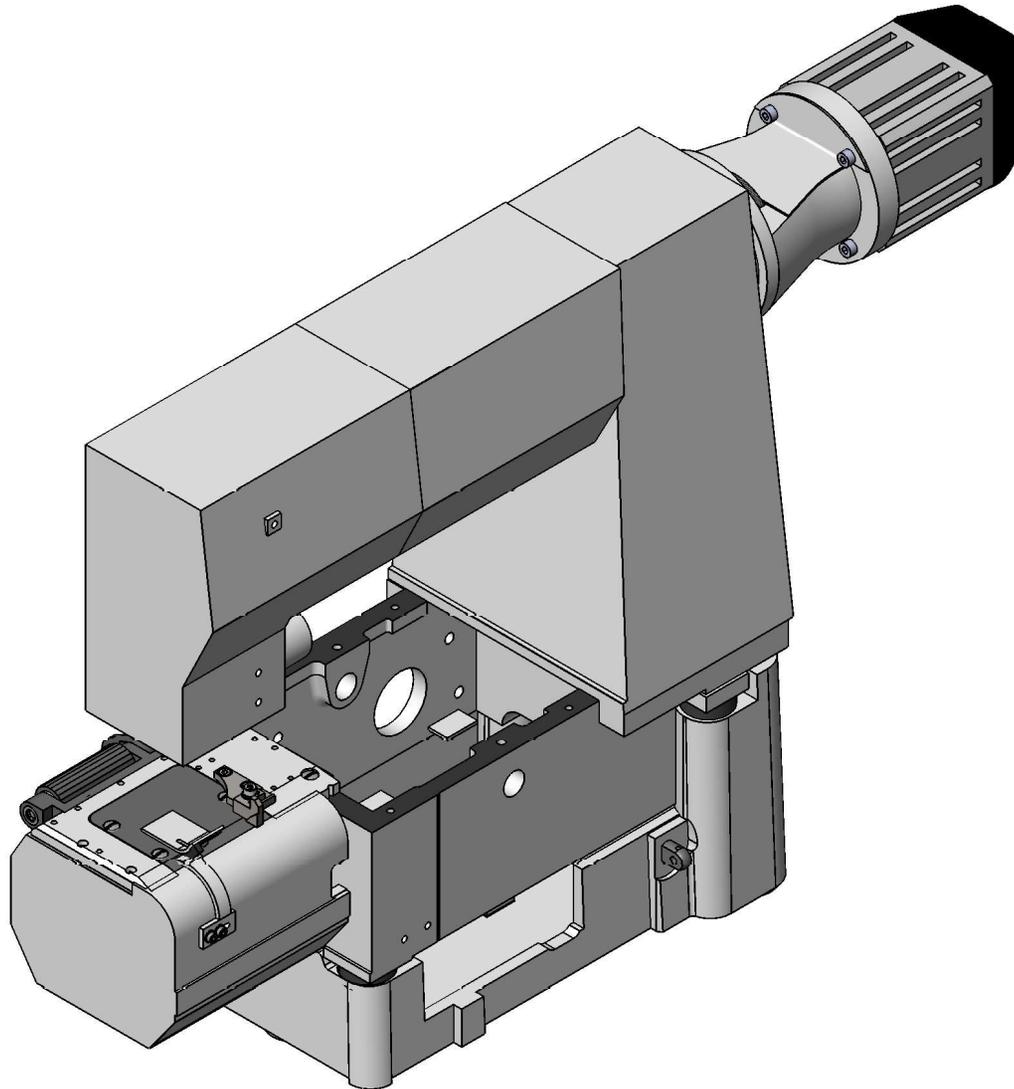
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013976	MODIFIED CASTING MOUNT (W11-68)	1
2	G013978	MODIFIED COUPLING (W11-6C)	1
3	DC1200	EFA MOTOR	1
4	G013980	MOTOR MOUNT	1
5	GSSC515	M5 X .15 SHCS	2
6	GWFS000	M5 PM	2
7	GSSC525	M5X25 SHCS	4
8	G013982	WHEEL (W10-6E)	1
9	GSSS508	M5 X .8 SHSS, 8MM LONG	1
10	GSSC450	SHCS M4 x 50	1
11	G013981	COVER (W11-6F)	1

DATE	REV.	DESCRIPTION	BY
REVISIONS			

GENERAL TOLERANCE				Date		Rev.No.		Revisions		Int.		
MEASURING METRIC	MILLING	PRESS	CASTING FORGING									
0.5-6	±0.2	±0.2	±0.4	Hardness				Hard.Dpth.				
6-30	±0.2	±0.25	±0.5	Heat T'mnt.				Modif.No.			GTN1828	
30-120	±0.3	±0.45	±0.7	Finish				Machine No.			302U201B	
120-315	±0.5	±0.6	±1.0	Material				Customer			CARRIART	
315-1000	±0.8	±1.1	±1.5					Part No.			G013916EX4	
1000 -	±1.2	±1.8	-					Assy No.			G013912	
PARALLELNESS			1/100	Part/ Assy Name				Date			3/17/15	
ANGLE TOLERANCE			1/100					Scale	1:1		Size	D"
SURFACE TOLERANCE			0.2/100	Drawn By				Checked By			Approved	
ROUNDSNESS			UNDER 30% TOLERANCE									
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED									
NOT TO EXCEED												

Tracking No. V005445

STEP 1: G013916

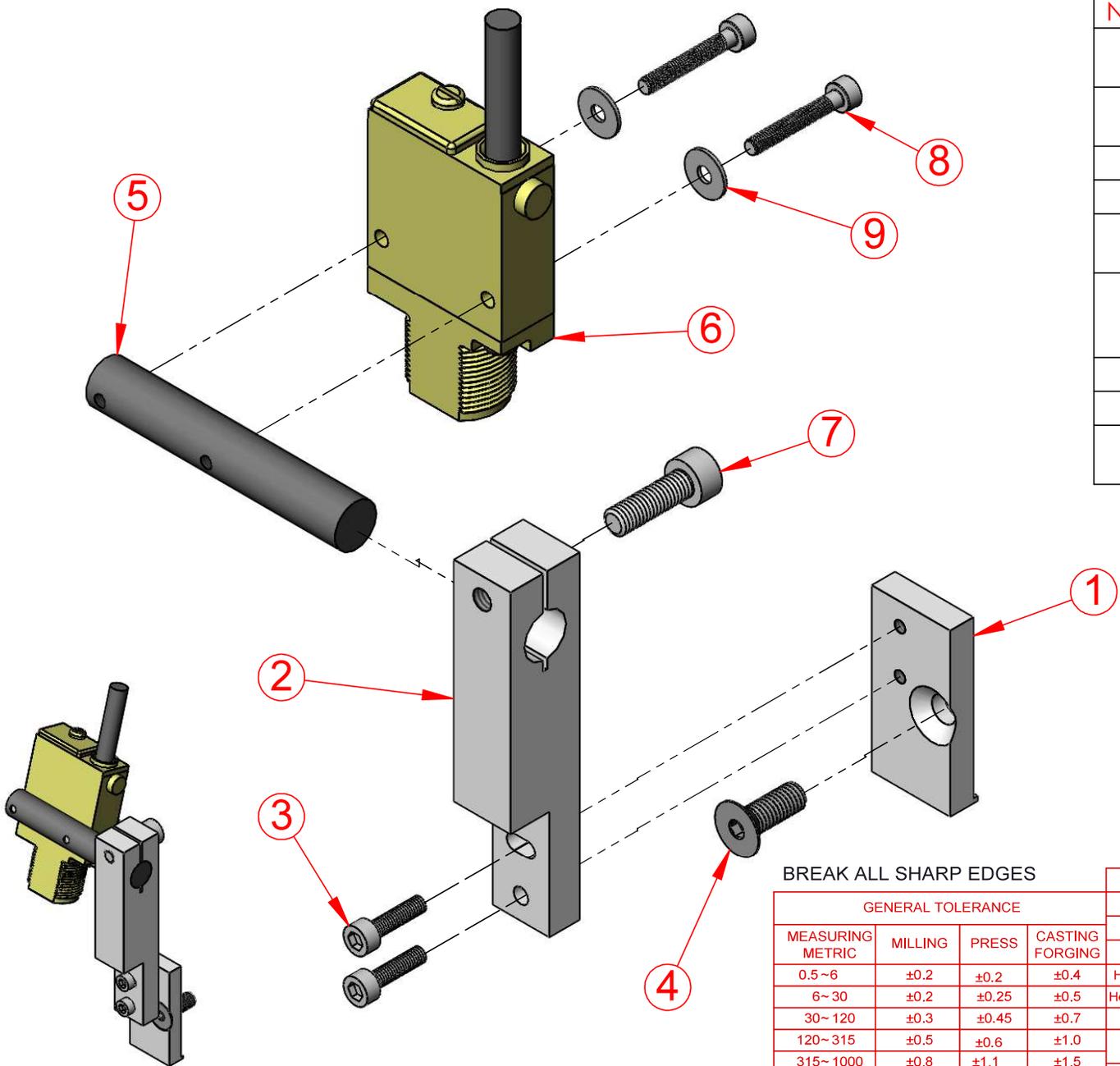


Tracking No. V005445

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Int.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.		GTN1828
6-30	±0.2	±0.25	±0.5	Heat T'mnt.		Modif.No.		302U201B
30-120	±0.3	±0.45	±0.7	Finish		Machine No.		CARSHARTT
120-315	±0.5	±0.6	±1.0	Material		Customer		G013919
315-1000	±0.8	±1.1	±1.5			Part No.		G013919
1000 -	±1.2	±1.8	-			Assy No.		
PARALLELNESS				Part/ Assy Name	GTN 1828	Date	9/22/15	
ANGLE TOLERANCE						Scale	1:1.3	Size : " D"
SURFACE TOLERANCE						Drawn By	Checked By	Approved
ROUGHNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	UNLESS OTHERWISE SPECIFIED					TZ		

DATE	REV.	DESCRIPTION	INT.
REVISIONS			



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013693	SENSOR BLOCK (32A)	1
2	G013694	PEC MOUNT (W10-5BB)	1
3	GSSC312	M3 X 12 SHCS	2
4	GSSF514	M5 X 14 FHCS	1
5	G013696	PEC SHAFT (15C)	1
6	G013695	BANNER SENSOR (W10-5D)	1
7	GSSC516	M5 X 16 SHCS	1
8	GSSC320	M3 X 20 SHCS	2
9	GWFO300	FLAT WASHER, M3	2

Tracking No. W005445

BREAK ALL SHARP EDGES

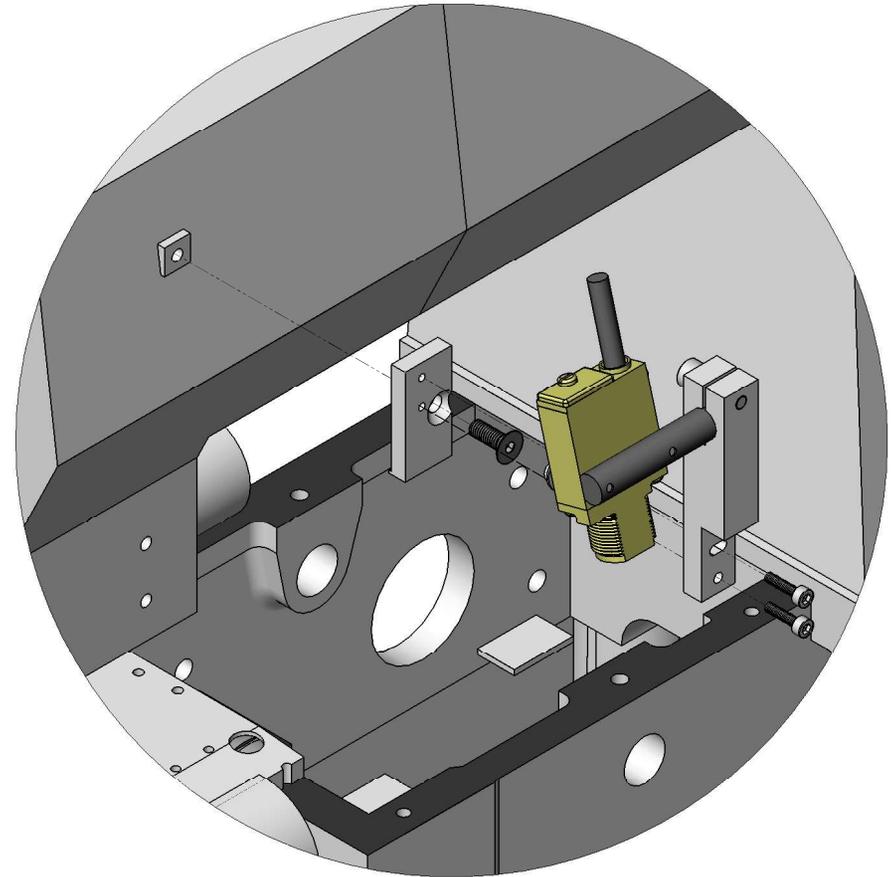
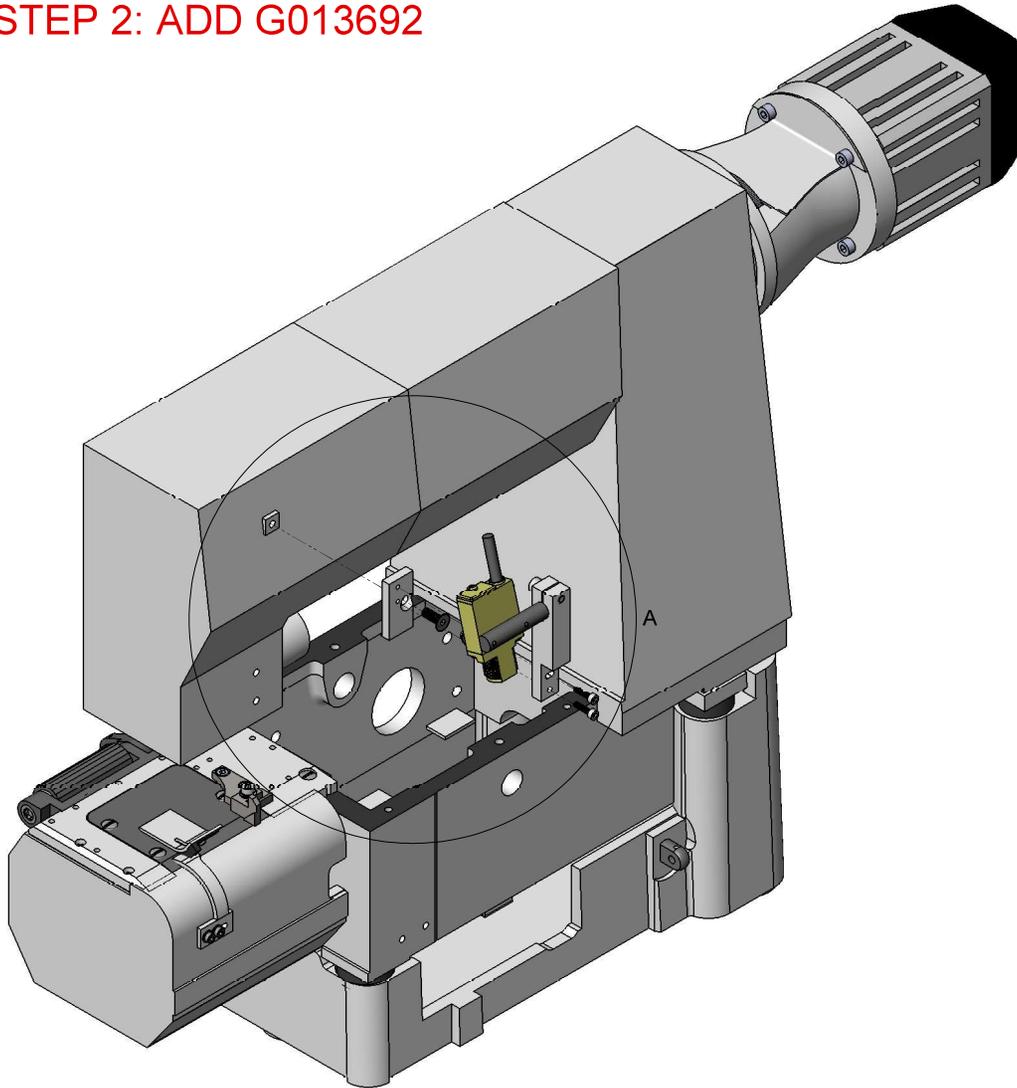
GENERAL TOLERANCE			
MEASURING METRIC	MILLING	PRESS	CASTING FORGING
0.5 ~ 6	±0.2	±0.2	±0.4
6 ~ 30	±0.2	±0.25	±0.5
30 ~ 120	±0.3	±0.45	±0.7
120 ~ 315	±0.5	±0.6	±1.0
315 ~ 1000	±0.8	±1.1	±1.5
1000 ~	±1.2	±1.8	-
PARALLELNESS		1/100	
ANGLE TOLERANCE		1/100	
SURFACE TOLERANCE		0.2/100	
ROUNDNESS		UNDER 30% TOLERANCE	
SURFACE FINISH NOT TO EXCEED		63 √ UNLESS OTHERWISE SPECIFIED	

Date	Rev.No.	Revisions	Init.
Hardness		Hard.Dpth.	
Heat T'mnt.		Model No.	GTN1828
Finish		Machine No.	302U201B
Material		Customer	CARHARTT
Part Name	FRONT UPPER SENSOR ASM	Part No.	G013692EX
		Ass'y No.	G013692
		Date	12/3/14
		Scale	1:1
		Size	"A"
Drawn By	Checked By	Approved	
TZ			

DATE	REV.	DESCRIPTION	INIT.
REVISIONS			



STEP 2: ADD G013692



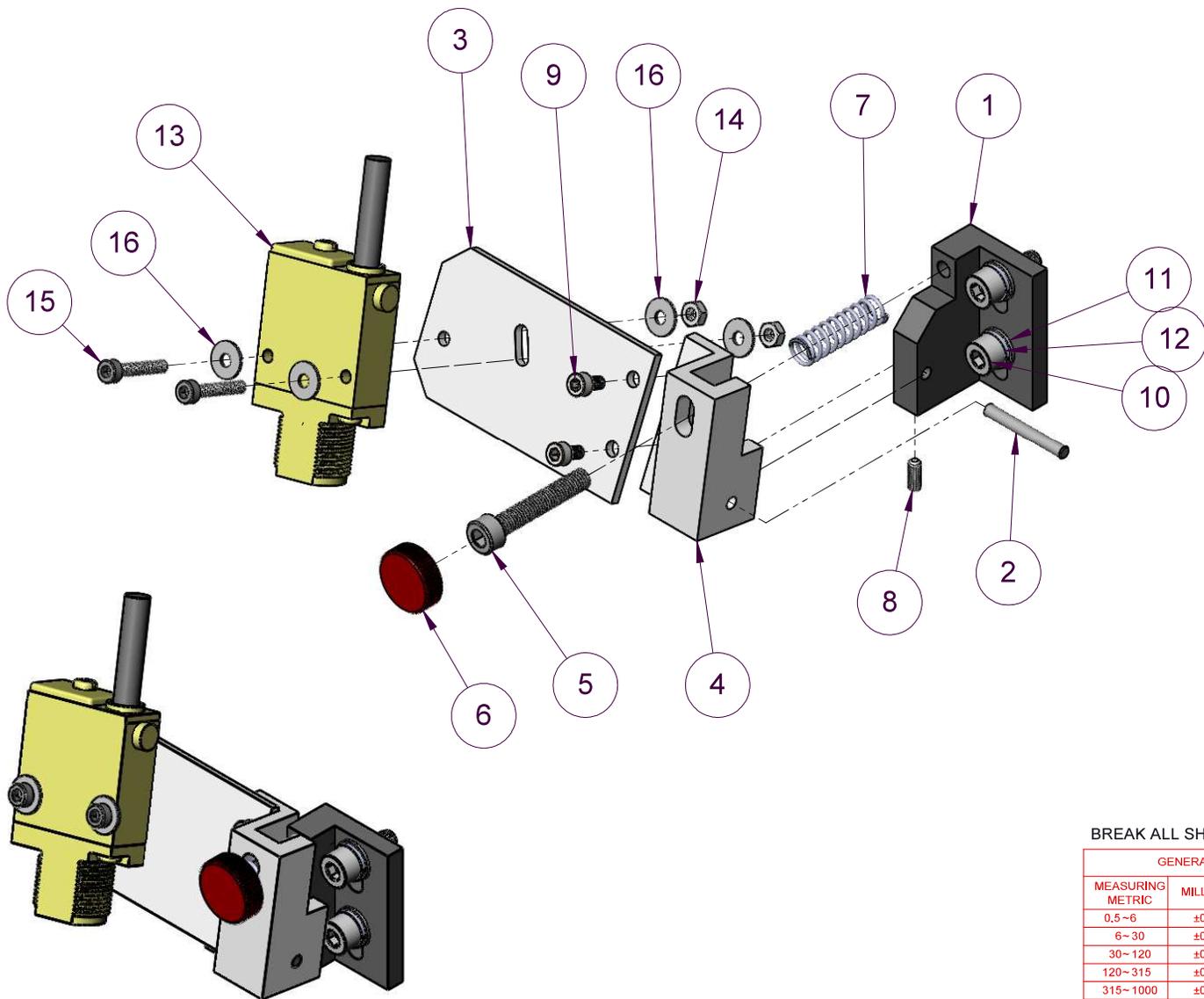
DETAIL A
SCALE 1.5 : 1

Tracking No. V005445

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	GTN1828
6-30	±0.2	±0.25	±0.5	Heat T'mnt.		Modul.No.	302U201B
30-120	±0.3	±0.45	±0.7	Finish		Machine No.	CASPAR ITT
120-315	±0.5	±0.6	±1.0	Material		Customer	G013919
315-1000	±0.8	±1.1	±1.5			Part No.	G013919
1000 -	±1.2	±1.8	-			Asly No.	
PARALLELNESS		1/100		Part/ Assy Name	GTN 1828	Date	9/22/15
ANGLE TOLERANCE		1/100				Scale	1:1.3 Size : " D"
SURFACE TOLERANCE		0.2/100		Drawn By	Checked By	Approved	
ROUNDNESS		UNDER 30% TOLERANCE					
SURFACE FINISH		UNLESS OTHERWISE SPECIFIED					
NOT TO EXCEED				TZ			

DATE	REV.	DESCRIPTION	INI.
REVISIONS			



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013682	PEC MOUNT (W11-5E)	1
2	98381A475	DOWEL 1/8 X 1 (62H)	1
3	G013680	PEC PLATE (35G)	1
4	G013681	PEC PIVOT	1
5	91290A254	5 X 30	1
6	91175A633	THUMB SCRW (32C)	1
7	9657K302	SPRING (32B)	1
8	GSSS308	M3 X 8 SET SCREW	1
9	GSSC306	SCREW, M3X6 SHCS	2
10	GSSC514	5MM, L14, SHCS	2
11	GWFO500	M5 FW	2
12	GWLO500	WASHER, M5 LOCK	2
13	G013695	BANNER SENSOR (W10-5D)	1
14	GN00300	HEX NUT, 3MM	2
15	GSSC318	SHCS M3 X 18	2
16	GWFO300	FLAT WASHER, M3	4

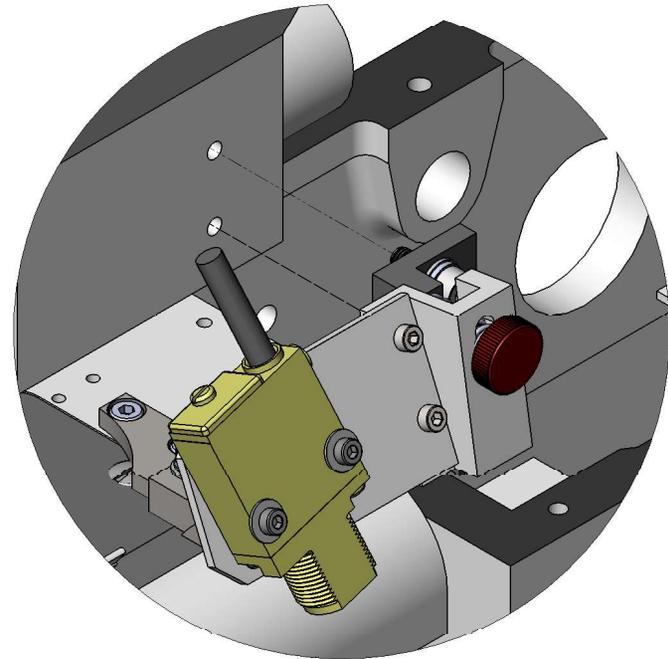
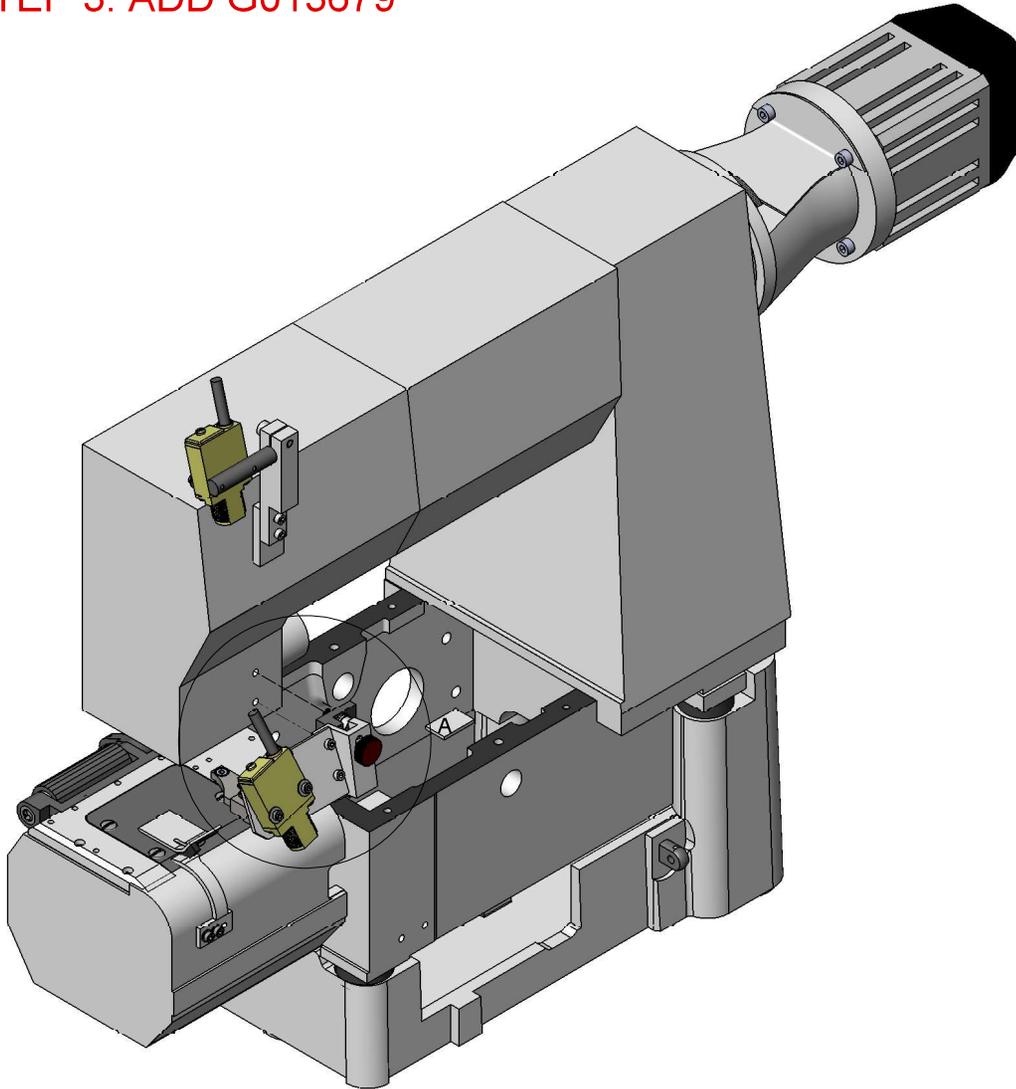
DATE	REV.	DESCRIPTION	INIT
REVISIONS			

Tracking No. W005445

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6-30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	GTN1828
30-120	±0.3	±0.45	±0.7	Finish	G013679	Machine No.	302U201B
120-315	±0.5	±0.6	±1.0	Material		Customer	CARHARTT
315-1000	±0.8	±1.1	±1.5			Part No.	G013679EX
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name		Assy No.	G013679
PARALLELNESS			1/100	FRONT LOWER SENSOR ASM			
ANGLE TOLERANCE			1/100				
SURFACE TOLERANCE						Date	12/3/14
						Scale	1:1
						Size	B
ROUNDNESS	UNDER 30% TOLERANCE			Drawn By	Checked By	Approved	
SURFACE FINISH NOT TO EXCEED				TZ		GTN, INC.	

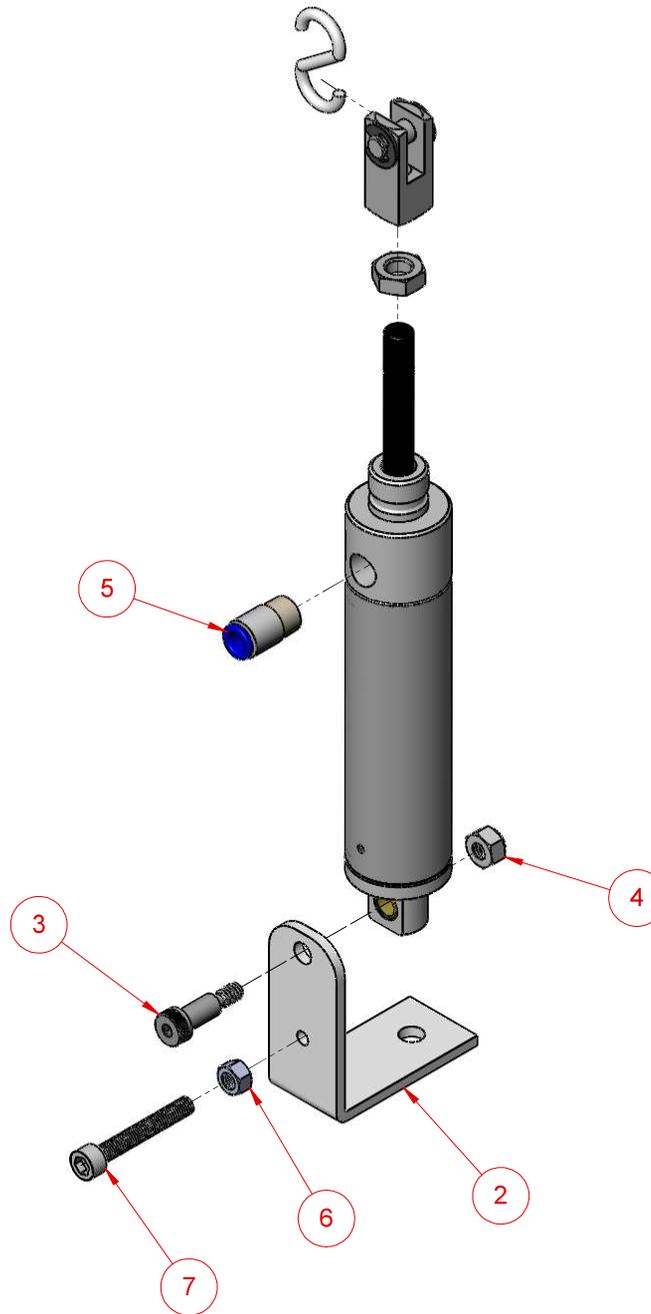
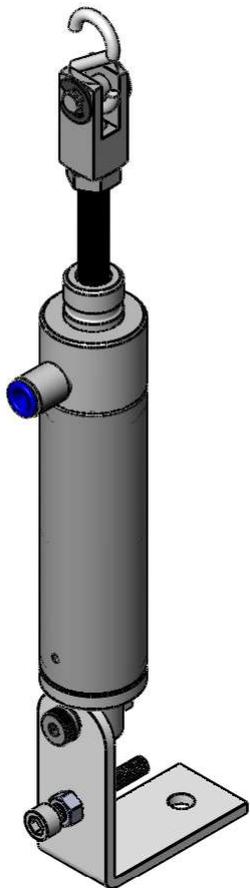
STEP 3: ADD G013679



DETAIL A
SCALE 2 : 1

DATE	REV.	DESCRIPTION	BY
REVISIONS			

BREAK ALL SHARP EDGES										Tracking No.	V005445	
GENERAL TOLERANCE												
MEASURING METRIC	MILLING	PRESS	CASTING	FORGING	Date	Rev.No.	Revisions		Int.			
0.5-6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth.					
6-30	±0.2	±0.25	±0.5	Heat T'mnt.			Modif.No.				GTN1828	
30-120	±0.3	±0.45	±0.7	Finish			Machine No.				302U201B	
120-315	±0.5	±0.6	±1.0	Material			Customer				CASPAR ITT	
315-1000	±0.8	±1.1	±1.5				Part No.				G013919	
1000 -	±1.2	±1.8	-				Assy No.				G013919	
PARALLELNESS			1/100	Part/ Assy Name			GTN 1828	Date			9/22/15	
ANGLE TOLERANCE			1/100				Scale			1:1.3	Size	11 D"
SURFACE TOLERANCE			0.2/100	Drawn By	Checked By	Approved						
ROUNDNESS			UNDER 30% TOLERANCE									
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED									
NOT TO EXCEED			UNLESS OTHERWISE SPECIFIED									



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013898	S-HOOK (31F)	1
2	G013899	PRESS FT BKT (W11-5B)	1
3	91259A537	SHLDR SCREW 1/4 X 1/2, 10-24 (61B)	1
4	GN0LK00	10-24 LOCK NUT	1
5	G013960	RND AIR FITTING, 6 MM (12B)	1
6	GN00500	M5 NUT	1
7	GSSC535	M5 X 35 SHCS, FULL THREAD (61C)	1
8	G013897	CLEVIS	1
9	G013896	AIR CYL	1

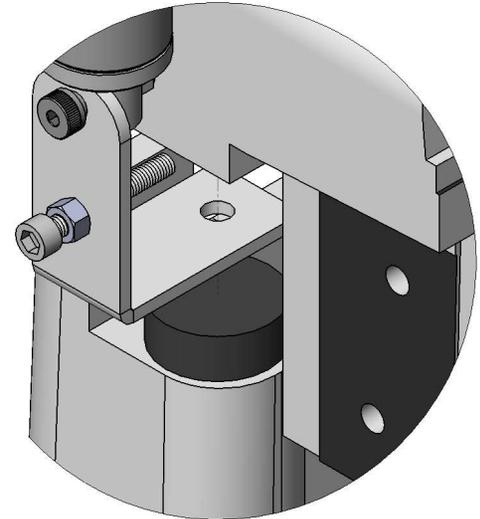
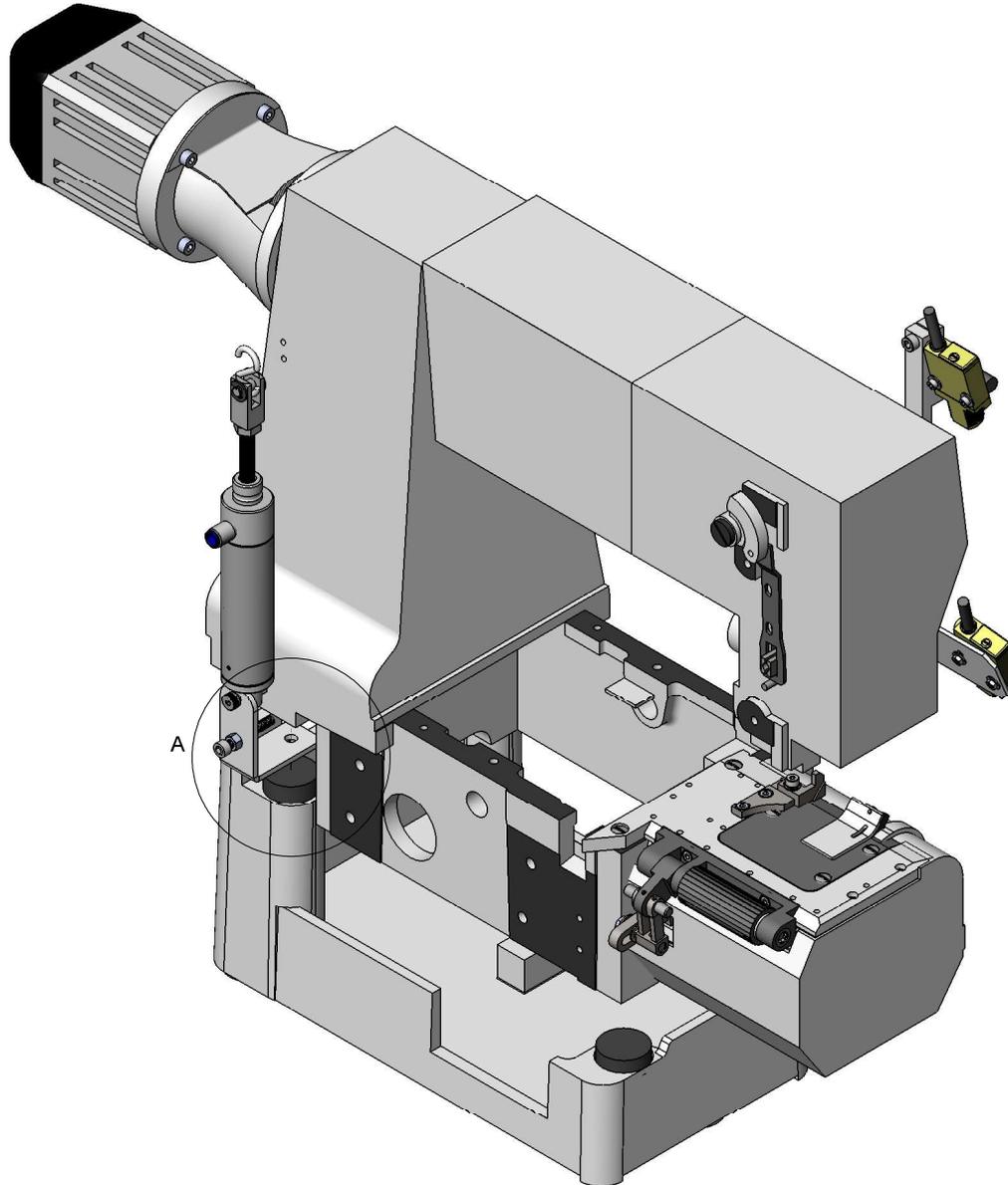
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

