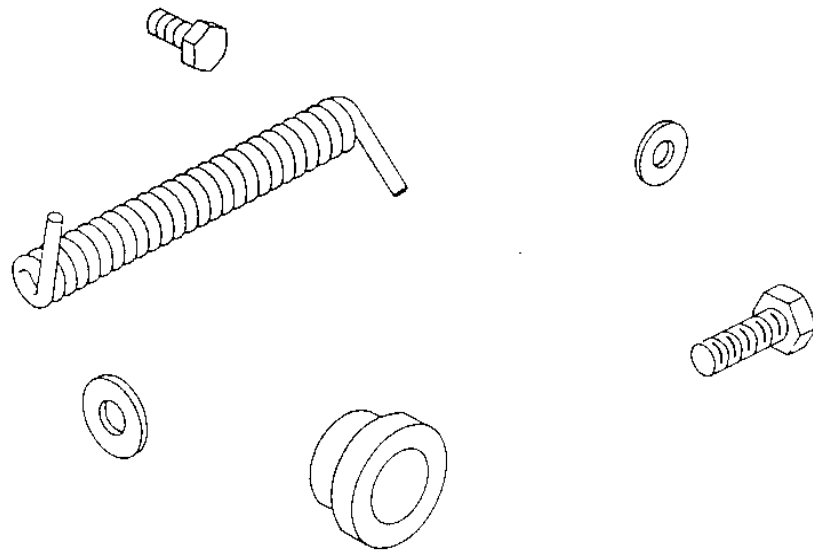


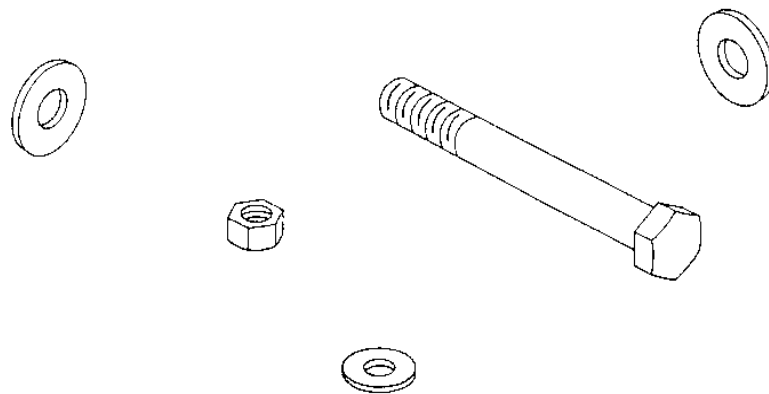


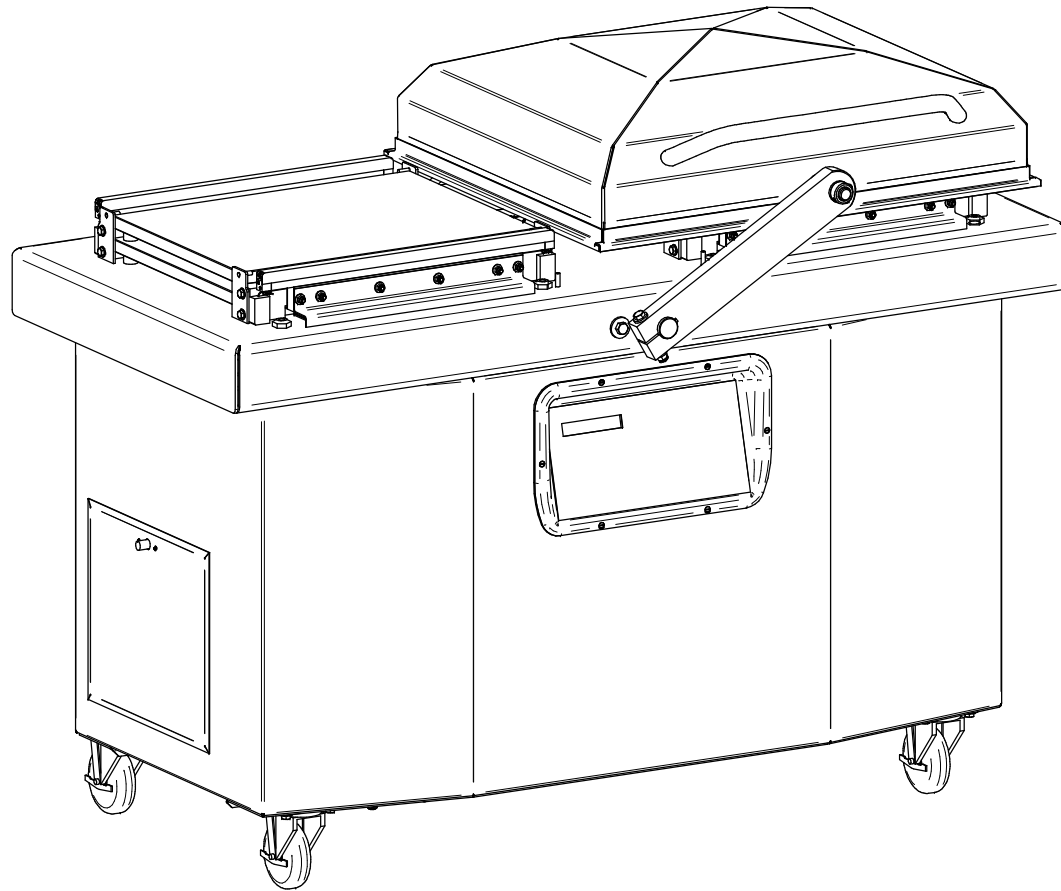
Parts List

VACCUM MACHINE
420A



MECHANICAL DRAWING

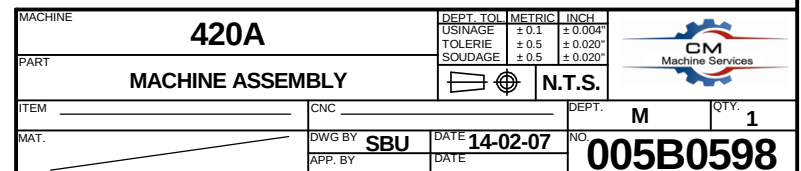


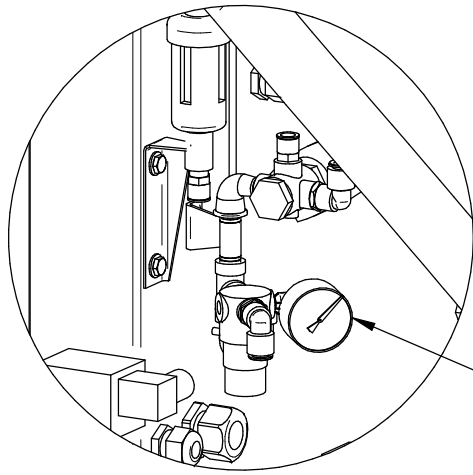


ITEM	PART #	DESCRIPTION	QT.
1	004A4109	VACUUM/ATMOSPHERE VALVE (OPT MUFFLER)	1
2	004A4110	VACUUM/ATMOSPHERE VALVE (OPT SOFT AIR)	1
3	004A4111	VACUUM/ATMOSPHERE VALVE (OPT SOFT AIR+MUFFLER)	1
4	004A4119	PUMP "BUSCH" 40M³ ASSY	1
5	004A4120	PUMP "BUSCH" 63M³ ASSY	1
6	004A4121	PUMP "BUSCH" 2X 20M³	1
7	004A4150	BASE MACHINE ASSEMBLY	1
8	004A4152	AIR REGULATOR VALVE ASSY	1
9	004B0126	UPPER SEAL BAR ASSY	2
10	004B4104	BELLOWS VALVE ASSY	1
11	004B4105	BELLOWS VALVE ASSY (OPT AIR REG)	1
12	004B4113	GAS VALVE ASSEMBLY (OPTION)	2
13	005A0455	COVER 8" ASSY	1
14	005A0533	LEFT GAS INJECTION BAR ASSEMBLY	2
15	005A0808	RIGHT GAS INJECTION BAR ASSEMBLY	2
16	005A1355	SEAL BAR ASSEMBLY W/SUPP. TWIN SEAL	4
17	005A1356	SEAL BAR ASSEMBLY W/SUPP. BAG CUT	4
18	005B0583	MC-40 CONTROL BOARD	1
19	005B1370	SLANTED FILLER PLATE ASS'Y	2
20	033-0014	MC-40 KEYBOARD "FOODPAK"	1
21	033-0015	MC-40 KEYBOARD "SIPROMAC"	1
22	033-0016	MC-40 KEYBOARD "HOLLYMATIC"	1
23	033-0018	MC-40 KEYBOARD "BERKEL"	1
24	033-0019	MC-40 KEYBOARD "BSA"	1
25	033-0021	MC-40 KEYBOARD "SUPPLY ONE"	1
26	039-0191	THERMOSTAT HAMMOND	1
27	039-0192	HEATER 100W HAMMOND	1
28	051-0255	BOLT 1/4-20 x 1-3/4" HEX SS	6
29	051-0300	BOLT 5/16"-18 x 3/4" S/S	16
30	051-0581	NUT 1/4"-20 NYLON LOCK S/S	6
31	051-0601	NUT 5/16"-18 NYLON LOCK S/S	16
32	051-0740	WASHER 1/4" FLAT S/S	12
33	051-0760	WASHER 5/16" FLAT S/S	32
34	104-0064	SILICONE TUBING 3/8" OD x 3/16" ID x 80mm	4
35	130-4PHB	4" PL.CASTER SWIVEL W/BRAKE	4

-OPTION -

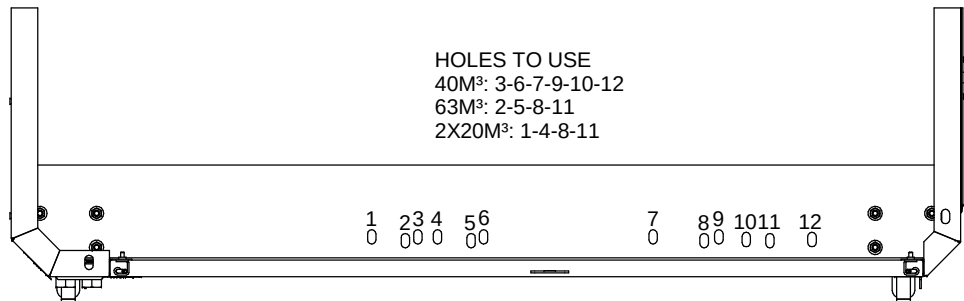
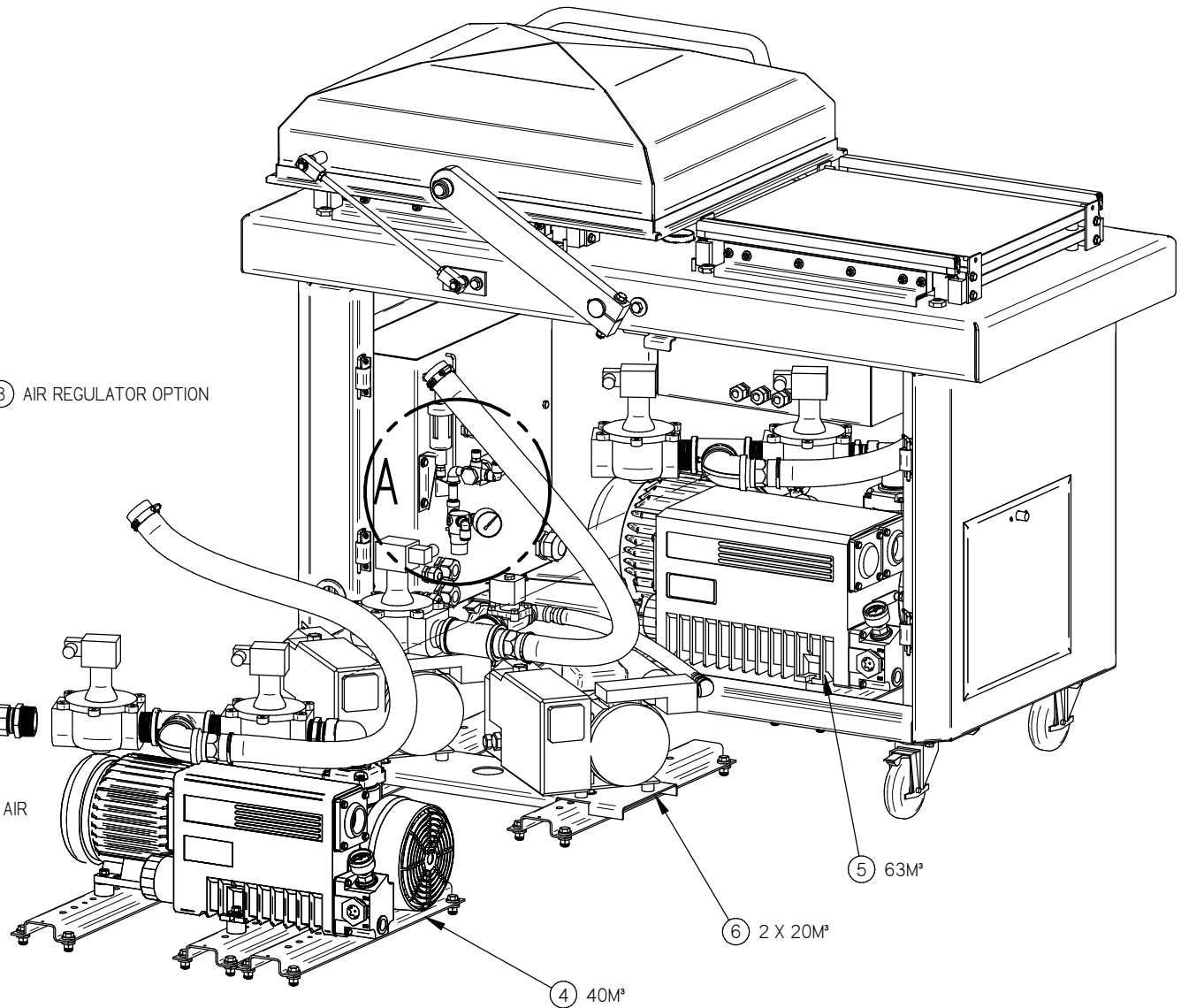
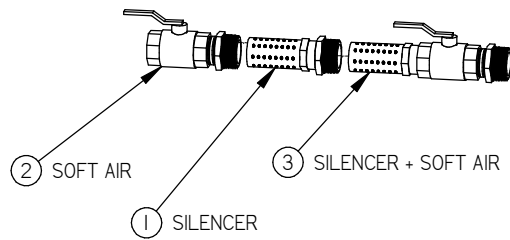
MACHINE 420A		DEPT. TOL. USINAGE TOLERIE SOUDEAGE	METRIC ± 0.1 ± 0.5 ± 0.5	INCH ± 0.004" ± 0.020" ± 0.020"	
PART MACHINE ASSEMBLY		N.T.S.			
ITEM	CNC	DEPT.		M	QTY. 1
MAT.	DWG BY SBU	DATE 14-02-07	NO. 005B0598		
APP. BY		DATE			





