

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	22-00124-07	ASSY, BASE, FL, 204
2	1	22-00124-02	ASSY, SHUTTLE TABLE, BASE, FL
3	1	22-00124-01	ASSY, TABLE , FL, 204, VERSION 1
4	1	22-00124-05	ASSY, SHUTTLE DRIVE SYS, FL
5	1	22-00124-06	ASSY, MAT TRAY, ROLLING, FL
6	1	21-00593-54	STL-S, OFF FALL CATCH RAMP, FL
7	1	21-00593-49	STL-S, PANEL CLOSE OUT, REAR, FL
8	2	92-02980-00	ASSY, PROX FLAT W/ 3-PIN MOLEX CONN
9	2	51-00359-00	HARDSTOP, Y AXIS, 5000 SERIES
10	2	94-03397-03	BUMPER, ROUND, ADJUSTABLE, M6X15
11	1	21-00593-46	STL-S, COVER, FRAME TUBE, FL
12	2	21-00593-71	STL-S, STOP, MAT TRAY, FL
13	6	941F0073-0	FASTENER, SHCS M12-1.75 X 40
14	12	941F0441-0	FASTENER, WASHER, FLAT M12
15	6	941F0447-0	FASTENER, NUT, M12-1.75 HEX
16	6	94-03075-140	FASTENER, HHCS, M8-1.25 X 140MM
17	25	941F0049-1	FASTENER, BHCS M6-1.0 X 16
18	13	94-03397-38	FST, FHLN, M6

DESCRIPTION				ECOR	DATE	REV	BY

APPROVALS	DATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS X.X = ±0.030 X.XX = ±0.010 X.XXX = ±0.005 FRACTIONS ±1/32	ANGLE X.X = ±1.0° X.XX = ±0.5°
DESIGN	JBF 4/18/2014		
DRAWN	JBF 5/8/2014		
CHECKED			
APPROVED			

SEE BOM	
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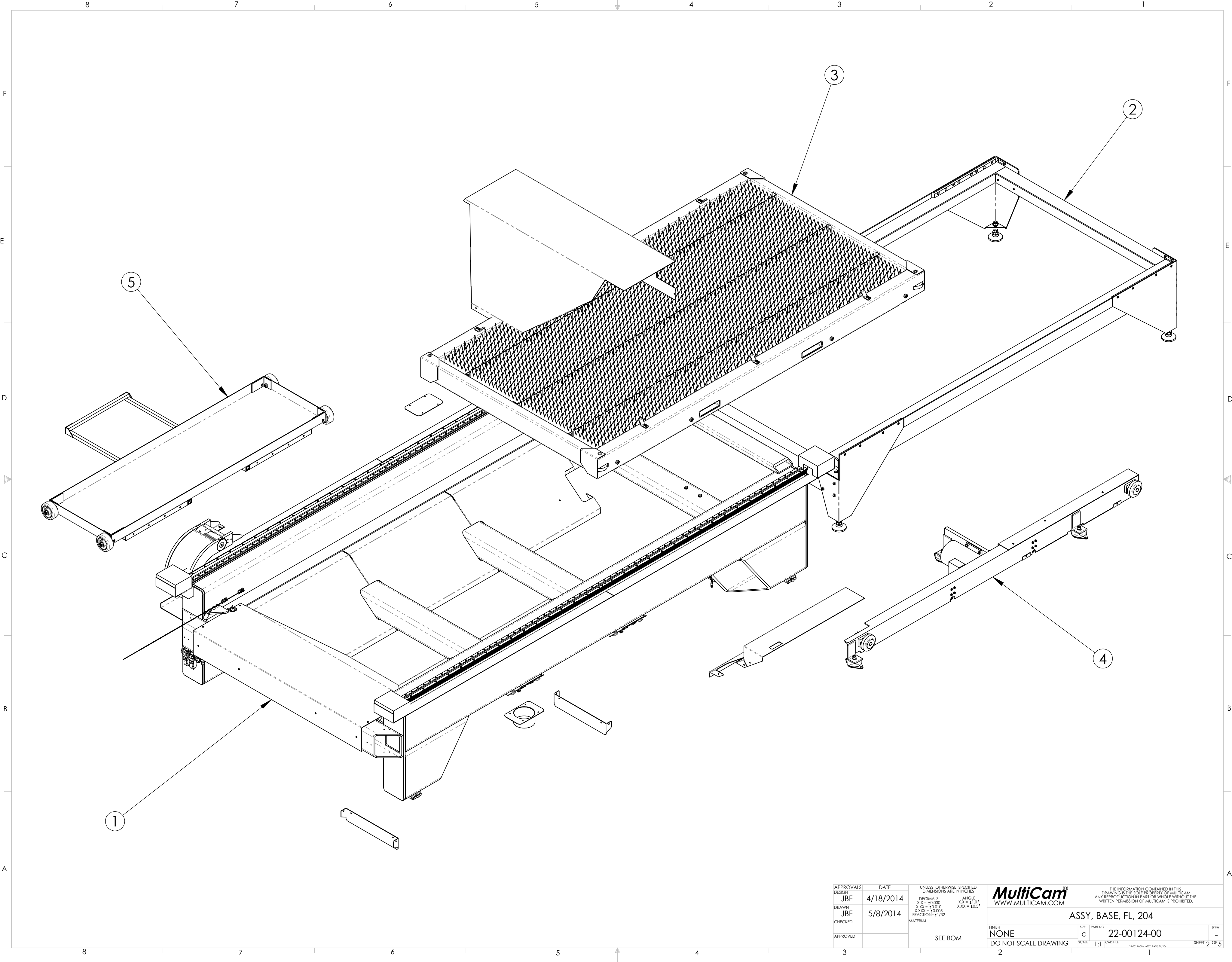
FINISH		SIZE	PART NO.	REV.
NONE		C	22-00124-00	
DO NOT SCALE DRAWING		SCALE	1:1	ICAD FILE
		22-00124-00 - ASSY, BASE, FL, 204		SHEET 1 OF 5