Tracking No. W005449

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness		Hard,Dpth.	
0,5-6	±0,2	±0,2	±0,4	Heat Trmnt.		Model No.	GTN1828
6-30	±0,2	±0,25	±0,5	Finish		Machine No.	302U201B
30-120	±0,3	±0,45	±0,7	Material		Customer	CARHARTT
120-315	±0,5	±0,6	±1,0	Part/ Ass'y Name	PRESSER FT ASM	Part No.	G013892EX
315-1000	±0,8	±1,1	±1,5	Ass'y No.		Ass'y No.	G013892
1000 ~	±1,2	±1,8	-	Date		Date	3/6/15
PARALLELNESS			1/100	Scale	1:1	Size	"C"
ANGLE TOLERANCE			1/100	Drawn By	Checked By	Approved	
SURFACE TOLERANCE			0,2/100	TZ			
ROUNDNESS	UNDER 30% TOLERANCE						
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED						

STEP 4: ADD G013892



DETAIL A
SCALE 2 : 1

Tracking No. V005445

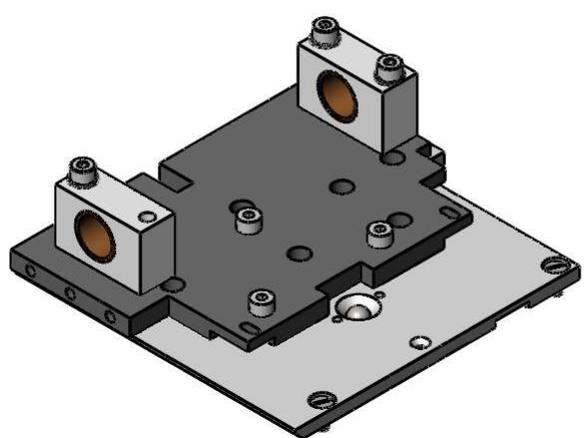
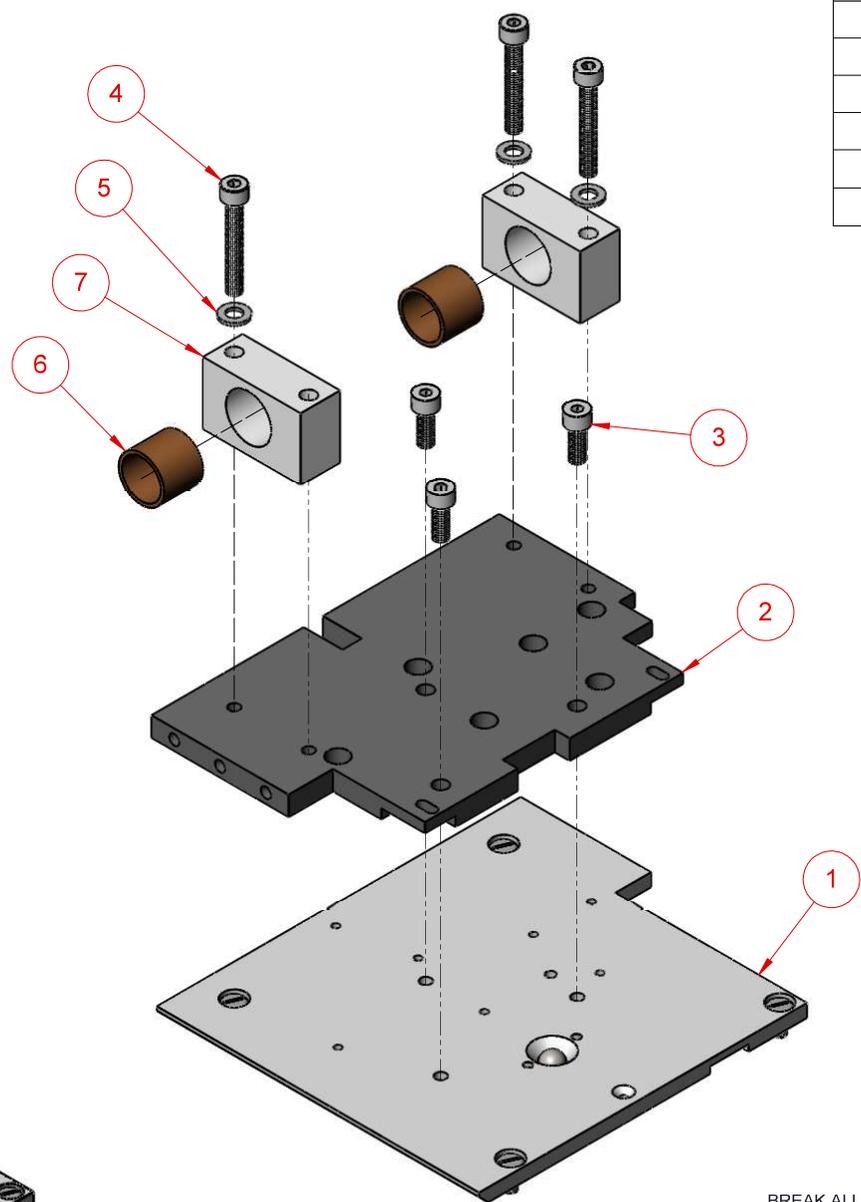
BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	GTN1828
6-30	±0.2	±0.25	±0.5	Heat T'mnt.		Modif.No.	302U201B
30-120	±0.3	±0.45	±0.7	Finish		Machine No.	CASPAR ITT
120-315	±0.5	±0.6	±1.0	Material		Customer	G013819
315-1000	±0.8	±1.1	±1.5			Part No.	G013819
1000 -	±1.2	±1.8	-			Asly No.	
				Part/ Assy Name		Date	9/22/15
PARALLELNESS			1/100			Scale	1:1.3 Size : " D"
ANGLE TOLERANCE			1/100				
SURFACE TOLERANCE			0.2/100				
ROUNDNESS			UNDER 30% TOLERANCE	Drawn By	Checked By	Approved	
SURFACE FINISH NOT TO EXCEED			UNLESS OTHERWISE SPECIFIED	TZ			



DATE	REV.	DESCRIPTION	INC.
REVISIONS			

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012855	MOD MACH PLATE	1
2	G013589	PLATE (W11-3C)	1
3	GSSC616	M6 X 16 SHCS	3
4	GSSC640	M6 X 40 SHCS	3
5	GWF0600	FW M6	3
6	2868T169	BRONZE SLEEVE (17A)	1
7	G012447	BEARING BLOCK (W10-6G)	1



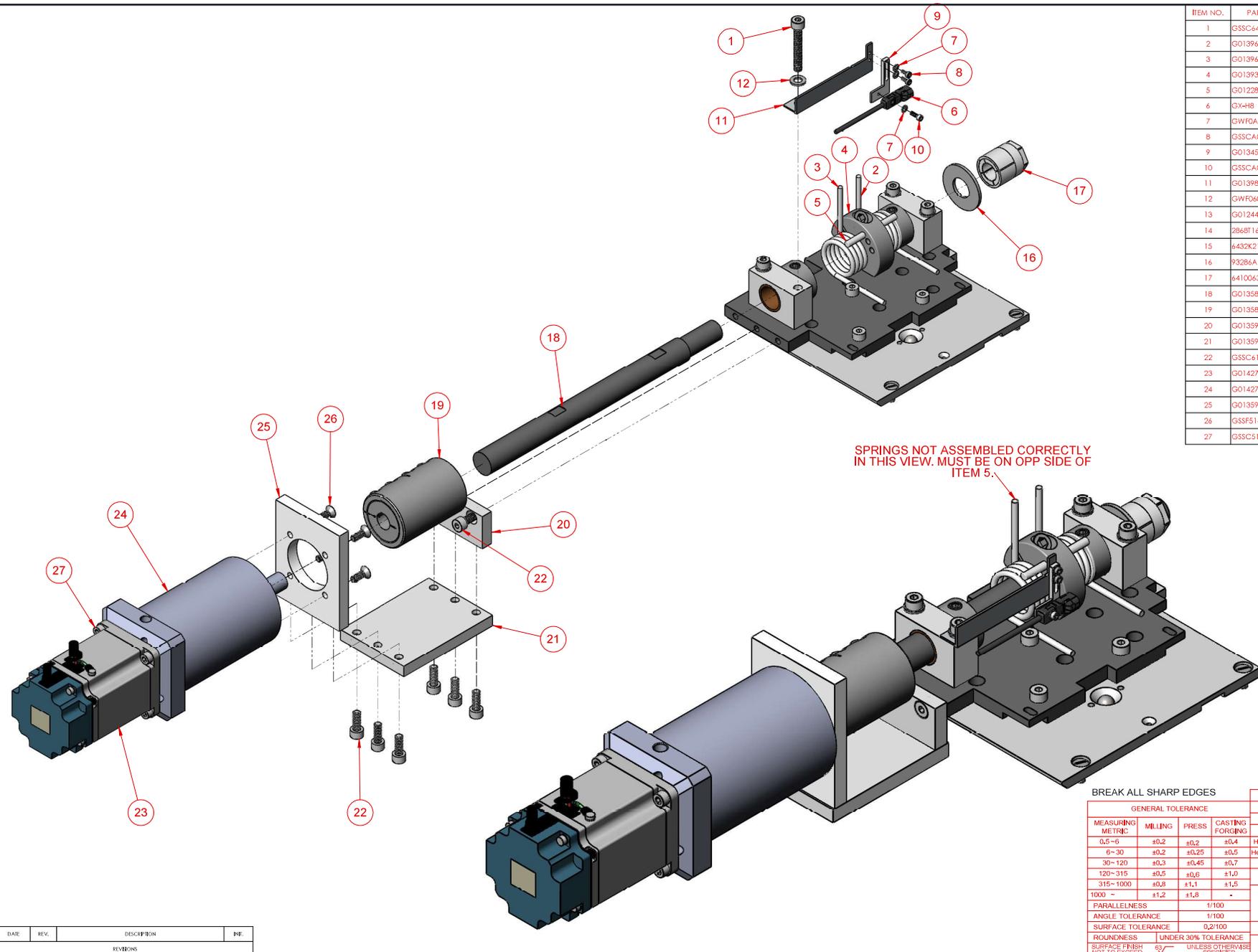
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

Tracking No. W005449

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness		Hard,Dpth.		
0,5-6	±0,2	±0,2	±0,4	Heat Trmnt.		Model No.	GTN1828	
6-30	±0,2	±0,25	±0,5	Finish		Machine No.	302U201B	
30-120	±0,3	±0,45	±0,7	Material		Customer	CARHARTT	
120-315	±0,5	±0,6	±1,0	Part/ Ass'y Name	ARM SHAFT ASM	Part No.	G013920EX1	
315-1000	±0,8	±1,1	±1,5			Ass'y No.	G013920	
1000 ~	±1,2	±1,8	-			Date	10/1/14	
PARALLELNESS	1/100			Scale	1:1	Size	"C"	
ANGLE TOLERANCE	1/100			Drawn By	Checked By	Approved		
SURFACE TOLERANCE	0,2/100							
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED			TZ				





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSSC640	M6 X 40 SHCS	1
2	G013968	TORSION SPRING LEFT (W11-3E)	1
3	G013969	TORSION SPRING RIGHT (W11-3D)	1
4	G013930	ARM STOP (W10-5C8)	1
5	G012286	DOWEL 3/16 X 2	1
6	GX-H8	SENSOR (W11-3F)	1
7	GWFA00	M2.5 FW	3
8	GSSCA06	M2.5 X 6 SHCS	2
9	G013451	SENSOR MOUNT	1
10	GSSCA08	M2.5 X 8 SHCS	1
11	G013984	ARM SENSOR BRKT (W11-1A-7E)	1
12	GWFO600	FW M6	1
13	G012447	BEARING BLOCK (W10-6G)	1
14	2868T169	BRONZE SLEEVE (17A)	2
15	6432K21	3/4 COLLAR (W10-6GB)	2
16	93266A146	OVERSIZED WSHR (17C)	1
17	6410063	TRANSTORQUE MINI 5/8 (W10-6H)	1
18	G013587	ARM SHAFT (W10-6I)	1
19	G013586	SHAFT COUPLING (W11-4J)	1
20	G013596	MOTOR BRKT 1 (W10-6HB)	1
21	G013597	MOTOR BRKT 2 (W11-3B)	1
22	GSSC616	M6 X 16 SHCS	9
23	G014277	SERVO MOTOR	1
24	G014278	GEAR BOX 25:1	1
25	G013590	MOTOR MOUNT	1
26	GSSF514	M5 X 14 FHCS	4
27	GSSC514	5MM, L14, SHCS	4

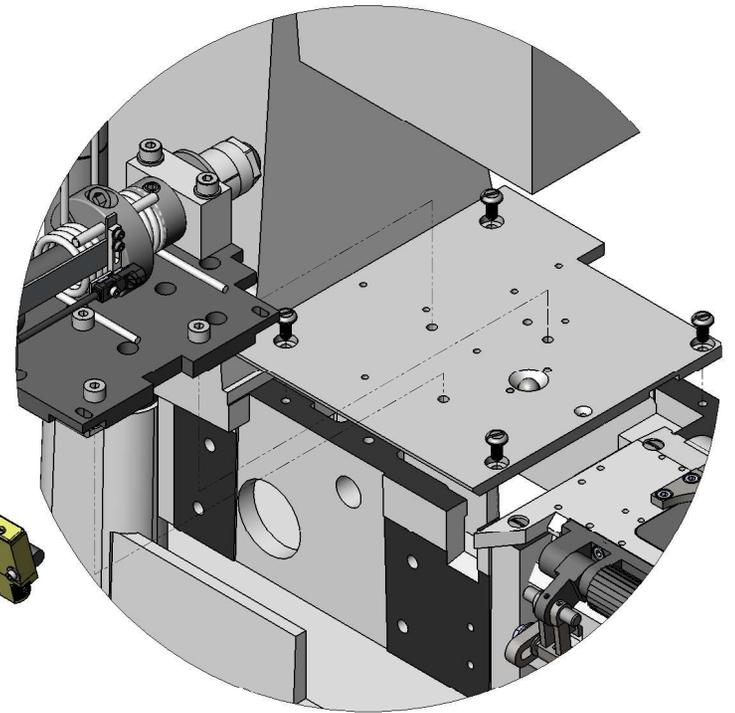
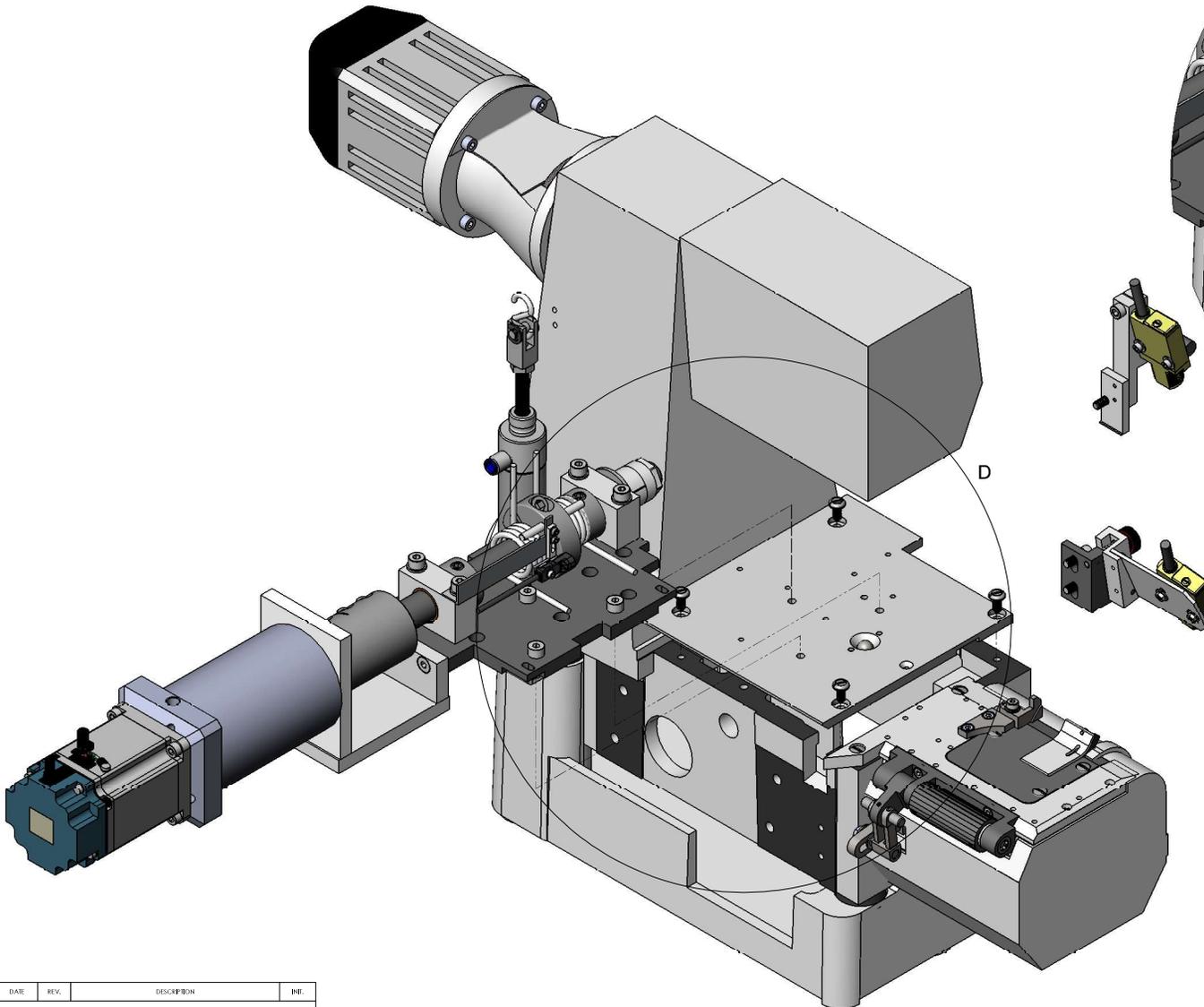
SPRINGS NOT ASSEMBLED CORRECTLY IN THIS VIEW. MUST BE ON OPP SIDE OF ITEM 5.

Tracking No. V005445

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Int.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6-30	±0.2	±0.25	±0.5	Heat T'mnt.		Modif.No.	GTN1828
30-120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120-315	±0.5	±0.6	±1.0	Material		Customer	CARRIARTT
315-1000	±0.8	±1.1	±1.5	Part/ Assy Name	ARM SHAFT ASM	Part No.	G013520EX2
1000 -	±1.2	±1.8	-	Date	10/1/14	Asly No.	G013520
PARALLELNESS			1/100	Scale	1:1	Size	"D"
ANGLE TOLERANCE			1/100	Drawn By	TZ	Checked By	Approved
SURFACE TOLERANCE			0.2/100	SURFACE FINISH NOT TO EXCEED \sqrt{V} UNLESS OTHERWISE SPECIFIED			
ROUNDNESS			UNDER 30% TOLERANCE				

DATE	REV.	DESCRIPTION	INC.
REVISIONS			

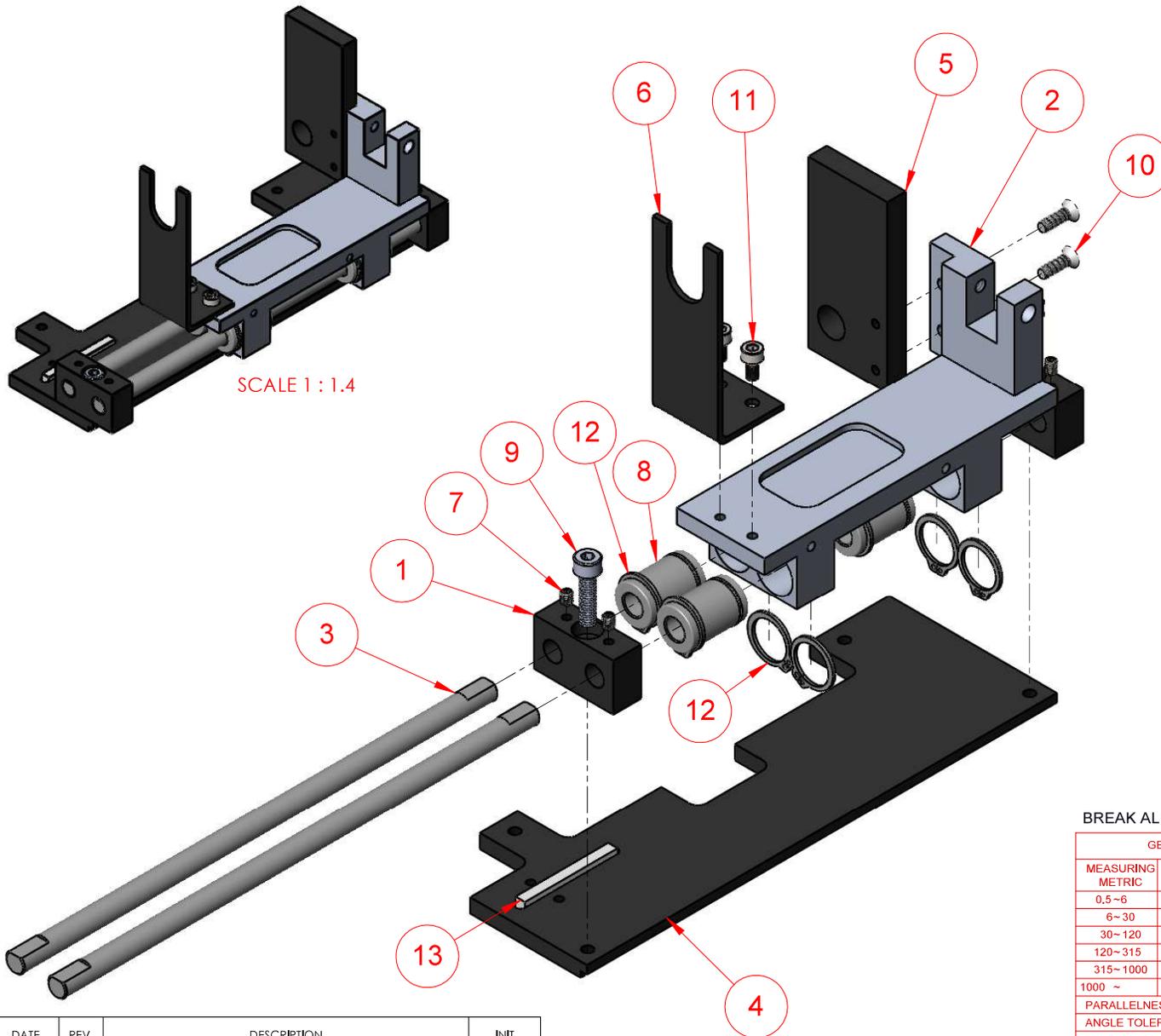
STEP 5: ADD G013920



DETAIL D
SCALE 1 : 1.1

DATE	REV.	DESCRIPTION	BY
REVISIONS			

BREAK ALL SHARP EDGES										Tracking No. : W005445	
GENERAL TOLERANCE											
MEASURING METRIC	MILLING	PRESS	CASTING	FORGING	Date	Rev.No.	Revisions			Int.	
0.5-6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth.				
6-30	±0.2	±0.25	±0.5	Heat T'mnt.			Modif.No.			GTN1828	
30-120	±0.3	±0.45	±0.7	Finish			Machine No.			302U201B	
120-315	±0.5	±0.6	±1.0	Material			Customer			CASPAR ITT	
315-1000	±0.8	±1.1	±1.5				Part No.			G013919	
1000 -	±1.2	±1.8	-				Asly No.			G013919	
PARALLELNESS			1/100	Part/ Assy Name				Date			9/22/15
ANGLE TOLERANCE			1/100					Scale			1:1.3 Size : " D"
SURFACE TOLERANCE			0.2/100	Drawn By	Checked By	Approved					
ROUNDNESS			UNDER 30% TOLERANCE								
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED								
NOT TO EXCEED											



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012652	LINEAR BRG SHAFT BKT (17G)	2
2	G013622	SLIDE PLATE (W11-3G)	1
3	G013621	1/4 SHAFT W FLATS (W11-3H)	2
4	G013656	TRANSFER PLATE (W11-3I)	1
5	G012650	PUSH PLATE (25A)	1
6	G012649	MAGNET PLATE (25C)	1
7	GSSS304	SET SCRW M3 X 4	4
8	G014258	1/4" LINEAR BUSHING (W11-3HB)	4
9	GSSC416	M4 X 16 SHCS	2
10	GSSF310	FHCS M3 x 10	2
11	GSSC306	SCREW, M3X6 SHCS	2
12	97633A200	RETAINING RING (56G)	8
13	G013831	KEY (21B)	1

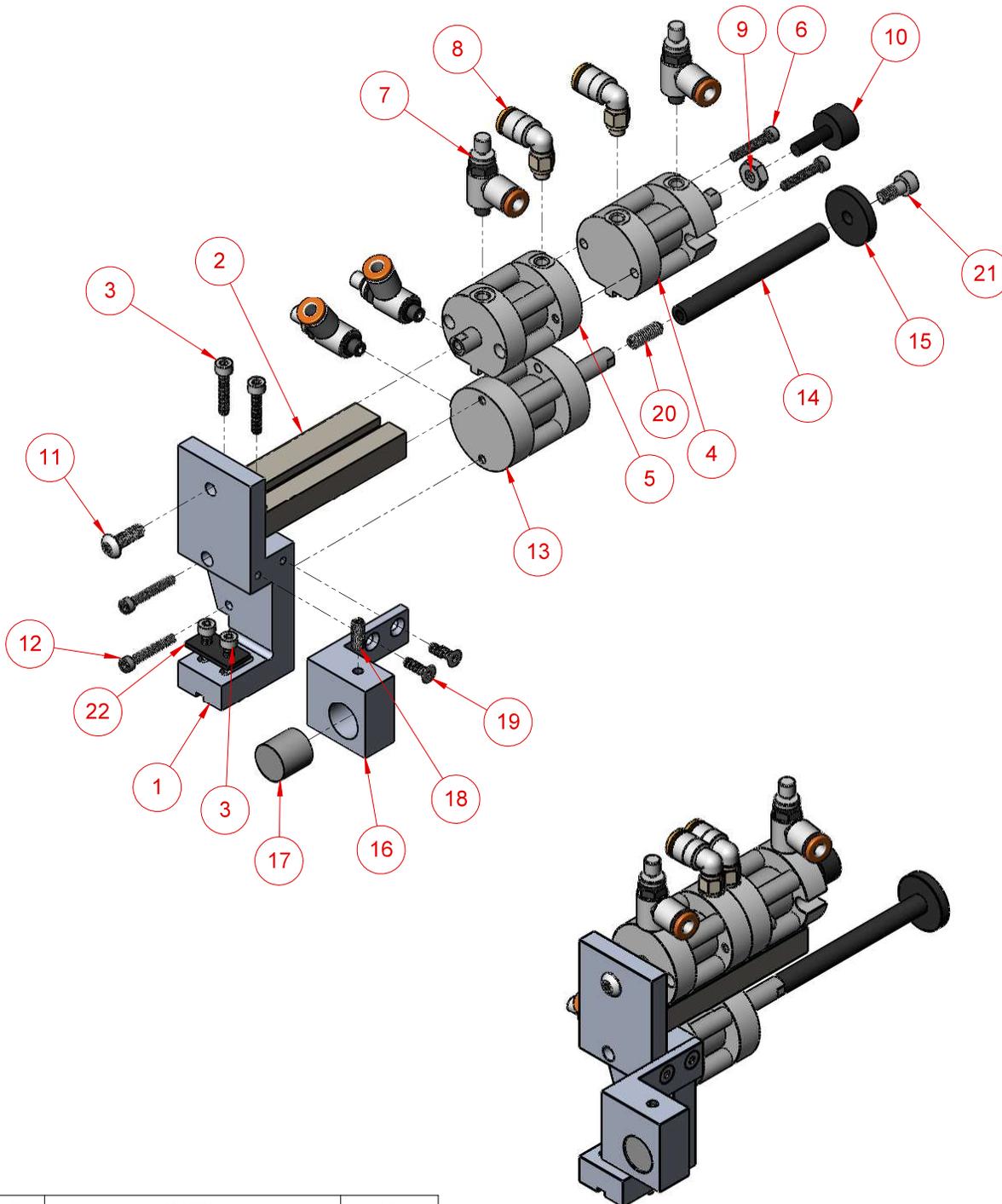
Tracking No. W005445

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness		Hard.Dpth.	
0.5~6	±0.2	±0.2	±0.4	Heat T'mnt.		Model No.	GTN1828
6~30	±0.2	±0.25	±0.5	Finish		Machine No.	302U201B
30~120	±0.3	±0.45	±0.7	Material		Customer	CARHARTT
120~315	±0.5	±0.6	±1.0	Part/ Ass'y Name	TRANSFER SUB ASM	Part No.	G013566
315~1000	±0.8	±1.1	±1.5			Assy No.	G013566
1000 ~	±1.2	±1.8	-	Drawn By	Checked By	Date	9/17/14
PARALLELNESS			1/100	Scale	1:1	Size	B
ANGLE TOLERANCE			1/100	Approved			
SURFACE TOLERANCE			0.2/100				
ROUNDNESS	UNDER 30% TOLERANCE						
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED						

DATE	REV.	DESCRIPTION	INIT
REVISIONS			





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012646	CYL MOUNT (W11-3J)	1
2	G012645	CYL TRACK (W11-3JB)	1
3	GSSC316	SHCS M3 X 16	4
4	G012642	MOD AIR CYL (W11-3K)	1
5	G012641	MOD AIR CYL (W11-3KB)	1
6	GSSCE16	4-40 X 5/8 SHCS	2
7	JW000014	FITTING FLO CON (D2C7)	4
8	JW000001	ELBOW FITTING (D2C6)	2
9	GN00J00	HEX NUT, 8/32	1
10	G012644	BUMPER (21C)	1
11	GSSBJ13	8-32 X 1/2 BHCS	1
12	GSSCE19	4-40 X 3/4 SHCS	2
13	G014245	AIR CYL (W11-3FB)	1
14	G012637	CYL ROD EXT (25E)	1
15	G012638	STOP (21D)	1
16	G012639	MAGNET BKT (W11-4A)	1
17	G013569	ENCASED MAGNET (21E)	1
18	GSSS410	M4 X 10 SET SCREW	1
19	GSSF310	FHCS M3 x 10	2
20	GSSSJ13	8-32 X 1/2 SET SCREW	1
21	GSSCJ10	SCH CAP SCR, B18.3	1
22	G012648	DOUBLE WASHER (21F)	1

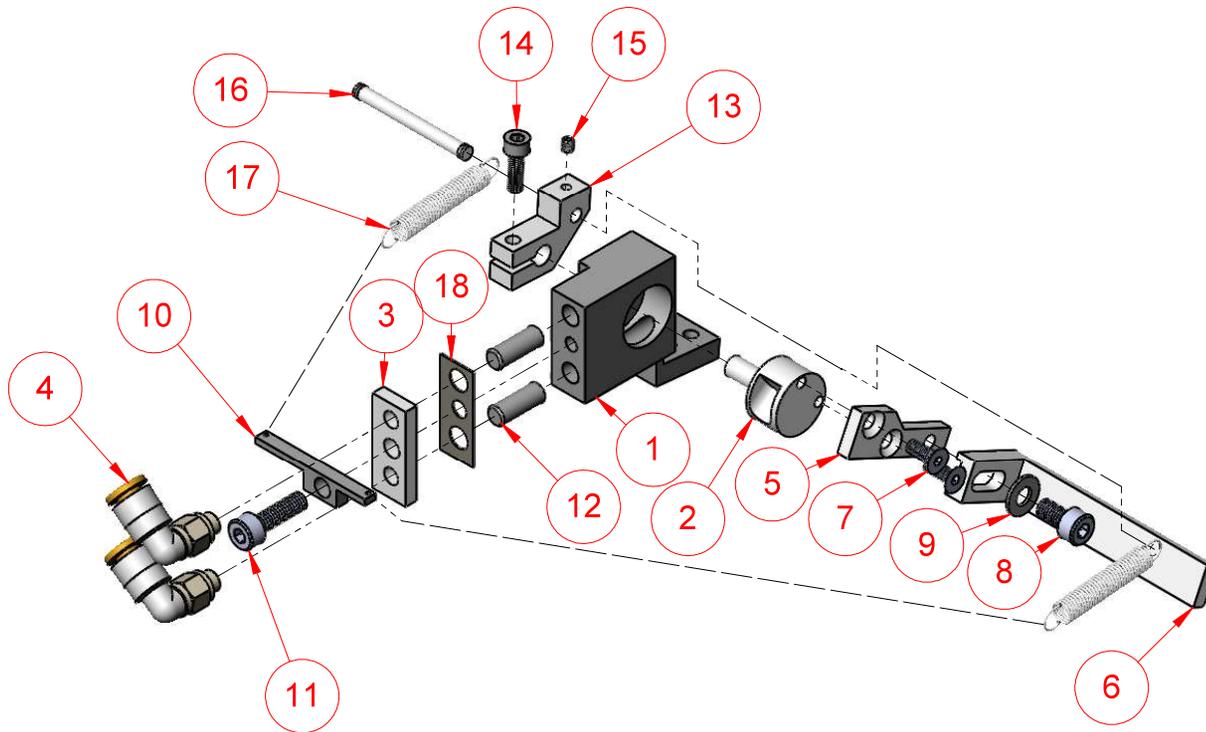
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

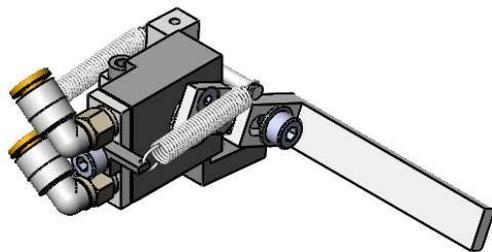
GENERAL TOLERANCE				Date		Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness			Hard,Dpth.		
0,5-6	±0,2	±0,2	±0,4	Heat Trmnt.			Model No.		
6-30	±0,2	±0,25	±0,5	Finish			Machine No.		
30-120	±0,3	±0,45	±0,7	Material			Customer		
120-315	±0,5	±0,6	±1,0	Part/ Ass'y Name	TRANSFER SUB ASM		Part No.	G013568	
315-1000	±0,8	±1,1	±1,5	Scale	1:1		Size	"C"	
1000 ~	±1,2	±1,8	-	Drawn By	Checked By	Approved			
PARALLELNESS	1/100								
ANGLE TOLERANCE	1/100								
SURFACE TOLERANCE	0,2/100								
ROUNDNESS	UNDER 30% TOLERANCE								
SURFACE FINISH NOT TO EXCEED	63		UNLESS OTHERWISE SPECIFIED						

Tracking No.