8 AIR REGULATOR OPTION

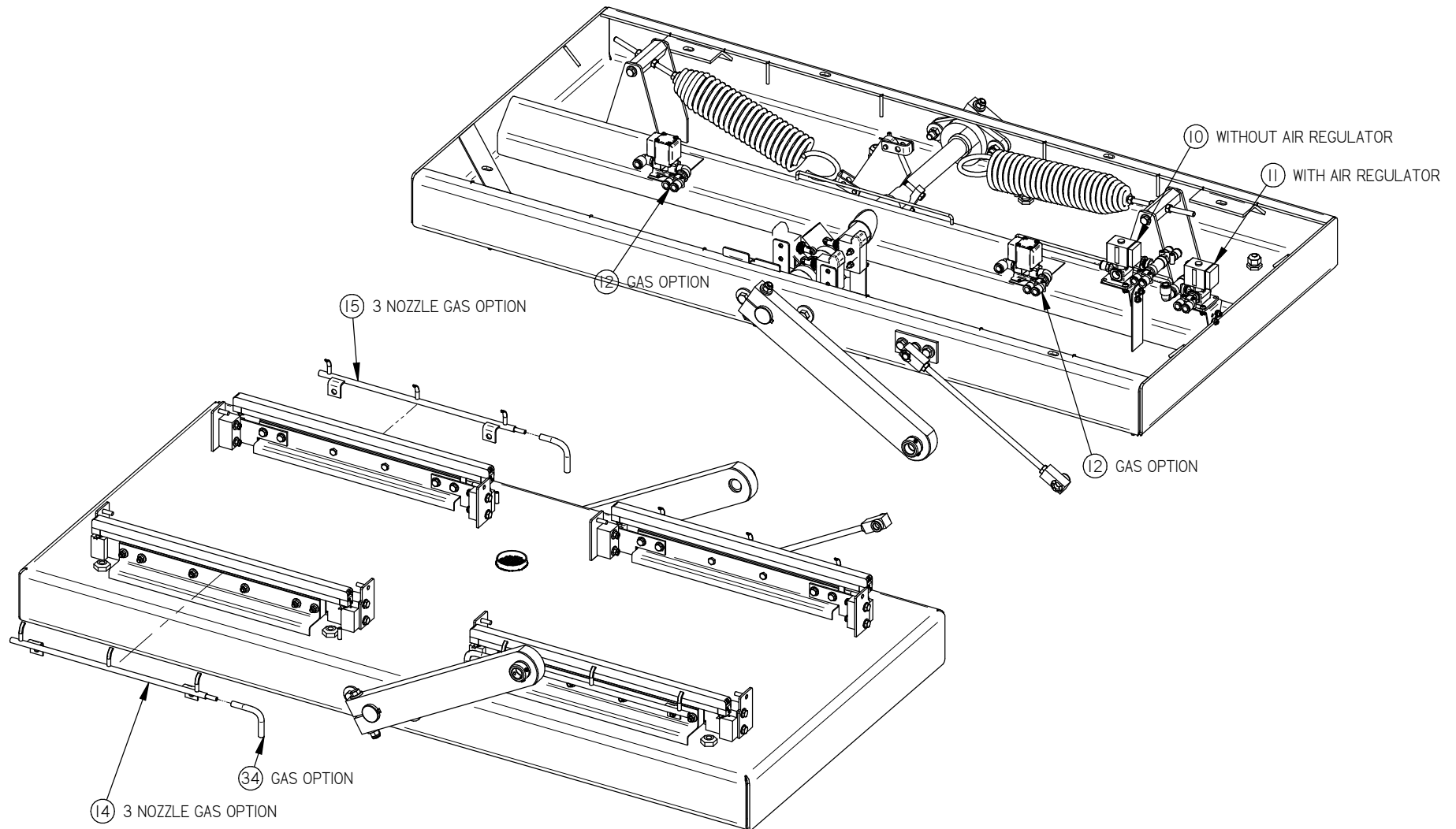
DETAIL A



HOLES TO USE
 40M³: 3-6-7-9-10-12
 63M³: 2-5-8-11
 2X20M³: 1-4-8-11

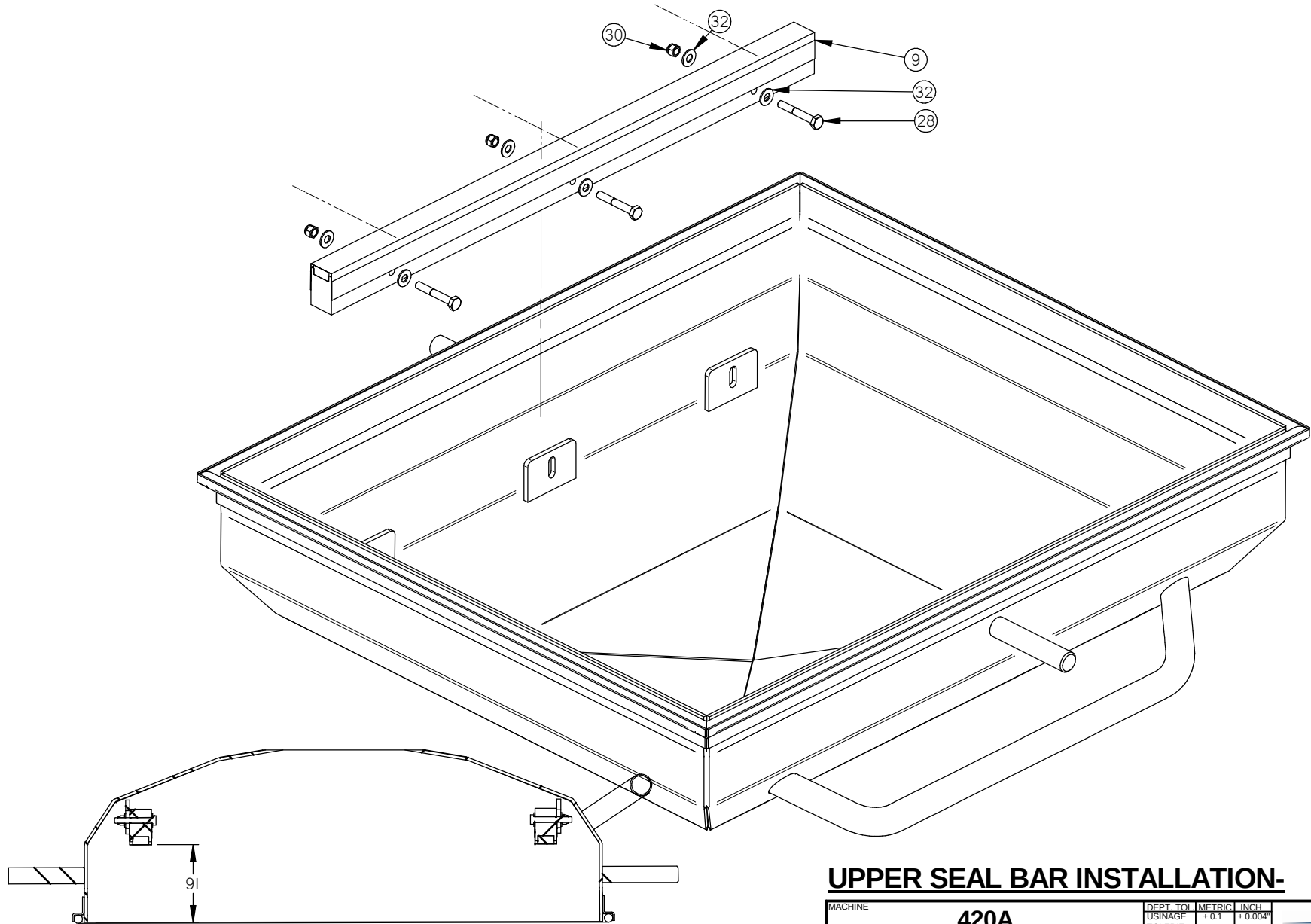
-PUMP + AIR REGULATOR INSTALLATION-

MACHINE		420A		DEPT. TOL.	METRIC	INCH			
PART		MACHINE ASSEMBLY		USINAGE	± 0.1	± 0.004"			
				TOLERIE	± 0.5	± 0.020"			
				SOUDAGE	± 0.5	± 0.020"			
						N.T.S.			
ITEM		CNC				DEPT.	M	QTY.	1
MAT.		DWG BY		SBU	DATE	14-02-07	NO.	005B0598	
		APP. BY			DATE				



-GAS BAR + BELLOWS VALVE INSTALLATION-

MACHINE		420A		DEPT. TOL.	METRIC	INCH	
PART		MACHINE ASSEMBLY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		SOUDEGE	± 0.5	± 0.020"	
		DWG BY SBU		DATE 14-02-07		NO.	005B0598
						DEPT.	
						M	1

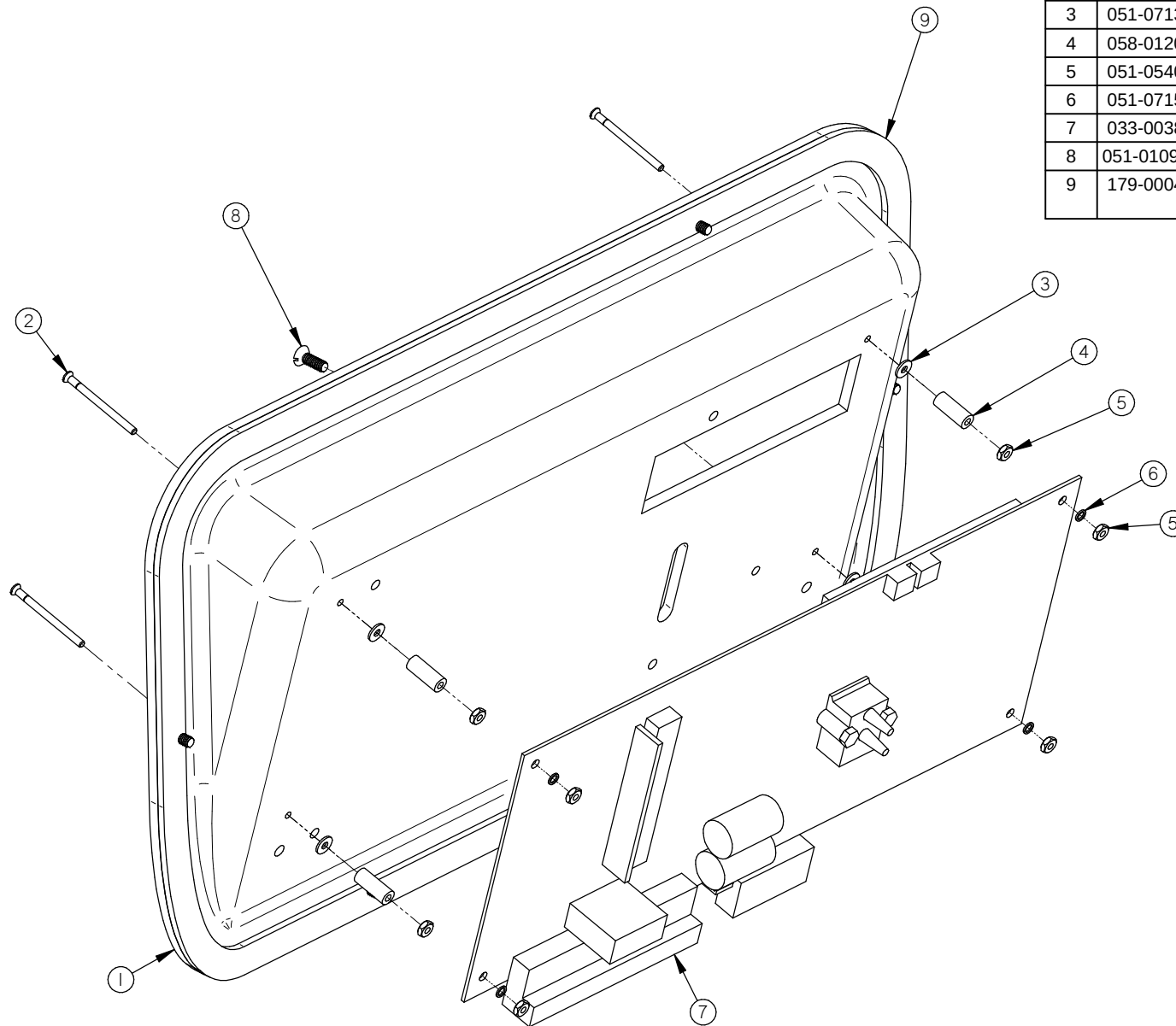


UPPER SEAL BAR INSTALLATION-

MACHINE		420A		DEPT. TOL.		METRIC		INCH			
PART		MACHINE ASSEMBLY		USINAGE		± 0.1		± 0.004"			
				TOLERIE		± 0.5		± 0.020"			
				SOUDEGE		± 0.5		± 0.020"			
								N.T.S.			
ITEM				CNC				DEPT.		M	
								QTY.		1	
MAT.				DWG BY		SBU		DATE		14-02-07	
				APP. BY				DATE			
								NO.		005B0598	