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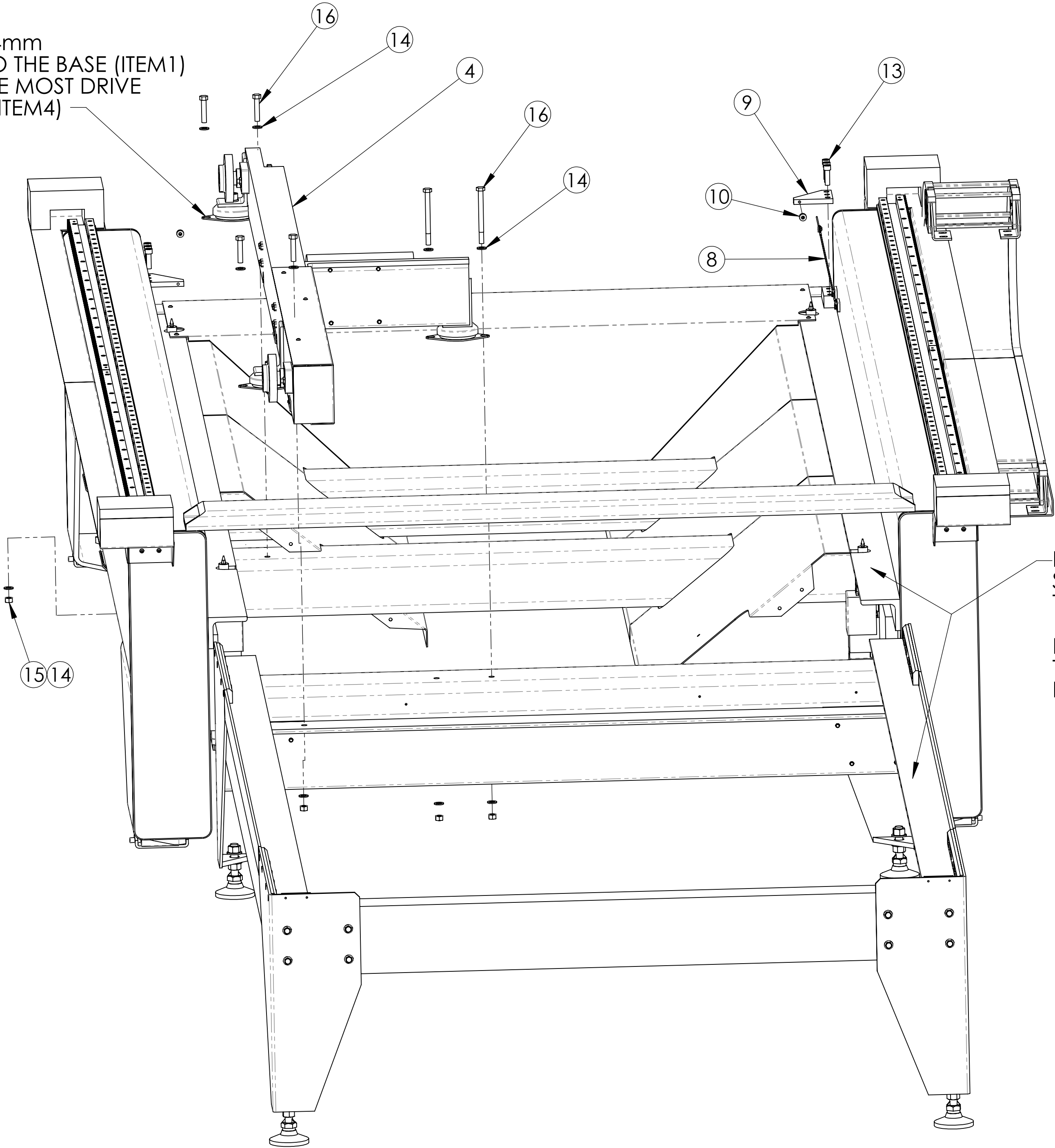
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ASSY, BASE, FL, 204