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013635	ROTATE BLOCK (26A)	1
2	G013636	ACTUATOR (23A)	1
3	G013640	END CAP (23B)	1
4	JW000001	ELBOW FITTING (D2C6)	2
5	G013638	WIPER ARM (23C)	1
6	G013637	BAND WIPER (23D)	1
7	GSSF308	M3X8 FHCS	2
8	GSSC408	M4 X 8 SHCS	1
9	GWFO400	FLAT WASHER M4	1
10	G013641	SPRING ANCHOR (23E)	1
11	GSSC414	M4 X 14 SHCS	1
12	98381A505	DOWEL 3/16 X 1/2 (57G)	2
13	G012498	SPRING CLAMP (23F)	1
14	GSSC310	M3X10 SHCS	1
15	GSSSA04	M2.5 X 4 SET SCREW	1
16	G012499	SPRING PIN (23G)	1
17	G012500	SPRING (23H)	2
18	G014232	GASKET (W12-1A-2D)	1

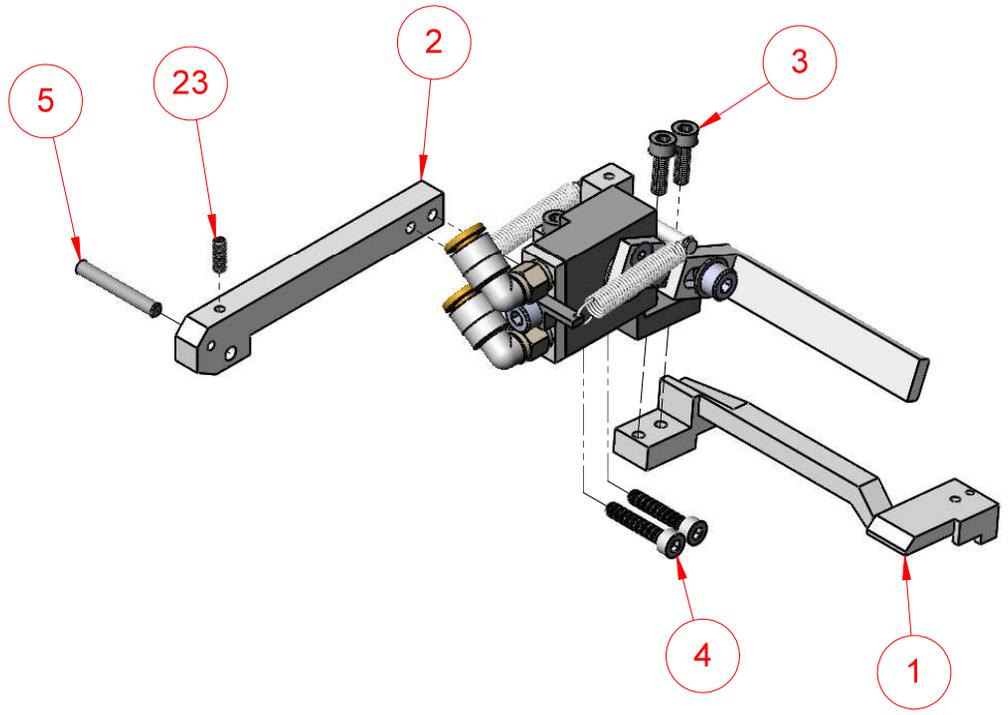


DATE	REV.	DESCRIPTION	INIT
REVISIONS			

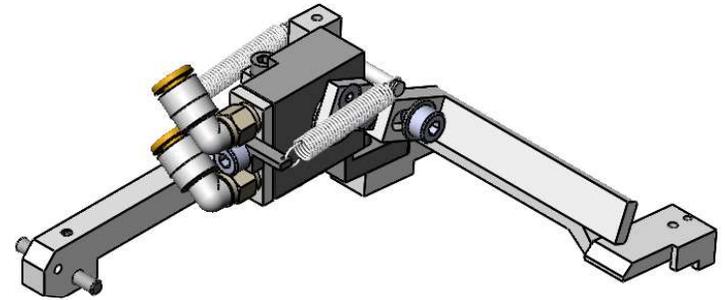
BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.		Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness				Hard.Dpth.		
0.5~6	±0.2	±0.2	±0.4	Heat T'mnt.				Model No.		
6~30	±0.2	±0.25	±0.5	Finish				Machine No.		
30~120	±0.3	±0.45	±0.7	Material				Customer		
120~315	±0.5	±0.6	±1.0	Part/ Ass'y Name	ROT ACT ASM	Part No.	Ass'y No.	Part No.	G013634	
315~1000	±0.8	±1.1	±1.5					Date		
1000 ~	±1.2	±1.8	-	Scale :	1:1	Size :	B			
PARALLELNESS	1/100			Drawn By	Checked By	Approved				
ANGLE TOLERANCE	1/100									
SURFACE TOLERANCE	0.2/100									
ROUNDNESS	UNDER 30% TOLERANCE									
SURFACE FINISH	UNLESS OTHERWISE SPECIFIED									
NOT TO EXCEED	63									





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012489	TOP GUIDE (25G)	1
2	G012488	TOP ARM (22H)	1
3	GSSC310	M3X10 SHCS	3
4	GSSC316	SHCS M3 X 16	2
5	98381A474	DOWEL 1/8 X 7/8 (57E)	1
6	G013635	ROTATE BLOCK (26A)	1
7	G013636	ACTUATOR (23A)	1
8	G013640	END CAP (23B)	1
9	JW000001	ELBOW FITTING (D2C6)	2
10	G013638	WIPER ARM (23C)	1
11	G013637	BAND WIPER (23D)	1
12	GSSF308	M3X8 FHCS	2
13	GSSC408	M4 X 8 SHCS	1
14	GWFO400	FLAT WASHER M4	1
15	G013641	SPRING ANCHOR (23E)	1
16	GSSC414	M4 X 14 SHCS	1
17	98381A505	DOWEL 3/16 X 1/2 (57G)	2
18	G012498	SPRING CLAMP (23F)	1
19	GSSSA04	M2.5 X 4 SET SCREW	1
20	G012499	SPRING PIN (23G)	1
21	G012500	SPRING (23H)	2
22	G014232	GASKET (W12-1A-2D)	1
23	GSSSA08	M2.5 X 8 SET SCREW	1

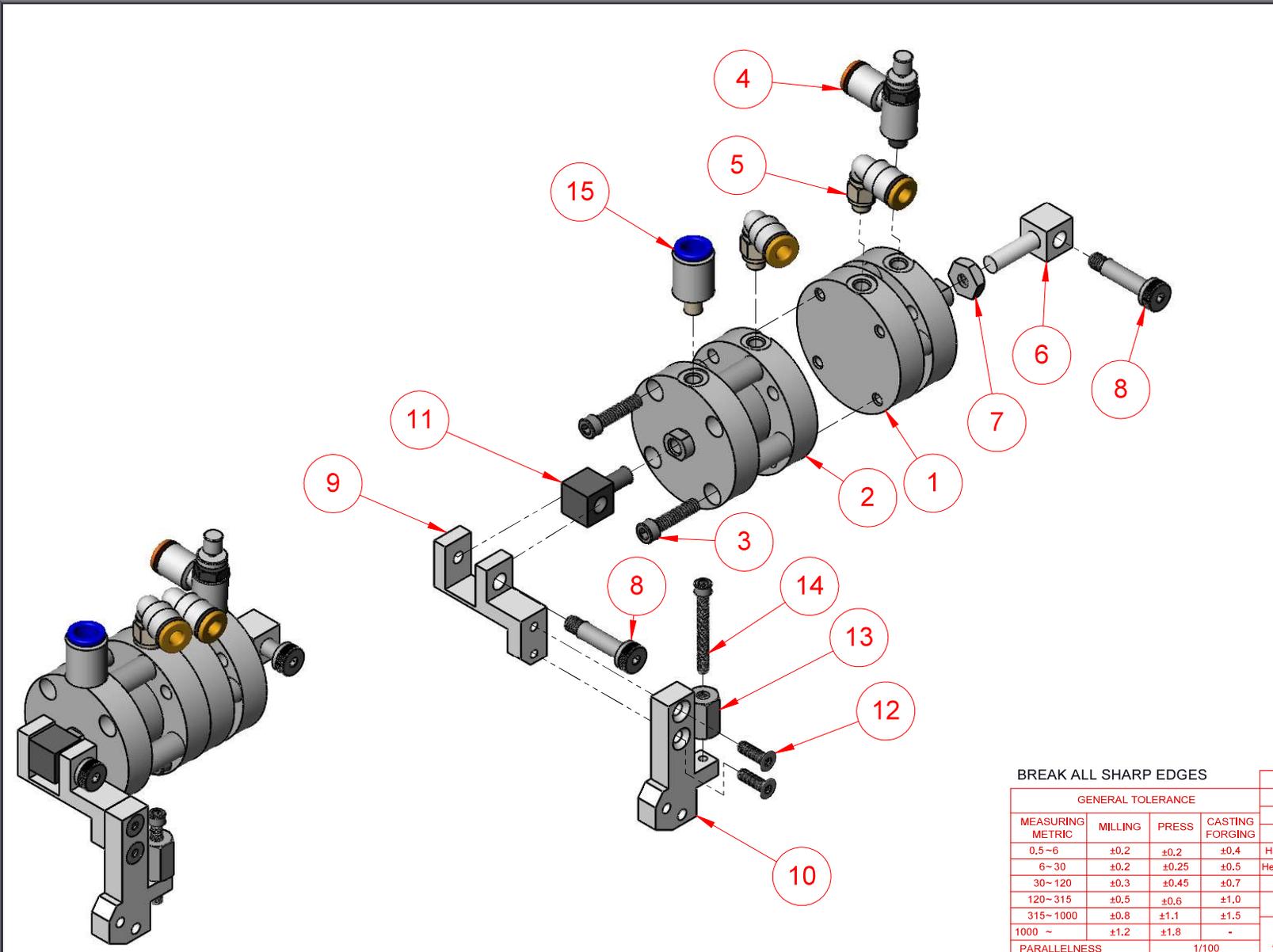


DATE	REV.	DESCRIPTION	INIT
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.		Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness				Hard.Dpth.		
0.5~6	±0.2	±0.2	±0.4	Heat T'mnt.				Model No.		
6~30	±0.2	±0.25	±0.5	Finish				Machine No.		
30~120	±0.3	±0.45	±0.7	Material				Customer		
120~315	±0.5	±0.6	±1.0					Part No.	G013642	
315~1000	±0.8	±1.1	±1.5					Ass'y No.		
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name	TOP CLAMP SUB ASM			Date		
PARALLELNESS			1/100	Scale :	1:1	Size :	B			
ANGLE TOLERANCE			1/100	Drawn By	Checked By	Approved				
SURFACE TOLERANCE			0.2/100							
ROUNDNESS	UNDER 30% TOLERANCE									
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED									





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G014246	AIR CYL (W11-4B)	1
2	G014247	AIR CYL (W11-4BB)	1
3	91251A150	6-32 X 5/8 SHCS	2
4	JW000014	FITTING FLO CON (D2C7)	1
5	JW000001	ELBOW FITTING (D2C6)	2
6	G012507	CLEVIS (21H)	1
7	90480A011	NUT, #10-24 HEX	1
8	97345A492	SHLDR SCRW 3/16 X 5/8, 8-32 (61E)	2
9	G012508	CYL PIVOT (22A)	1
10	G013572	DRIVE (22B)	1
11	G012510	CLEVIS (13H)	1
12	GSSF310	FHCS M3 x 10	2
13	90264A410	COUPLING NUT (22D)	1
14	90044A111	4-40 X 1 SHCS	1
15	G013452	AIR FITTING, 6 MM (24B)	1

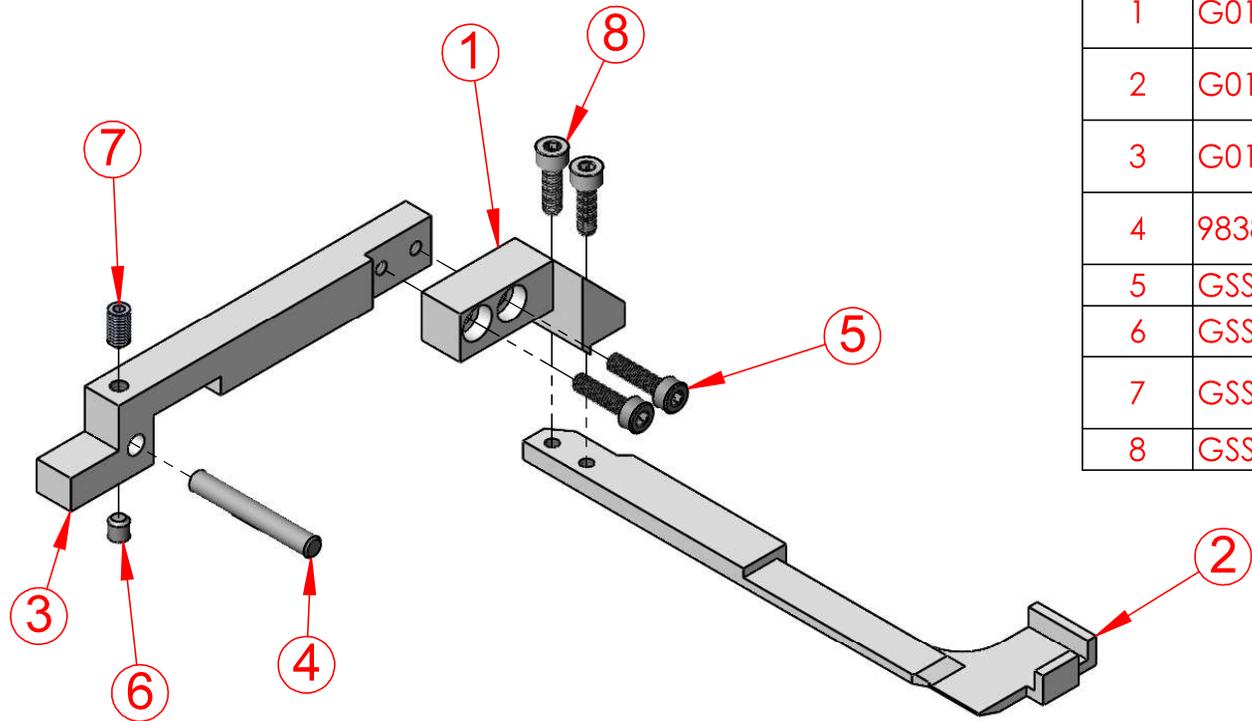
DATE	REV.	DESCRIPTION	INIT
REVISIONS			

BREAK ALL SHARP EDGES

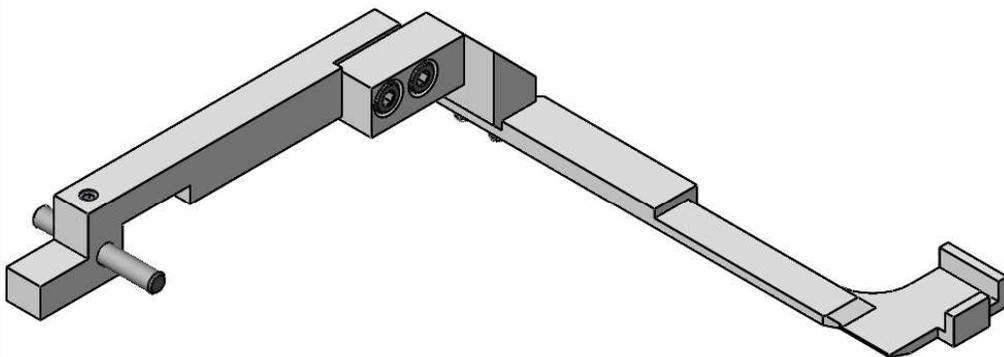
GENERAL TOLERANCE			
MEASURING METRIC	MILLING	PRESS	CASTING FORGING
0.5 ~ 6	±0.2	±0.2	±0.4
6 ~ 30	±0.2	±0.25	±0.5
30 ~ 120	±0.3	±0.45	±0.7
120 ~ 315	±0.5	±0.6	±1.0
315 ~ 1000	±0.8	±1.1	±1.5
1000 ~	±1.2	±1.8	-
PARALLELNESS	1/100		
ANGLE TOLERANCE	1/100		
SURFACE TOLERANCE	0.2/100		
ROUNDNESS	UNDER 30% TOLERANCE		
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED		

Date		Rev.No.	Revisions		Init.
Hardness		Hard.Dpth.			
Heat T'mnt.		Model No.			
Finish		Machine No.			
Material		Customer		Part No. G013571	
Part/ Ass'y Name		Ass'y No.		Date	
Scale : 1:1		Size : B			
Drawn By	Checked By	Approved			





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012484	BOTTOM GUIDE BKT (22E)	1
2	G012483	BOTTOM GUIDE (25E)	1
3	G013582	BOTTOM ARM (22F)	1
4	98381A474	DOWEL W FLAT 1/8 X 7/8 (57C)	1
5	GSSCA10	SCREW GSSCA10	2
6	GSSS303	SCREW, M3X3 SET	1
7	GSSS306	SCREW, M3 X 6 SET	1
8	GSSCA08	M2.5 X 8 SHCS	2



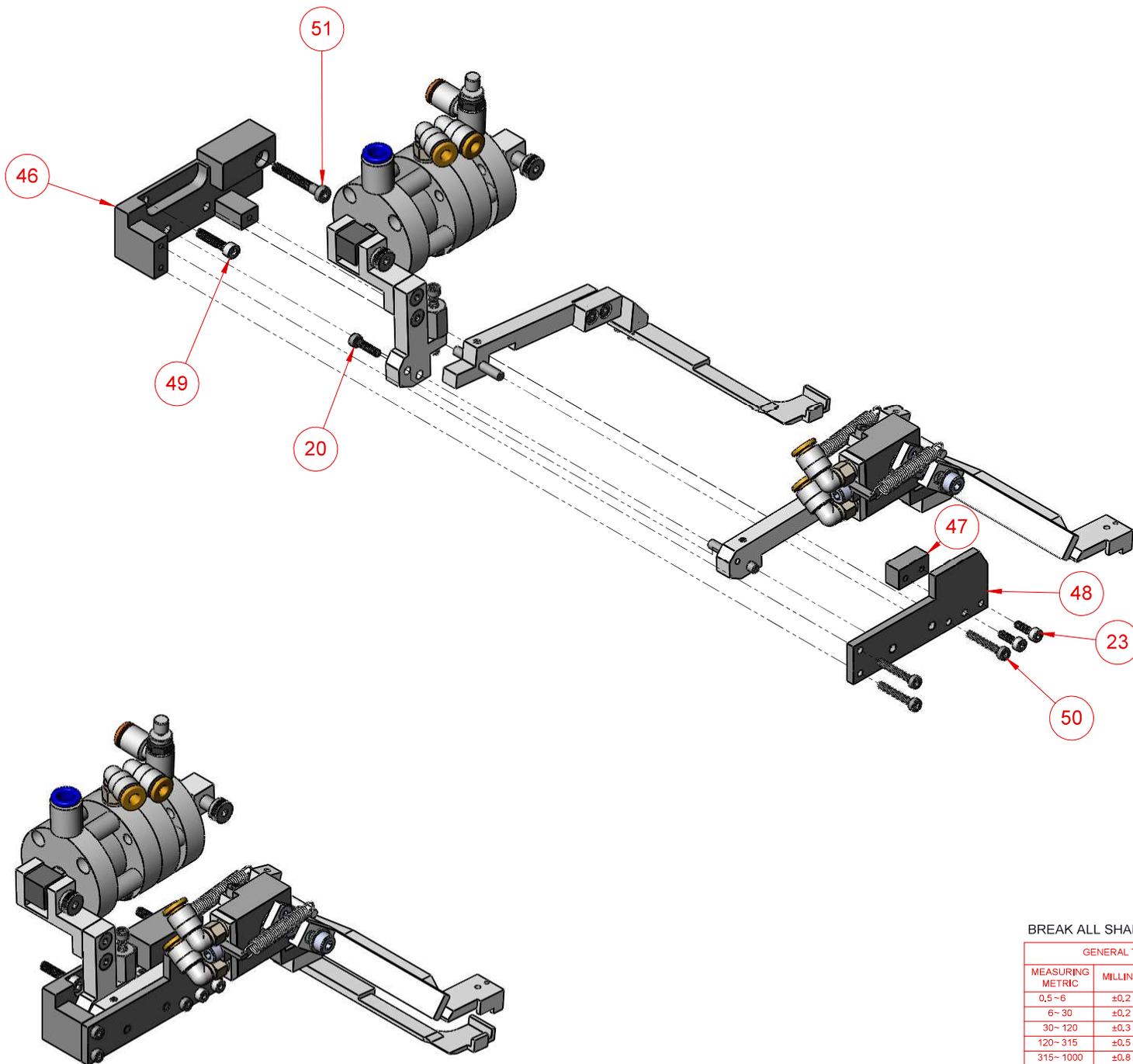
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.		Revisions		Init.	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness				Hard.Dpth.			
0.5~6	±0.2	±0.2	±0.4	Heat T'mnt.				Model No.			
6~30	±0.2	±0.25	±0.5	Finish				Machine No.			
30~120	±0.3	±0.45	±0.7	Material				Customer			
120~315	±0.5	±0.6	±1.0	Part/ Ass'y Name				Part No.	G013583		
315~1000	±0.8	±1.1	±1.5					Ass'y No.			
1000 ~	±1.2	±1.8	-					Date			
PARALLELNESS	1/100			Scale	1:1		Size	"A"			
ANGLE TOLERANCE	1/100			Drawn By	Checked By	Approved					
SURFACE TOLERANCE	0.2/100										
ROUNDNESS	UNDER 30% TOLERANCE										
SURFACE FINISH	63 UNLESS OTHERWISE SPECIFIED										

Tracking No.





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G014246	AIR CYL (W11-4B)	1
2	G014247	AIR CYL (W11-4BB)	1
3	91251A150	6-32 X 5/8 SHCS	2
4	JW000014	FITTING FLO CON (D2C7)	1
5	JW000001	ELBOW FITTING (D2C6)	4
6	G012507	CLEVIS (21H)	1
7	90480A011	NUT, #10-24 HEX	1
8	97345A492	SHLDR SCR W 3/16 X 5/8, 8-32 (61E)	2
9	G012508	CYL PIVOT (22A)	1
10	G013572	DRIVE (22B)	1
11	G012510	CLEVIS (13H)	1
12	GSSF310	FHCS M3 X 10	2
13	90264A410	COUPLING NUT (22D)	1
14	90044A111	4-40 X 1 SHCS	1
15	G013452	AIR FITTING, 6 MM (24B)	1
16	G012484	BOTTOM GUIDE BKT (22E)	1
17	G012483	BOTTOM GUIDE (25E)	1
18	G013582	BOTTOM ARM (22F)	1
19	98381A474	DOWEL W FLAT 1/8 X 7/8 (57C)	1
20	GSSCA10	SCREW GSSCA10	3
21	GSSS303	SCREW, M3X3 SET	1
22	GSSS306	SCREW, M3 X 6 SET	1
23	GSSCA08	M2.5 X 8 SHCS	4
24	G012489	TOP GUIDE (25G)	1
25	G012488	TOP ARM (22H)	1
26	GSSC310	M3X10 SHCS	3
27	GSSC316	SHCS M3 X 16	2
28	98381A474	DOWEL 1/8 X 7/8 (57E)	1
29	GSSSA08	M2.5 X 8 SET SCREW	1
30	G013635	ROTATE BLOCK (26A)	1
31	G013636	ACTUATOR (23A)	1
32	G013640	END CAP (23B)	1
33	G013638	WIPER ARM (23C)	1
34	G013637	BAND WIPER (23D)	1
35	GSSF308	M3X8 FHCS	2
36	GSSC408	M4 X 8 SHCS	1
37	GWFO400	FLAT WASHER M4	1
38	G013641	SPRING ANCHOR (23E)	1
39	GSSC414	M4 X 14 SHCS	1
40	98381A505	DOWEL 3/16 X 1/2 (57G)	2
41	G012498	SPRING CLAMP (23F)	1
42	GSSSA04	M2.5 X 4 SET SCREW	1
43	G012499	SPRING PIN (23G)	1
44	G012500	SPRING (23H)	2
45	G014232	GASKET (W12-1A-2D)	1
46	G013630	ARM BLOCK (W11-4AB)	1
47	G012635	BOTTOM ARM SPACER (24A)	1
48	G012636	ARM BLOCK COVER (26C)	1
49	GSSC314	SHCS M3 X 14	1
50	GSSCA16	M2.5 X 16 SHCS	3
51	GSSC322	M3 X 22 SHCS	1

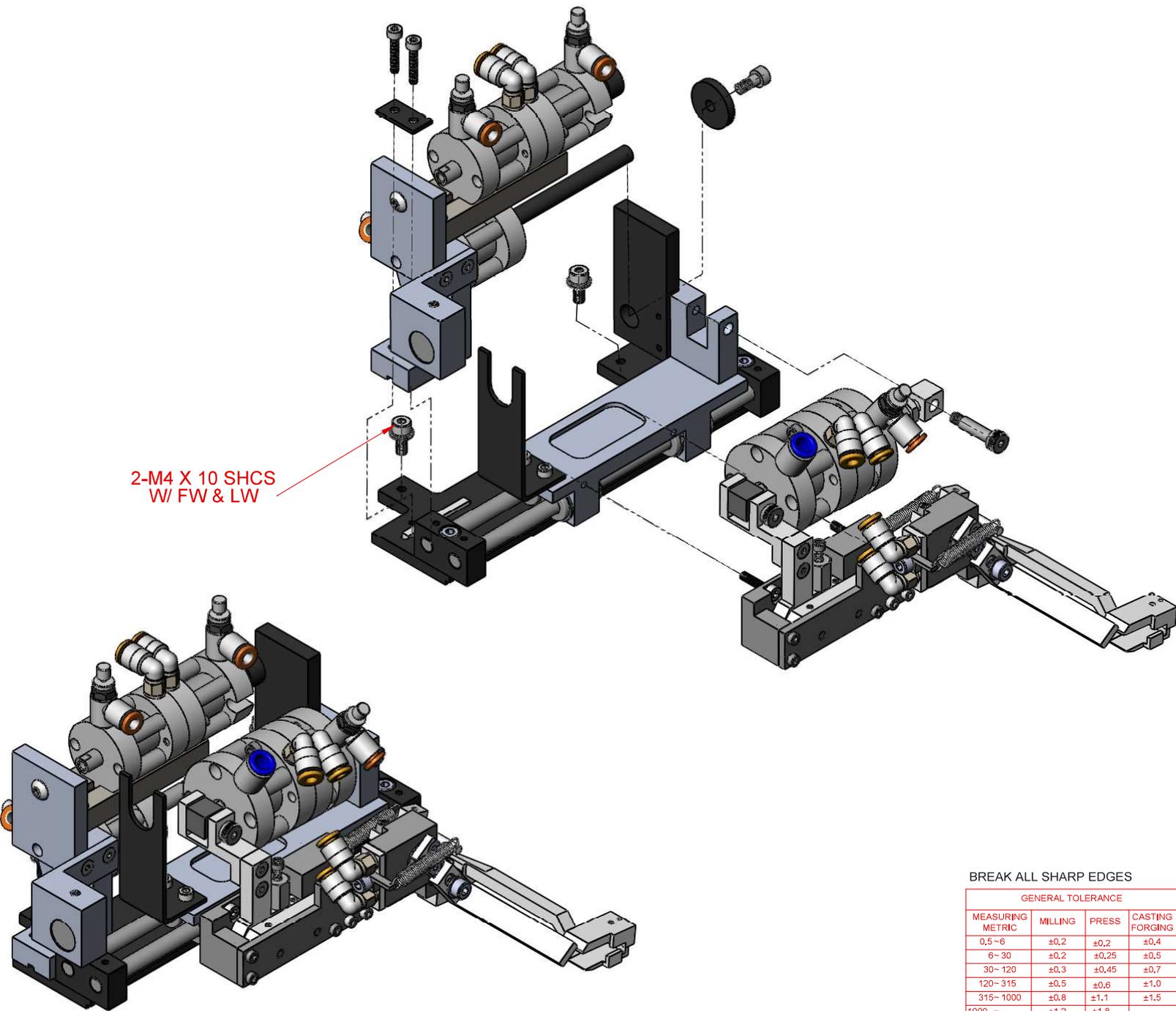
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

Tracking No. W005449

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness		Hard,Dpth.		
0,5-6	±0,2	±0,2	±0,4	Heat Trmnt.		Model No.	GTN1828	
6-30	±0,2	±0,25	±0,5	Finish		Machine No.	302U201B	
30-120	±0,3	±0,45	±0,7	Material		Customer	CARHARTT	
120-315	±0,5	±0,6	±1,0	Part/ Ass'y Name	TRANSFER SUB ASM		Part No.	G013570
315-1000	±0,8	±1,1	±1,5	Scale	1:1		Ass'y No.	G013570
1000 ~	±1,2	±1,8	-	Date	9/17/14			
PARALLELNESS	1/100			Drawn By	Checked By	Approved		
ANGLE TOLERANCE	1/100			TZ				
SURFACE TOLERANCE	0,2/100							
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED							





2-M4 X 10 SHCS
W/ FW & LW

DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

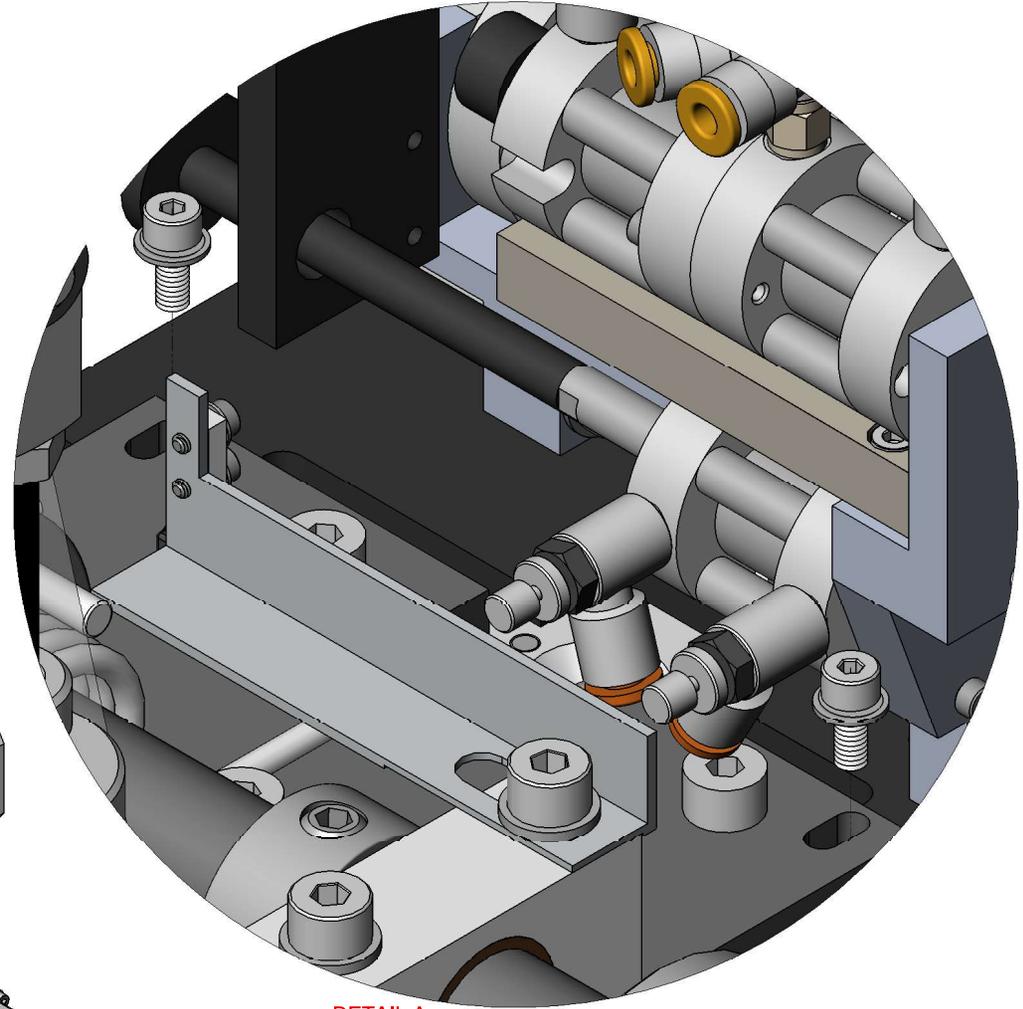
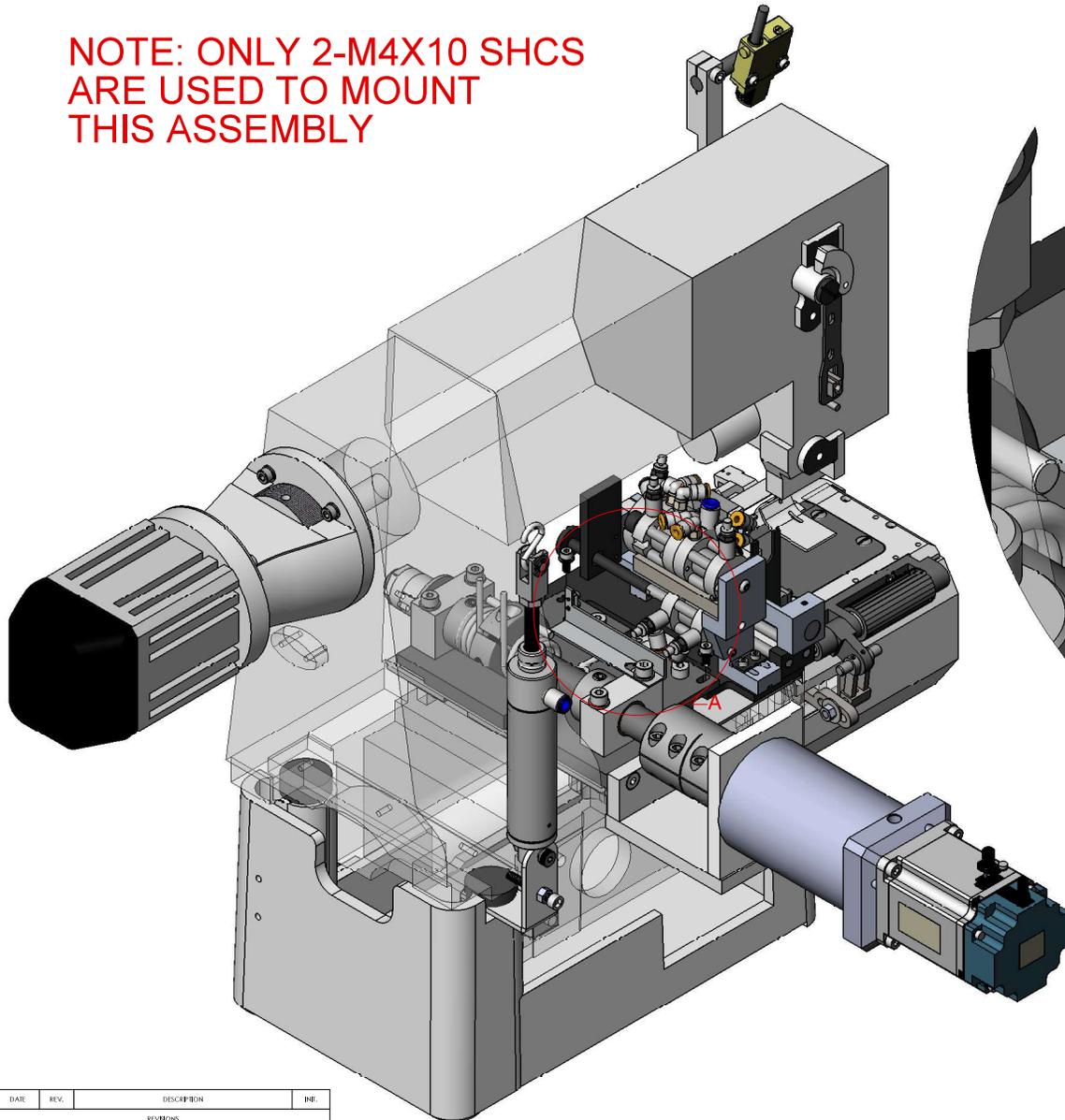
Tracking No. W005449

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness		Hard,Dpth.			
0,5-6	±0,2	±0,2	±0,4	Heat Trmnt.		Model No.	GTN1828		
6-30	±0,3	±0,25	±0,5	Finish		Machine No.	302U201B		
30-120	±0,3	±0,45	±0,7	Material		Customer	CARHARTT		
120-315	±0,5	±0,6	±1,0	Part/ Ass'y Name	TRANSFER ASM	Part No.	G013565		
315-1000	±0,8	±1,1	±1,5			Assy No.	G013565		
1000 ~	±1,2	±1,8	-			Date	9/17/14		
PARALLELNESS						Scale	1:1	Size	"C"
ANGLE TOLERANCE						Drawn By	Checked By	Approved	
SURFACE TOLERANCE									
ROUNDNESS	UNDER 30% TOLERANCE								
SURFACE FINISH NOT TO EXCEED	UNLESS OTHERWISE SPECIFIED					TZ			



STEP 6: ADD G013565

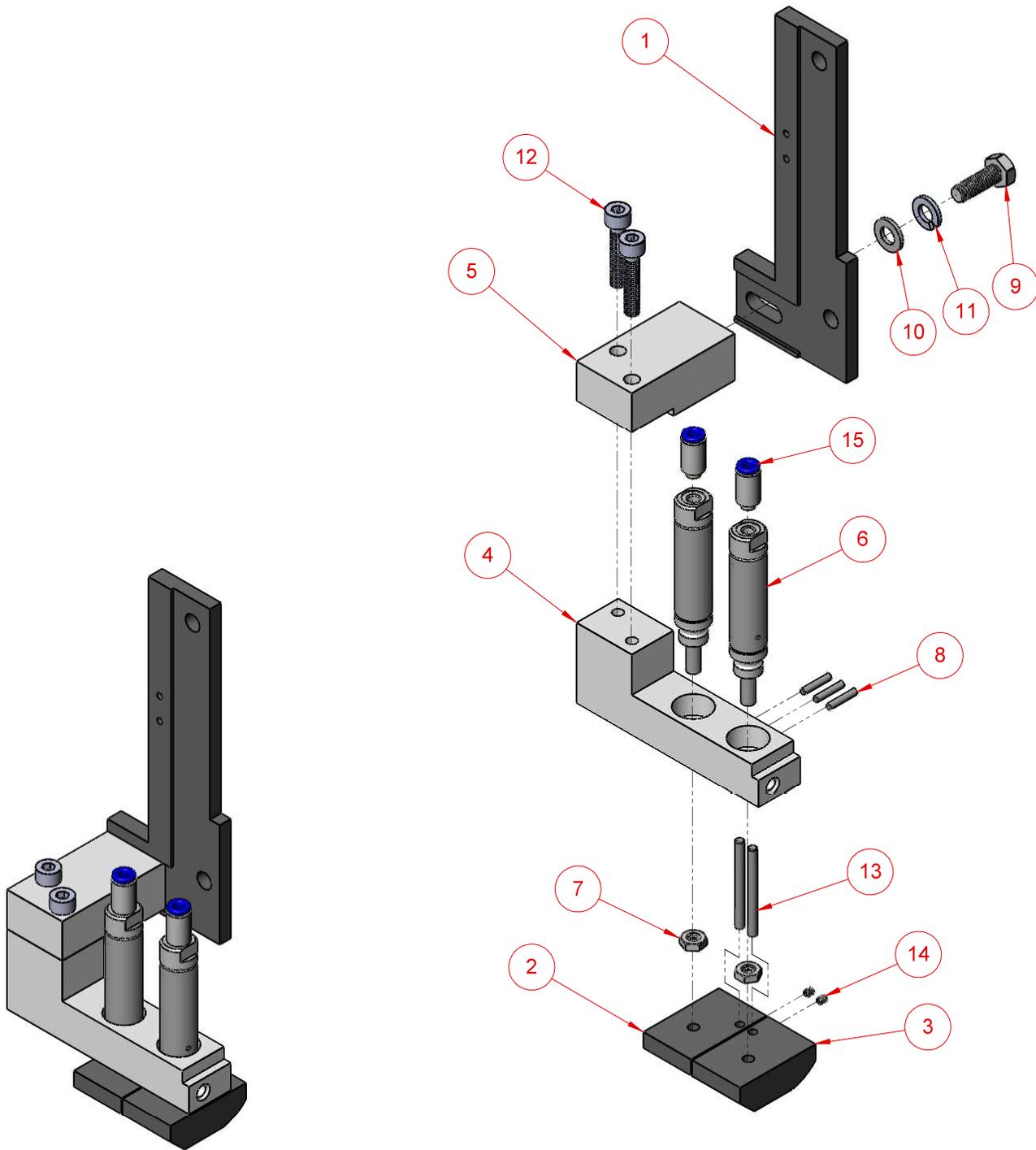
NOTE: ONLY 2-M4X10 SHCS ARE USED TO MOUNT THIS ASSEMBLY



**DETAIL A
SCALE 3.5 : 1**

DATE	REV.	DESCRIPTION	INE
REVISIONS			

BREAK ALL SHARP EDGES										Tracking No.	V005445	
GENERAL TOLERANCE												
MEASURING METRIC	MILLING	PRESS	CASTING	FORGING	Date	Rev.No.	Revisions		Int.			
0.5-6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth.					
6-30	±0.2	±0.25	±0.5	Heat T'mnt.			Modif.No.				GTN1828	
30-120	±0.3	±0.45	±0.7	Finish			Machine No.				302U201B	
120-315	±0.5	±0.6	±1.0	Material			Customer				CARSIARTT	
315-1000	±0.8	±1.1	±1.5				Part No.				G013519	
1000 -	±1.2	±1.8	-				Asly No.				G013519	
PARALLELNESS			1/100	Part/ Assy Name	GTN 1828		Date	9/22/15		Scale	1:1.3 Size	"D"
ANGLE TOLERANCE			1/100	Drawn By	Checked By	Approved						
SURFACE TOLERANCE			0.2/100									
ROUNDNESS			UNDER 30% TOLERANCE									
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED									
NOT TO EXCEED												