005B0583

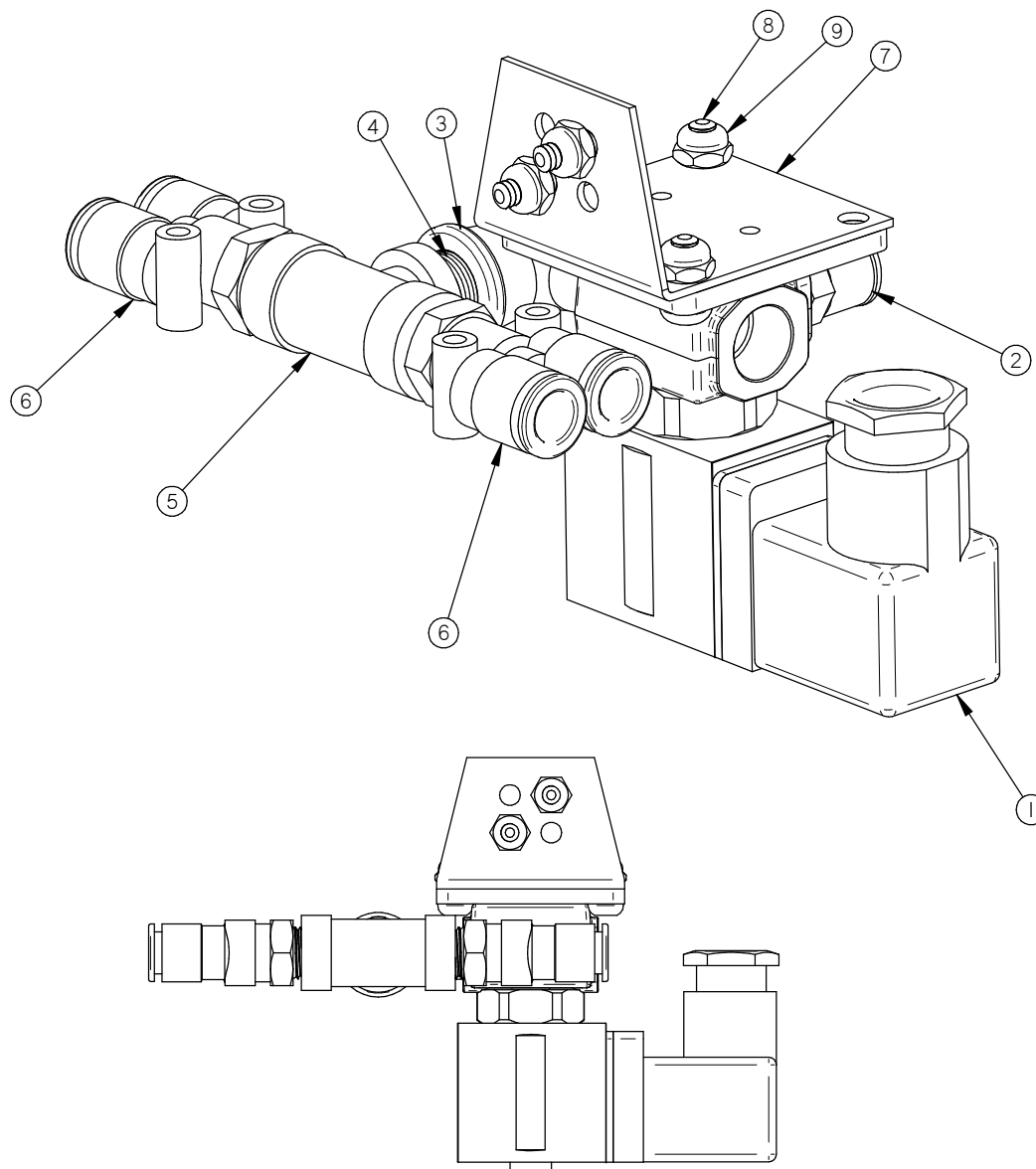
ITEM	PART #	DESCRIPTION	QT.
1	003A0403	CONTROL INSERT	1
2	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	4
3	051-0713	WASHER #4 FLAT S/S	4
4	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
5	051-0540	NUT #4-40 HEX S/S	8
6	051-0715	WASHER #4 LOCK SS	4
7	033-0038	MC-40 SENSOR VACUUM	1
8	051-01095	SCREW 8-32 x 1/2 FLAT SLOT SS	6
9	179-0004	NITRILE 1/2" X 1/8" AUTOCOLLANT X 1220mm long	1



MACHINE		VACUUM		DEPT. TOL	METRIC	INCH	
PART		MC-40 CONTROL BOARD		USINAGE	± 0.1	± 0.004"	
				TOLERIE	± 0.5	± 0.020"	
ITEM		CNC		SOUDEGE	± 0.5	± 0.020"	N.T.S.
MAT.		DWG BY SBU		DATE 13-11-21		DEPT. M QTY. 1	
		APP. BY		DATE		NO. 005B0583	

LET.	MODIFICATION	DATE	INT.
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004B4104



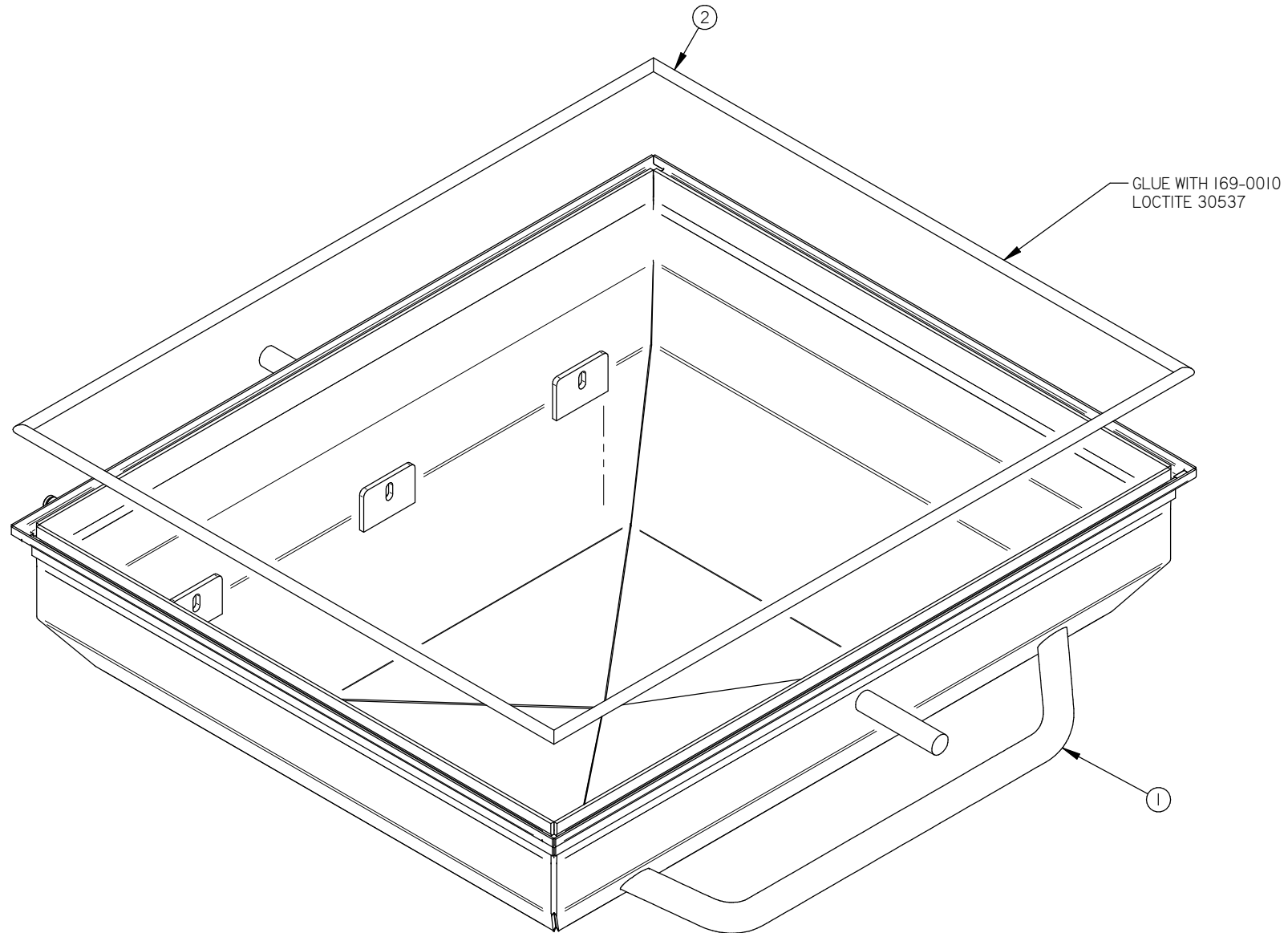
ITEM	PART #	DESCRIPTION	QT.
1	106-00701	VALVE 3WAY 24V 1/4"NPT	1
2	102-0410	MALE CONN.1/4"MNPTx3/8"T.QUICK	1
3	100-0065	STREET ELBOW 1/4" NPT SS	1
4	100-0225	CLOSE NIPPLE 1/4" NPT SS	1
5	100-0463	TEE 1/4" NPT S/S	1
6	102-0361	Y BRANCH 1/4" MNPT X 3/8" T. QUICK	2
7	001B6779	VALVE SUPPORT BRACKET	1
8	051-0144	SCREW #10-24 N.C 1/2"PAN PHIL. S/S	4
9	051-0572	NUT #10-24 NYLON LOCK S/S	4

A	VALVE UPDATE	14-05-27	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH		
PART		BELLOWS VALVE ASSY		USINAGE	± 0.1	± 0.004"		
ITEM		CNC		TOLERIE	± 0.5	± 0.020"		
MAT.		APP. BY		SOUDEAGE	± 0.5	± 0.020"	N.T.S.	
		DWG BY SBU		DATE 14-05-27		NO.		1
						DEPT. M		QTY. 1
								004B4104

005A0455

ITEM	PART #	DESCRIPTION	QT.
1	004A0238	COVER 8" WELDED ASSY	1
2	179-0020	NEOPRENE SPONGE 1/2" x 9'	1

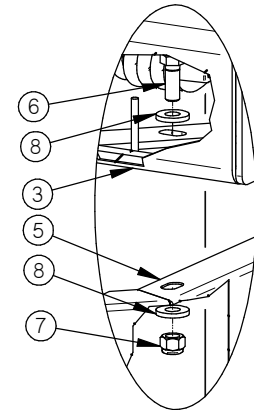
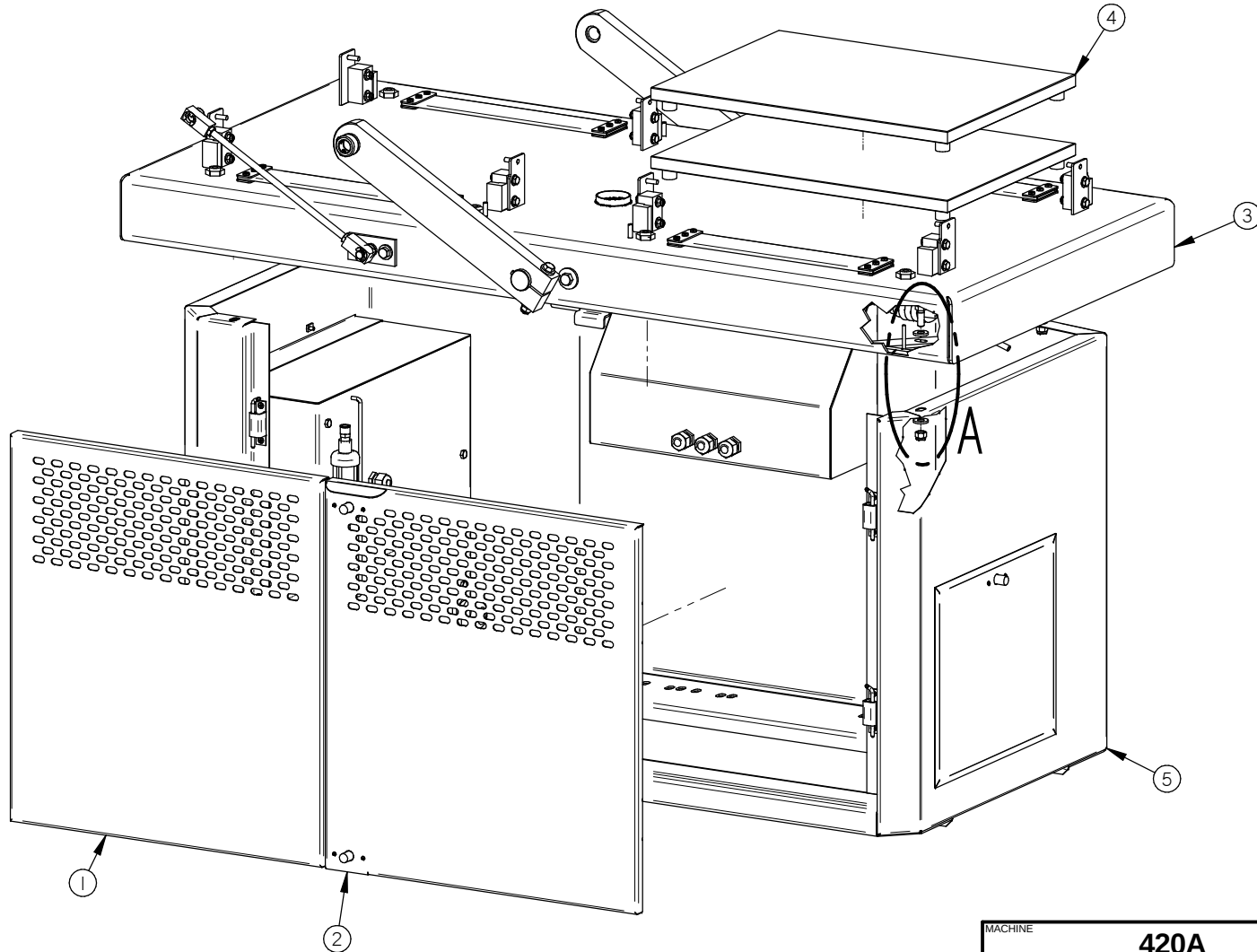


B	COVER WIDENED BY 54MM FOR 19" BAR	14-01-29	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE		420A		DEPT. TOL.	METRIC	INCH	
PART		COVER 8" ASSY		USINAGE	± 0.1	± 0.004"	
				TOLERIE	± 0.5	± 0.020"	
ITEM				SOUDEAGE	± 0.5	± 0.020"	N.T.S.
MAT.				CNC			DEPT. M
		DWG BY SBU		DATE 14-01-28			QTY. 1
		APP. BY		DATE			NO. 005A0455