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DESIGN	JBF	4/18/2014	DECIMALS	ANGLE			
DRAWN	JBF	5/8/2014	X.X = ±0.030	X.X = ±1.0°			
CHECKED			X.XX = ±0.010	X.XX = ±0.5°			
APPROVED			X.XXX = ±0.005		ASSY, BASE, FL, 204		REV.
			MATERIAL		SIZE	PART NO.	
			SEE BOM		C	22-00124-00	-
					SCALE	1:1	SHEET 2 OF 5
					DO NOT SCALE DRAWING		

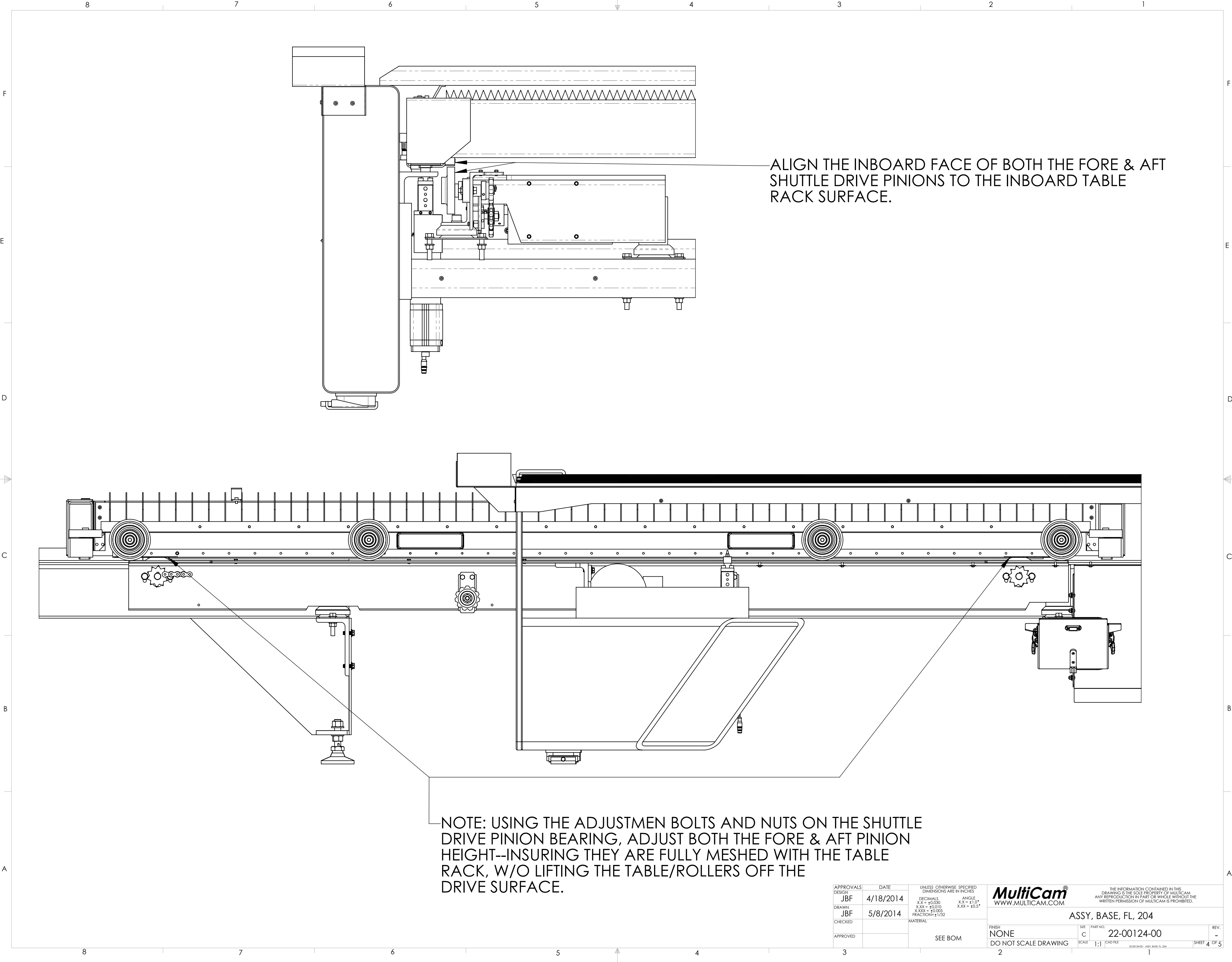
ADD QTY2 14mm
DIA HOLES TO THE BASE (ITEM1)
FOR THE FORE MOST DRIVE
SYS MOUNT (ITEM4)