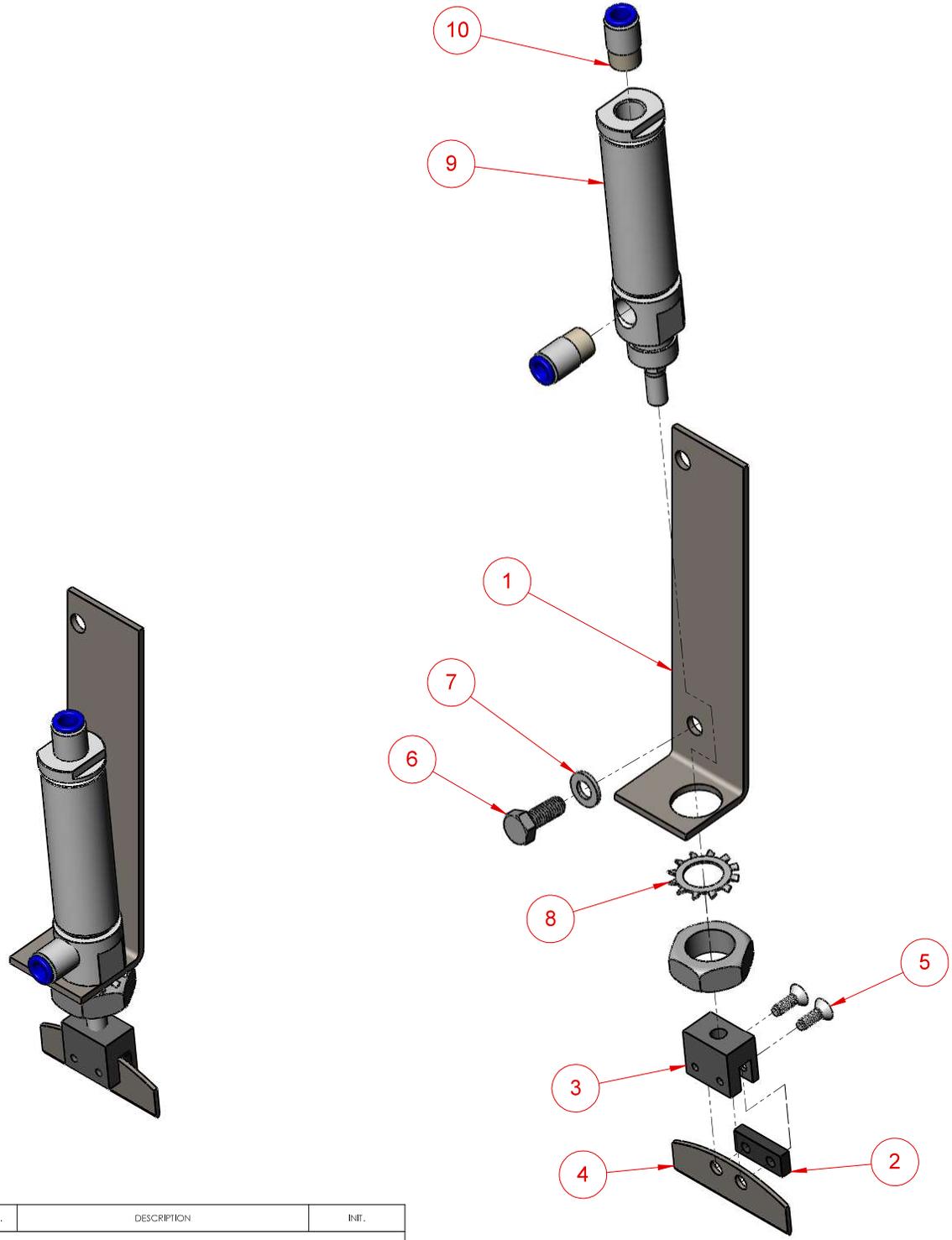
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012840	MOUNT, MAIN (W10-4FB)	1
2	G012836	PRESSER, RIGHT (W10-4G)	1
3	G012837	PRESSER, LEFT (W10-4GB)	1
4	G012838	MOUNT, CYLINDERS (W10-4H)	1
5	G012839	EXTENSION (W10-4HB)	1
6	G014256	AIR CYL (W10-4I)	2
7	GN00L00	10-32 NUT	2
8	98381A438	DOWEL 3/32 X 1/2 (63A)	3
9	GSHC618	M6 CAP SCREW	1
10	GWFO600	FW M6	1
11	GWLO600	WSHR, LOCK M6	1
12	GSSC525	M5X25 SHCS	2
13	98381A494	DOWEL 1/8 X 1 3/8 (63B)	2
14	GSSSA04	M2.5 X 4 SET SCREW	2
15	G013961	AIR FITTING, 4 MM (12A)	2

DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness			Hard,Dpth.		
0,5-6	±0,2	±0,2	±0,4	Heat Trmnt.			Model No.		
6-30	±0,2	±0,25	±0,5	Finish			Machine No.		
30-120	±0,3	±0,45	±0,7	Material			Customer		
120-315	±0,5	±0,6	±1,0	Part/ Ass'y Name			Part No.		
315-1000	±0,8	±1,1	±1,5	Scale : 1:1			Ass'y No.		
1000 ~	±1,2	±1,8	-	Size : "C"			Date		
PARALLELNESS	1/100			Drawn By	Checked By	Approved	G012813EX1		
ANGLE TOLERANCE	1/100			GTN, INC.					
SURFACE TOLERANCE	0,2/100								
ROUNDNESS	UNDER 30% TOLERANCE								
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED								

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012816	MOUNT, ANGLE (W10-4IB)	1
2	G012819	INSERT, SOFT (W11-1A-1H)	1
3	G012818	SUPPORT, BLADE (W10-4J)	1
4	G012817	BLADE (W11-1A-1G)	1
5	GSSF011	6-32 X 7/16 FHCS	2
6	GSHC616	M6 X 16 CAP SCREW	1
7	GWFO600	FW M6	1
8	GWE0U00	TOOTH LW	1
9	G014250	KNIFE AIR CYL (W10-4KB)	1
10	G013960	RND AIR FITTING, 6 MM (12B)	2



DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

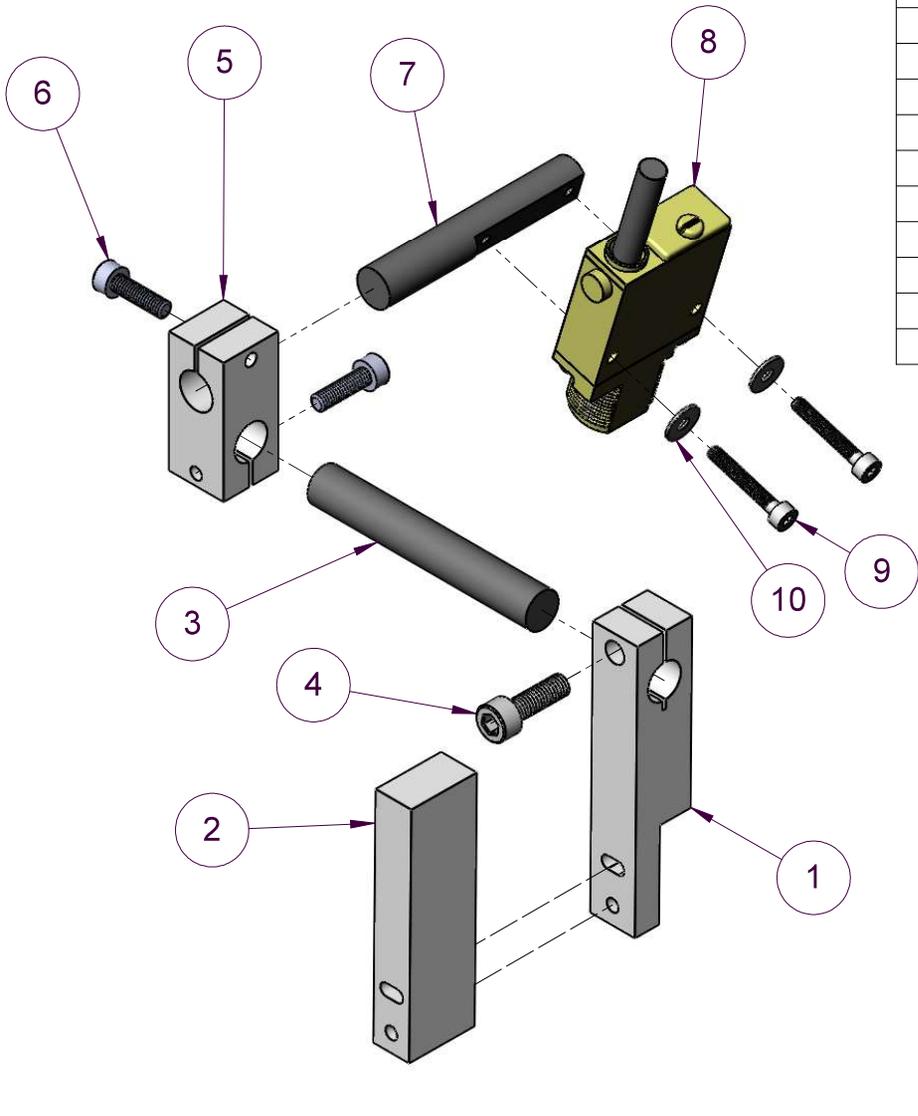
BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.		Revisions		Init.	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness				Hard,Dpth.		Model No.	
0,5-6	±0,2	±0,2	±0,4	Heat Trmnt.				Machine No.		Customer	
6-30	±0,2	±0,25	±0,5	Material				Part No.		Ass'y No.	G012813EX2
30-120	±0,3	±0,45	±0,7	Part/ Ass'y Name				Date		Scale	1:1 Size : "C"
120-315	±0,5	±0,6	±1,0	Drawn By		Checked By		Approved			
315-1000	±0,8	±1,1	±1,5								
1000 ~	±1,2	±1,8	-								
PARALLELNESS	1/100										
ANGLE TOLERANCE	1/100										
SURFACE TOLERANCE	0,2/100										
ROUNDNESS	UNDER 30% TOLERANCE										
SURFACE FINISH NOT TO EXCEED	UNLESS OTHERWISE SPECIFIED										

Tracking No.

G012813EX2





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013694	PEC MOUNT (W10-5BB)	1
2	G013751	SENSOR BLOCK (W10-5C)	1
3	G013752	SENSOR SHAFT (W11-1A-3E)	1
4	GSSC516	M5 X 16 SHCS	1
5	G013753	JOINT (W10-5B)	1
6	GSSC414	M4 X 14 SHCS	2
7	G013696	PEC SHAFT (W11-1A-5C)	1
8	G013695	BANNER SENSOR (W10-5D)	1
9	GSSC320	M3 X 20 SHCS	2
10	GWFO300	FLAT WASHER, M3	2

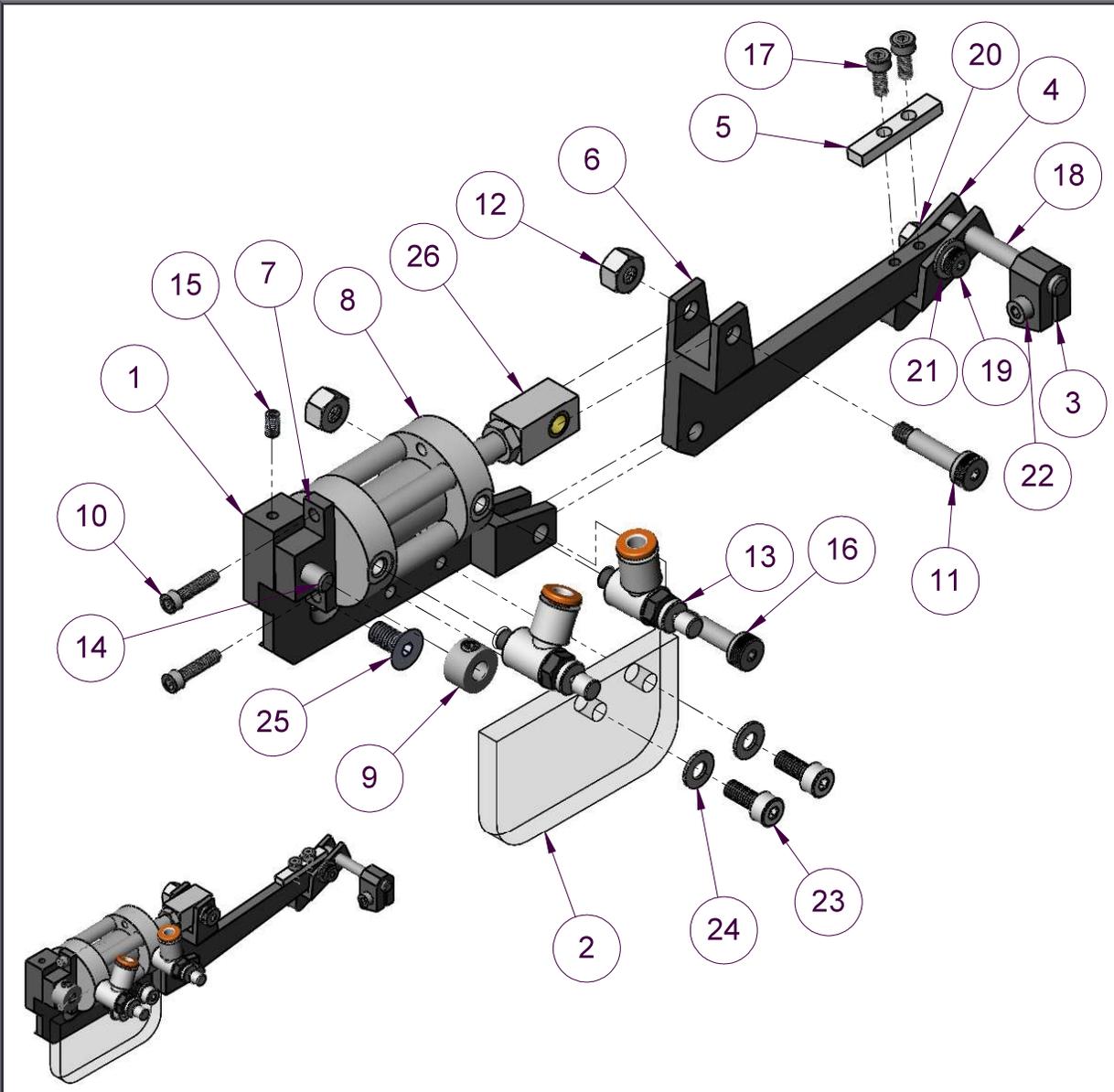
DATE	REV.	DESCRIPTION	INIT
REVISIONS			

BREAK ALL SHARP EDGES

Tracking No. W005445

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5 ~ 6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6 ~ 30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	GTN1828
30 ~ 120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120 ~ 315	±0.5	±0.6	±1.0	Material		Customer	CARHARTT
315 ~ 1000	±0.8	±1.1	±1.5	Part/ Ass'y Name	CHOP SENSOR ASM	Part No.	G012813EX3
1000 ~	±1.2	±1.8	-			Ass'y No.	G013750
PARALLELNESS			1/100			Date	12/3/14
ANGLE TOLERANCE			1/100			Scale	1:1 Size : B
SURFACE TOLERANCE			0.2/100	Drawn By	Checked By	Approved	
ROUNDNESS	UNDER 30% TOLERANCE			TZ			
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED						



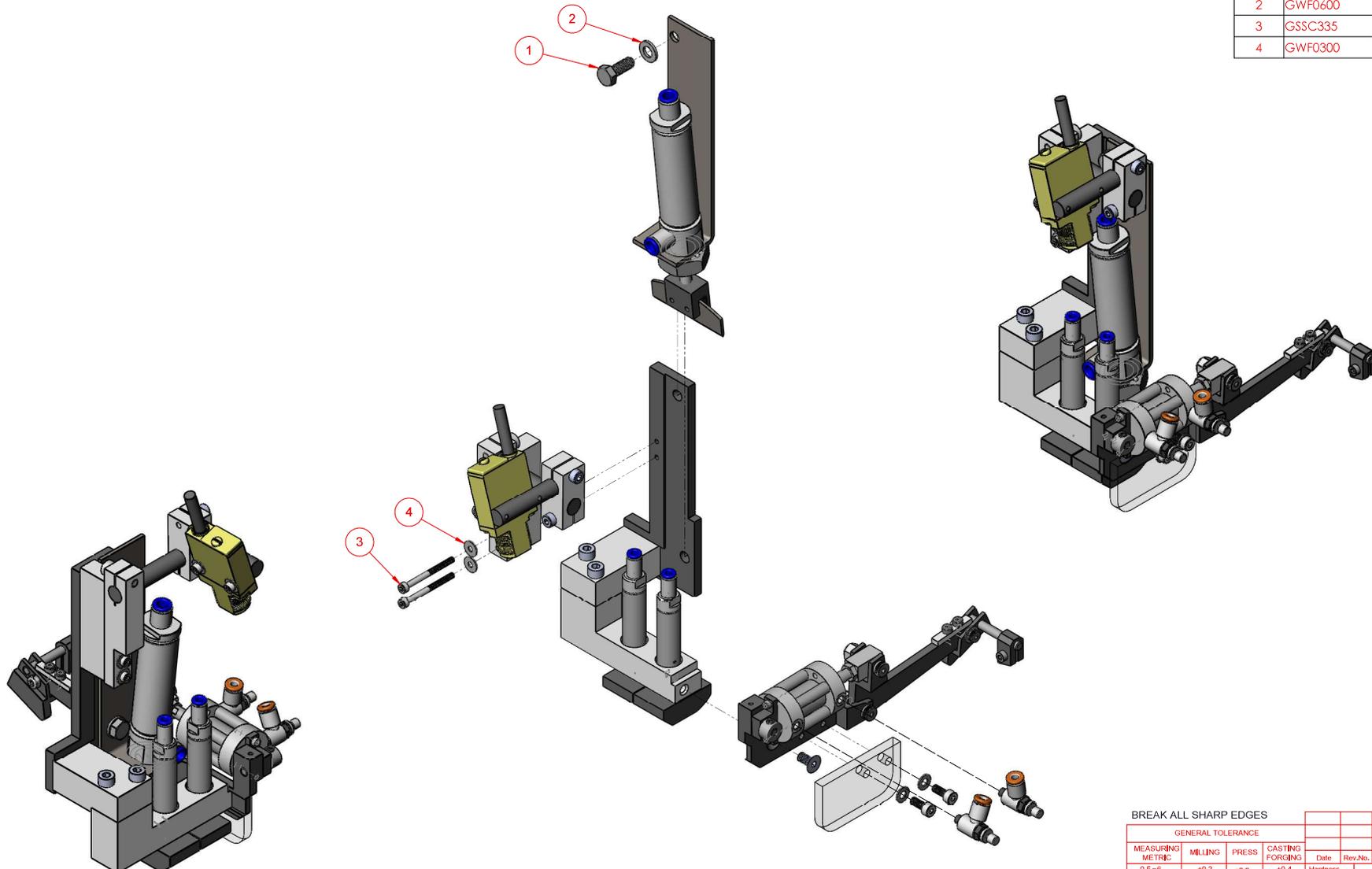


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013492	TOP CLAMP BRKT (W10-4JB)	1
2	G012821	SAFETY BRKT (W11-1A-5A)	1
3	G012826	LIFTER PAD (W11-1A-2G)	1
4	G012828	TOP PAD (W11-1A-2H)	1
5	G012829	LIMIT (W11-1A-3A)	1
6	G012830	TOP CLAMP ARM (W10-5A)	1
7	G012833	CYL BRKT (W11-1A-3B)	1
8	G014251	AIR CYL (W10-5AB)	1
9	9414T5	COLLAR 3/16 (13C)	1
10	GSSCE13	4/40 X 1/2 SHCS	2
11	97345A492	SHLDR SCRW 3/16 X 5/8, 8-32 (61E)	1
12	GN0LJ00	LOCK NUT, 8-32	2
13	JW000014	FITTING FLO CON (D2C7)	2
14	98381A509	DOWEL 3/16 X 7/8 (63C)	1
15	GSSS306	SCREW, M3 X 6 SET	1
16	91259A166	SHLDR SCRW 3/16 X 1/2, 8-32 (61D)	1
17	GSSC308	SHCS M3 x 8	2
18	98381A514	DOWEL 3/16 X 1 1/2 (63D)	1
19	91259A156	SHLDR SCRW 1/8 X 3/8, 4-40 (61G)	1
20	GN0LE00	LOCK NUT 4-40	1
21	GWFOE00	#4 FW	1
22	GSSC310	M3X10 SHCS	1
23	GSSC410	SHCS M4 x 10	2
24	GWFO400	FLAT WASHER M4	2
25	GSSF510	SCREW, M5X10 FHCS	1
26	G013428	CLEVIS (13D)	1

DATE	REV.	DESCRIPTION	INIT
REVISIONS			

BREAK ALL SHARP EDGES		Tracking No. W005445	
GENERAL TOLERANCE			
MEASURING METRIC	MILLING	PRESS	CASTING FORGING
0.5-6	±0.2	±0.2	±0.4
6-30	±0.2	±0.25	±0.5
30-120	±0.3	±0.45	±0.7
120-315	±0.5	±0.6	±1.0
315-1000	±0.8	±1.1	±1.5
1000 ~	±1.2	±1.8	-
PARALLELNESS	1/100		
ANGLE TOLERANCE	1/100		
SURFACE TOLERANCE	0.2/100		
ROUNDNESS	UNDER 30% TOLERANCE		
SURFACE FINISH	UNLESS OTHERWISE SPECIFIED		
NOT TO EXCEED	63		
Date	Rev.No.	Revisions	
		Hard.Dpth.	Init.
		Heat T'mnt.	Model No. GTN1828
		Finish	Machine No. 302U201B
		Material	Customer CARHARTT
Part/ Ass'y Name	PANEL SUPPORT ASM		Part No. G012813EX4
			Ass'y No. G012820
			Date 8/10/14
Drawn By	Checked By	Approved	
TZ		GTN, INC.	
		Scale : 1:1	Size : B

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSHC616	M6 X 16 CAP SCREW	1
2	GWFO600	FW M6	1
3	GSSC335	SHCS M3 X 35	2
4	GWFO300	FLAT WASHER, M3	2



DATE	REV.	DESCRIPTION	INE.
REVISIONS			

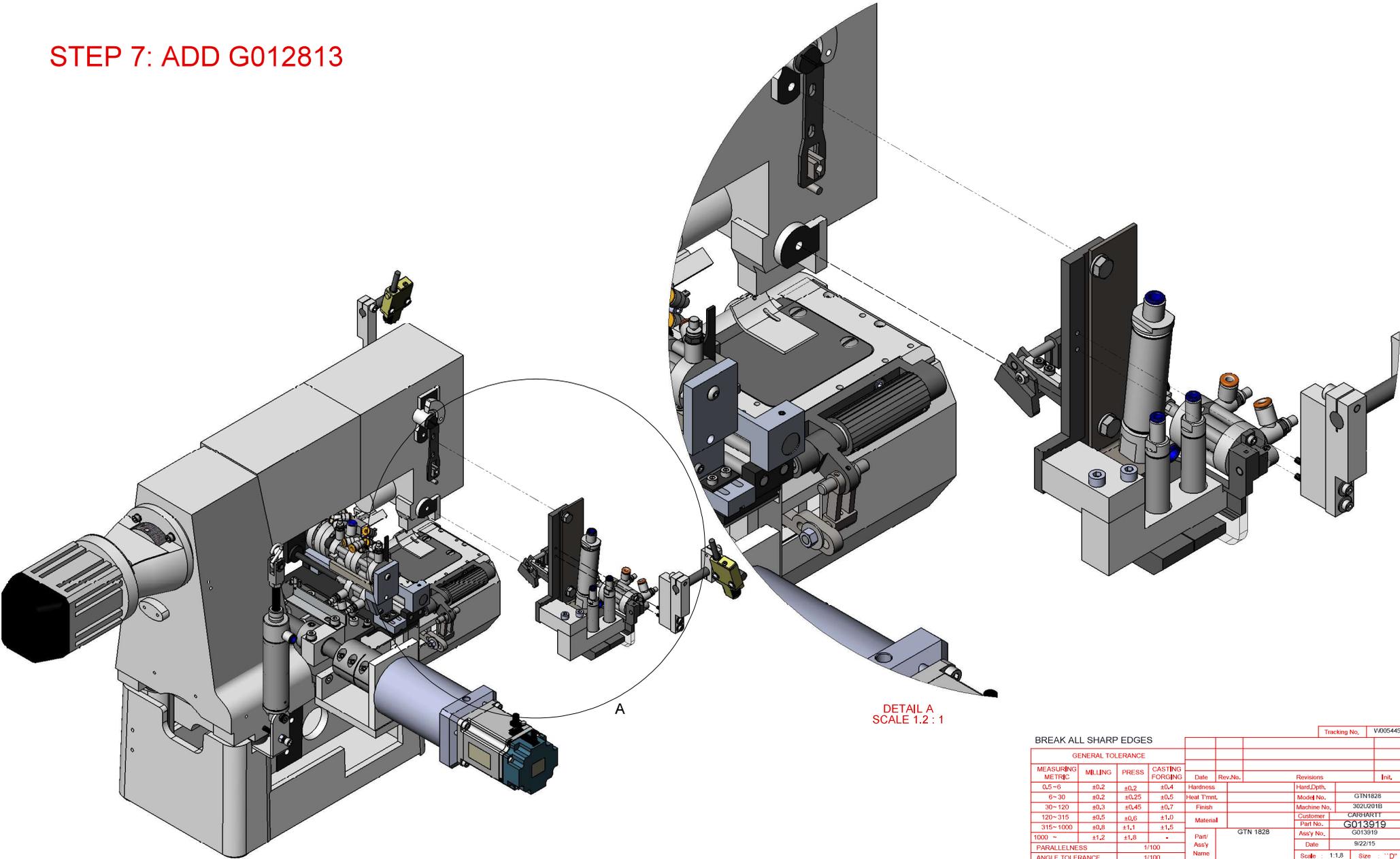
MEASURING METRIC		MILLING	PRESS	CASTING	FORGING	Date	Rev.No.	Revisions	Int.
0.5-6	±0.2	±0.2	±0.4	Hardness				Hard.Depth	
6-30	±0.2	±0.25	±0.5	Heat T'mnt.				Modif.No.	GTN1828
30-120	±0.3	±0.45	±0.7	Finish				Machine No.	302U201B
120-315	±0.5	±0.6	±1.0	Material				Customer	CARSIARTT
315-1000	±0.8	±1.1	±1.5	Part No.				Part No.	G012813EX5
1000 =	±1.2	±1.8	-	Assy No.				Assy No.	G012813
PARALLELNESS			1/100	Part Name	UPPER PANEL SUPPORT ASM				
ANGLE TOLERANCE			1/100	Part Name					
SURFACE TOLERANCE			0.2/100	Part Name					
ROUNDNESS	UNDER 30% TOLERANCE			Part Name					
SURFACE FINISH	UNLESS OTHERWISE SPECIFIED			Part Name					
NOT TO EXCEED	UNLESS OTHERWISE SPECIFIED			Part Name					

Tracking No. V005445

Drawn By	Checked By	Approved
TZ		



STEP 7: ADD G012813

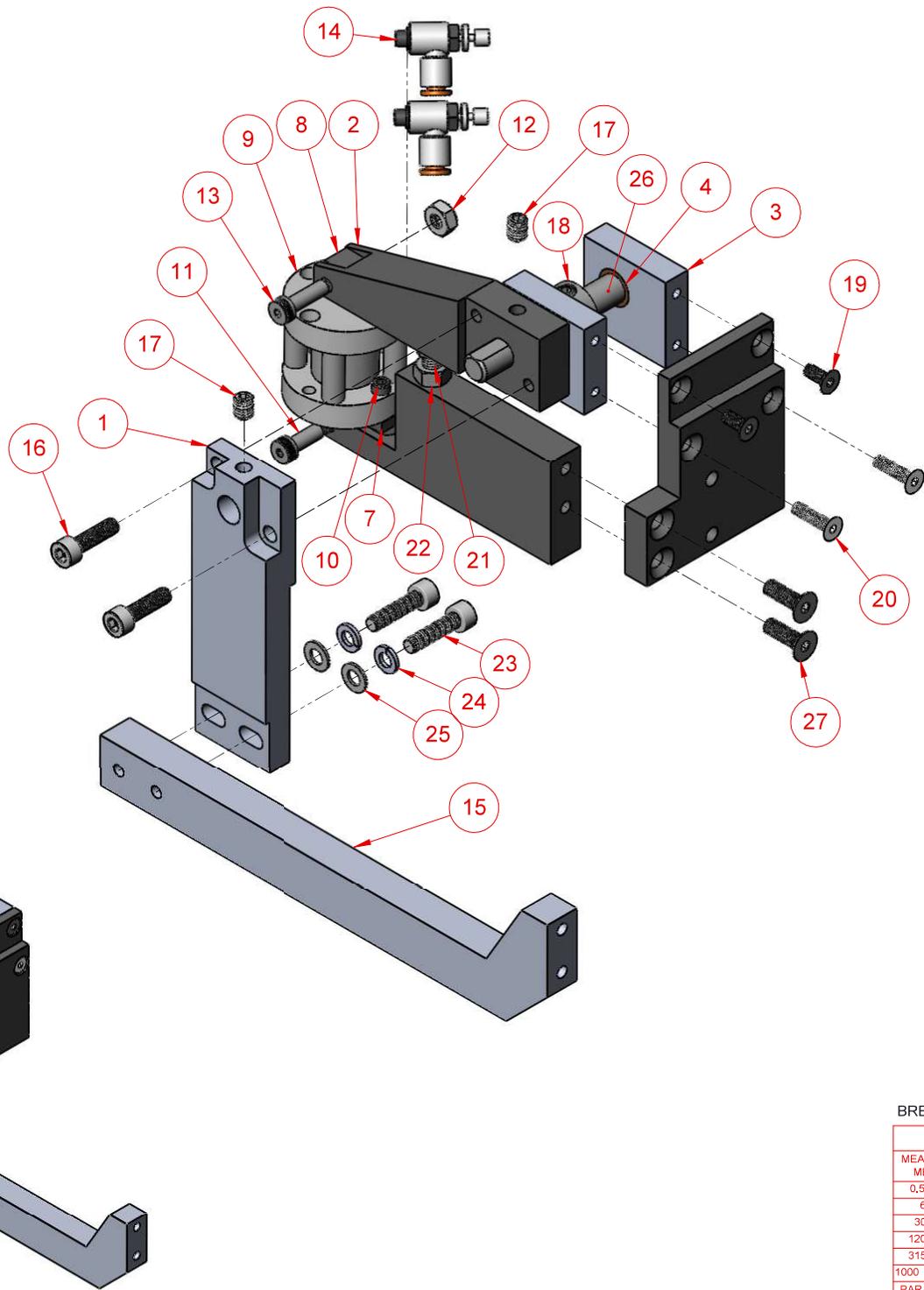


DETAIL A
SCALE 1.2:1

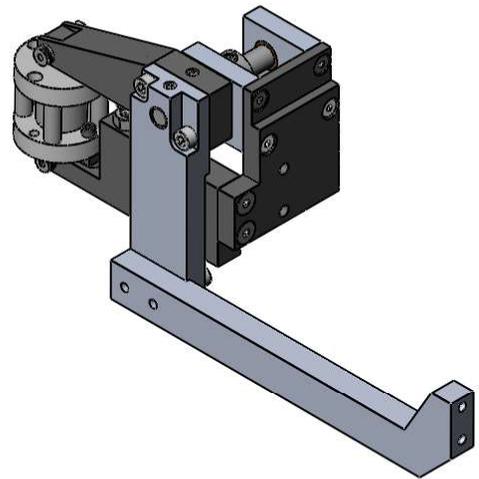
DATE	REV.	DESCRIPTION	INC.
REVISIONS			

BREAK ALL SHARP EDGES										Tracking No.	V005445
GENERAL TOLERANCE											
MEASURING METRIC	MILLING	PRESS	CASTING	FORGING	Date	Rev.No.	Revisions			Int.	
0.5-6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth.				
6-30	±0.2	±0.25	±0.5	Heat T'mnt.			Modif.No.			GTN1828	
30-120	±0.3	±0.45	±0.7	Finish			Machine No.			302U201B	
120-315	±0.5	±0.6	±1.0	Material			Customer			CASPAR ITT	
315-1000	±0.8	±1.1	±1.5				Part No.			G013919	
1000 =	±1.2	±1.8	-				Asly No.			G013919	
PARALLELNESS			1/100	Part/ Assy Name	GTN 1828		Date			9/22/15	
ANGLE TOLERANCE			1/100				Scale			1:1.8 Size : " D"	
SURFACE TOLERANCE			0.2/100	Drawn By	Checked By	Approved					
ROUNDNESS			UNDER 30% TOLERANCE								
SURFACE FINISH NOT TO EXCEED			UNLESS OTHERWISE SPECIFIED								





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012764	PANEL VERT ARM (W10-5E)	1
2	G012762	PANEL CLAMP DRIVE (W10-5F)	1
3	G012760	BEARING BLOCK (W10-5G)	2
4	2868T5	BRONZE SLEEVE (13F)	2
5	G012759	PANEL CLAMP MTG. (W10-5GB)	1
6	G012758	BOTTOM CYL BRKT (W10-5H)	1
7	G012756	CYL MOUNT (W11-1A-3G)	1
8	G012510	CLEVIS (W11-1A-3H)	1
9	G012770	AIR CYL (W10-5I)	1
10	GSSCG13	6-32 X 1/2 SHCS	2
11	91259A166	SHLDR SCRW 3/16 X 1/2, 8-32 (61D)	1
12	GNOLL00	10-32 LOCK NUT	2
13	97345A492	SHLDR SCRW 3/16 X 5/8, 8-32 (61E)	1
14	JW000014	FITTING FLO CON (D2C7)	2
15	G012755	CYL BRKT (W10-5J)	1
16	GSSC518	M5 X 18 SHCS	2
17	GSSS606	M6 X 6 SET SCREW	2
18	9414T8	SHAFT COLLAR (14A)	1
19	GSSF410	M4 X 10 FHCS	2
20	GSSF416	M4 X 16 FHCS	2
21	GSHC625	M6 X 25 CAP SCREW	1
22	GN00600	NUT, M6 HEX	1
23	GSSC520	M5 X 20 SHCS	2
24	GWL0500	WASHER, M5 LOCK	2
25	GWFO500	M5 FW	2
26	G013511	PANEL SUPPORT SHAFT (16G)	1
27	GSSF516	M5 X 16 FLHD	2

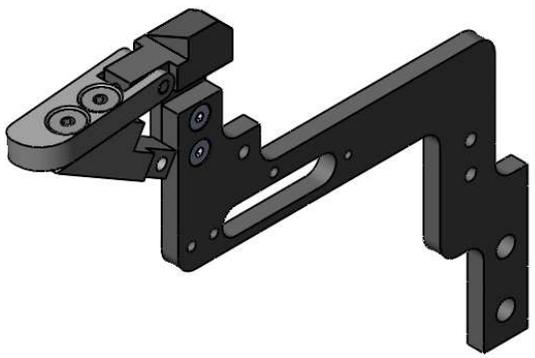
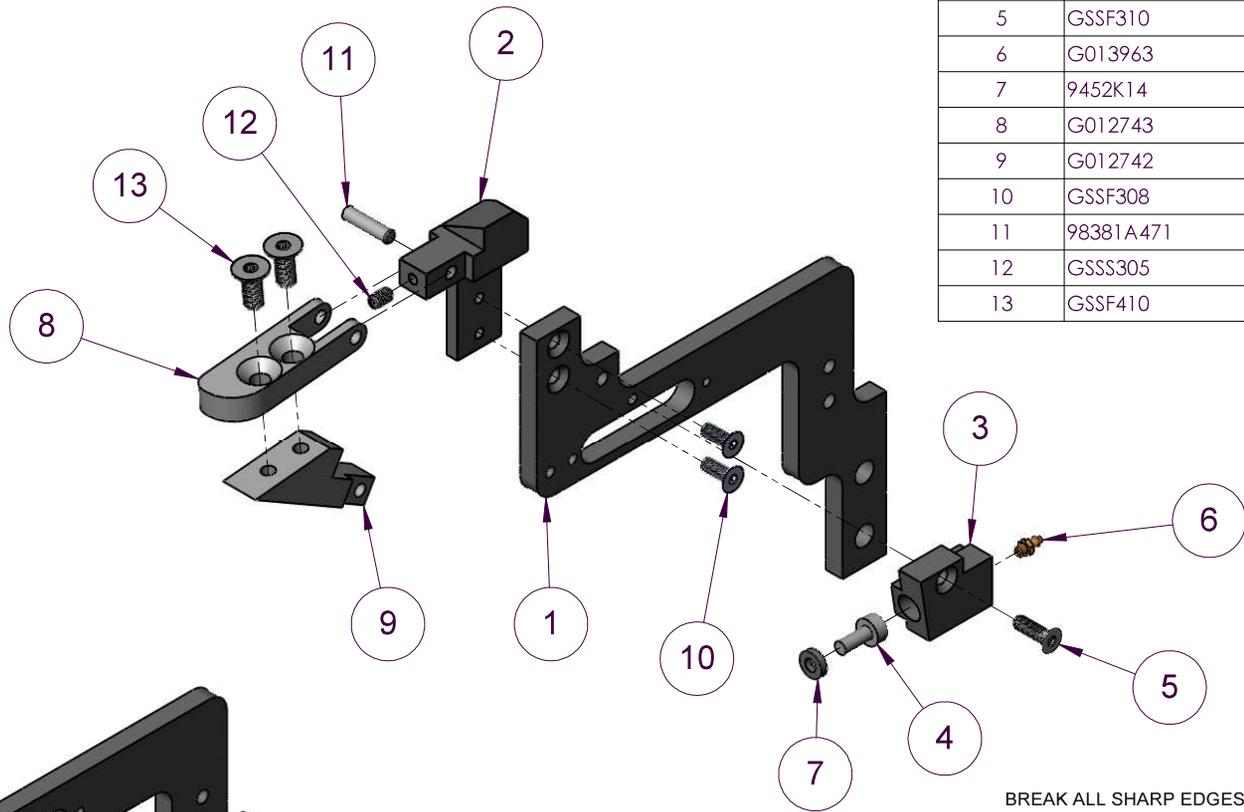


DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING						
0.5-6	±0.2	±0.2	±0.4	Hardness			Hard, Dpth.		
6-30	±0.2	±0.25	±0.5	Heat Trmt.			Model No.		
30-120	±0.3	±0.45	±0.7	Finish			Machine No.		
120-315	±0.5	±0.6	±1.0	Material			Customer		
315-1000	±0.8	±1.1	±1.5	Part/ Ass'y Name	BACK LOWER PANEL SUPPORT ASM		Part No.	G013497EX1	
1000 ~	±1.2	±1.8	-	Scale	1:1		Ass'y No.		
PARALLELNESS	1/100			Drawn By	Checked By	Approved	Date		
ANGLE TOLERANCE	1/100			Scale : 1:1 Size : "C"					
SURFACE TOLERANCE	0.2/100			UNLESS OTHERWISE SPECIFIED					
ROUNDNESS	UNDER 30% TOLERANCE			GTN, INC.					
SURFACE FINISH NOT TO EXCEED	63								

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012752	PANEL CLAMP OFFSET (W10-5K)	1
2	G012751	PANEL CLAMP PAD (W11-1A-5E)	1
3	G013506	EAR TUCK CYL (W11-1A-4D)	1
4	G013507	PISTON (W11-1A-4E)	1
5	GSSF310	FHCS M3 x 10	1
6	G013963	MINI AIR FITTING (12E)	1
7	9452K14	O-RING (21A)	1
8	G012743	EXTENSION (W11-1A-4G)	1
9	G012742	EXTENSION ARM (W11-1A-5G)	1
10	GSSF308	M3X8 FHCS	2
11	98381A471	DOWEL 1/8 X 1/2 (62A)	1
12	GSSS305	M3 X 5 SET SCREW	1
13	GSSF410	M4 X 10 FHCS	2



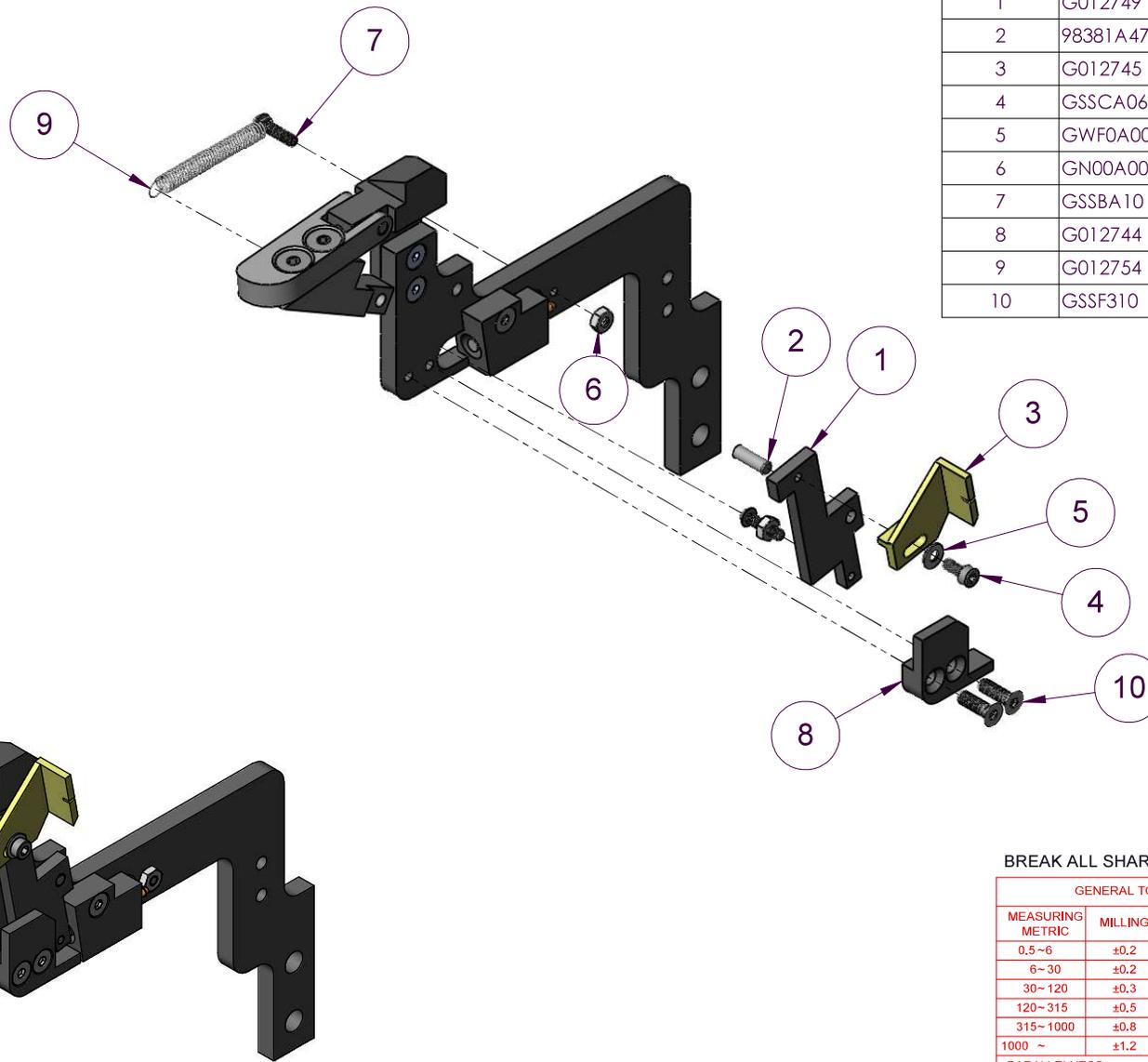
DATE	REV.	DESCRIPTION	INIT
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE			
MEASURING METRIC	MILLING	PRESS	CASTING FORGING
0.5~6	±0.2	±0.2	±0.4
6~30	±0.2	±0.25	±0.5
30~120	±0.3	±0.45	±0.7
120~315	±0.5	±0.6	±1.0
315~1000	±0.8	±1.1	±1.5
1000 ~	±1.2	±1.8	-
PARALLELNESS		1/100	
ANGLE TOLERANCE		1/100	
SURFACE TOLERANCE 0.2/100			
ROUNDNESS		UNDER 30% TOLERANCE	
SURFACE FINISH NOT TO EXCEED 63 UNLESS OTHERWISE SPECIFIED			

Date		Rev.No.	Revisions	Init.
Hardness		Hard.Dpth.		
Heat T'mnt.		Model No.		
Finish		Machine No.		
Material		Customer		
Part/ Ass'y Name		Part No.		G013497EX2
		Ass'y No.		
		Date		
		Scale : 1:1		Size : B
Drawn By	Checked By	Approved		





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012749	EAR TUCK ARM (W11-1A-4B)	1
2	98381A470	DOWEL 1/8 X 3/8 (61F)	1
3	G012745	EAR TUCKER (W11-1A-4C)	1
4	GSSCA06	M2.5 X 6 SHCS	1
5	GWFOA00	M2.5 FW	1
6	GN00A00	M2.5 NUT	2
7	GSSBA10	M2.5 X 10 BHCS	2
8	G012744	RETAINER (W11-1A-4F)	1
9	G012754	SPRING (W11-1A-4H)	1
10	GSSF310	FHCS M3 x 10	2

DATE	REV.	DESCRIPTION	INIT
REVISIONS			

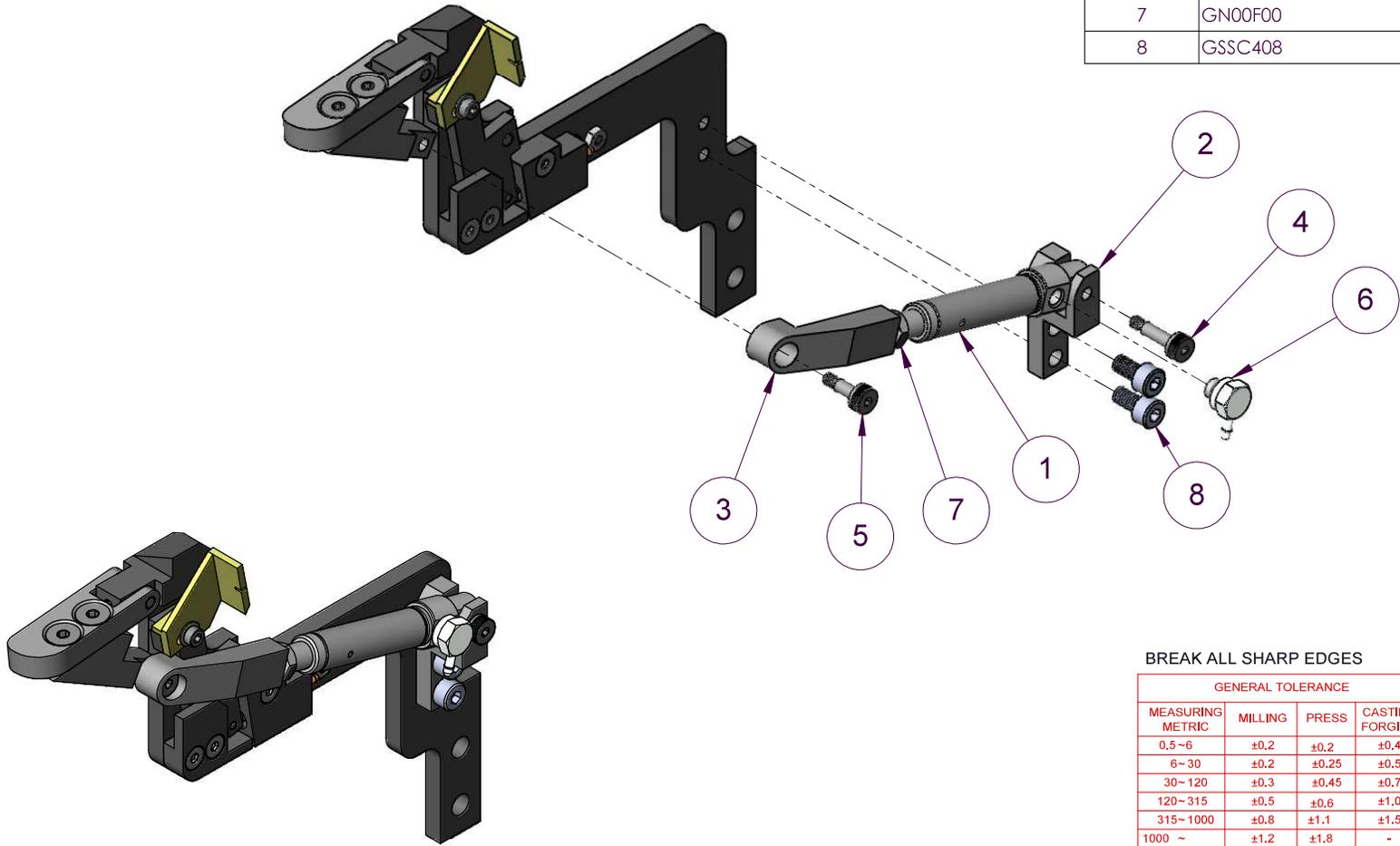
BREAK ALL SHARP EDGES

GENERAL TOLERANCE			
MEASURING METRIC	MILLING	PRESS	CASTING FORGING
0.5~6	±0.2	±0.2	±0.4
6~30	±0.2	±0.25	±0.5
30~120	±0.3	±0.45	±0.7
120~315	±0.5	±0.6	±1.0
315~1000	±0.8	±1.1	±1.5
1000 ~	±1.2	±1.8	-
PARALLELNESS		1/100	
ANGLE TOLERANCE		1/100	
SURFACE TOLERANCE		0.2/100	
ROUNDNESS		UNDER 30% TOLERANCE	
SURFACE FINISH NOT TO EXCEED		63 UNLESS OTHERWISE SPECIFIED	

Date		Rev.No.	Revisions		Init.
Hardness		Hard.Dpth.		Model No.	
Heat T'mnt.		Customer		Machine No.	
Finish		Material		Part No. G013497EX3	
Part/ Ass'y Name		FRONT LOWER PANEL SUPPORT SUB ASM		Ass'y No.	
Date		Scale : 1:1		Size : B	
Drawn By	Checked By	Approved			



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G014248	AIR CYL (16A)	1
2	G012739	5/16 CYL MOUNT (W11-1A-6C)	1
3	G012740	LIFTER ROD END (W11-1A-6E)	1
4	91259A156	SHLDR SCRW 1/8 X 3/8, 4-40 (61G)	1
5	91259A155	SHLDR SCREW 1/8 X 1/4, 4-40 (61H)	1
6	G014249	FITTING (12F)	1
7	GN00F00	5-40 NUT	1
8	GSSC408	M4 X 8 SHCS	2



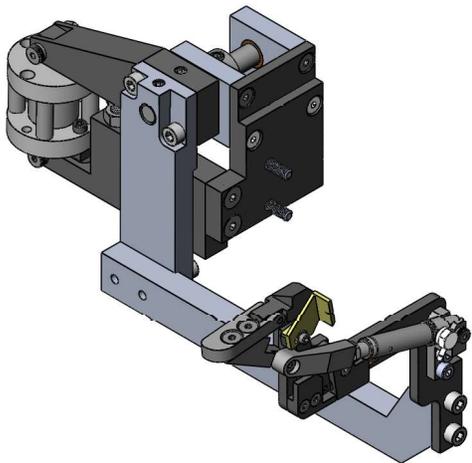
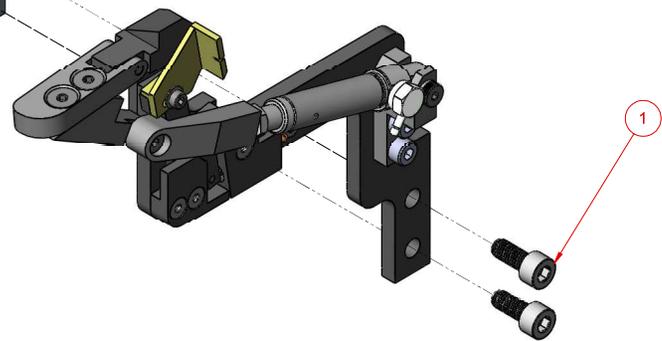
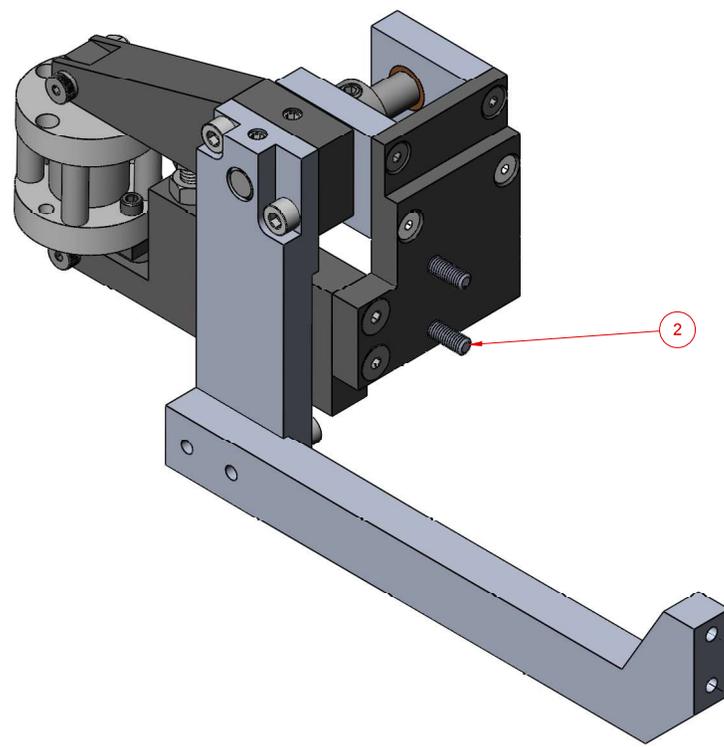
DATE	REV.	DESCRIPTION	INIT
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	
120~315	±0.5	±0.6	±1.0	Material		Customer	
315~1000	±0.8	±1.1	±1.5			Part No.	G013497EX4
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name		Ass'y No.	
PARALLELNESS			1/100	FRONT LOWER PANEL SUPPORT SUB ASM			
ANGLE TOLERANCE			1/100	Date			
SURFACE TOLERANCE			0.2/100	Scale : 1:1 Size : B			
ROUNDNESS	UNDER 30% TOLERANCE			Drawn By	Checked By	Approved	
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED			GTN, INC.			

Tracking No.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSSC512	M5 X 12 SHCS	2
2	GSSCL16	10-32 X 5/8" SHCS	2

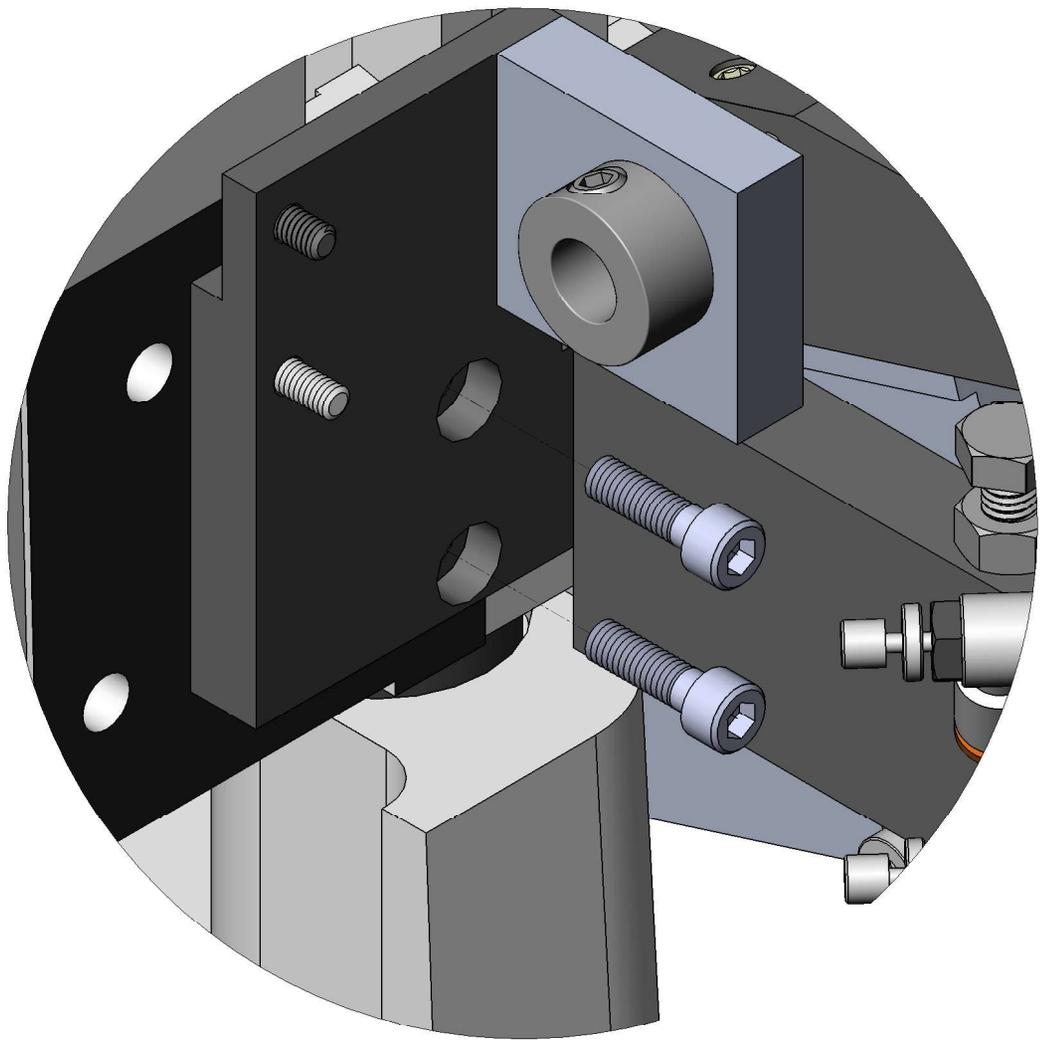
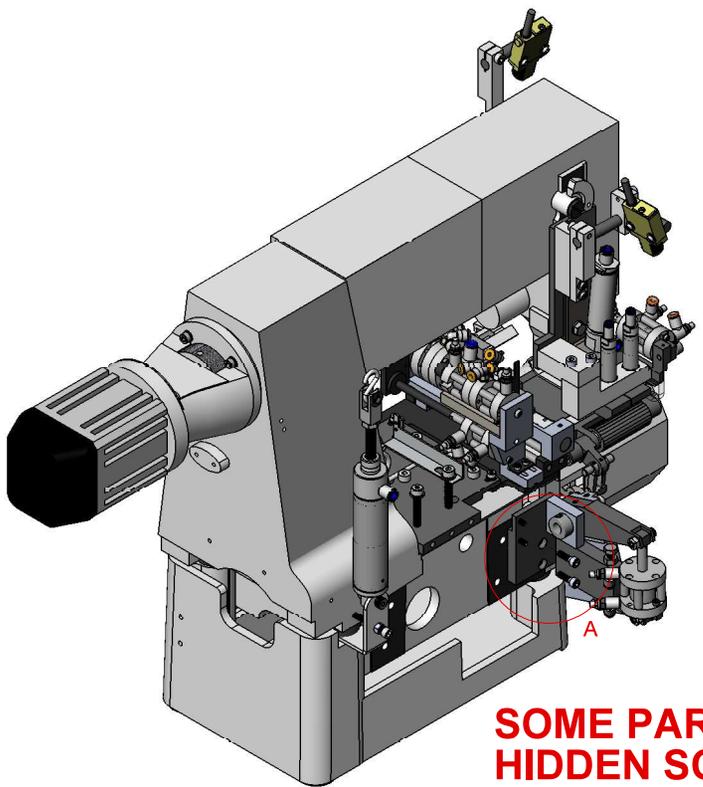


Tracking No. V005445

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness		Hard.Dpth.		
0.5-6	±0.2	±0.2	±0.4	Heat T'mnt.		Modif.No.		GTN1828
6-30	±0.2	±0.25	±0.5	Finish		Machine No.		302U201B
30-120	±0.3	±0.45	±0.7	Material		Customer		CARLIART
120-315	±0.5	±0.6	±1.0	Part No.		Part No.		G013497EX5
315-1000	±0.8	±1.1	±1.5	Assy No.		Assy No.		G013512
1000 -	±1.2	±1.8	-	LOWER PANEL SUPPORT ASM				
PARALLELNESS			1/100	Part Name		Date		8/15/14
ANGLE TOLERANCE			1/100	Scale		1:1		Size
SURFACE TOLERANCE			0.2/100	Drawn By		Checked By		Approved
ROUNDNESS			UNDER 30% TOLERANCE					
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED					
NOT TO EXCEED								

DATE	REV.	DESCRIPTION	INE
REVISIONS			

STEP 8: ADD G013497
NOTE: ONLY 2-10-32X5/8 SHCS
ARE USED TO MOUNT
THIS ASSEMBLY

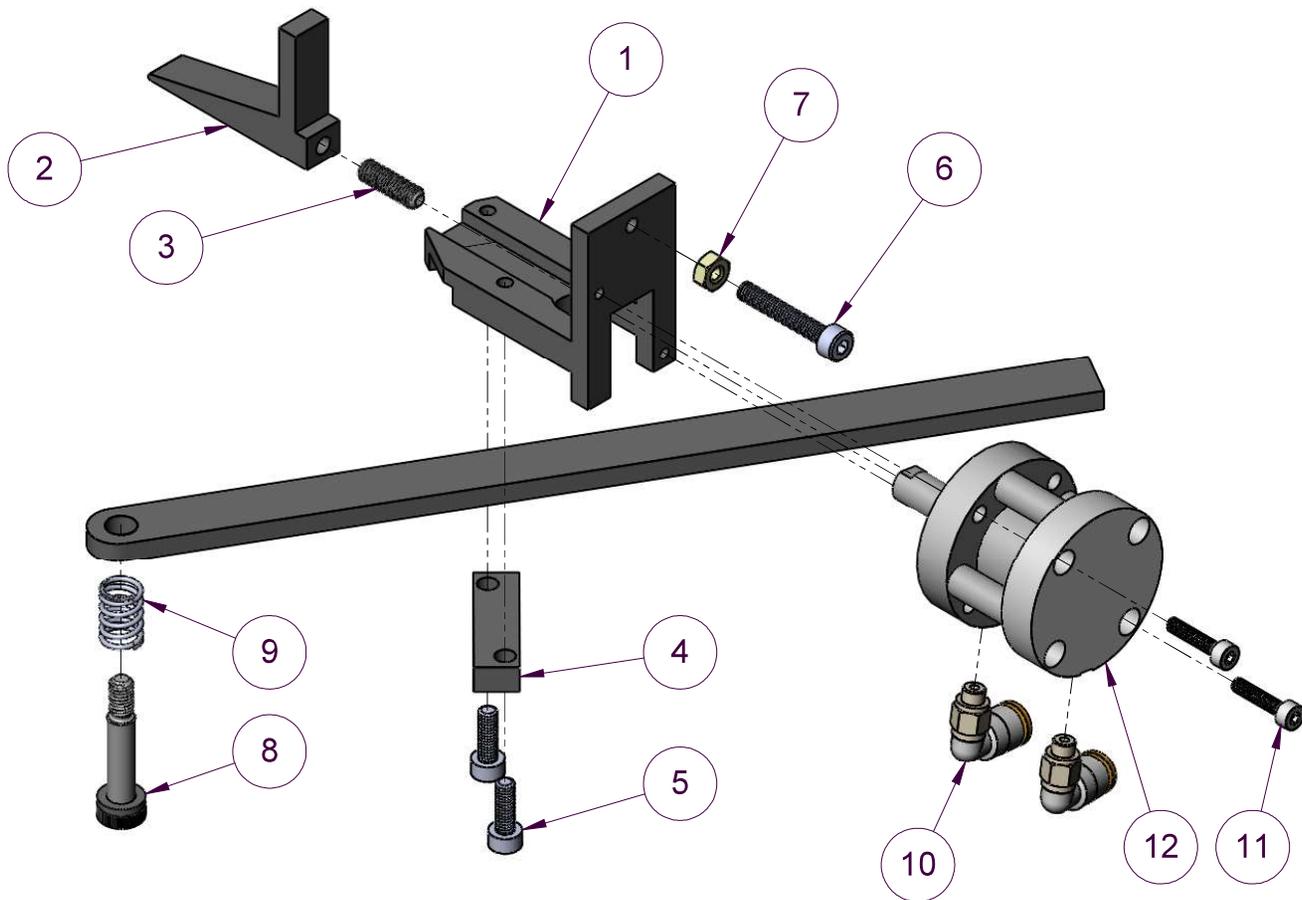


DETAIL A
SCALE 4 : 1

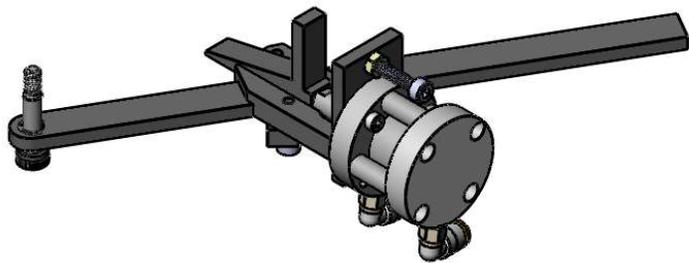
SOME PARTS IN G013497 ARE
HIDDEN SO SCREWS CAN BE VIEWED

DATE	REV.	DESCRIPTION	BY
REVISIONS			

Tracking No. V005445									
BREAK ALL SHARP EDGES									
GENERAL TOLERANCE									
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions		Int.	
0.5-6	±0.2	±0.2	±0.4			Hard.Dpth.	GTN1828		
6-30	±0.2	±0.25	±0.5			Heat T'mnt.	302U201B		
30-120	±0.3	±0.45	±0.7			Finish	Machine No.		
120-315	±0.5	±0.6	±1.0				Customer CAPS HART		
315-1000	±0.8	±1.1	±1.5			Material	Part No. G013919		
1000 -	±1.2	±1.8	-				Date 9/22/15		
PARALLELNESS						Part/ Assy Name	GTN 1828		
ANGLE TOLERANCE							Scale : 1:2 Size : 11" D"		
SURFACE TOLERANCE							Date		
ROUNDNESS	UNDER 30% TOLERANCE					Drawn By	Checked By	Approved	
SURFACE FINISH NOT TO EXCEED	UNLESS OTHERWISE SPECIFIED					TZ			



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013768	WEDGE GUIDE (W11-5D)	1
2	G013769	WEDGE (35E)	1
3	GSSSL16	10-32 X 5/8 SET SCREW	1
4	G013770	WEDGE GUIDE STRAP (31G)	1
5	GSSC412	M4 X 12 SHCS	2
6	GSSC425	M4 X 25 SHCS	1
7	GN00400	M4 NUT	1
8	92981A103	SHLDR SCRW 6 X 20, M5 (62G)	1
9	94125K631	SPRING (11H)	1
10	JW000001	ELBOW FITTING (D2C6)	2
11	GSSC314	SHCS M3 X 14	2
12	G013767	AIR CYL	1



DATE	REV.	DESCRIPTION	INIT
REVISIONS			

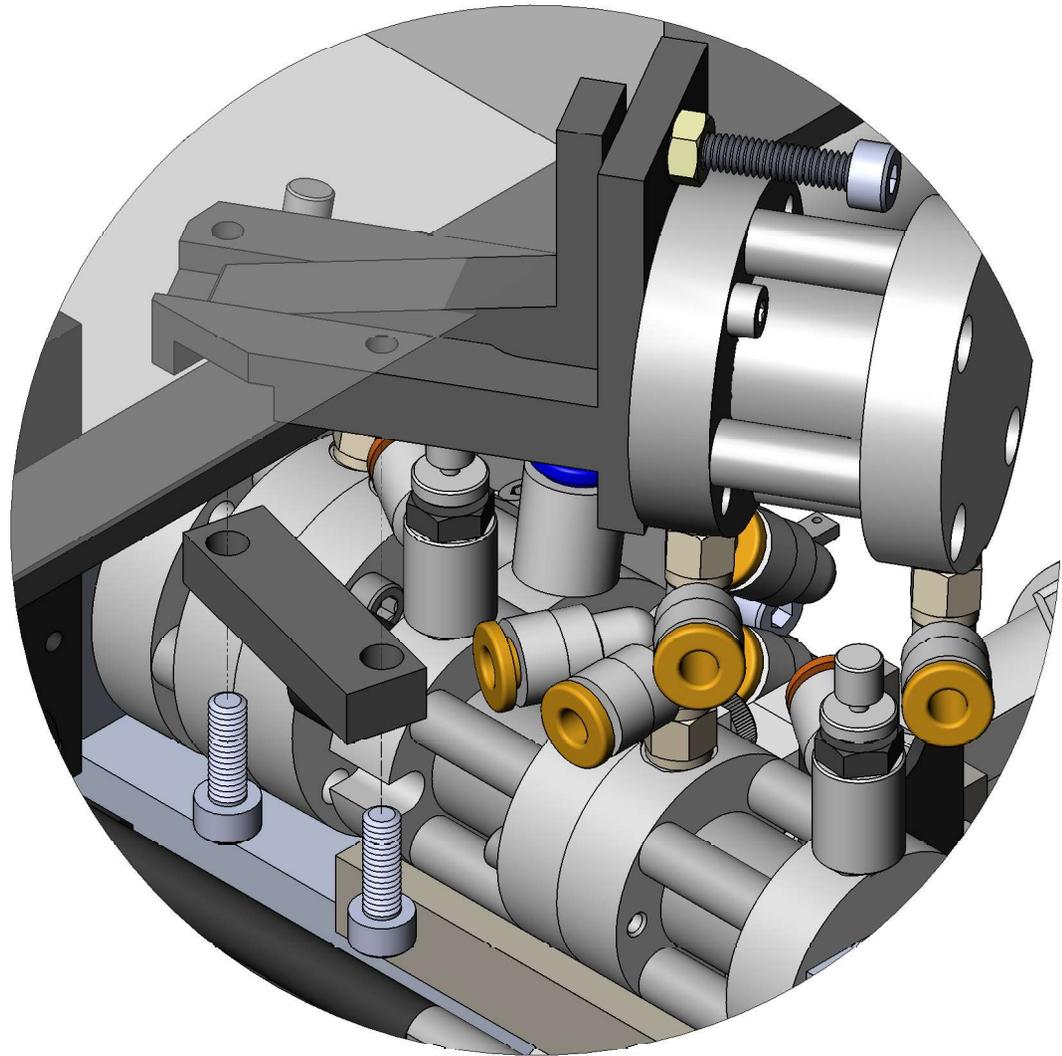
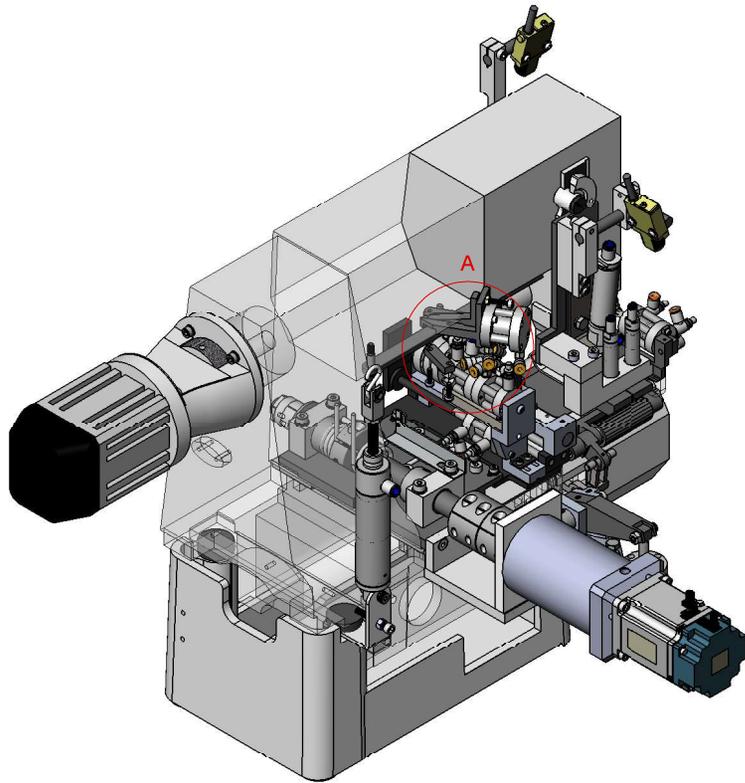
Tracking No. W005445

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.		
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	GTN1828	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B	
120~315	±0.5	±0.6	±1.0	Material		Customer	CARHARTT	
315~1000	±0.8	±1.1	±1.5			Part No.	G013766	
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name	ADJ FOOT PRESSURE ASM	Ass'y No.	G013766	
PARALLELNESS						Date	12/11/14	
ANGLE TOLERANCE						Scale	1:1	Size : B
SURFACE TOLERANCE						Drawn By	Checked By	Approved
ROUNDNESS	UNDER 30% TOLERANCE					TZ		
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED							



STEP 9: ADD G013766



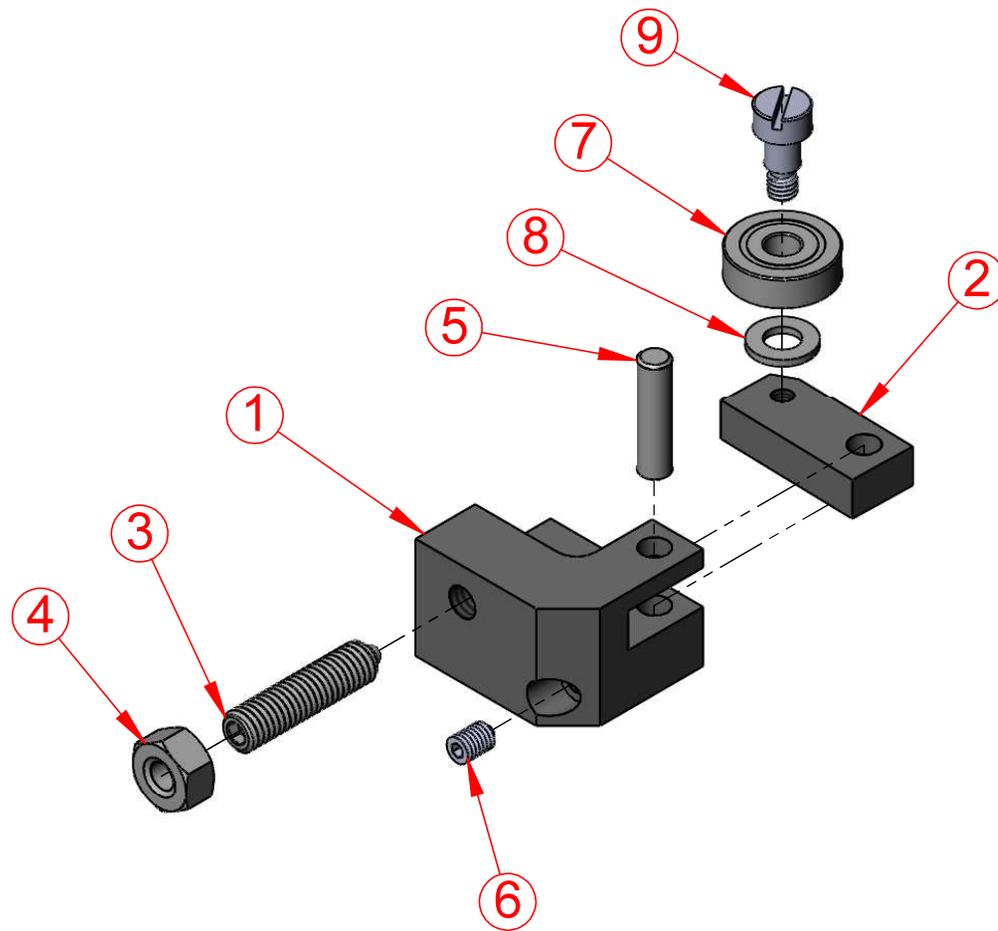
Tracking No. V005445

BREAK ALL SHARP EDGES

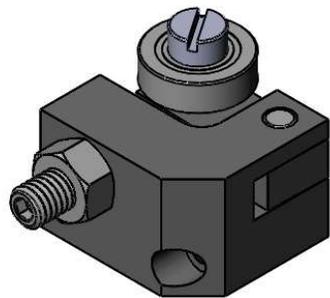
GENERAL TOLERANCE				Date	Rev.No.	Revisions		Int.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING			Hard.Dpth.	Modif.No.	
0.5-6	±0.2	±0.2	±0.4					GTN1828
6-30	±0.2	±0.25	±0.5					302U201B
30-120	±0.3	±0.45	±0.7					Customer CAPSAR ITT
120-315	±0.5	±0.6	±1.0					Part No. G013919
315-1000	±0.8	±1.1	±1.5					Part No. G013919
1000 -	±1.2	±1.8	-					Date 9/22/15
PARALLELNESS			1/100					Scale: 1:2 Size: 11" D"
ANGLE TOLERANCE			1/100					
SURFACE TOLERANCE			0.2/100					
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH	UNLESS OTHERWISE SPECIFIED							
NOT TO EXCEED	63							