004A4150

ITEM	PART #	DESCRIPTION	QT.
1	004A4116	LEFT REAR ACCESS DOOR PRE-ASSY	1
2	004A4118	RIGHT REAR ACCESS DOOR ASSY	1
3	004A4151	TABLE ASSY W/ARM	1
4	005A0333	FILLER PLATE	4
5	005D0599	STRUCTURE ASSY	1
6	051-0360	BOLT 3/8"-16nc. X 1" S/S	6
7	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	6
8	051-0783	WASHER 3/8" FLAT THICK S/S	12

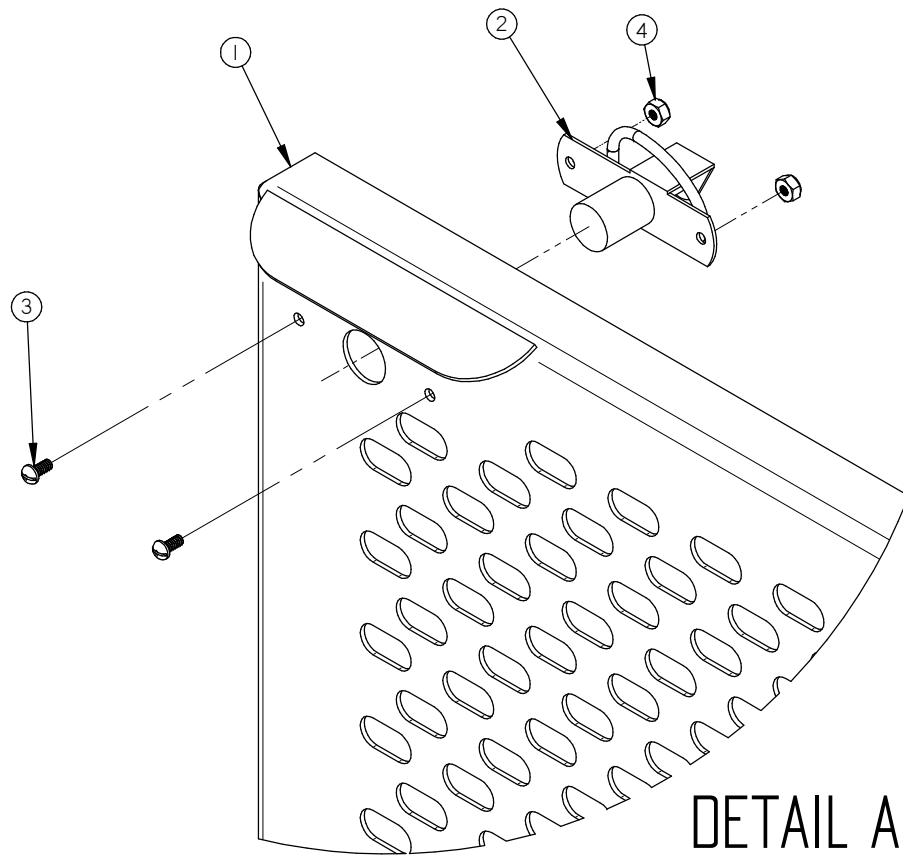
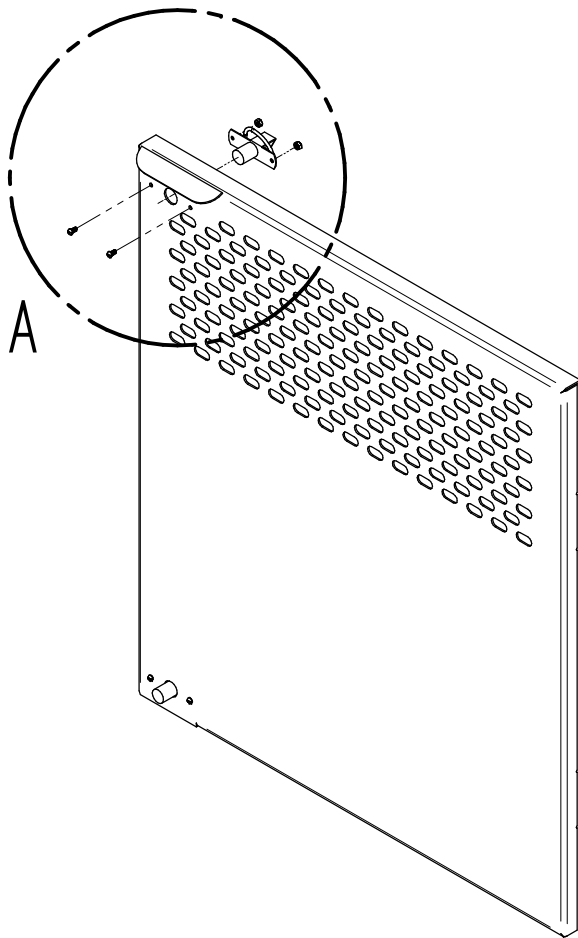


LET.	MODIFICATION	DATE	INT.

MACHINE		420A		DEPT. TOL.	METRIC	INCH		
PART		BASE MACHINE ASSEMBLY		USINAGE	± 0.1	± 0.004"		
ITEM		CNC		TOLERIE	± 0.5	± 0.020"		
MAT.		APP. BY		SOUDEAGE	± 0.5	± 0.020"		
DWG BY		SBU		DATE		14-02-07	DEPT.	M
DATE		DATE		NO.		004A4150	QTY.	1

004A4118

ITEM	PART #	DESCRIPTION	QT.
1	004A4117	RIGHT REAR ACCESS DOOR PRE-ASSY	1
2	056-2600	SPRING PAWL LATCHE SS KNOB	2
3	051-0071	SCREW 4-40 x 1/4" RND SLOT S/S	4
4	051-0541	NUT # 4-40 NYLON LOCK SS	4

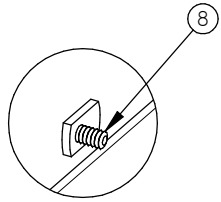


LET.	MODIFICATION	DATE	INT.
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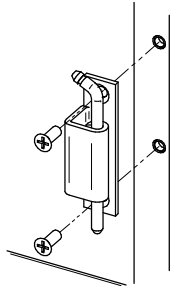
MACHINE		420A		DEPT. TOL.	METRIC	INCH		
PART		RIGHT REAR ACCESS DOOR ASSY		USINAGE	± 0.1	± 0.004"		
ITEM		CNC		TOLERIE	± 0.5	± 0.020"		
MAT.		APP. BY		SOUDEGE	± 0.5	± 0.020"	N.T.S.	
		DWG BY SBU		DATE 14-02-06		NO.		1
						DEPT. M		1
								004A4118

005D0599

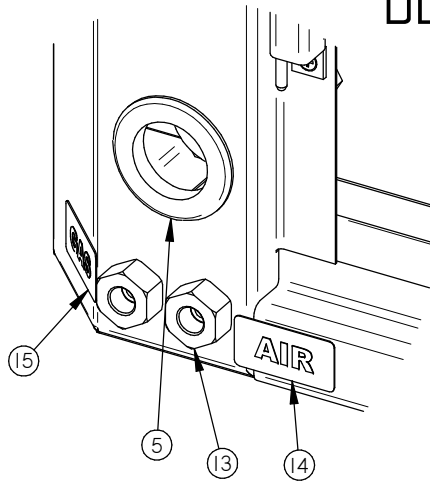
ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
11	056-3010-1	HINGE CONCEALED SS304 - BASE	4	1	004A4090	ACCESS DOOR ASSEMBLY	1
12	056-3010-3	HINGE CONCEALED SS304 - PIN	4	2	004A4098	ELECTRIC BOX ASS'Y	1
13	102-0551	BULKHEAD 1/4"NPT X 3/8 TUBE QUICK	2	3	004A4138	VACUUM SENSOR FILTER	1
14	127-0040	STICKER "AIR" BLUE/WHITE 1" X 2"	1	4	004D0437	STRUCTURE WELD ASSY	1
15	127-0041	STICKER "GAS" YELLOW/BLACK 1" X 2"	1	5	036-0265	GROMMET 1-1/2" ID X 2-3/8" OD RUBBER	1
				6	036-0409	PRESSE-ETOUPE CD13	3
				7	051-01385	SCREW 10-24 x 1/2"FLAT-UND. PHIL S/S	8
				8	051-0144	SCREW #10-24 N.C 1/2"PAN PHIL. S/S	8
				9	051-0180	BOLT. HEX. 1/4"-20 NC. x 1/2" S/S	2
				10	051-0740	WASHER 1/4" FLAT S/S	2