NOTE: LEVEL AND ALIGN TRAVEL
SURFACES OF ITEMS 1 & 2 TO INSURE
THAT THE TABLE ROLLS SMOOTHLY.

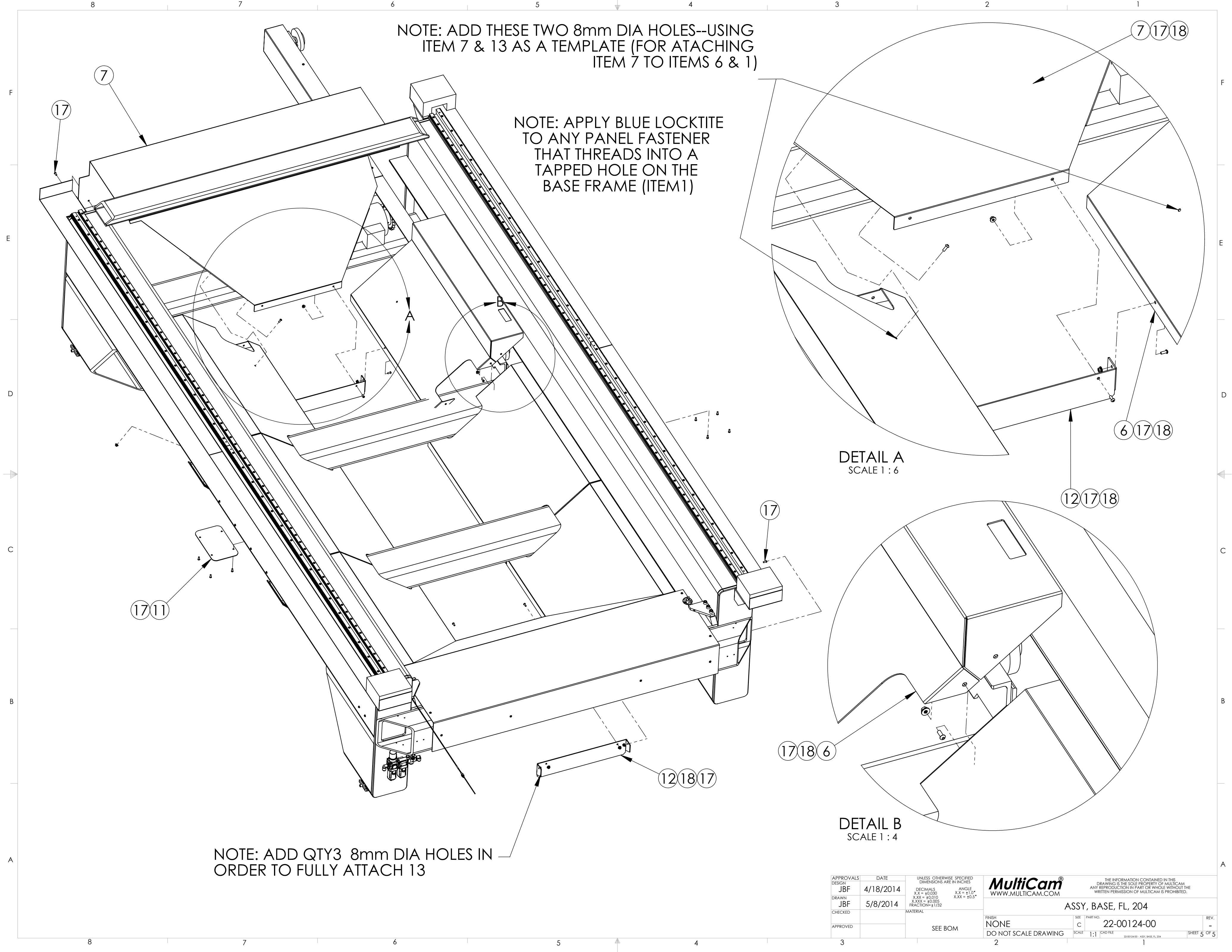
REFRENCES NOTES ON PAGE 4 PRIOR
TO TORQUING DOWN THE SHUTTLE
DIVE SYSTEM (ITEM 4).