Part/ Assy Name	GTN 1828	Drawn By	Checked By	Approved
		TZ		

DATE	REV.	DESCRIPTION	INE
REVISIONS			



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012711	DETENT BRKT (26E)	1
2	G012712	DETENT ARM (24F)	1
3	G012717	SPRING PLUNGER (24G)	1
4	GN00600	NUT, M6 HEX	1
5	G012284	DOWEL 3/16 X 3/4 (62C)	1
6	GSSS406	SCREW, M4X6 SET	1
7	6153K69	BEARING (31A)	1
8	91635A230	BRASS WASHER (24H)	1
9	90270A658	SHLDR SCRW 5 X 6, M4 (62B)	1

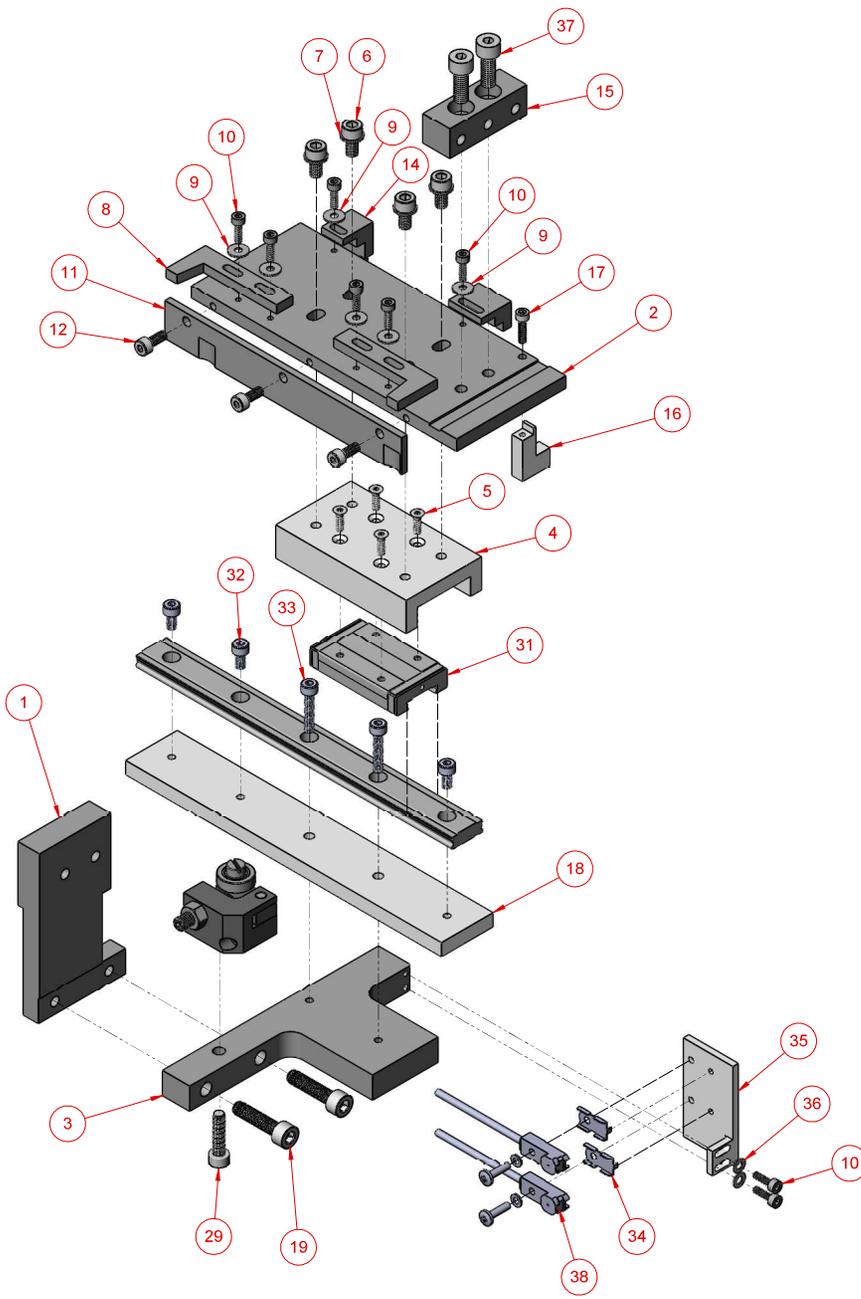


DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness			Hard.Dpth.		
0.5~6	±0.2	±0.2	±0.4	Heat T'mnt.			Model No.		
6~30	±0.2	±0.25	±0.5	Finish			Machine No.		
30~120	±0.3	±0.45	±0.7	Material			Customer		
120~315	±0.5	±0.6	±1.0	Part/ Ass'y Name	ROLLER GUIDE ASM		Part No.	G013493	
315~1000	±0.8	±1.1	±1.5		Ass'y No.		Date		
1000 ~	±1.2	±1.8	-	Scale	1:1	Size	"A"		
PARALLELNESS		1/100		Drawn By	Checked By	Approved			
ANGLE TOLERANCE		1/100							
SURFACE TOLERANCE		0.2/100							
ROUNDNESS		UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED		63 √ UNLESS OTHERWISE SPECIFIED							

Tracking No.

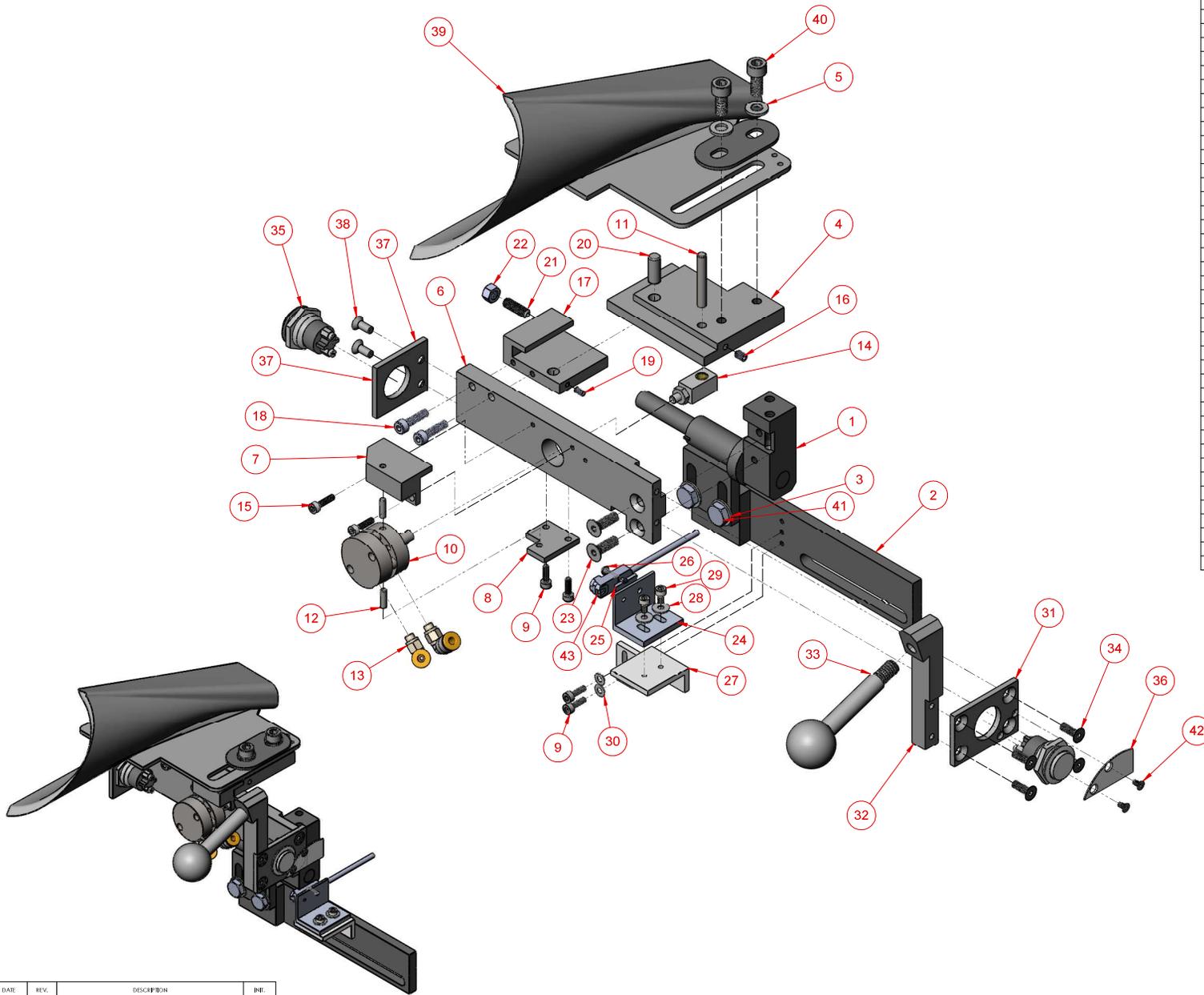


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013455	FRONT SLIDE MOUNT (W11-4C)	1
2	G013457	PLATE FOLDER (W11-4D)	1
3	G013456	SLIDE SUPPORT (W11-4E)	1
4	G013458	PLATE TO SLIDE MOUNT (W11-4F)	1
5	GSSF310	FHCS M3 x 10	4
6	GSSC510	MSX.8, L10 SHCS	4
7	GWFO500	M5 FW	4
8	G013459	FOLDER STOP (W11-4CB)	2
9	GWFO300	FLAT WASHER, M3	6
10	GSSC310	M3X10 SHCS	8
11	G012724	DETENT (W11-4G)	1
12	GSSC410	SHCS M4 x 10	3
13	G012720	MIDDLE FLAG (24C)	1
14	G012719	HOME FLAG (24D)	1
15	G013486	FOLDER ASM MOUNT	1
16	G013460	FOLDER IN FLAG (24E)	1
17	GSSC312	M3 X 12 SHCS	1
18	G013461	SLIDE SUPPORT (W11-4H)	1
19	GSSC625	M6 X 25 SHCS	2
20	G012711	DETENT BRKT (26E)	1
21	G012712	DETENT ARM (24F)	1
22	G012717	SPRING PLUNGER (24G)	1
23	GN00600	NUT, M6 HEX	1
24	G012284	DOWEL 3/16 X 3/4 (62C)	1
25	GSSS406	SCREW, M4X6 SET	1
26	6153K69	BEARING (31A)	1
27	91635A230	BRASS WASHER (24H)	1
28	90270A658	SHLDR SCRW 5 X 6, M4 (62B)	1
29	GSSC520	M5 X 20 SHCS	1
30	G013462	MODIFIED SLIDE RAIL (W11-4J)	1
31	SHW12HRMUU_Slide12_550	RAIL CAR (W11-4FB)	1
32	GSSC408	M4 X 8 SHCS	3
33	GSSC420	M4 X 20 SHCS	2
34	MS-GXL8	SENSOR BRKT (A1G4)	2
35	G013465	SENSOR BRKT (27A)	1
36	GWFO300	FW M3	2
37	GSSC616	M6 X 16 SHCS	2
38	JZ000033	SENSOR	2

DATE	REV.	DESCRIPTION	INC.
REVISIONS			

MEASURING METRIC		MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Int.	
0.5-6	±0.2	±0.2	±0.4	Hardness			Hard.Depth		
6-30	±0.2	±0.25	±0.5	Heat Tmnt.			Modif.No.	GTN1628	
30-120	±0.3	±0.45	±0.7	Finish			Machine No.	302U201B	
120-315	±0.5	±0.6	±1.0				Customer	CARRIART	
315-1000	±0.8	±1.1	±1.5				Part No.	G013454	
1000 -	±1.2	±1.8	-				Asly No.	G013454	
PARALLELNESS				Part/ Assy Name	FOLDER SLIDE ASM			Date	8/3/14
ANGLE TOLERANCE				Name				Scale	1:1
SURFACE TOLERANCE				Drawn By	Checked By	Approved	TZ		
ROUNDNESS	UNDER 30% TOLERANCE								
SURFACE FINISH	UNLESS OTHERWISE SPECIFIED								
NOT TO EXCEED									

Tracking No. W005445



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013490	FOLDER ROT JOINT (W11-5A)	1
2	G013489	FOLDER MOUNT (W11-5A)	1
3	90107A013	1/4" FLAT	2
4	G013472	FOLDER PLATE (W11-4JB)	1
5	GWFO600	FW M6	2
6	G013471	SWITCH MOUNT (W11-4JB)	1
7	G013477	TOP CYL MOUNT (W11-4KB)	1
8	G012693	BOTTOM CYL MOUNT (31B)	1
9	GSSC310	M3X10 SHCS	4
10	G012697	MOD AIR CYL (2&G)	1
11	G012354	DOWEL 3/16 X 1 1/4 (56A)	1
12	98381A218	DOWEL 1/8 X 7/16 (62E)	2
13	JW000001	ELBOW FITTING (D2C6)	2
14	G013428	CLEVIS (13D)	1
15	GSSC312	M3 X 12 SHCS	2
16	GSSS406	SCREW, M4X6 SET	1
17	G013478	RETAINER (W11-4K)	1
18	GSSC416	M4 X 16 SHCS	2
19	GSSS306	SCREW, M3 X 6 SET	1
20	98381A539	DOWEL 1/4 X 5/8 (62F)	1
21	GSSS516	SET SCREW	1
22	GN00500	NUT, M5 HEX	1
23	GSSF516	M5 X 16 FLHD	2
24	G013468	FOLDER SENSOR BRKT (35A)	1
25	MS-GXL8	SENSOR BRKT (A1G4)	1
26	GSSBA08	M2.5 X 8 BHCS	1
27	G013488	ADJ SENSOR BRKT (35C)	1
28	GWFO300	FLAT WASHER, M3	2
29	GSSC306	SCREW, M3X6 SHCS	2
30	GWFO300	M3 FW	2
31	G013759	SWITCH BRKT RIGHT (31D)	1
32	G013760	HANDLE BRKT (27E)	1
33	6303K44	HANDLE (27G)	1
34	GSSF412	SCREW, M4X12 FHCS	4
35	G013757	MOMENTARY SWITCH (27C)	2
36	G013487	BREAK FLAG (31E)	1
37	G013756	SWITCH BRKT LEFT (31C)	1
38	GSSF410	M4X10 FHCS	2
39	G013470	MODIFIED FOLDER ASM (W11-5A)	1
40	GSSC614	M6 X 14 SHCS	2
41	GSHCM22	1/4-20 X 7/8 CAP SCREW	2
42	GSSFA05	M2.5 X 5 FHCS	2
43	JZ000033	SENSOR	1

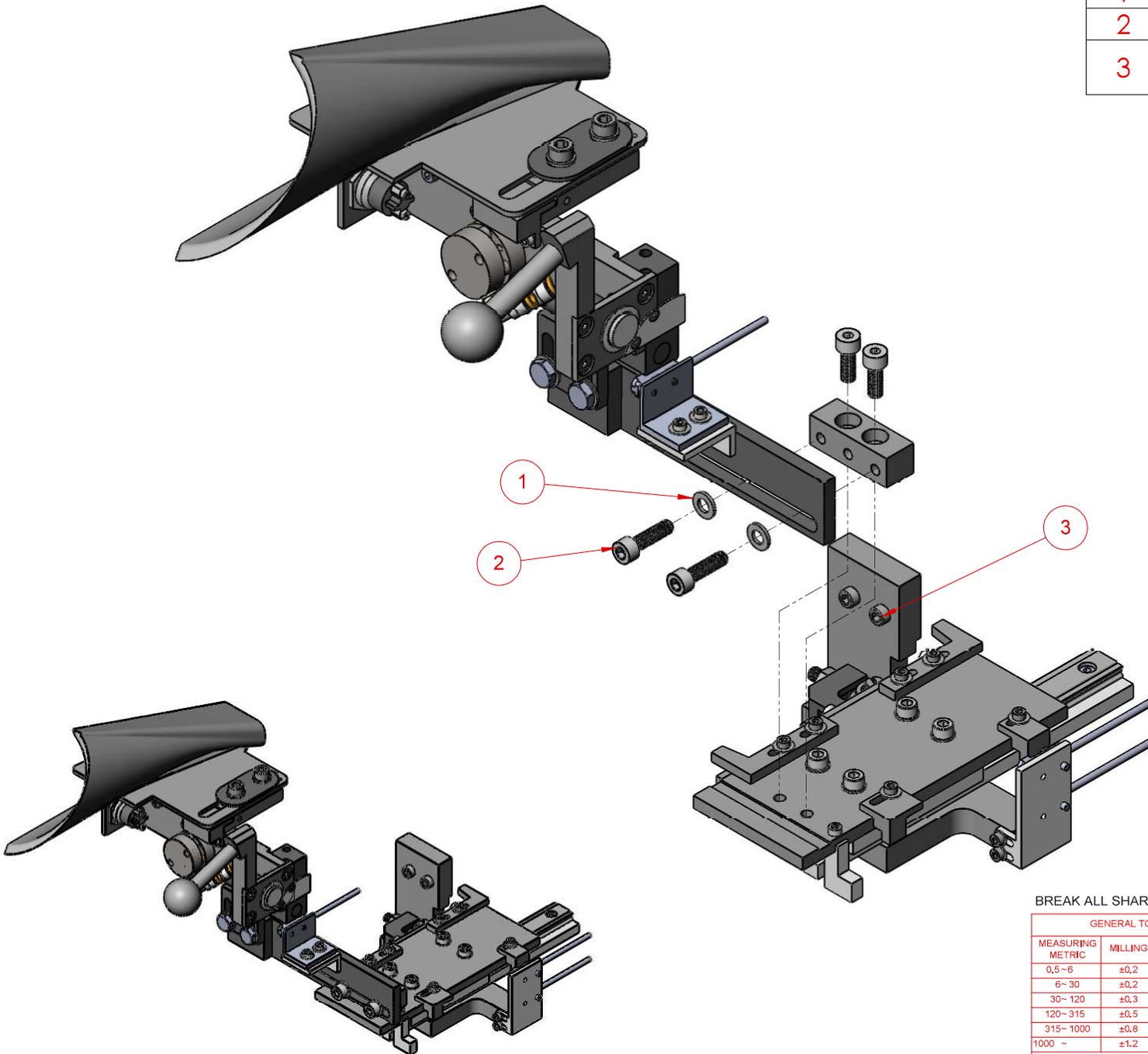
BREAK ALL SHARP EDGES

Tracking No. V005445

GENERAL TOLERANCE			Date	Rev.No.	Revisions	Int.
MEASURING METRIC	MILLING	PRESS	CASTING			
			FORGING			
0.5-6	±0.2	±0.2	±0.4	Hardness	Hard.Dpth.	GTN1828
6-30	±0.2	±0.25	±0.5	Heat Tmnt.	Modif.No.	302U201B
30-120	±0.3	±0.45	±0.7	Finish	Machine No.	CASPIAR IT
120-315	±0.5	±0.6	±1.0	Material	Customer	G013466
315-1000	±0.8	±1.1	±1.5		Part No.	G013490
1000 -	±1.2	±1.8	-		Asly No.	
PARALLELNESS			1/100	Part	FOLDER ASM	8/5/14
ANGLE TOLERANCE			1/100	Assy		
SURFACE TOLERANCE			0.2/100	Name		Scale : 1:1 Size : 11"D
ROUNDNESS			UNDER 30% TOLERANCE	Drawn By	Checked By	Approved
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED	TZ		
NOT TO EXCEED						

DATE	REV.	DESCRIPTION	INT.
REVISIONS			

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GWFO600	FW M6	2
2	GSSC622	M6X1, L22 SHCS	2
3	GSSCL19	10-32 X 3/4 SHCS	2



DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

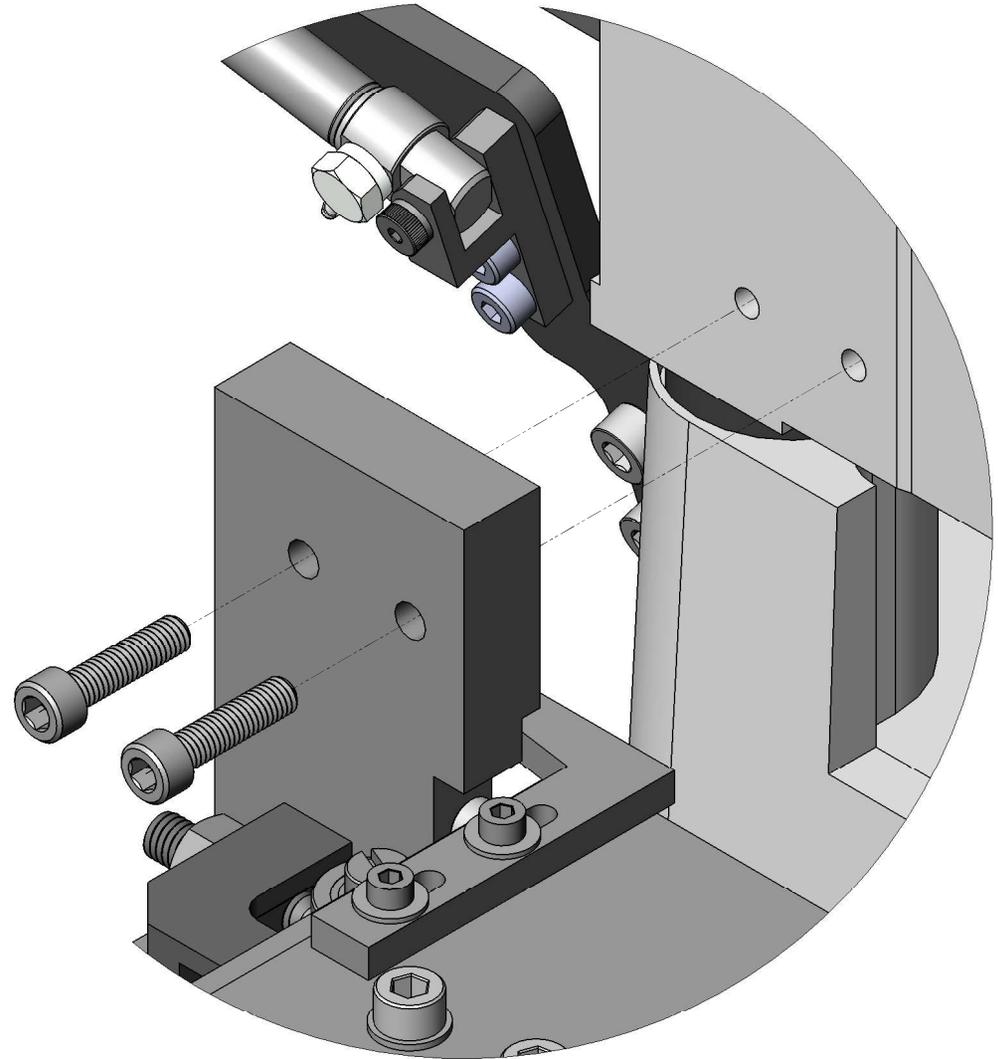
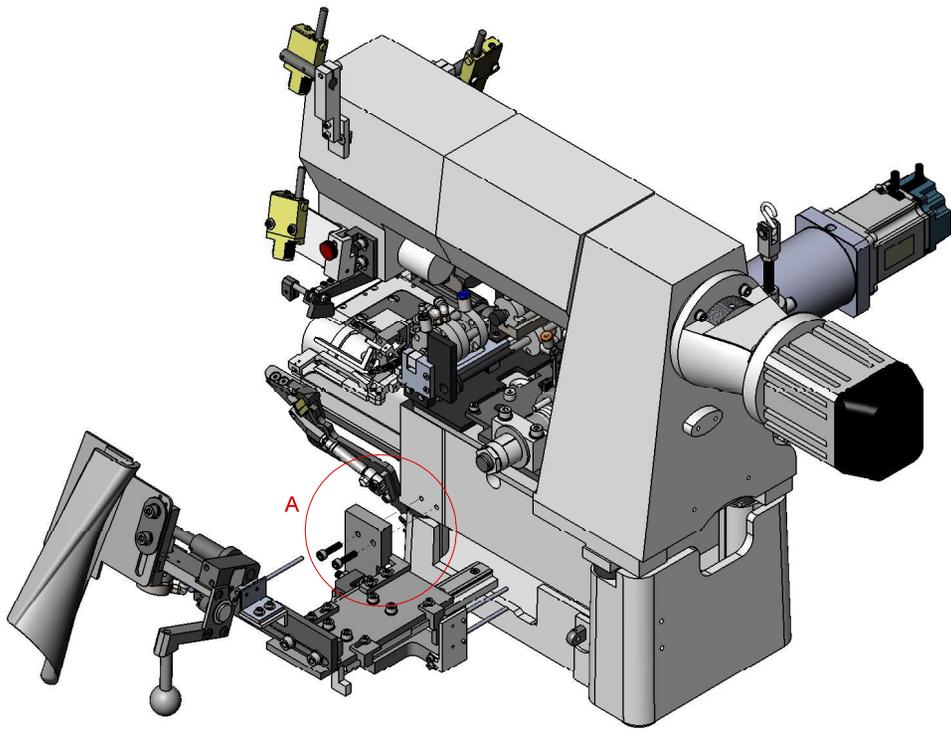
BREAK ALL SHARP EDGES

Tracking No. W005449

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness		Hard,Dpth.		
0,5-6	±0,2	±0,2	±0,4	Heat Trmnt.		Model No.	GTN1828	
6-30	±0,2	±0,25	±0,5	Finish		Machine No.	302U201B	
30-120	±0,3	±0,45	±0,7	Material		Customer	CARHARTT	
120-315	±0,5	±0,6	±1,0	Part/ Ass'y Name	FOLDER ASM	Part No.	G013485	
315-1000	±0,8	±1,1	±1,5			Ass'y No.	G013485	
1000 ~	±1,2	±1,8	-	Scale	1:1.2	Date	12/3/14	
PARALLELNESS	1/100			Drawn By	Checked By	Approved		
ANGLE TOLERANCE	1/100							
SURFACE TOLERANCE	0,2/100							
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED			TZ				



STEP 10: ADD G013485

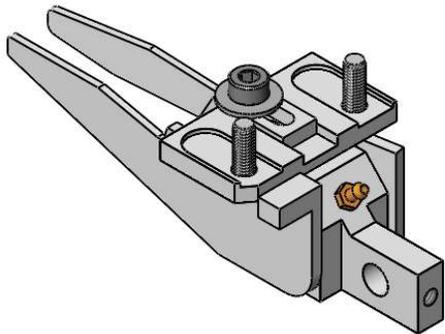
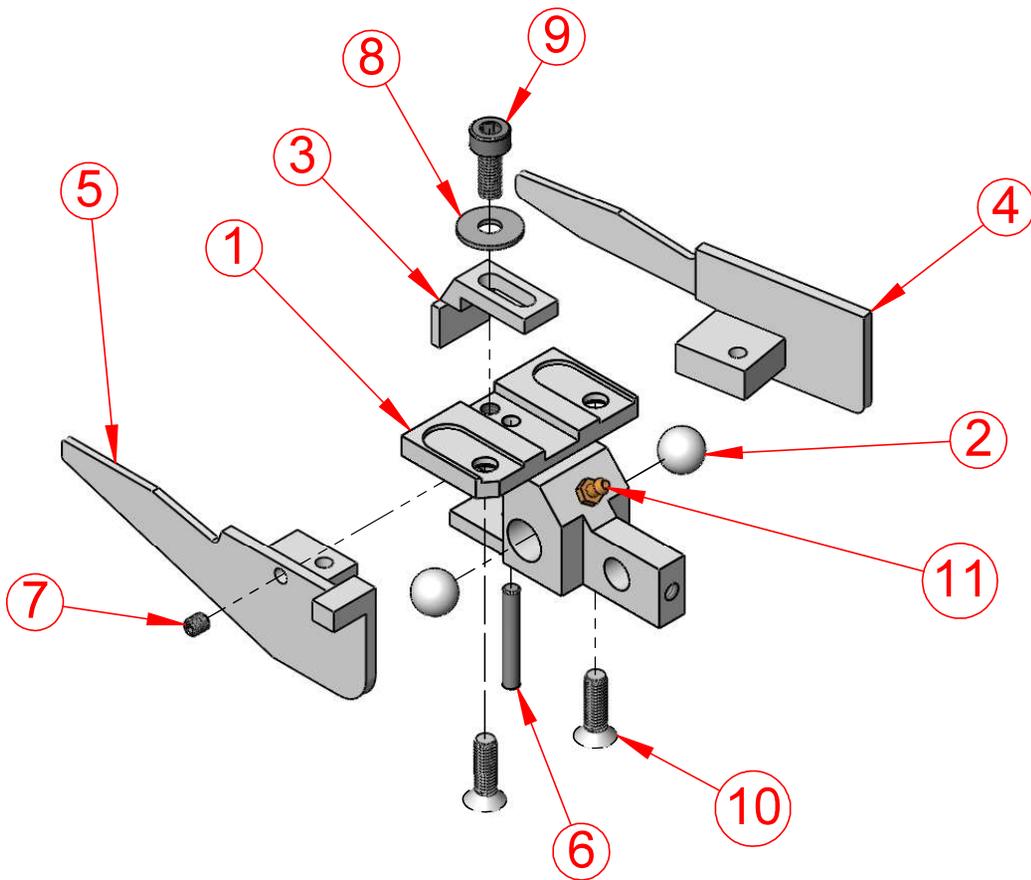


DETAIL A
SCALE 3.5 : 1

DATE	REV.	DESCRIPTION	BY
REVISIONS			

GENERAL TOLERANCE				Date		Rev.No.		Revisions		Int.	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness				Hard.Depth			
0.5-6	±0.2	±0.2	±0.4	Heat T'mnt.						GTN1828	
6-30	±0.2	±0.25	±0.5	Finish						302U201B	
30-120	±0.3	±0.45	±0.7	Material						CASPAR ITT	
120-315	±0.5	±0.6	±1.0	Part/ Assy Name						G013919	
315-1000	±0.8	±1.1	±1.5	GTN 1828						G013919	
1000 -	±1.2	±1.8	-	Date						9/22/15	
PARALLELNESS			1/100	Scale					1:2	Size	" D"
ANGLE TOLERANCE			1/100	Drawn By				Checked By		Approved	
SURFACE TOLERANCE			0.2/100	TZ							
ROUNDNESS			UNDER 30% TOLERANCE								
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED								
NOT TO EXCEED											

Tracking No. V005445



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012429	FRAME SPREADER (33E)	1
2	G013438	1/4" SS BALL (33F)	2
3	G012428	SPDR CENTER (33G)	1
4	G012426	TOP BLADE (33H)	1
5	G012427	BOTTOM BLADE (34A)	1
6	98381A440	DOWEL 3/32 X 5/8 (56E)	1
7	GSSSA04	M2.5 X 4 SET SCREW	1
8	GWF0300	FLAT WASHER, M3	1
9	GSSC308	M3 X 8 SHCS	1
10	GSSF310	FHCS M3 x 10	2
11	G013963	MINI AIR FITTING (12E)	1

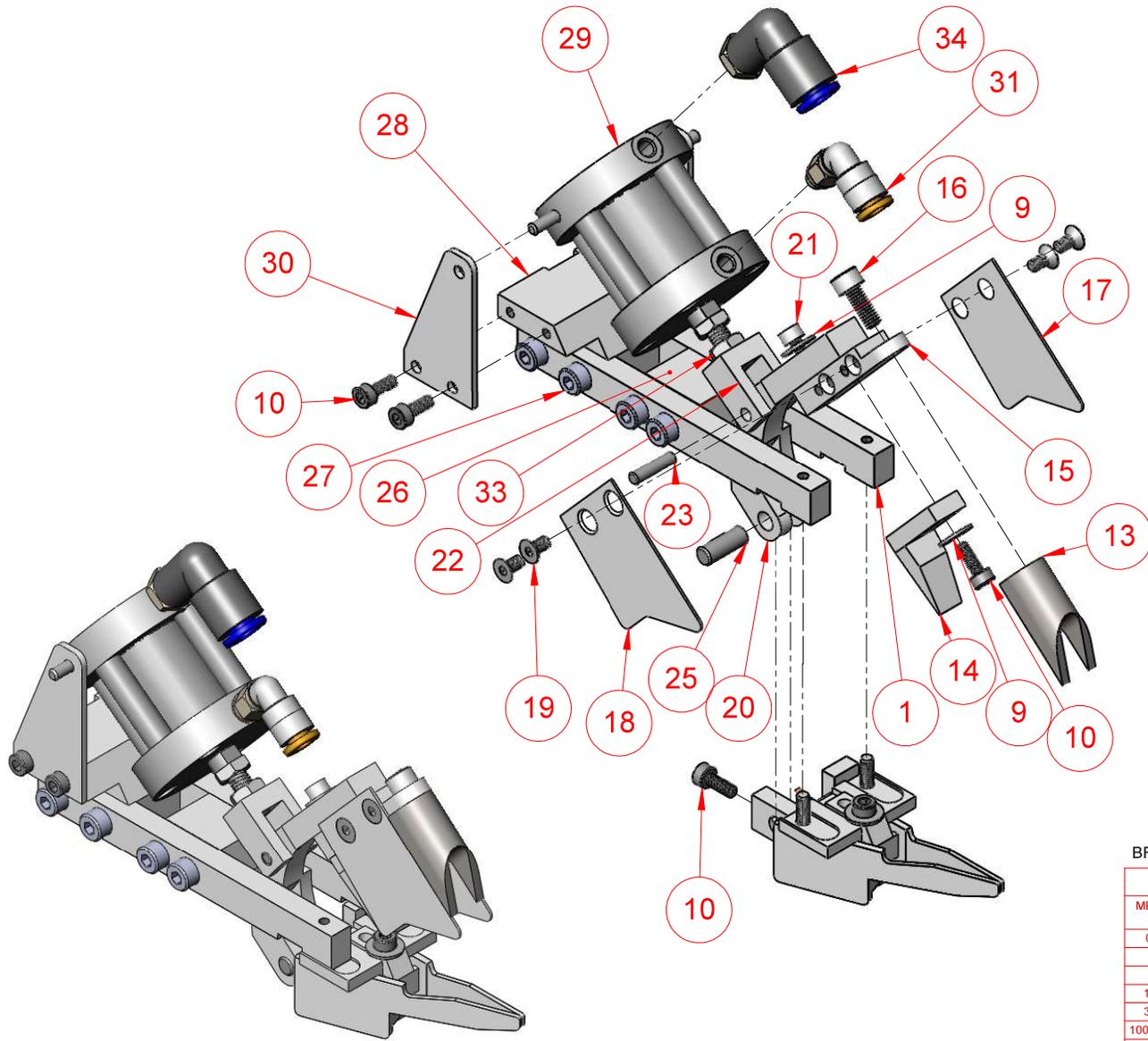
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.	Revisions		Init.	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness			Hard.Dpth.			
0.5~6	±0.2	±0.2	±0.4	Heat T'mnt.			Model No.			
6~30	±0.2	±0.25	±0.5	Finish			Machine No.			
30~120	±0.3	±0.45	±0.7	Material			Customer			
120~315	±0.5	±0.6	±1.0	Part/ Ass'y Name			Part No.	G012425		
315~1000	±0.8	±1.1	±1.5		Ass'y No.			Date		
1000 ~	±1.2	±1.8	-				Scale	1:1	Size	"A"
PARALLELNESS		1/100		Drawn By	Checked By	Approved				
ANGLE TOLERANCE		1/100								
SURFACE TOLERANCE		0.2/100								
ROUNDNESS		UNDER 30% TOLERANCE								
SURFACE FINISH NOT TO EXCEED		63 $\sqrt{\quad}$ UNLESS OTHERWISE SPECIFIED								

Tracking No.