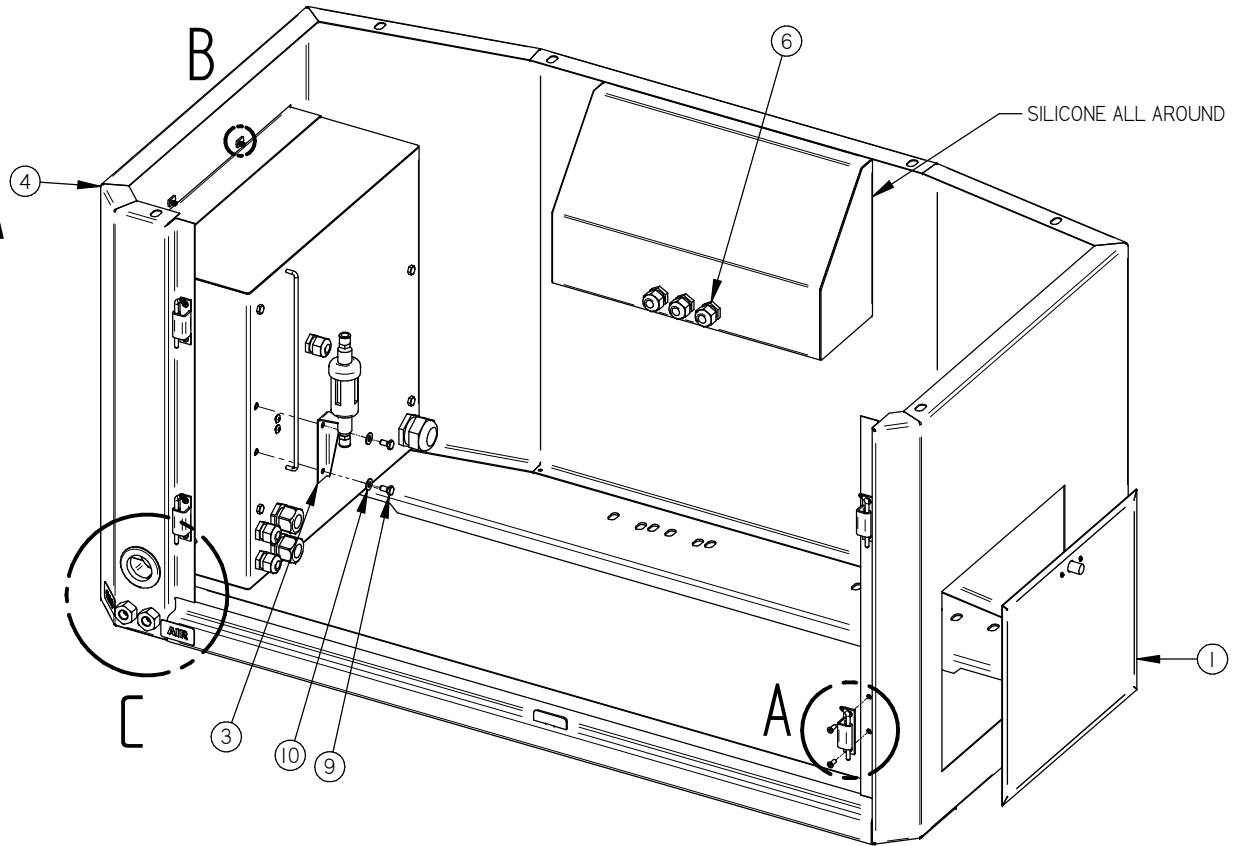
DETAIL B



DETAIL A



DETAIL C

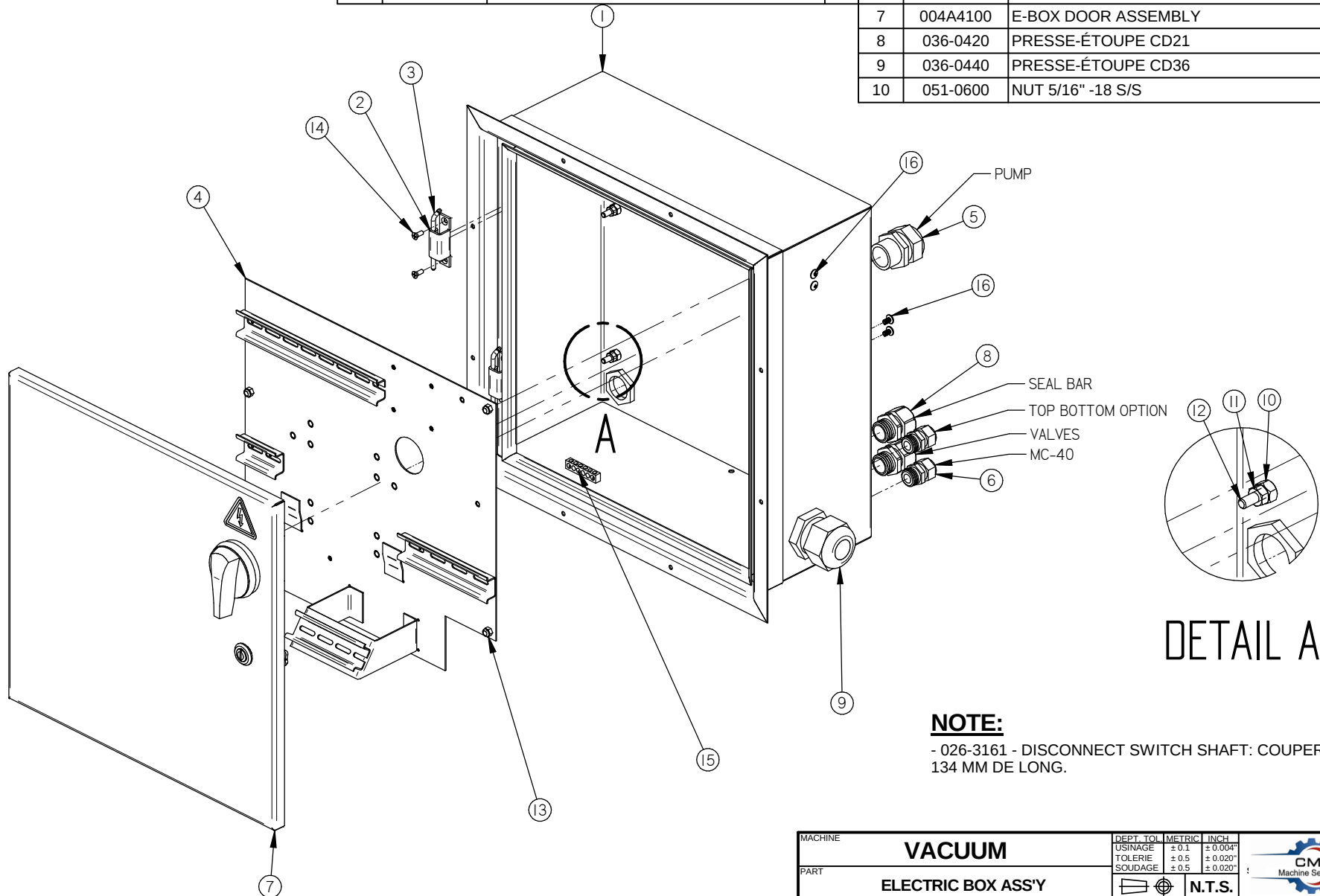


MACHINE		420A		DEPT. TOL.	METRIC	INCH	
PART		STRUCTURE ASSY		USINAGE	± 0.1	± 0.004"	
				TOLERIE	± 0.5	± 0.020"	
ITEM	CNC			SOUDEGE	± 0.5	± 0.020"	N.T.S.
MAT.	DWG BY	SBU		DATE	14-02-06		DEPT. M
	APP. BY			DATE			QTY. 1
							NO. 005D0599

A	NEW DESIGN	14-02-06	SBU
LET.	MODIFICATION	DATE	INT.

004A4098

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
11	051-0580	NUT 1/4"-20 S/S	4	1	004A4099	E-BOX PRE-ASSY	1
12	051-0210	BOLT 1/4"-20nc. X 1" S/S	4	2	056-3010-1	HINGE CONCEALED SS304 - BASE	2
13	051-0581	NUT 1/4"-20 NYLON LOCK S/S	4	3	056-3010-3	HINGE CONCEALED SS304 - PIN	2
14	051-0139	SCREW 10-24 x 1/2" FLAT PHIL S/S	4	4	004A4102	E-BOX FALSE BOTTOM	1
15	028-0105	GROUND BARRIER (6 HOLES)	1	5	036-0430	PRESSE-ÉTOUPE CD29	1
16	051-0128	SCREW 10-24 x 3/8" TRUSS PHIL S/S	4	6	036-0409	PRESSE-ÉTOUPE CD13	3
				7	004A4100	E-BOX DOOR ASSEMBLY	1
				8	036-0420	PRESSE-ÉTOUPE CD21	2
				9	036-0440	PRESSE-ÉTOUPE CD36	1
				10	051-0600	NUT 5/16" -18 S/S	4



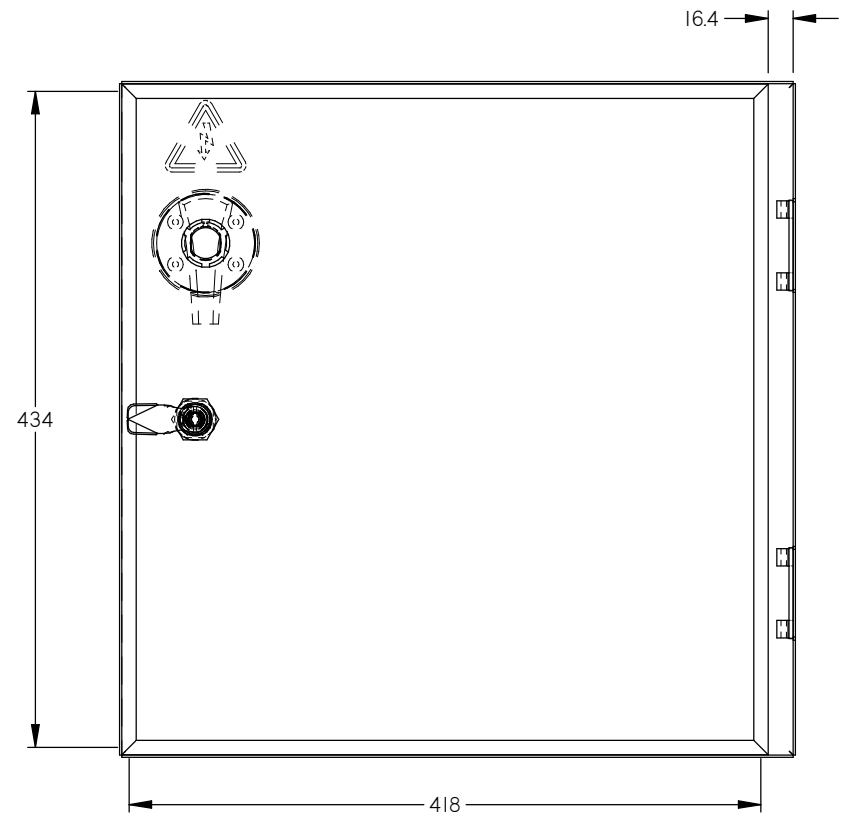
NOTE:

- 026-3161 - DISCONNECT SWITCH SHAFT: COUPER À 134 MM DE LONG.

MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	
PART		ELECTRIC BOX ASS'Y		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		SOUDEAGE	± 0.5	± 0.020"	
DWG BY		SBU		DATE	13-09-23		004A4098
DEPT.		M		QTY.	1		
NO.		DATE					

LET.	MODIFICATION	DATE	INT.
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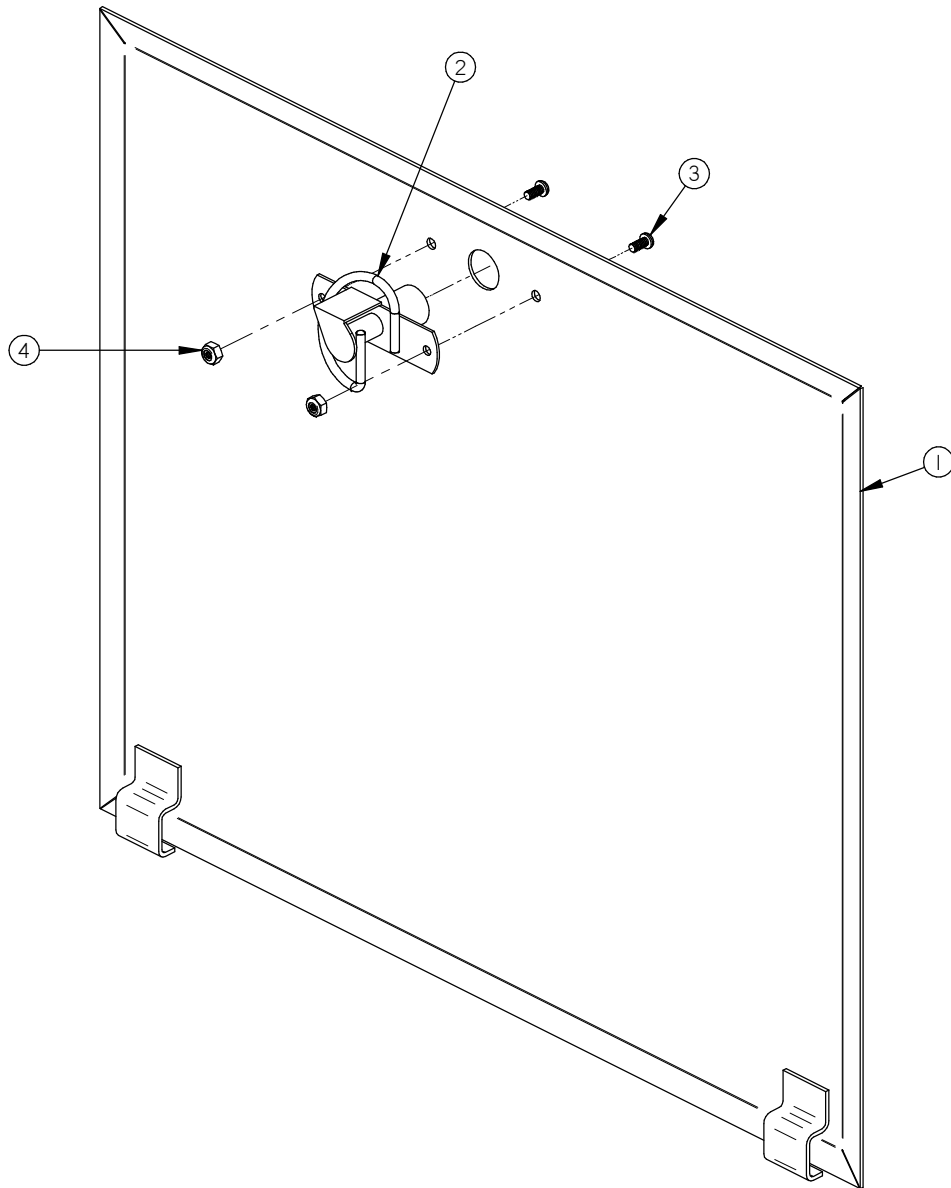
ITEM	PART #	DESCRIPTION	QT.
1	004A4101	E-BOX DOOR PRE-ASSY	1
2	056-2612	CAM LOCK QUARTER TURN SS304	1
3	179-0026	D-SHAPED RUBBER SEAL 1683mm LONG	1
4	026-3160	HANDLE RED/YELLOW NEMA 4X, COMPACT, PADLOCKABLE	1
5	127-0100	STICKER ELEC.HAZARD ISO 2-1/2" TRIANGLE	1



MACHINE		VACUUM DEPT. TOL. METRIC INCH USINAGE ± 0.1 ± 0.004 TOLERIE ± 0.5 ± 0.020 SOUDAGE ± 0.5 ± 0.020						
PART		E-BOX DOOR ASSEMBLY  N.T.S.						
ITEM				CNC	DEPT.	M	QTY.	1
MAT.				DWG BY	DATE	NO.		
				APP. BY	DATE	004A4100		

004A4090

ITEM	PART #	DESCRIPTION	QT.
1	004A4089	ACCESS PANEL PRE-ASSY	1
2	056-2600	SPRING PAWL LATCHE SS KNOB	1
3	051-0071	SCREW 4-40 x 1/4" RND SLOT S/S	2
4	051-0541	NUT # 4-40 NYLON LOCK SS	2

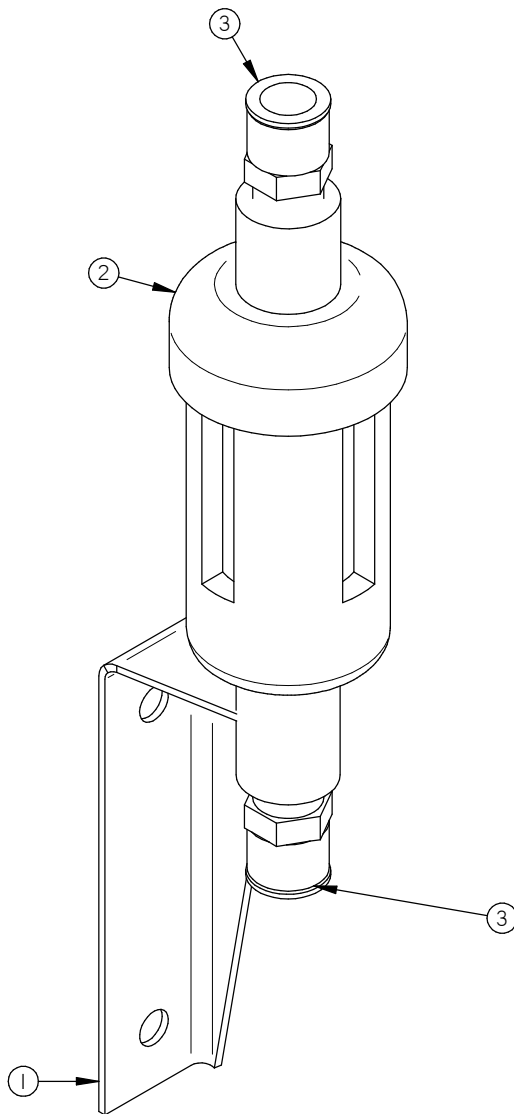


MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	
PART		ACCESS DOOR ASSEMBLY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		DATE	13-09-11	NO.	1
LET.		MODIFICATION		DATE		INT.	