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DESIGN	JBF	4/18/2014	DECIMALS	ANGLE			
DRAWN	JBF	5/8/2014	X.X = ±0.030	X.X = ±1.0°			
CHECKED			X.XX = ±0.010	X.XX = ±0.5°			
APPROVED			X.XXX = ±0.005		ASSY, BASE, FL, 204		REV.
			FRACTION = ±1/32		C 22-00124-00		-
			SEE BOM		DO NOT SCALE DRAWING		3 OF 5
					SCALE 1:1		



APPROVALS	DATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
DESIGN JBF	4/18/2014	DECIMALS X.X = ±0.030 X.XX = ±0.010 X.XXX = ±0.005 FRACTIONS ±1/32
DRAWN JBF	5/8/2014	ANGLE X.X = ±1.0° X.XX = ±0.5°
CHECKED		MATERIAL
APPROVED		SEE BOM

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ASSY, BASE, FL, 204		SIZE C	PART NO. 22-00124-00
FINISH NONE	SCALE 1:1	DO NOT SCALE DRAWING	REV. -
SHEET 4 OF 5		22-00124-00 - ASSY, BASE, FL, 204	



NOTE: ADD THESE TWO 8mm DIA HOLES--USING ITEM 7 & 13 AS A TEMPLATE (FOR ATTACHING ITEM 7 TO ITEMS 6 & 1)

NOTE: APPLY BLUE LOCKTITE TO ANY PANEL FASTENER THAT THREADS INTO A TAPPED HOLE ON THE BASE FRAME (ITEM1)

NOTE: ADD QTY3 8mm DIA HOLES IN ORDER TO FULLY ATTACH 13

DETAIL A
SCALE 1 : 6

DETAIL B
SCALE 1 : 4

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DESIGN	JBF	4/18/2014	DECIMALS X.X = ±0.030	ANGLE X.X = ±1.0° X.XX = ±0.5°		ASSY, BASE, FL, 204			
DRAWN	JBF	5/8/2014	X.XXX = ±0.005						
CHECKED			FRACTION = ±1/32						
APPROVED			MATERIAL	SEE BOM					
						FINISH	SIZE	PART NO.	REV.
						NONE	C	22-00124-00	-
						DO NOT SCALE DRAWING	SCALE	CAD FILE	SHEET 5 OF 5
						2	1:1	22-00124-00 - ASSY, BASE, FL, 204	