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012434	STRAP (33D)	2
2	G012429	FRAME SPREADER (33E)	1
3	G013438	1/4" SS BALL (33F)	2
4	G012428	SPDR CENTER (33G)	1
5	G012426	TOP BLADE (33H)	1
6	G012427	BOTTOM BLADE (34A)	1
7	98381A440	DOWEL 3/32 X 5/8 (56E)	1
8	GSSSA04	M2.5 X 4 SET SCREW	1
9	GWF0300	FLAT WASHER, M3	3
10	GSSC308	M3 X 8 SHCS	7
11	GSSF310	FHCS M3 x 10	2
12	G013963	MINI AIR FITTING (12E)	1
13	G013441	BULLET (34B)	1
14	G012420	EAR WIPER (34C)	1
15	G012421	BLOCK (34D)	1
16	GSSC410	SHCS M4 x 10	1
17	G012417	BOTTOM FOLD BLADE (34E)	1
18	G012418	TOP FOLD BLADE (34F)	1
19	91294A126	FLAT HEAD M3, L6	4
20	G012416	FOLD ARM (34G)	1
21	GSSC312	M3 X 12 SHCS	1
22	G012415	CLEVIS (34H)	1
23	98381A471	MOD DOWEL (41A)	1
24	GSSS306	SCREW, M3 X 6 SET	1
25	98381A505	MOD DOWEL, 3/16 X 1/2 (41B)	1
26	G012412	STOP (41C)	1
27	GSSC412	M4 X 12 SHCS	8
28	G012411	BRACKET (36G)	1
29	G013436	1 AIR CYL (W11-6BB)	1
30	G012410	CYL MOUNT (41D)	2
31	JW000001	ELBOW FITTING (D2C6)	1
32	GSSSL25	SET SCREW, 10-32 X 1"	1
33	GN00L00	10-32 NUT	2
34	G014021	FITTING 10-32 TO 6mm (12C)	1

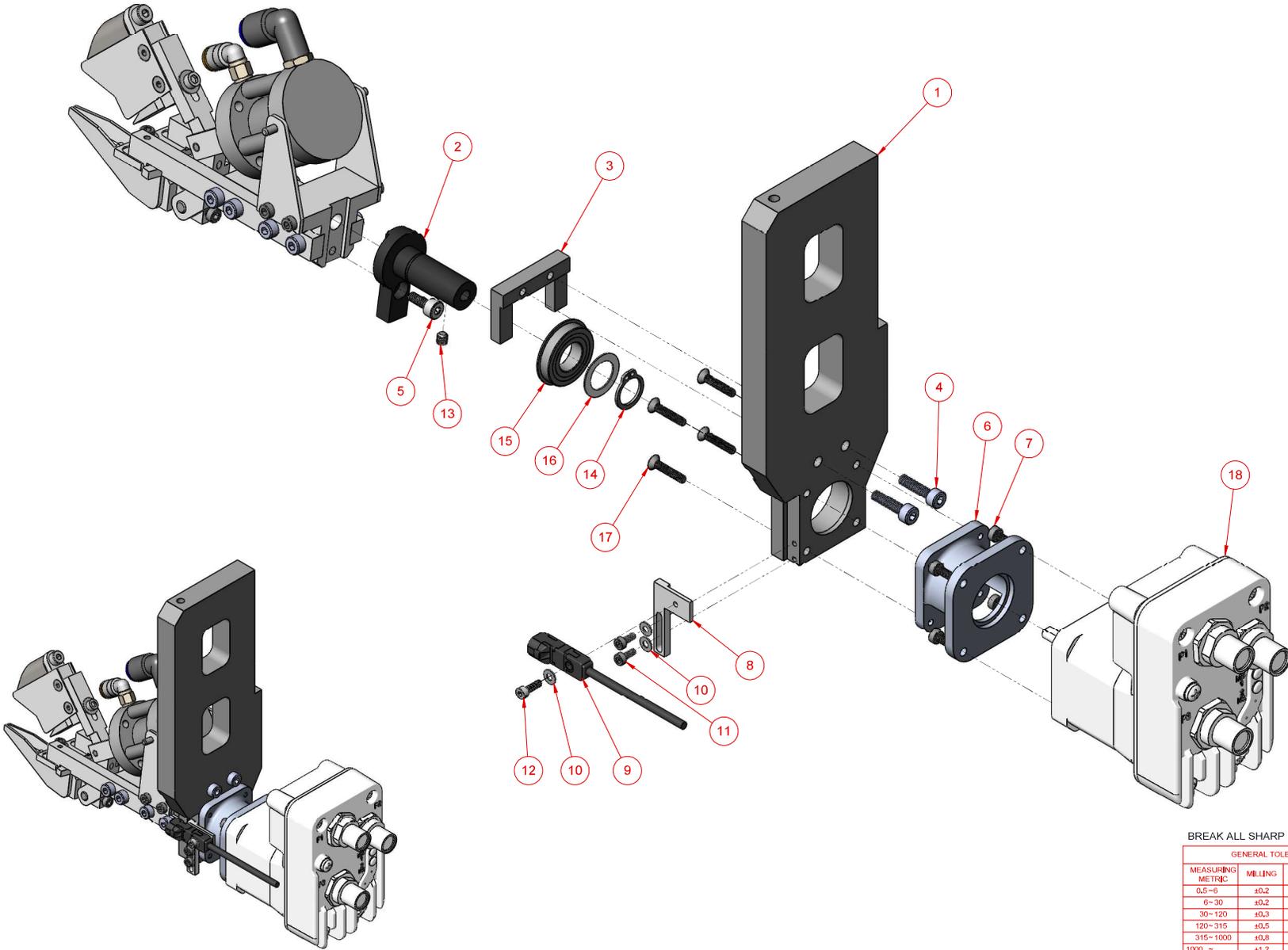
BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.		
6-30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.		
30-120	±0.3	±0.45	±0.7	Finish		Machine No.		
120-315	±0.5	±0.6	±1.0	Material		Customer		
315-1000	±0.8	±1.1	±1.5	Part/ Ass'y Name		Part No.	G014124EX	
1000 ~	±1.2	±1.8	-			Ass'y No.		
PARALLELNESS	1/100			SPREADER ASM		Date		
ANGLE TOLERANCE	1/100			Scale	1:1	Size	B	
SURFACE TOLERANCE	0.2/100			Drawn By	Checked By	Approved		
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH	UNLESS OTHERWISE SPECIFIED							
NOT TO EXCEED	63							

DATE	REV.	DESCRIPTION	INIT
REVISIONS			

Tracking No.





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G014117	FRAME ROTATE	1
2	G014123	DRIVE SHAFT (33C)	1
3	G013450	STOP	1
4	GSSC416	M4 X 16 SHCS	2
5	GSSC410	SHCS M4 x 10	1
6	G014126	MOTOR MOUNT (37A)	1
7	GSSC308	SHCS M3 x 8	4
8	G013451	SENSOR MOUNT	1
9	GX-H8	SENSOR (W11-9F)	1
10	GWFOA00	M2,5 FW	3
11	GSSCA06	M2,5 X 6 SHCS	2
12	GSSCA08	M2,5 X 8 SHCS	1
13	GSSS404	M4 X 4 FLAT SET SCREW	1
14	98541A119	RETAINING RING (41G)	1
15	G014132	BEARING (41H)	1
16	G014133	SHIM WSHR (42A)	1
17	GSSFS16	M3 X 16 FHCS	4
18	G014169	MOTOR	1

DATE	REV.	DESCRIPTION	INE
REVISIONS			

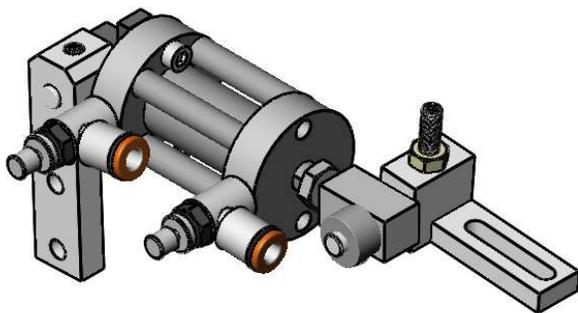
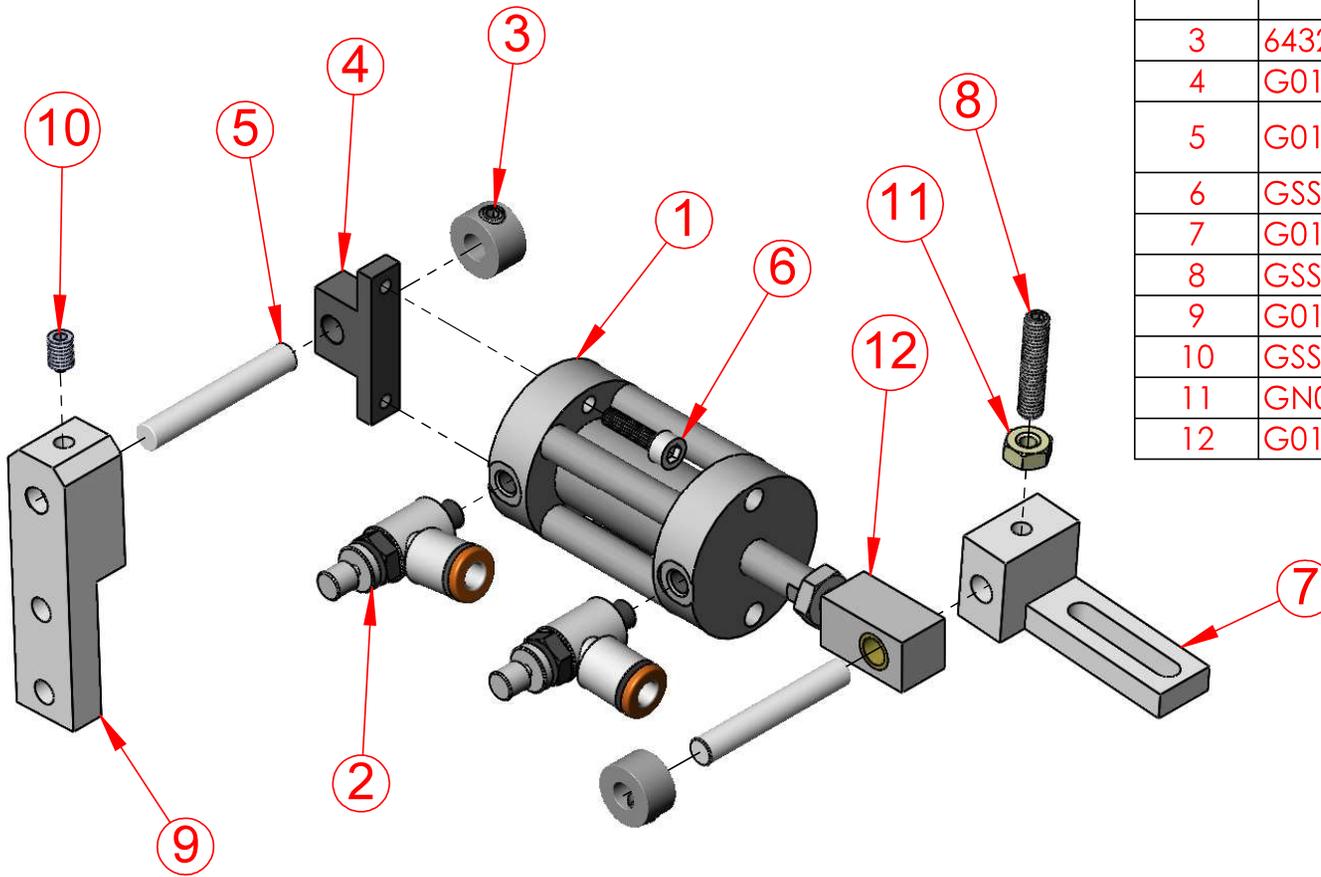
BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.		Revisions		Int.	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING								
0.5-6	±0.2	±0.2	±0.4	Hardness				Hard.Dpth.			
6-30	±0.2	±0.25	±0.5	Heat T'mnt.				Modif.No.			
30-120	±0.3	±0.45	±0.7	Finish				Machine No.			
120-315	±0.5	±0.6	±1.0	Material				Customer Part No.			
315-1000	±0.8	±1.1	±1.5					Asly No.			G014118EX
1000 ~	±1.2	±1.8	-	Part/ Assy Name				Date			
PARALLELNESS											
ANGLE TOLERANCE											
SURFACE TOLERANCE											
ROUNDNESS											
SURFACE FINISH NOT TO EXCEED											

Scale : 1:1 Size : 11"D

Drawn By: _____ Checked By: _____ Approved: _____

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013430	1 1/4 AIR CYL (36C)	1
2	JW000014	FITTING FLO CON (D2C7)	2
3	6432K19	3/16 COLLAR (32F)	2
4	G012353	CYL BRKT (32E)	1
5	G012354	DOWEL 3/16 X 1 1/4 (56A)	2
6	GSSC312	M3 X 12 SHCS	2
7	G012369	CYL MOUNT (32H)	1
8	GSSS420	M4 X 20 SET SCREW	1
9	G012370	SPDR PIVOT (33A)	1
10	GSSS406	SCREW, M4X6 SET	1
11	GN00400	M4 NUT	1
12	G013428	CLEVIS (13D)	1



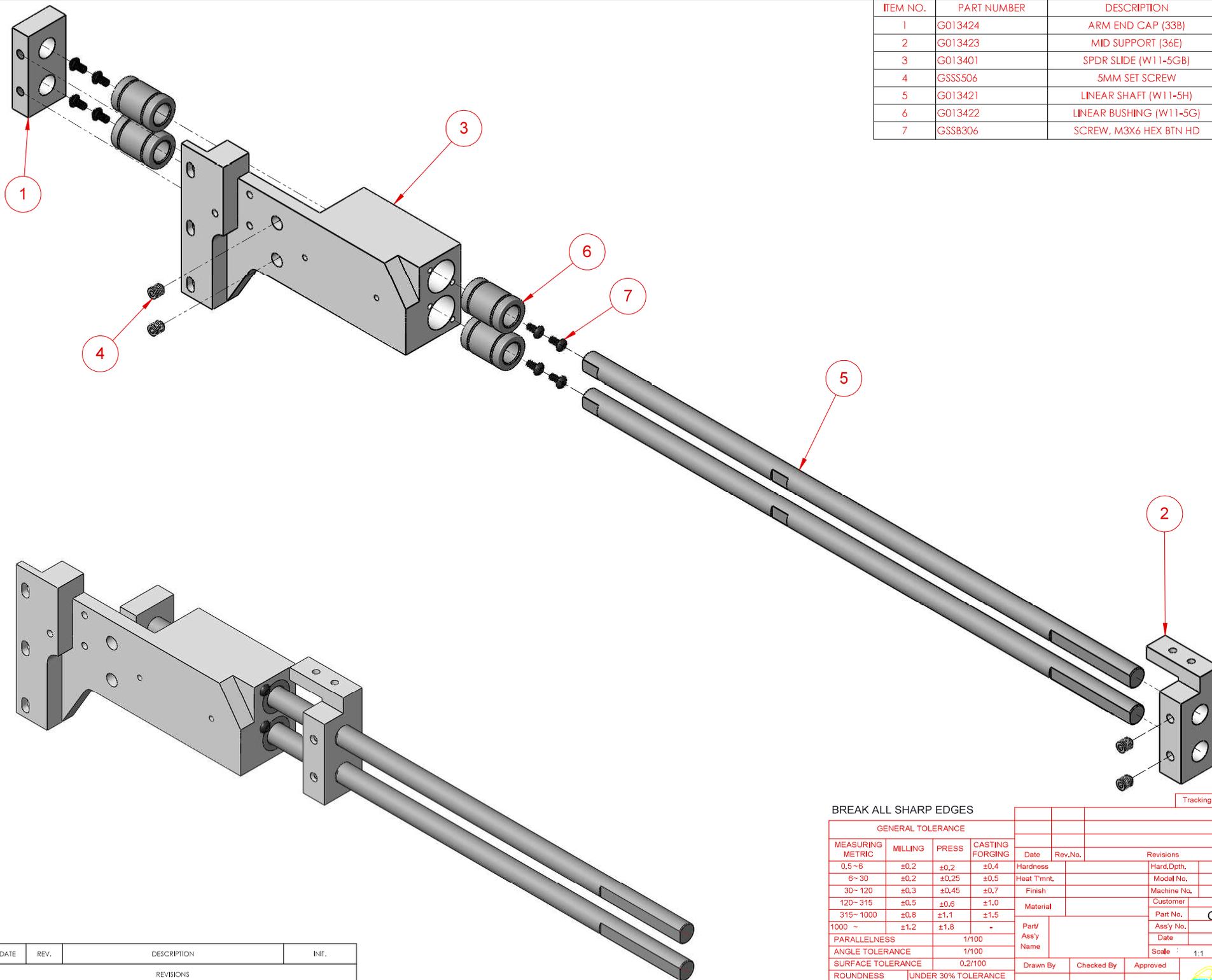
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness			Hard.Dpth.		
0.5~6	±0.2	±0.2	±0.4	Heat T'mnt.			Model No.		
6~30	±0.2	±0.25	±0.5	Finish			Machine No.		
30~120	±0.3	±0.45	±0.7	Material			Customer		
120~315	±0.5	±0.6	±1.0	Part/ Ass'y Name			Part No.	G013431	
315~1000	±0.8	±1.1	±1.5		Ass'y No.				
1000 ~	±1.2	±1.8	-	Date			Scale : 1:1	Size : "A"	
PARALLELNESS		1/100		Drawn By	Checked By	Approved			
ANGLE TOLERANCE		1/100							
SURFACE TOLERANCE		0.2/100							
ROUNDNESS		UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED		63 √ UNLESS OTHERWISE SPECIFIED							

Tracking No. _____





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013424	ARM END CAP (33B)	1
2	G013423	MID SUPPORT (36E)	1
3	G013401	SPDR SLIDE (W11-5GB)	1
4	GSSS506	5MM SET SCREW	4
5	G013421	LINEAR SHAFT (W11-5H)	2
6	G013422	LINEAR BUSHING (W11-5G)	4
7	GSSB306	SCREW, M3X6 HEX BTN HD	8

DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

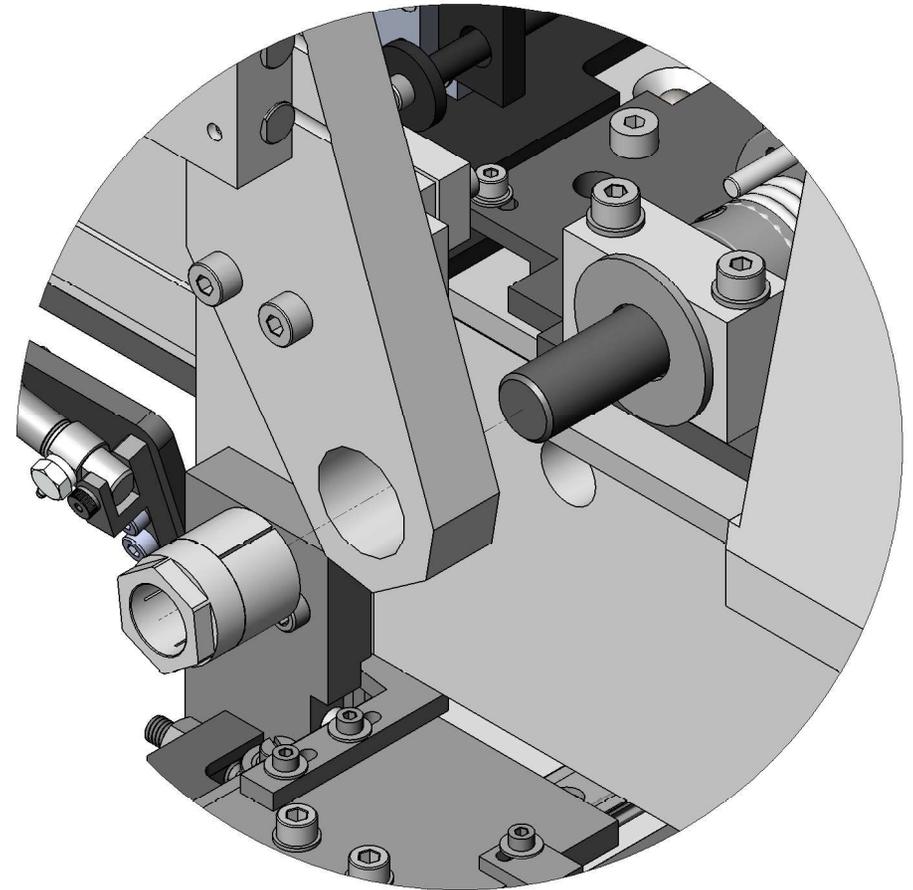
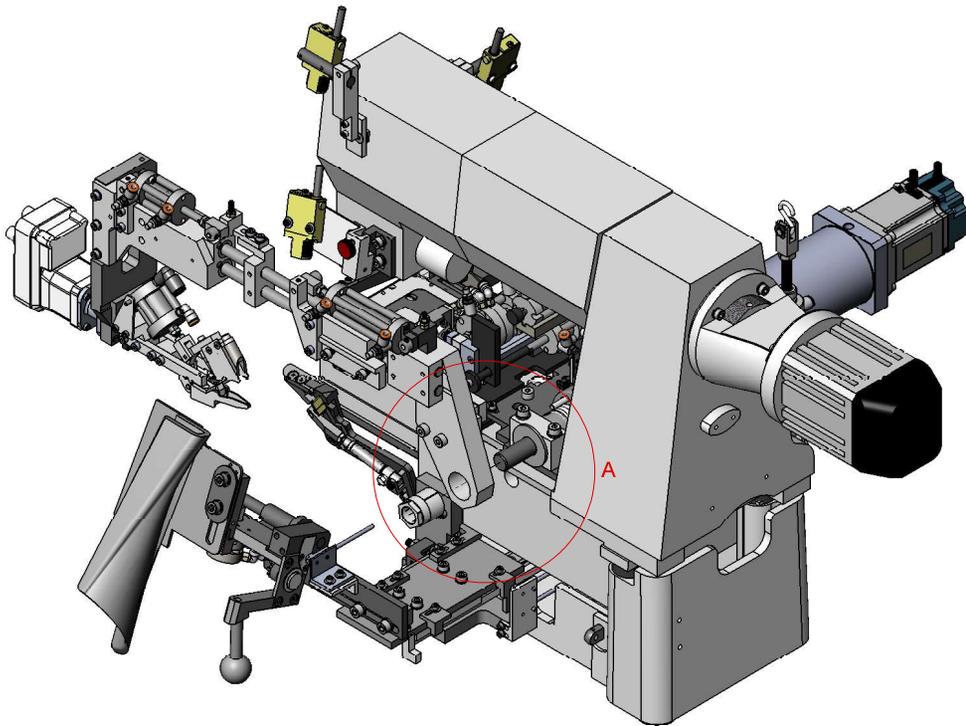
BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date		Rev.No.		Revisions		Init.	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness				Hard,Dpth.			
0,5-6	±0,2	±0,2	±0,4	Heat Trmnt.				Model No.			
6-30	±0,2	±0,25	±0,5	Finish				Machine No.			
30-120	±0,3	±0,45	±0,7	Material				Customer			
120-315	±0,5	±0,6	±1,0	Part/ Ass'y Name				Part No.			
315-1000	±0,8	±1,1	±1,5					Ass'y No.			G013404
1000 ~	±1,2	±1,8	-	Scale	1:1			Date			
PARALLELNESS	1/100			Drawn By		Checked By		Approved			
ANGLE TOLERANCE	1/100			Scale		1:1		Size		"C"	
SURFACE TOLERANCE	0,2/100										
ROUNDNESS	UNDER 30% TOLERANCE										
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED										

Tracking No.



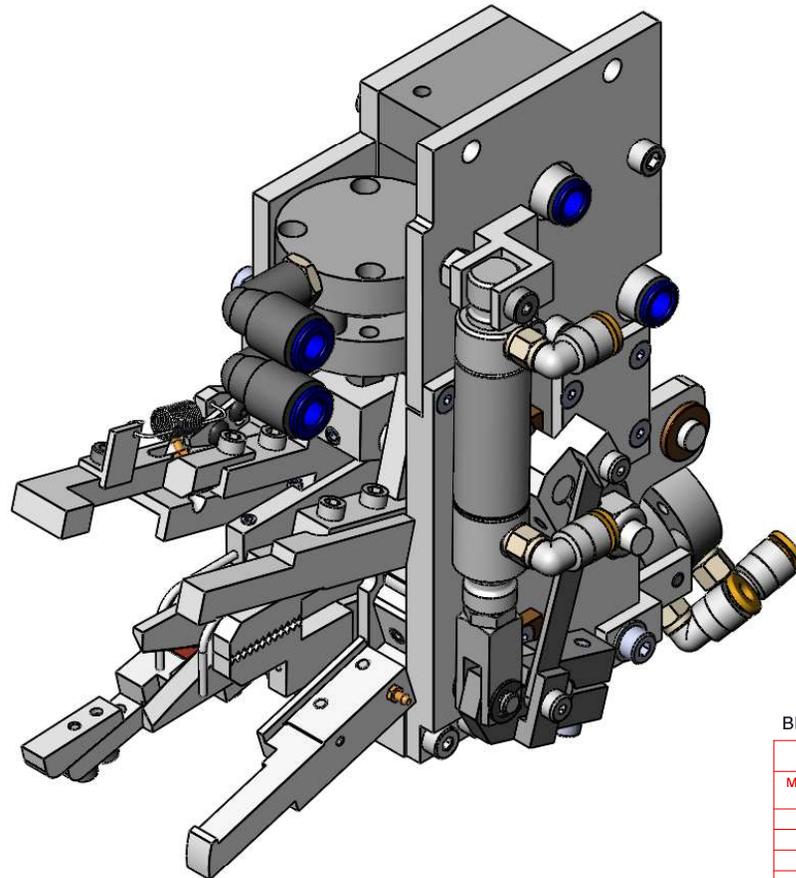
STEP 11: ADD G014151



DATE	REV.	DESCRIPTION	BY
REVISIONS			

BREAK ALL SHARP EDGES										Tracking No.	V005445		
GENERAL TOLERANCE													
MEASURING METRIC	MILLING	PRESS	CASTING	FORGING	Date	Rev.No.	Revisions		Int.				
0.5-6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth.			GTN1828			
6-30	±0.2	±0.25	±0.5	Heat T'mnt.			Modif.No.			302U201B			
30-120	±0.3	±0.45	±0.7	Finish			Machine No.			Customer CAPS HART			
120-315	±0.5	±0.6	±1.0	Material			Part No.			G013919			
315-1000	±0.8	±1.1	±1.5				Asly No.			G013919			
1000 -	±1.2	±1.8	-	Part/ Assy Name			Date			9/22/15			
PARALLELNESS			1/100			GTN 1828				Scale	1:2	Size	"D"
ANGLE TOLERANCE			1/100			Drawn By	Checked By	Approved					
SURFACE TOLERANCE			0.2/100										
ROUNDNESS			UNDER 30% TOLERANCE										
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED										
NOT TO EXCEED			✓										

ANIMATION OF ASSEMBLY: https://www.youtube.com/watch?v=XxL_UQ_UFU8&feature=youtu.be



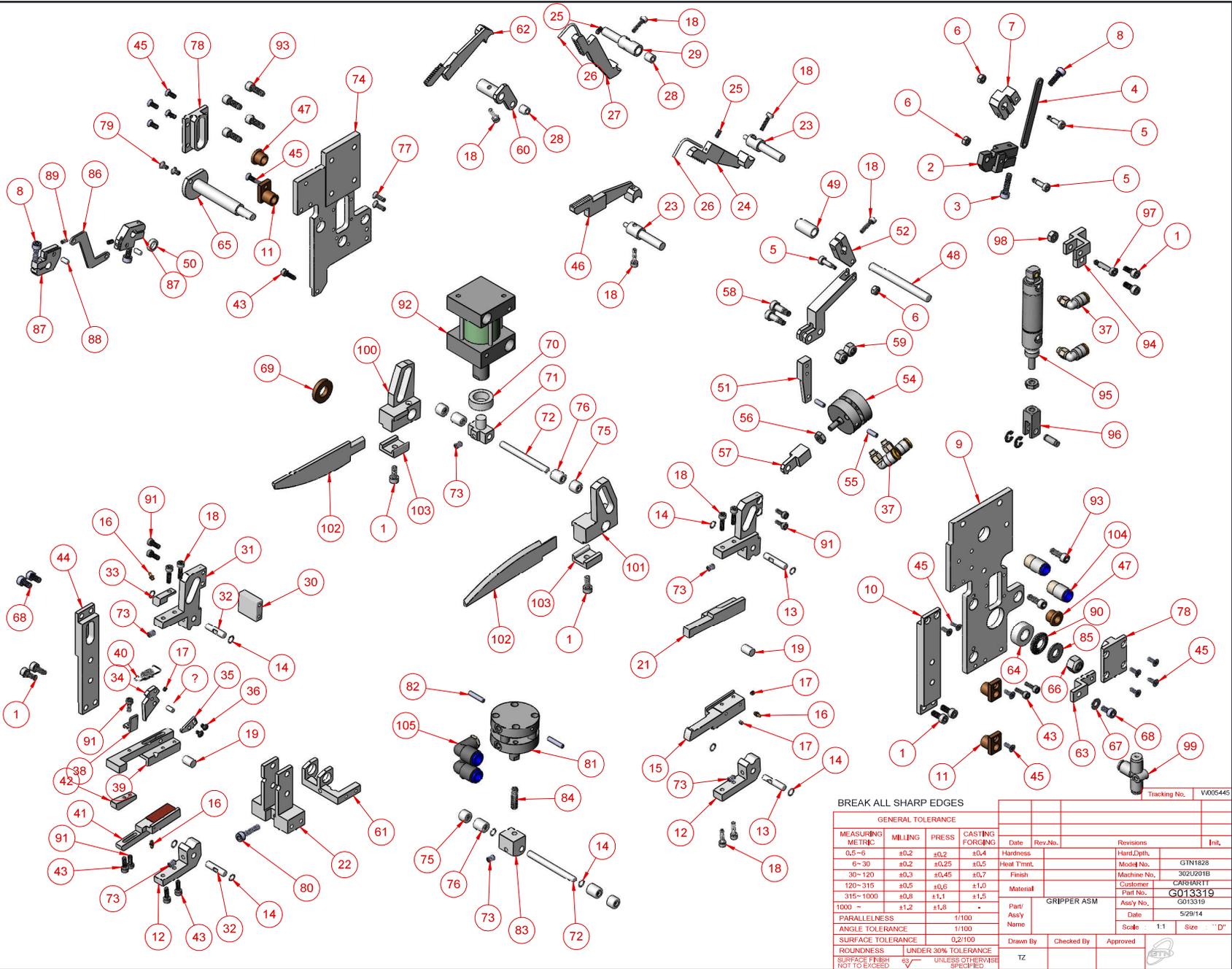
DATE	REV.	DESCRIPTION	INIT
REVISIONS			

BREAK ALL SHARP EDGES

Tracking No. W005445

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Hardness		Hard.Dpth.		
0.5 ~ 6	±0.2	±0.2	±0.4	Heat T'mnt.		Model No.	GTN1828	
6 ~ 30	±0.2	±0.25	±0.5	Finish		Machine No.	302U201B	
30 ~ 120	±0.3	±0.45	±0.7	Material		Customer	CARHARTT	
120 ~ 315	±0.5	±0.6	±1.0	Part/ Ass'y Name	GRIPPER ASM	Part No.	G013319	
315 ~ 1000	±0.8	±1.1	±1.5			Ass'y No.	G013319	
1000 ~	±1.2	±1.8	-			Date	5/29/14	
PARALLELNESS						Scale :	1:1	Size : B
ANGLE TOLERANCE								
SURFACE TOLERANCE								
ROUNDNESS	UNDER 30% TOLERANCE			Drawn By	Checked By	Approved		
SURFACE FINISH NOT TO EXCEED	63 UNLESS OTHERWISE SPECIFIED			TZ				

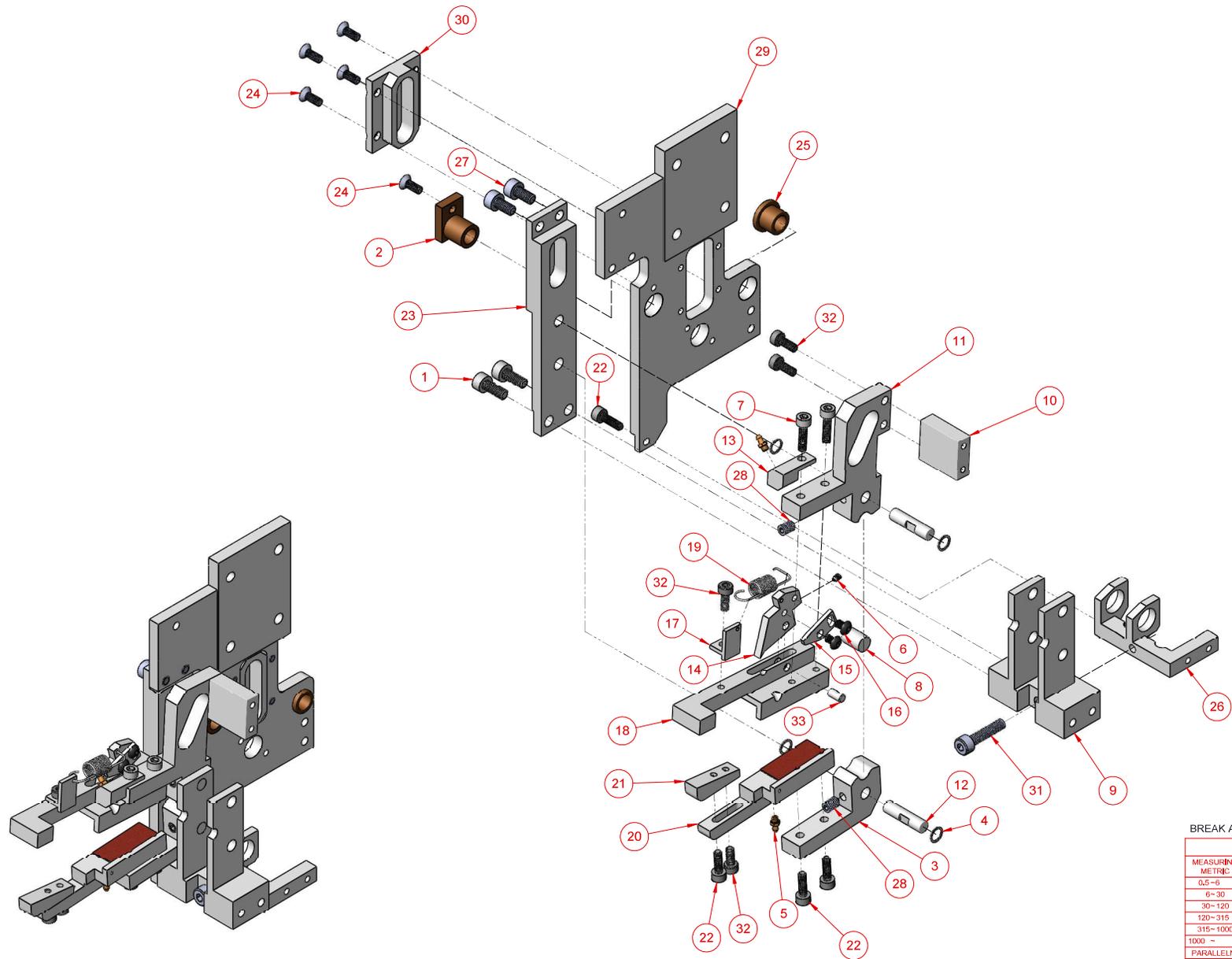
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSSC410	SHCS M4 x 10	8
2	GO12242	BAND CLAMP, BTM PIVOT	1
3	GSSC414	M4 X 14 SHCS	1
4	GO12243	LINKAGE, PIVOT BAND CLAMP	1
5	G007771	SHOULDR 1/8 X 3/8 4/40 (3SD)	3
6	GH0LE00	LOCK NUT 4-40	3
7	GO12248	BAND CLAMP, TOP PIVOT	1
8	GSSC412	M4 X 12 SHCS	3
9	GO13320	FRONT PLATE (W1+6C)	1
10	GO12253	GUIDE BAND CLAMP	1
11	GO12254	CLAMP HUB	3
12	GO12254	PIN MNT. BAND CLAMP W AIR	2
13	GO12258	PIVOT PIN	2
14	GO12259	WASHER FOR PIN	10
15	GO12260	BAND CLAMP W/O AIR (4SE)	1
16	GO13943	MN4 AIR FITTING (12E)	3
17	GSS5A03	SET SCREW, M2.5 X 3	3
18	GSSC312	M3 X 12 SHCS	11
19	GO12261	FRUCCLE	2
20	GO12262	GRP BRKT RIGHT (4SG)	1
21	GO12263	BAND CLAMP W/O AIR	1
22	GO12264	GRP PIVOT	1
23	GO12267	CLAMP SHAFT	2
24	GO12268	BAND CLAMP 2 PIECE 1	1
25	GSS3306	SCREW, M3 X 6 SET	2
26	GO12269	CLAMP WIRE	2
27	GO12270	BAND CLAMP 2 PIECE 1	1
28	R368796	BRONZE SLEEVE BEARING (3F)	2
29	GO12271	CLAMP SHAFT	1
30	GO12272	GRP-IE	1
31	GO12273	PIN MOUNT, GRIPPER	1
32	GO12284	PIVOT PIN	2
33	GO12274	AIR BLOCK, GRIPPER	1
34	GO12275	PAWL	1
35	GO12276	PAWL STOP	1
36	GSS3304	M3X6 BRKT	1
37	JW00001	ELBOW FITTING (D2C8)	4
38	GO12278	PAWL SPRING BRKT	1
39	GO12279	GRIPPER W LIMB & STOP	1
40	GO12280	SPRINGS (4AG)	1
41	GO12281	GRIPPER, OTHER (44H)	1
42	GO12282	STOP	1
43	GSSC310	M3X10 SHCS	6
44	GO12283	GUIDE GRIPPER	1
45	GSS3308	M3X8 FHCS	14
46	GO12289	BAND CLAMP 2 PIECE 2	1
47	a338K411	BRONZE FLANGED SLEEVE (2D)	2
48	GO12290	CLAMP SHAFT	1
49	GO12292	CLAMP SPACER	1
50	GO12291	SPACER	1
51	GO12293	CYL MOUNT	1
52	GO12294	LINK	1
53	GO12295	CLAMP LINK	1
54	GO13344	MODIFIED AIR CYL (55A)	1
55	P7395A435	DOWEL 1/8 X 3/8 (54C)	2
56	GH00J00	HEX NUT, 8/32	1
57	GO12296	POD PIVOT	1
58	P4035A204	SHDR SCRW, 5/32 X 9/16, B-32 (54D)	2
59	GH0LJ00	LOCK NUT, B-32	2
60	GO13341	CLAMP SHAFT	1
61	GO12299	SPANNER	1
62	GO12297	BAND CLAMP 3 PIECE 2	1
63	GO12307	CYL MOUNT	1
64	GO12310	BEARING 10, KNIFE	1
65	GO12309	SHAFT, KNIFE	1
66	GH0LM00	LOCK NUT 1/4-20	1
67	GHWF000	FLAT WASHER 1/4	1
68	GSSC408	M4 X 8 SHCS	3
69	GO12311	BUSHINGS	1
70	GO13323	DERRN WASHER	1
71	GO13322	TRM DRIVE	1
72	GO12286	PIN FOR CAM ROLLERS	2
73	GSS3406	SCREW, M4X6 SET	6
74	GO13321	PLATE 2, NEW PIVOT	1
75	GO12285	NEEDLE BEARING	4
76	GO12287	NEEDLE BEARING	4
77	GSS3310	FHCS M3 X 10	2
78	GO12326	GUIDE BRACKET	2
79	R1284126	FLAT HEAD M3.5x6	2
80	GSSC418	M4 X 18 SHCS	1
81	GO13343	MODIFIED AIR CYL (55C)	1
82	P7395A445	DOWEL 1/8 X 5/8 (54G)	2
83	GO12288	GRIP DRIVE	1
84	GSS5L19	SET SCREW 10-32 X 3/4	1
85	GHWF000	FLAT WSHR 1/4	1
86	GO12335	REAR LINK	1
87	GO13344	TOP CLEVIS FOR LINK	2
88	GO12336	PIN FOR GO13334	3
89	GSS5A06	SET SCREW M2.5 X 6	2
90	HO1274030	BELLEVILLE WASHR 5/16 (54H)	0
91	GSSC308	SHCS M3 X 8	2
92	GO13859	SQUARE AIR CYL (W1+4D)	1
93	GSSC313	SHCS 8-32 X 1/2	6
94	GO13339	TRM BRKT	1
95	GO11376	ROUND A/C (55E)	1
96	A005407	CLEVIS	1
97	P4035A151	SHDR SCRW, 5/32 X 9/16, B-32 (55C)	1
98	GH0LJ00	LOCKNUT 4-32	1
99	GO14257	FITTING BRANCH T 1/8 (42G)	1
100	GO13843	BOTTOM TRM BRKT (47E)	1
101	GO13844	TOP TRM BRKT	1
102	GO12318	KNIFE	1
103	GO13845	TRM BRKT	2
104	GO13940	RND AIR FITTING, 4 MM (12B)	2
105	GO14021	FITTING 10-32 TO 6mm (12C)	2