004A4090

004A4138

ITEM	PART #	DESCRIPTION	QT.
1	004A4139	VACUUM SENSOR FILTER SUPPORT	1
2	114-2020	FILTER / DRYER ¼"mnpt. X 1¼"t.p. COMP.	1
3	102-0410	MALE CONN.1/4"MNPTx3/8"T.QUICK	2

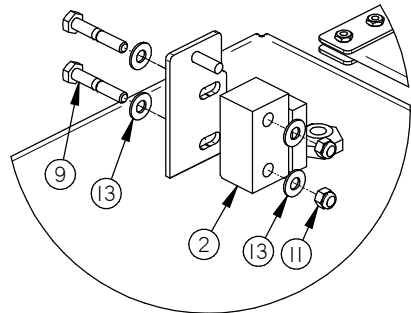


MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	
PART		VACUUM SENSOR FILTER		USINAGE	± 0.1	± 0.004"	
				TOLERIE	± 0.5	± 0.020"	
ITEM				SOUDEGE	± 0.5	± 0.020"	N.T.S.
MAT.							
DWG BY		SBU		DATE		13-11-19	DEPT. M
APP. BY				DATE			QTY. 1
							004A4138

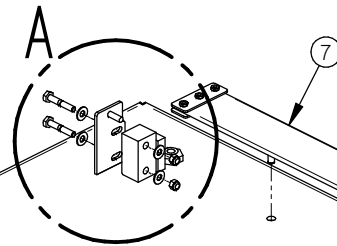
LET.	MODIFICATION	DATE	INT.
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004A4151

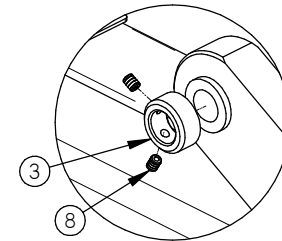
ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
11	051-0581	NUT 1/4"-20 NYLON LOCK S/S	16	1	002-0326	LEFT SEAL BAR GUIDE BLOCK	4
12	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	2	2	002-0327	RIGHT SEAL BAR GUIDE BLOCK	4
13	051-0740	WASHER 1/4" FLAT S/S	32	3	002-0390	COVER ARM COLLAR	2
14	051-0783	WASHER 3/8" FLAT THICK S/S	4	4	004A0348	COVER ARM ASS'Y	2
15	056-01675	KEY 1/4" SQ. x 1 1/4" ROUNDED END S/S	2	5	004B0124	TABLE ASSEMBLY	1
16	056-0331	EXT. RETAINING RING 1/2" S/S	2	6	004B1393	GUIDE ARM PRE-ASS'Y	1
17	058-0050	NYLON SPACER 1/2IDx3/4ODx1/16"	2	7	005-0532	BELLOWS ASSEMBLY	4
18	058-0060	NYLON SPACER 1/2IDx3/4ODx1/4"	2	8	051-0178	SCREW 1/4"-20 x 5/16" SKT SET S/S	4
				9	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	16
				10	051-0422	BOLT 3/8"-16nc. X 3/4" S/S	2



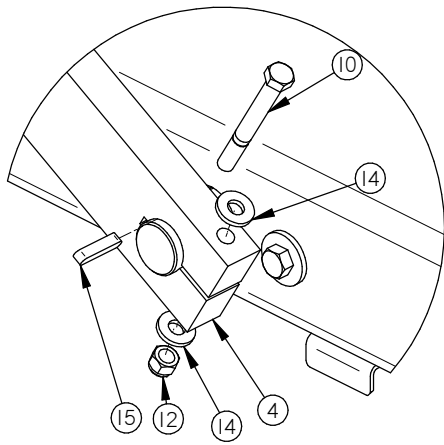
DETAIL A



DETAIL B



DETAIL C

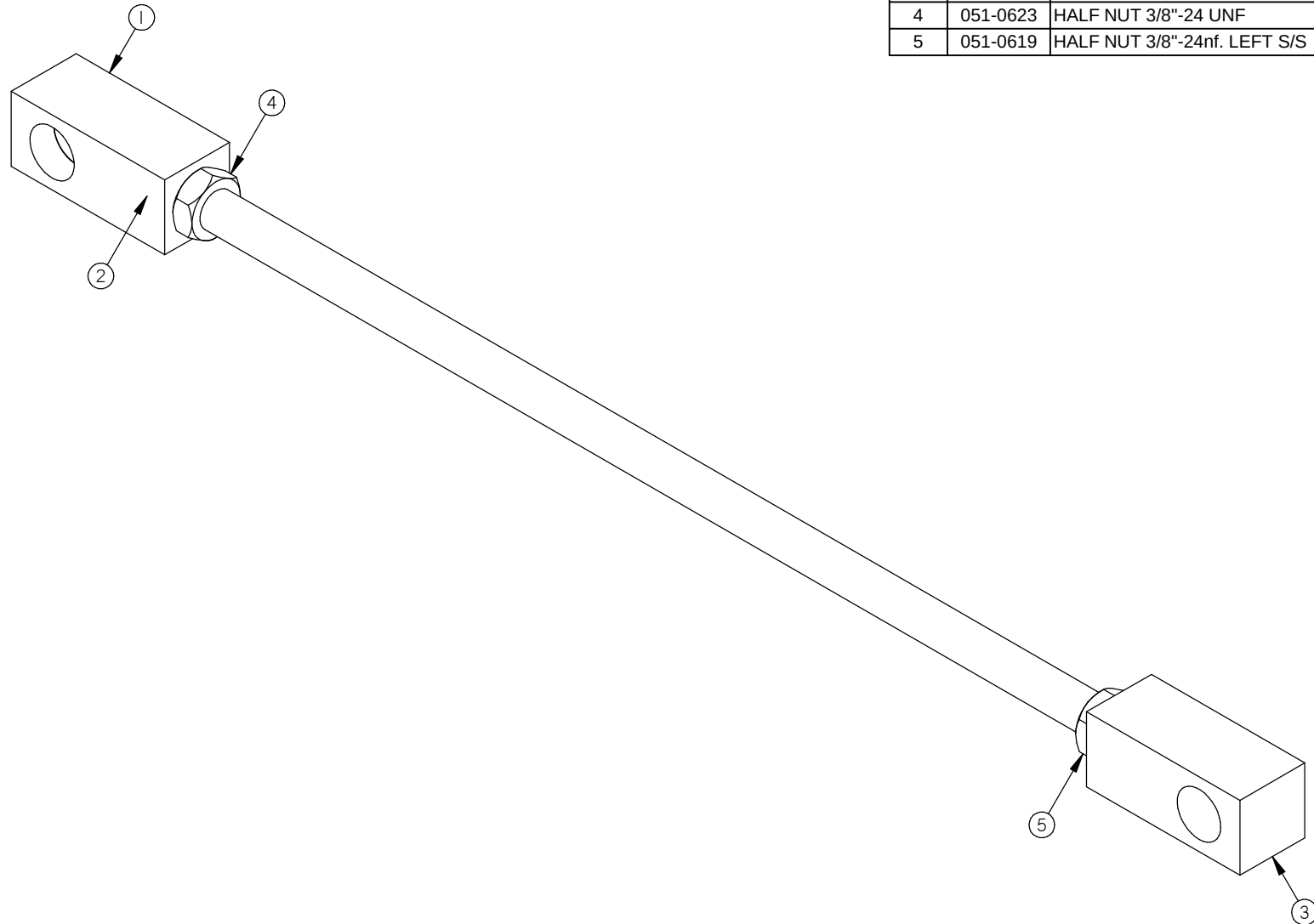


DETAIL D

MACHINE		420A		DEPT. TOL.	METRIC	INCH	
PART		TABLE ASSY W/ARM		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		DATE	14-01-31	NO.	004A4151
LET.		MODIFICATION		DATE		INT.	

004B1393

ITEM	PART #	DESCRIPTION	QT.
1	002-0679	RIGHT GUIDED ARM END	1
2	002A0680	GUIDE ARM ROD	1
3	002-0731	LEFT GUIDED ARM END	1
4	051-0623	HALF NUT 3/8"-24 UNF	1
5	051-0619	HALF NUT 3/8"-24nf. LEFT S/S	1



NOTE:

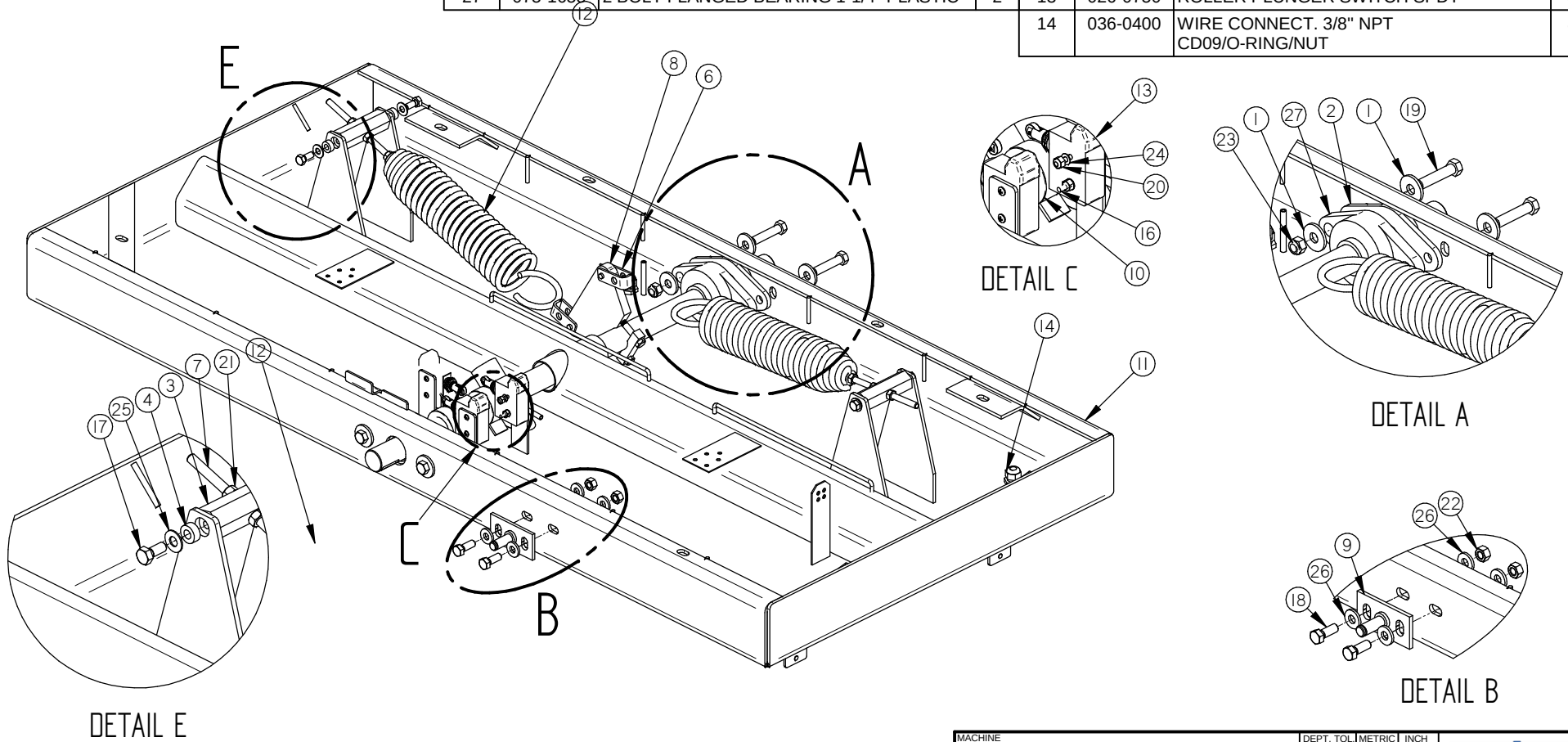
-PASSER AU JET DE SABLE APRÈS AVOIR ASSEMBÉ LES 5 ITEMS.

B	008A0680 WAS 008-0680	14-01-31	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE 420A		DEPT. TOL. METRIC USINAGE ± 0.1 TOLERIE ± 0.5 SOUDAGE ± 0.5	INCH ± 0.004" ± 0.020" ± 0.020"	
PART GUIDE ARM PRE-ASS'Y		N.T.S.		
ITEM	CNC	DEPT.	U-J-(M)	
MAT.	DWG BY SBU	DATE 14-01-31	NO. 004B1393	
	APP. BY	DATE		

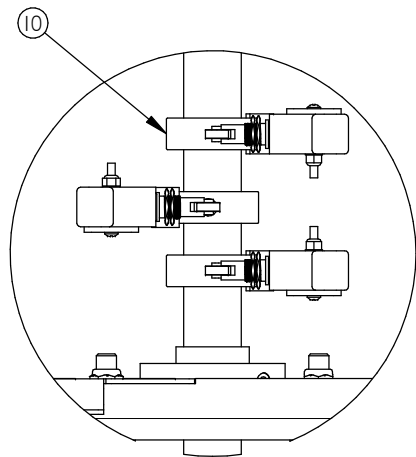
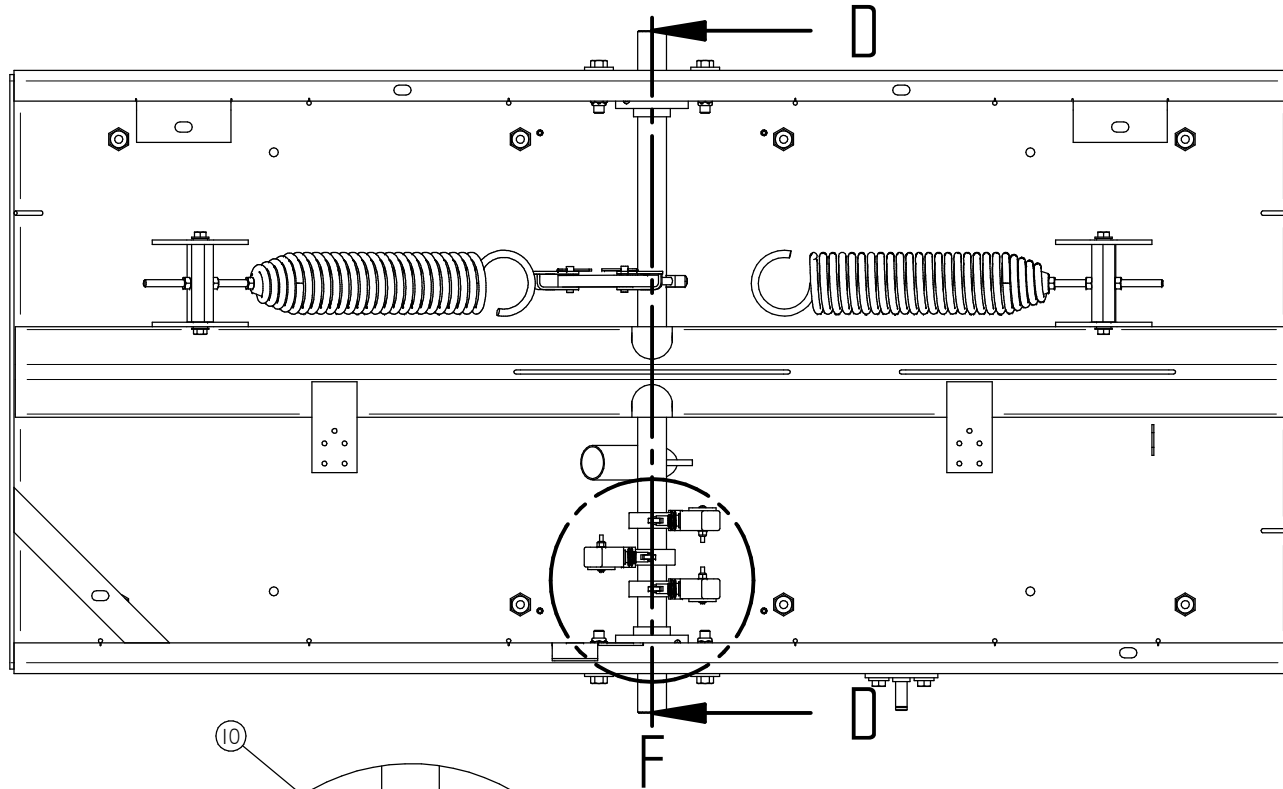
004B0124