Tracking No. V005445

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Int.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.		
6-30	±0.2	±0.25	±0.5	Heat Tmnt.		Machine No.		GTN1828
30-120	±0.3	±0.45	±0.7	Finish		Customer		302U201B
120-315	±0.5	±0.6	±1.0	Material		Customer		CASPAR ITT
315-1000	±0.8	±1.1	±1.5			Part No.		GO13319
1000 -	±1.2	±1.8	-			Asly No.		GO13319
PARALLELNESS			1/100	Part		GRIPPER ASM		
ANGLE TOLERANCE			1/100	Asly		Date		5/29/14
SURFACE TOLERANCE			0.2/100	Name		Scale	1:1	Size
ROUNDNESS			UNDER 30% TOLERANCE	Drawn By		Checked By		Approved
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED	TZ				



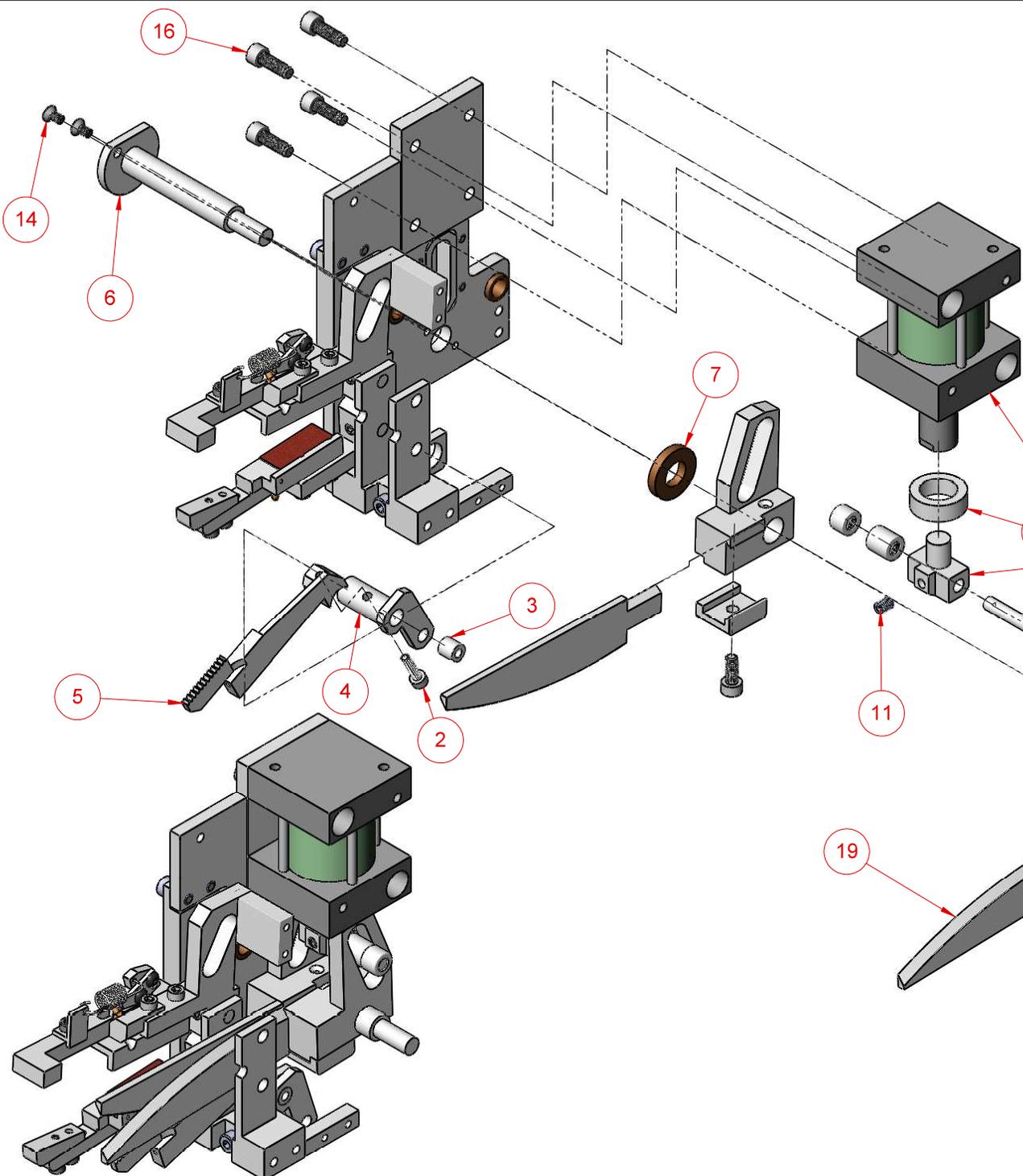
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSSC410	SHCS M4 X 10	2
2	G012254	CLAMP HUB	1
3	G012256	PIN MNT. BAND CLMP W AIR	1
4	G012259	WASHER FOR PIN	4
5	G013943	MINI AIR FITTING (12E)	2
6	GSSSA03	SET SCREW, M2.5 X 3	1
7	GSSC312	M3 X 12 SHCS	2
8	G012261	KNUCKLE	1
9	G012266	GRIP PIVOT	1
10	G012272	GRIP TIE	1
11	G012273	PIN MOUNT, GRIPPER	1
12	G012284	PIVOT PIN	2
13	G012274	AIR BLOCK, GRIPPER	1
14	G012275	PAWL	1
15	G012276	PAWL STOP	1
16	GSSB304	M3X4 BHCS	2
17	G012278	PAWL SPRING BRKT	1
18	G012279	GRIPPER W LIMIT & STOP	1
19	G012280	SPRING (44G)	1
20	G012281	GRIPPER, OTHER (44H)	1
21	G012282	STOP	1
22	GSSC310	M3X10 SHCS	4
23	G012283	GUIDE, GRIPPER	1
24	GSSF308	M3X8 FHCS	5
25	6338411	BRONZE FLANGED SLEEVE (42H)	1
26	G012299	SPANNER	1
27	GSSC408	M4 X 8 SHCS	2
28	GSSS406	SCREW, M4X6 SET	2
29	G013321	PLATE 2, NEW PIVOT	1
30	G012326	GUIDE BRACKET	1
31	GSSC418	M4 X 18 SHCS	1
32	GSSC308	SHCS M3 X 8	4
33	G012336	DOWEL 1/8 X 1/4 (54A)	1
34	G014257	FITTING, BRANCH T 1/8 (47G)	1

DATE	REV.	DESCRIPTION	INI.
REVISIONS			

Tracking No. V005445

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Intl.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6-30	±0.2	±0.25	±0.5	Heat Tmnt.		Modif.No.	GTN1828
30-120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120-315	±0.5	±0.6	±1.0	Material		Customer	CARRIART
315-1000	±0.8	±1.1	±1.5	Part/ Assy Name		Part No.	G013319EX1
1000 -	±1.2	±1.8	-			Asy No.	G013319
PARALLELNESS						Date	5/29/14
ANGLE TOLERANCE						Scale	1:1 Size "D"
SURFACE TOLERANCE						Drawn By	Checked By
ROUNDNESS						Approved	
SURFACE FINISH						GTN, INC.	
NOT TO EXCEED						UNLESS OTHERWISE SPECIFIED	



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSSC410	SHCS M4 x 10	2
2	GSSC312	M3 X 12 SHCS	1
3	9368196	BRONZE SLEEVE BEARING (43F)	1
4	G013361	CLAMP SHAFT	1
5	G012297	BAND CLAMP 3 PIECE 2	1
6	G012309	SHAFT, KNIFE	1
7	G012311	BUSHING	1
8	G013323	DELRIN WASHER	1
9	G013322	TRIM DRIVE	1
10	G012286	PIN FOR CAM ROLLERS	1
11	GSSS406	SCREW, M4X6 SET	1
12	G012285	NEEDLE BEARING	2
13	G012287	NEEDLE BEARING	2
14	91294A 126	FLAT HEAD M3, L6	2
15	G013959	SQUARE AIR CYL (W11-6D)	1
16	GSSCJ13	SHCS 8-32 X 1/2	4
17	G013643	BOTTOM TRIM BRKT (47E)	1
18	G013646	TOP TRIM BRKT	1
19	G012316	KNIFE	2
20	G013645	TRIM BRKT	2
21	G014257	FITTING, BRANCH T 1/8 (47G)	1

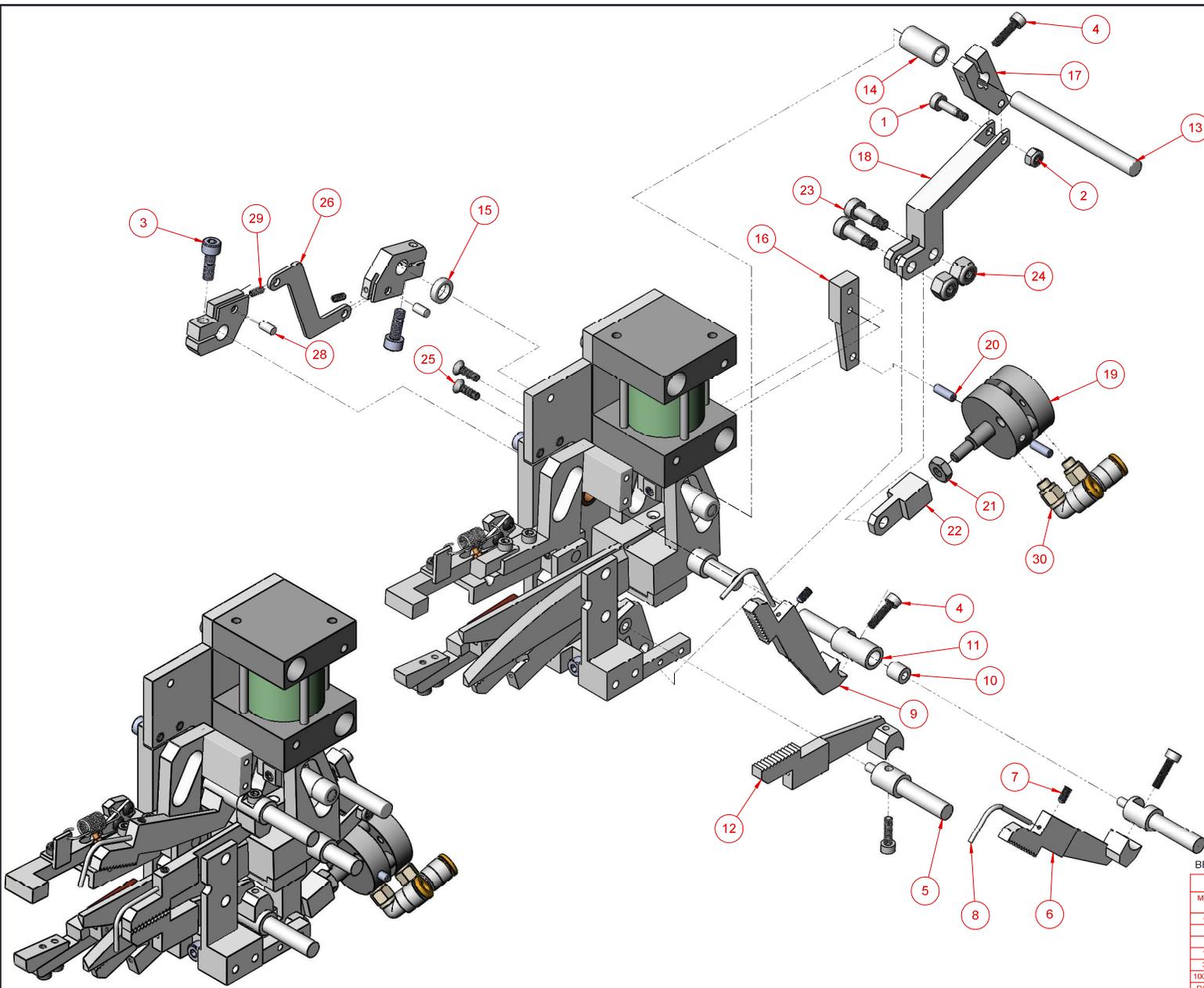
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE		Date		Rev.No.		Revisions		Init.	
MEASURING METRIC	MILLING	PRESS	CASTING	Hardness		Hard,Dpth.		Model No.	
0,5-6	±0,2	±0,2	±0,4	Heat Trmnt.		Machine No.		GTN1828	
6-30	±0,2	±0,25	±0,5	Finish		Customer		302U201B	
30-120	±0,3	±0,45	±0,7	Material		Part No.		CARHARTT	
120-315	±0,5	±0,6	±1,0	Part/ Ass'y Name		Ass'y No.		G013319EX2	
315-1000	±0,8	±1,1	±1,5	GRIPPER ASM		Date		5/29/14	
1000 ~	±1,2	±1,8	-	Scale : 1:1		Size : "C"			
PARALLELNESS		1/100		Drawn By		Checked By		Approved	
ANGLE TOLERANCE		1/100		TZ					
SURFACE TOLERANCE		0,2/100							
ROUNDNESS		UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED		63 UNLESS OTHERWISE SPECIFIED							

Tracking No. W005449





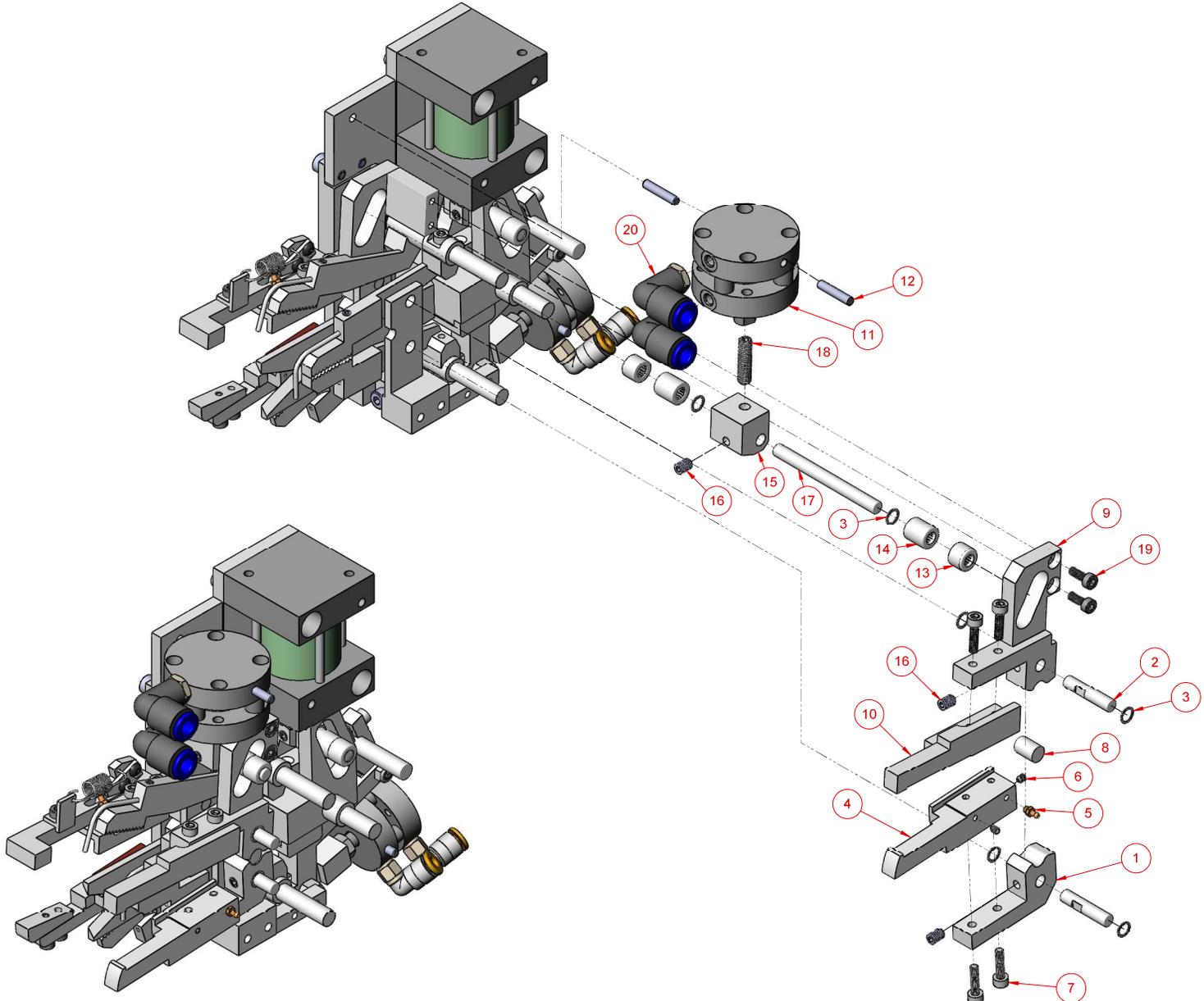
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G007771	SHOULDER 1/8 X 3/8 4/40 (SSD)	1
2	GNOL000	LOCK NUT 4-40	1
3	GSSC412	M4 X 12 SHCS	2
4	GSSC312	M3 X 12 SHCS	4
5	G012267	CLAMP SHAFT	2
6	G012268	BAND CLAMP 2 PIECE 1	1
7	GSSS306	SCREW, M3 X 6 SET	2
8	G012269	CLAMP WIRE	2
9	G012270	BAND CLAMP 3 PIECE 1	1
10	R368796	BRONZE SLEEVE BEARING (43F)	1
11	G012271	CLAMP SHAFT	1
12	G012289	BAND CLAMP 2 PIECE 2	1
13	G012290	CLAMP SHAFT	1
14	G012292	CLAMP SPACER	1
15	G012291	SPACER	1
16	G012293	CYL MOUNT	1
17	G012294	LINK	1
18	G012295	CLAMP LINK	1
19	G013346	MODIFIED AIR CYL (55A)	1
20	97395A-435	DOWEL 1/8 X 3/8 (54C)	2
21	GN00J00	HEX NUT, 8/32	1
22	G012296	ROD PIVOT	1
23	94035A-204	SHLDR SCR W, 3/16 x 3/8, 8-32 (54D)	2
24	GNOLJ00	LOCK NUT, 8-32	2
25	GSSF310	FHCS M3 x 10	2
26	G012335	REAR LINK	1
27	G012334	TOP CLEVER-REAR LINK	2
28	G012336	PIN FOR G012334	2
29	GSSA06	SET SCREW M2.5 x 6	2
30	JW000001	ELBOW FITTING (D2C6)	2

Tracking No. V005445

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Int.	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING			Hard.Dpth.			
0.5-6	±0.2	±0.2	±0.4			Modif.No.		GTN1828	
6-30	±0.2	±0.25	±0.5			Machine No.		302U201B	
30-120	±0.3	±0.45	±0.7			Customer		CARRIART	
120-315	±0.5	±0.6	±1.0			Part No.		G013319EX3	
315-1000	±0.8	±1.1	±1.5			Asly No.		G013319	
1000 -	±1.2	±1.8	-			Date		5/29/14	
PARALLELNESS						Scale	1:1	Size	"D"
ANGLE TOLERANCE						Part/ Assy Name	GRIPPER ASM		
SURFACE TOLERANCE						Drawn By	Checked By	Approved	
ROUNDNESS									
SURFACE FINISH									
NOT TO EXCEED									

DATE	REV.	DESCRIPTION	INT.
REVISIONS			



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012256	PIN MNT. BAND CLMP W AIR	1
2	G012258	PIVOT PIN	2
3	G012259	WASHER FOR PIN	6
4	G012260	BAND CLAMP W AIR (45E)	1
5	G013963	MINI AIR FITTING (12E)	1
6	GSSSA03	SET SCREW, M2.5 X 3	2
7	GSSC312	M3 X 12 SHCS	4
8	G012261	KNUCKLE	1
9	G012262	GRIP BRKT RIGHT (45G)	1
10	G012263	BAND CLAMP W/O AIR	1
11	G013343	MODIFIED AIR CYL (55C)	1
12	97395A.445	DOWEL 1/8 X 5/8 (54G)	2
13	G012285	NEEDLE BEARING	2
14	G012287	NEEDLE BEARING	2
15	G012289	GRIP DRIVE	1
16	GSSSA04	SCREW, M4X6 SET	3
17	G012286	PIN FOR CAM ROLLERS	1
18	GSSSL19	SET SCREW 10-32 x 3/4	1
19	GSSC308	SHCS M3 x 8	2
20	G014021	FITTING 10-32 TO 6mm (12C)	2

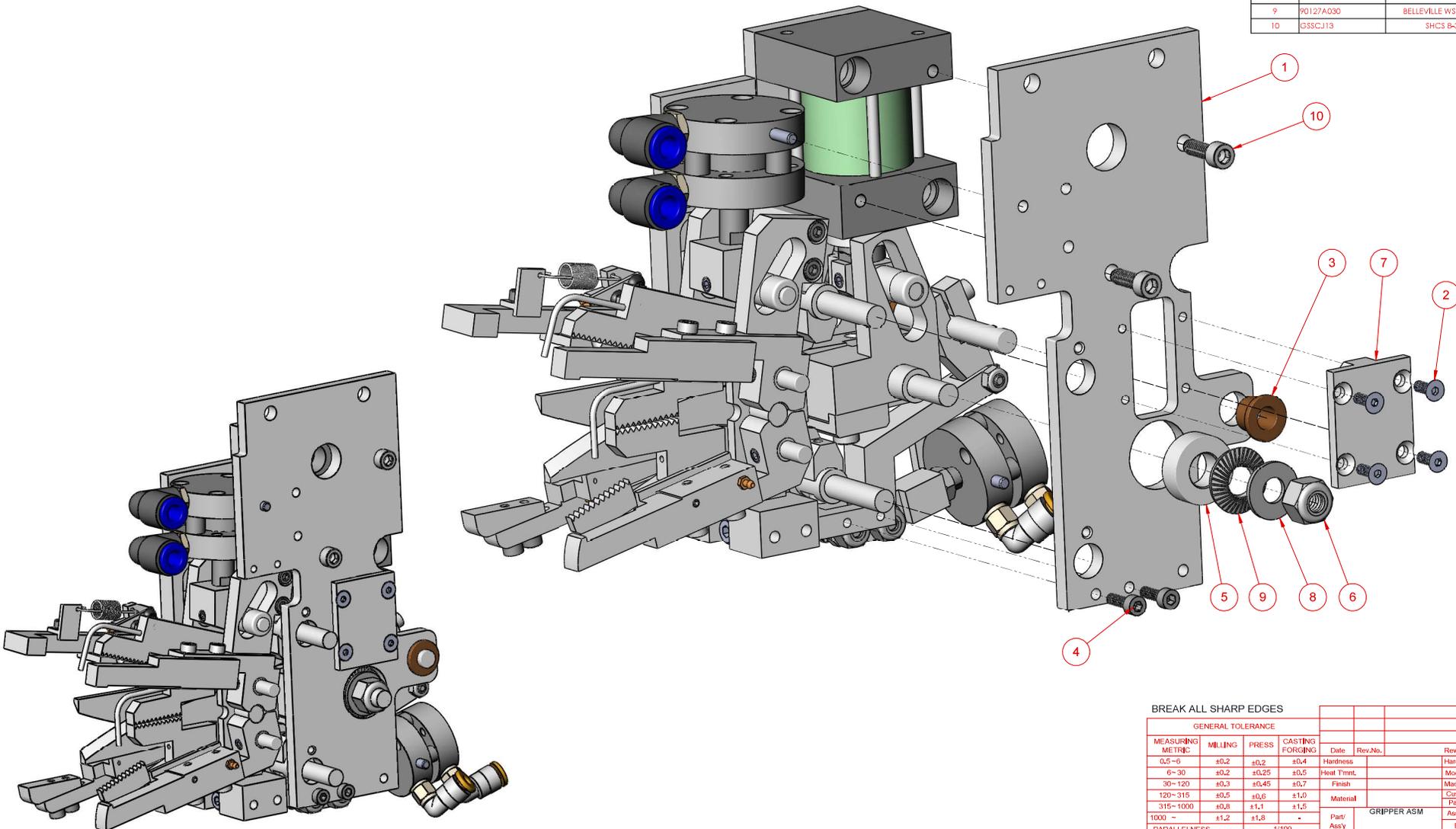
DATE	REV.	DESCRIPTION	INE
REVISIONS			

Tracking No. V005445

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Int.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6-30	±0.2	±0.25	±0.5	Heat T'mnt.		Modif.No.	GTN1828
30-120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120-315	±0.5	±0.6	±1.0			Customer	CARRIART
315-1000	±0.8	±1.1	±1.5			Part No.	G013319EX4
1000 -	±1.2	±1.8	-			Asly No.	G013319
PARALLELNESS				Part	GRIPPER ASM		Date
ANGLE TOLERANCE				Assy			5/29/14
SURFACE TOLERANCE				Name			Scale : 1:1 Size : 11"D"
ROUNDNESS	UNDER 30% TOLERANCE			Drawn By	Checked By	Approved	
SURFACE FINISH	UNLESS OTHERWISE SPECIFIED			TZ			
NOT TO EXCEED							

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013320	FRONT PLATE (W 1-6C)	1
2	G55F308	M3XB FHCS	4
3	6338K411	BRONZE FLANGED SLEEVE (42H)	1
4	G55C310	M3X10 SHCS	2
5	G012310	BEARING BLOCK, KNIFE	1
6	GNOLM00	LOCK NUT 1/4-20	1
7	G012326	GUIDE BRACKET	1
8	GWFGM00	FLAT WSHR 1/4	1
9	P0127A030	BELLEVILLE WSHR 5/16 (54H)	1
10	G55CJ13	SHCS 8-32 X 1/2	2

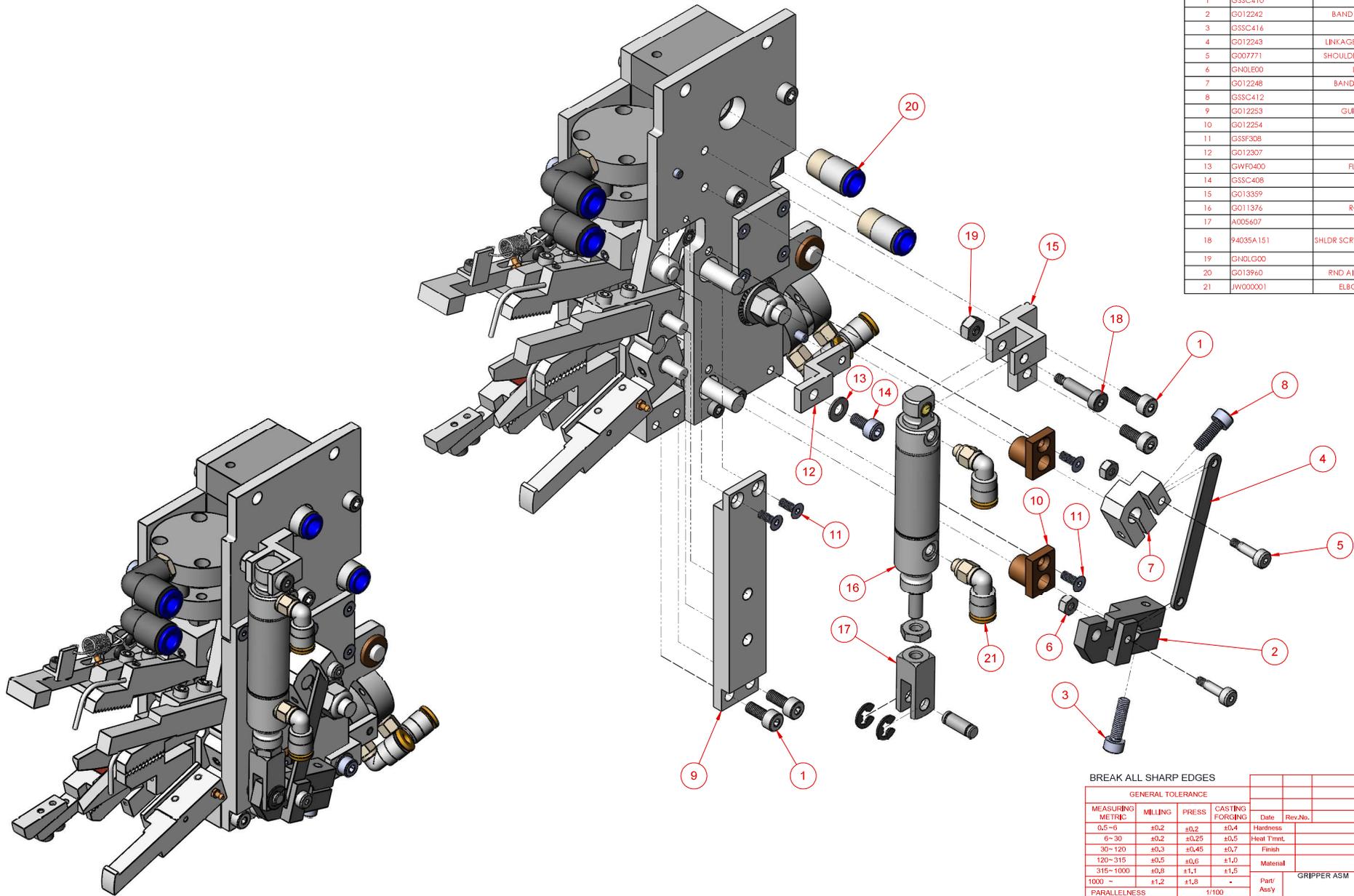


DATE	REV.	DESCRIPTION	INE.
REVISIONS			

BREAK ALL SHARP EDGES

Tracking No. V005445

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Int.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5-6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6-30	±0.2	±0.25	±0.5	Heat T'mnt.		Modif.No.	GTN1828
30-120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120-315	±0.5	±0.6	±1.0			Customer	CARRIART
315-1000	±0.8	±1.1	±1.5	Material		Part No.	G013319EX5
1000 ~	±1.2	±1.8	-			Asly No.	G013310
PARALLELNESS			1/100	Part/ Assy Name		Date	5/29/14
ANGLE TOLERANCE			1/100			Scale	1:2 Size "D"
SURFACE TOLERANCE			0.2/100	Drawn By	Checked By	Approved	
ROUNDNESS			UNDER 30% TOLERANCE				
SURFACE FINISH			UNLESS OTHERWISE SPECIFIED				
NOT TO EXCEED				TZ			



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSSC410	SHCS M4 X 10	4
2	G012242	BAND CLAMP, BTM PIVOT	1
3	GSSC416	M4 X 16 SHCS	1
4	G012243	LINKAGE, PIVOT BAND CLAMP	1
5	G007771	SHOULDER 1/8 X 3/8 4/40 (53D)	2
6	GH0LE00	LOCK NUT 4-40	2
7	G012248	BAND CLAMP, TOP PIVOT	1
8	GSSC412	M4 X 12 SHCS	1
9	G012253	GUIDE, BAND CLAMP	1
10	G012254	CLAMP HUB	2
11	GSSF308	M3X8 FHCS	4
12	G012307	CYL MOUNT	1
13	GWFR400	FLAT WASHER M4	1
14	GSSC408	M4 X 8 SHCS	1
15	G013359	CLEVIS	1
16	G011376	ROUND AC (55E)	1
17	A005607	CLEVIS	1
18	94035A151	SHLDR SCRW 5/32 x 9/16, 6-32 (55G)	1
19	GH0LG00	LOCKNUT 6-32	1
20	G013960	RND A/R FITTING, 6 MM (12B)	2
21	JW000001	ELBOW FITTING (D2C6)	2

Tracking No. V005445

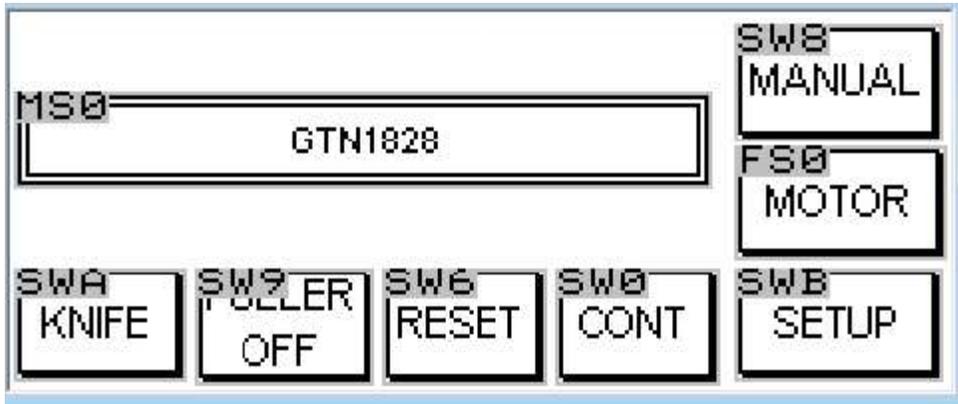
BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Int.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING			Hard.Dpth.		
0.5-6	±0.2	±0.2	±0.4			Modif.No.		GTN1828
6-30	±0.2	±0.25	±0.5			Heat T'mnt.		302U201B
30-120	±0.3	±0.45	±0.7			Finish		Machine No.
120-315	±0.5	±0.6	±1.0			Material		Customer
315-1000	±0.8	±1.1	±1.5			Part No.		CARRIART
1000 -	±1.2	±1.8	-			Asly No.		G013319EX6
PARALLELNESS						Date		G013319
ANGLE TOLERANCE						Part/ Assy Name		GRIPPER ASM
SURFACE TOLERANCE						Date		5/29/14
ROUNDSNESS						Scale	1:1	Size
SURFACE FINISH						Drawn By		TZ
NOT TO EXCEED						Checked By		Approved
						Unless otherwise specified		

DATE	REV.	DESCRIPTION	INE
REVISIONS			

TOUCH SCREEN

MAIN



MOTOR



KNIFE: Manually triggers knife behind the needles

PULLER OFF: Manually turn the puller off

RESET: Restarts the banding cycle and homes the machine. If the folder is not pulled away from the machine the band cycle will reset but the motors will not home up.

CONT: If the operator accidentally allows the tape on the folder to be seen by the sensors during operator sew the foot pedal will become inactive and the machine will stop sewing. Press this button to continue sewing.

MANUAL: MANUAL or AUTO is displayed on this button. This sets the cycle mode to automatic or manual. The text displayed is the mode the machine is set to.

MOTOR: Opens MOTOR screen

SETUP: Opens SETUP screen

SERVO UP: Makes the arm go up if the folder is back and the spreader is in the center position

SERVO DOWN: Makes the arm go down if the folder is back

SERVO OFF: Turns the motor that drives the arm off

BAND ENDING: If the arm is down, this turns the spreader to the second fold position

CENTER: Turns the spreader to the center position

BAND START: If the arm is down, this turns the spreader to the first fold position

ORIGIN: Origins all motors except for the sewing motor. For the machine to origin correctly the arm must be down and the folder back.

MAIN: Opens MAIN screen

SETUP

BAD END COUNT	D00	STITCHES	KEY	8	9
END PRESSURE	D01	STITCHES	/	8	9
PULLER	D02	STITCHES	4	5	6
KNIFE CUT	D03	STITCHES	1	2	3
FS0			0	ES	↵
OTHER					

BAND END COUNT: Set how many stitches for automatic sew

END PRESSURE: Set how many stitches for automatic sew that the band is being clamped with pressure.

Example:

BAND END COUNT 20 STITCHES

END PRESSURE 15 STITCHES

In this case the final sew will be 20 stitches and for the last 5 stitches the clamp will provide no pressure.

PULLER: Set how many stitches until the puller drops. The count begins when the operator begins sewing the first fold.

KNIFE CUT: Set how many stitches until the knife behind the needles is activated. The count starts when the back Banner sensor can see the sensor tape. The knife will not activate on the first pair of pants.

OTHER: Opens OTHER screen

MAIN: Opens MAIN screen

OTHER

START POSITION	D00	**	PUL:	KEY	8	9
CENTER POSITION	D01	**	PUL:	4	5	6
END POSITION	D02	**	PUL:	1	2	3
FS0				0	ES	↵
BACK						

The OTHER screen is for adjusting the spreader motor. It is recommended that these settings remain at the default settings.

START POSITION: Set the start position

CENTER POSITION: Set the center position

END POSITION: Set the end position

BACK: Opens SETUP screen

MAIN: Opens MAIN screen

In SETUP and OTHER screen the number pad is hidden until a number is touched. Enter (bottom right button) or ESC will hide the number pad. Enter will save the new setting if it is in range and ESC will cancel the new setting.