ITEM	PART #	DESCRIPTION	QT.	ITEM	PART #	DESCRIPTION	QT.
15	036-0400	WIRE CONNECTOR 3/8" NPT NUT	8	1	001A2954	WASHER 0.468"Ø ID x 1.250"OD x 3.5	8
16	051-0142	SCREW 8-32 x1-1/2"RND PHIL S/S	6	2	001A6546	BEARING SPACER	2
17	051-0300	BOLT 5/16"-18 x 3/4" S/S	4	3	002A3941	SPRING ADJ. PIVOT	2
18	051-0360	BOLT 3/8"-16nc. X 1" S/S	2	4	002A4002	SPRING ADJ. PIVOT SPACER	4
19	051-04285	BOLT 7/16-14 x 2" HEX S/S	4	5	002B0324	CENTRAL SHAFT	1
20	051-0560	NUT #8-32 NYLON LOCK S/S	6	6	004A3937	SHACKLE ASS'Y	2
21	051-0600	NUT 5/16" -18 S/S	4	7	004A3968	SPRING INSERT ASSEMBLY	2
22	051-0620	NUT 3/8"-16 NC S/S	2	8	004A4087	SPRING BLOCK PRE-ASSY	1
23	051-0624	NUT 7/16"-14 NYLON LOCK S/S	4	9	005-0317	GUIDE ARM AXIS ASS'Y	1
24	051-0720	WASHER #8 FLAT S/S	6	10	005A1437	MICRO SWITCH COLLAR ASSY	3
25	051-0760	WASHER 5/16" FLAT S/S	4	11	005B0327	TABLE ASSEMBLY	1
26	051-0783	WASHER 3/8" FLAT THICK S/S	4	12	008A1953	SPRING	2
27	075-1655	2 BOLT FLANGED BEARING 1-1/4" PLASTIC	2	13	026-0750	ROLLER PLUNGER SWITCH SPDT	3
				14	036-0400	WIRE CONNECT. 3/8" NPT CD09/O-RING/NUT	8

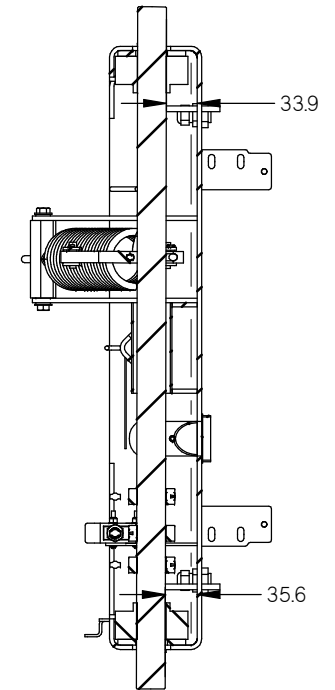


F	EXTENSION SPRING DESIGN	14-01-31	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE		420A		DEPT. TOL.	METRIC	INCH	CM Machine Services
PART		TABLE ASSEMBLY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		SOUDEAGE	± 0.5	± 0.020"	
		DWG BY SBU		DATE	13-12-18	NO.	004B0124
				DATE			
				DEPT.	M	QTY.	1



DETAIL F

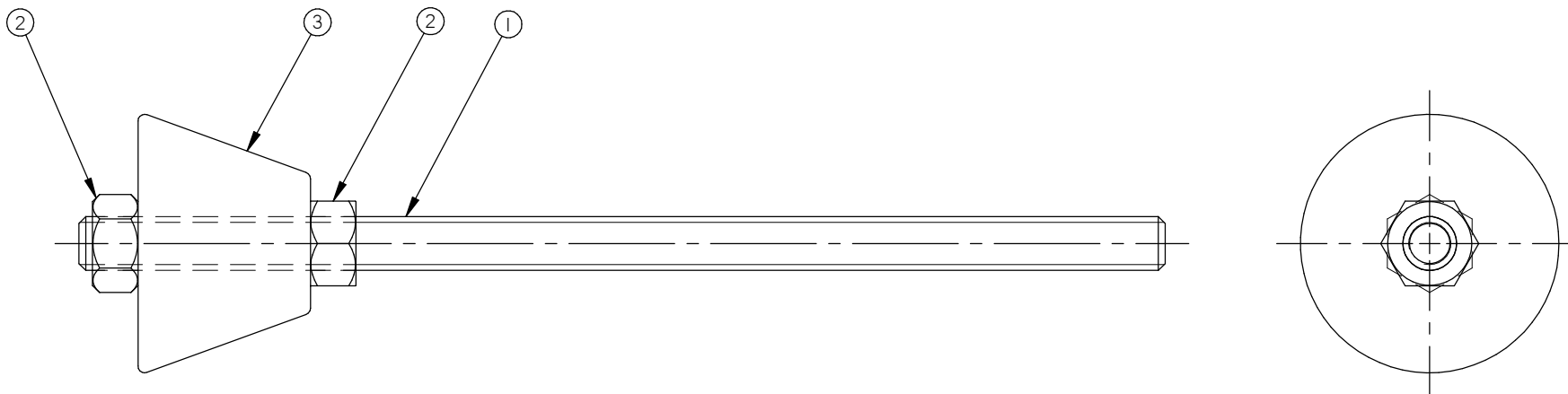


SECTION D-D

MACHINE		420A		DEPT. TOL.		METRIC		INCH			
PART		TABLE ASSEMBLY		USINAGE		± 0.1		± 0.004"			
				TOLERIE		± 0.5		± 0.020"			
				SOUDAGE		± 0.5		± 0.020"			
								N.T.S.			
ITEM				CNC				DEPT.		M	
MAT.				DWG BY SBU				DATE 13-12-18		QTY. 1	
				APP. BY				DATE		NO. 004B0124	

004A3968

ITEM	PART #	DESCRIPTION	QT.
1	002A3989	SPRING ADJUSTMENT ROD	1
2	051-0600	NUT 5/16" -18 S/S	2
3	002B3940	SPRING INSERT	1



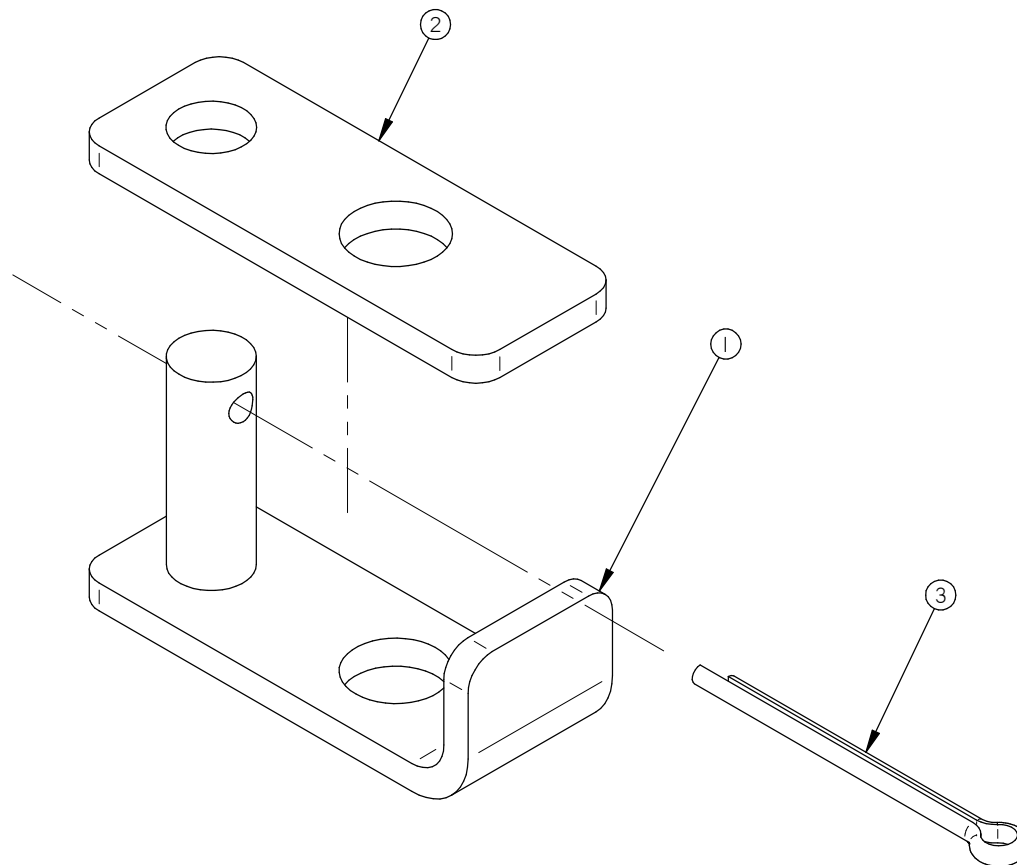
620A	4
600A	4
MACHINE	QTY

MACHINE		600A & 620A		DEPT. TOL.	METRIC	INCH	
PART		SPRING INSERT ASSEMBLY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		DWG BY J.G.		DATE	13-01-15		NO.
		APP. BY		DATE			004A3968

A	AJOUTER 620A	13-01-23	J.G.
LET.	MODIFICATION	DATE	INT.

004A3937

ITEM	PART #	DESCRIPTION	QT.
1	004A3935	SHACKLE PRE-ASS'Y	1
2	001A6269	SHACKLE PLATE	1
3	056-0118	COTTER PIN 3/32" x 1" S/S	1

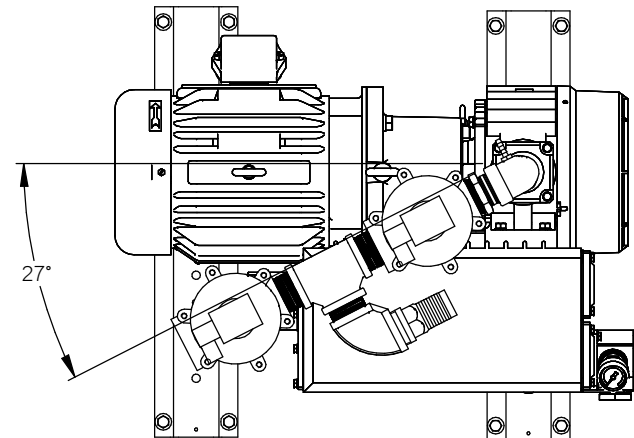
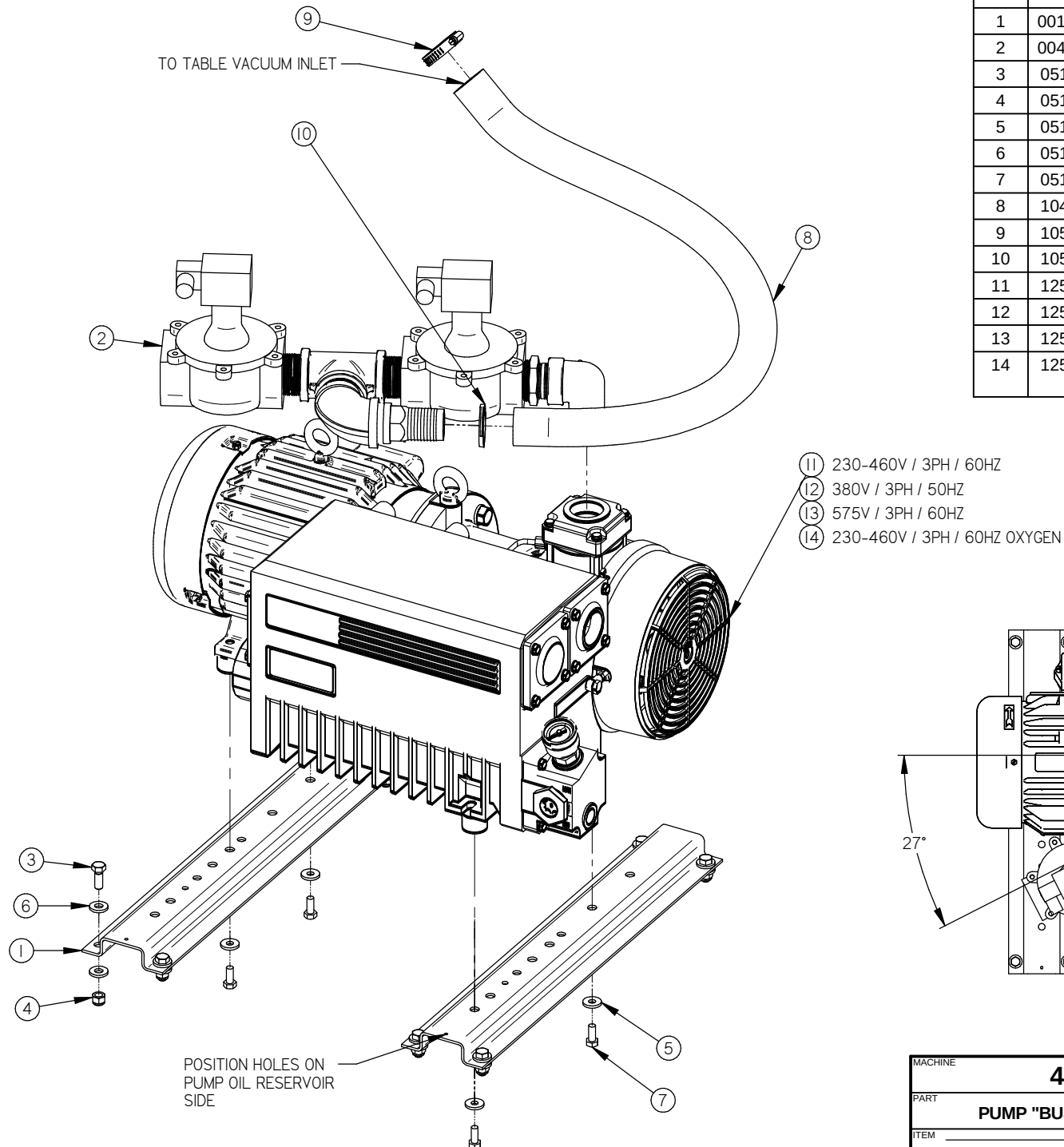


LET.	MODIFICATION	DATE	INT.
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MACHINE		600A		4
PART		MACHINE		QTY
ITEM		SHACKLE ASS'Y		
MAT.		N.T.S.		
DWG BY J.G.		DATE 12-11-06		NO. 004A3937
APP. BY		DATE		
DEPT. TOL		METRIC		INCH
USINAGE		± 0.1		± 0.004"
TOLERIE		± 0.5		± 0.020"
SOUDAGE		± 0.5		± 0.020"
MACHINE		CM		Machine Services
M-(M)		QTY		LISTE

004A4120

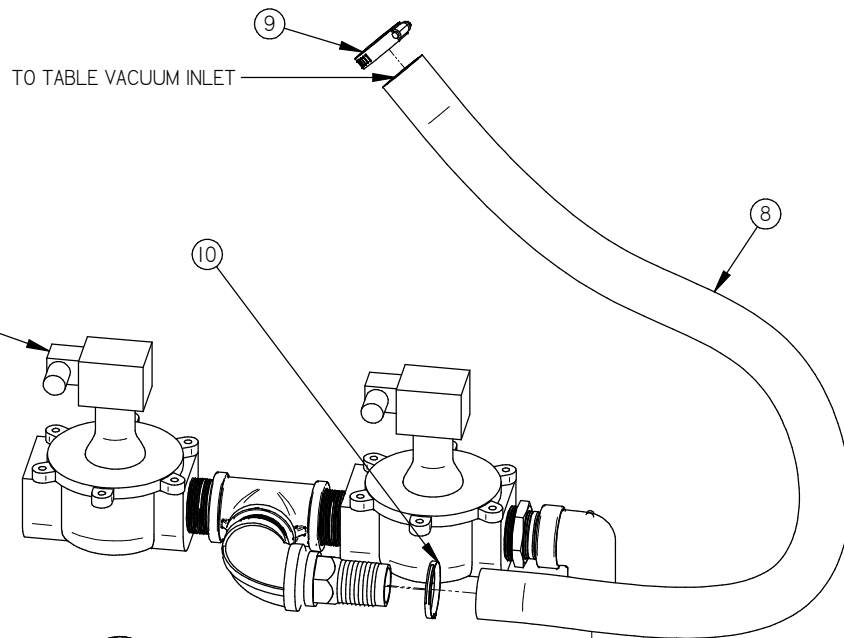
ITEM	PART #	DESCRIPTION	QT.
1	001A6589	PUMP SUPPORT	2
2	004B1404	VACUUM / ATMOSPHERE VALVE ASSY.	1
3	051-0360	BOLT 3/8"-16nc. X 1" S/S	8
4	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	8
5	051-0762	WASHER 5/16" THICK FLAT S/S	4
6	051-0783	WASHER 3/8" FLAT THICK S/S	16
7	051-0980	BOLT M8 x 20 S/S	4
8	104-0125	HOSE 1-1/2" ID VACUUM POLYWIRE (3')	1
9	105-0110	SCREW CLAMPS 1-1/16" TO 2" ALL S/S	1
10	105-0250	EAR CLAMP 1-1/2" S/S	1
11	125-0040	BUSCH RA-0063 230-460V/3PH/60HZ	1
12	125-0041	BUSCH RA0063 380V/3PH/50HZ	1
13	125-0042	BUSCH RA0063 575V/3PH/60HZ	1
14	125-0045	BUSCH RA0063 230-460V/3PH/60HZ OXYGENE	1



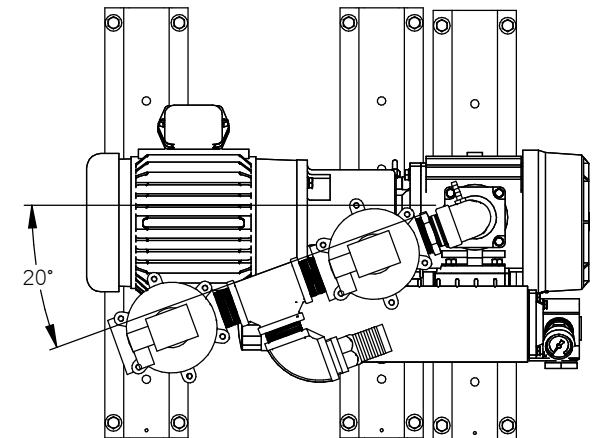
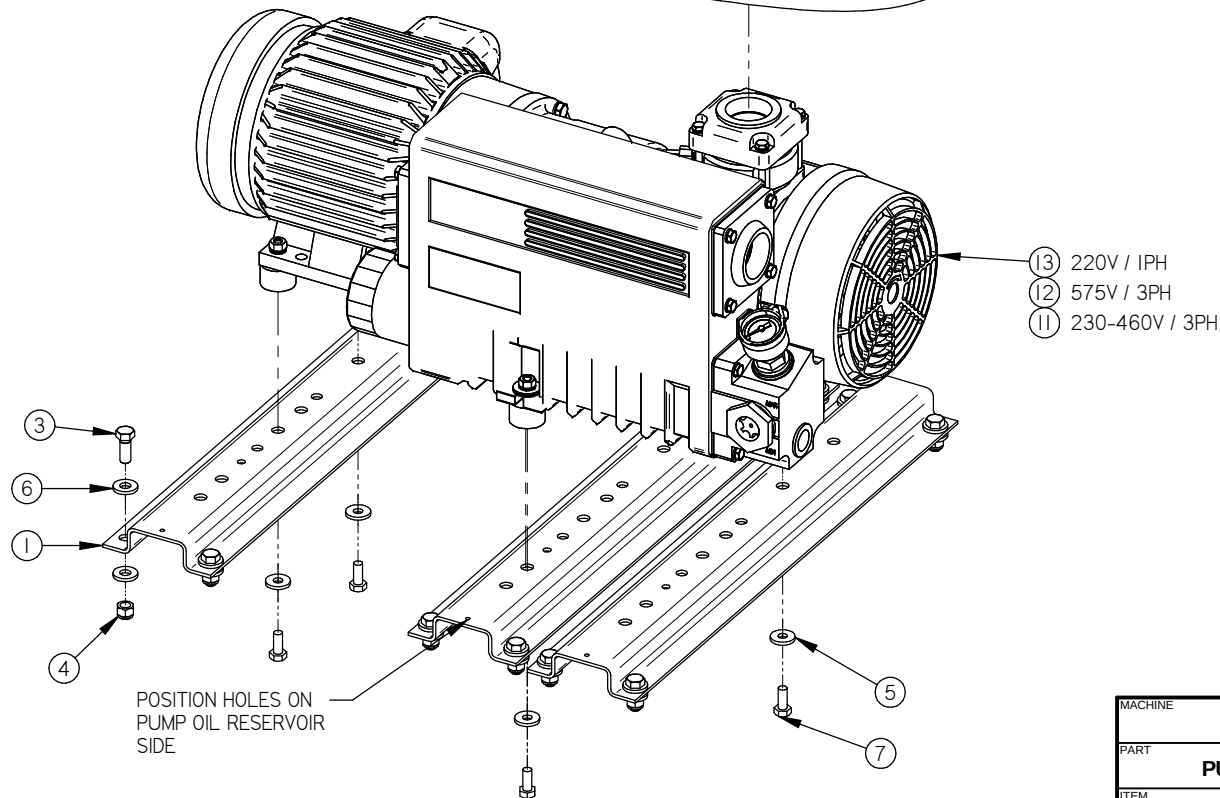
MACHINE		420A		DEPT. TOL.	METRIC	INCH	
PART		PUMP "BUSCH" 63M³ ASSY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		SBU		SOUDEGE	± 0.5	± 0.020"	
DATE		14-01-28		N.T.S.		DEPT.	M
APP. BY		DATE		NO.		QTY.	1
						004A4120	

LET.	MODIFICATION	DATE	INT.
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004A4119



ITEM	PART #	DESCRIPTION	QT.
1	001A6589	PUMP SUPPORT	3
2	004B1404	VACUUM / ATMOSPHERE VALVE ASSY.	1
3	051-0360	BOLT 3/8"-16nc. X 1" S/S	12
4	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	12
5	051-0762	WASHER 5/16" THICK FLAT S/S	4
6	051-0783	WASHER 3/8" FLAT THICK S/S	24
7	051-0980	BOLT M8 x 20 S/S	4
8	104-0125	HOSE 1-1/2" ID VACUUM POLYWIRE	1
9	105-0110	SCREW CLAMPS 1-1/16" TO 2" ALL S/S	1
10	105-0250	EAR CLAMP 1-1/2" S/S	1
11	125-0030	BUSCH RA-0040 230-460V/3PH/60HZ	1
12	125-0032	BUSCH RA-0040 575V/3PH/60Hz	1
13	125-0034	BUSCH RA0040 220V/1PH/60Hz	1

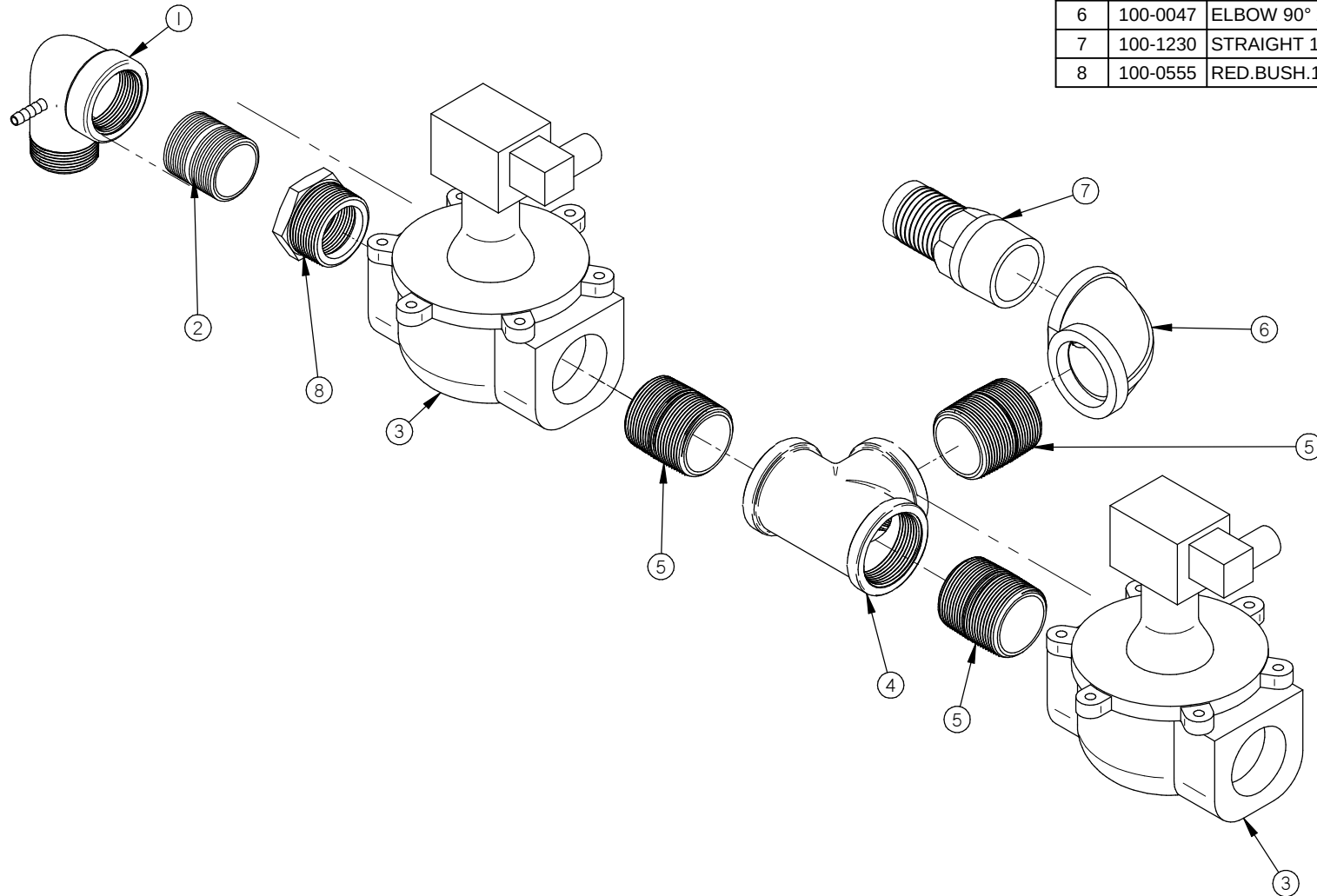


LET.	MODIFICATION	DATE	INT.
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MACHINE		420A		DEPT. TOL.	METRIC	INCH	
PART		PUMP "BUSCH" 40M³ ASSY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		SOUDEGE	± 0.5	± 0.020"	
DWG BY		SBU		DATE		14-01-27	004A4119
APP. BY		DATE		DEPT.		M	
						QTY.	1

004B1404

ITEM	PART #	DESCRIPTION	QT.
1	004A4081	BELLOWS ELBOW CONNECTOR ASSY	1
2	100-0245	CLOSE NIPPLE 1¼"npt. S/S	1
3	106-0051	VALVE 2WAY 24V 1-1/2"NPT60Hz	2
4	100-0485	TEE 1-1/2" NPT S/S	1
5	100-0440	NIPPLE 1-1/2" NPT X 2" SS	3
6	100-0047	ELBOW 90° X 1-1/2" NPT S/S	1
7	100-1230	STRAIGHT 1-1/2"MNPT x1-1/2" HOSE BARB	1
8	100-0555	RED.BUSH.1-1/2" x 1-1/4" NPT S/S	1

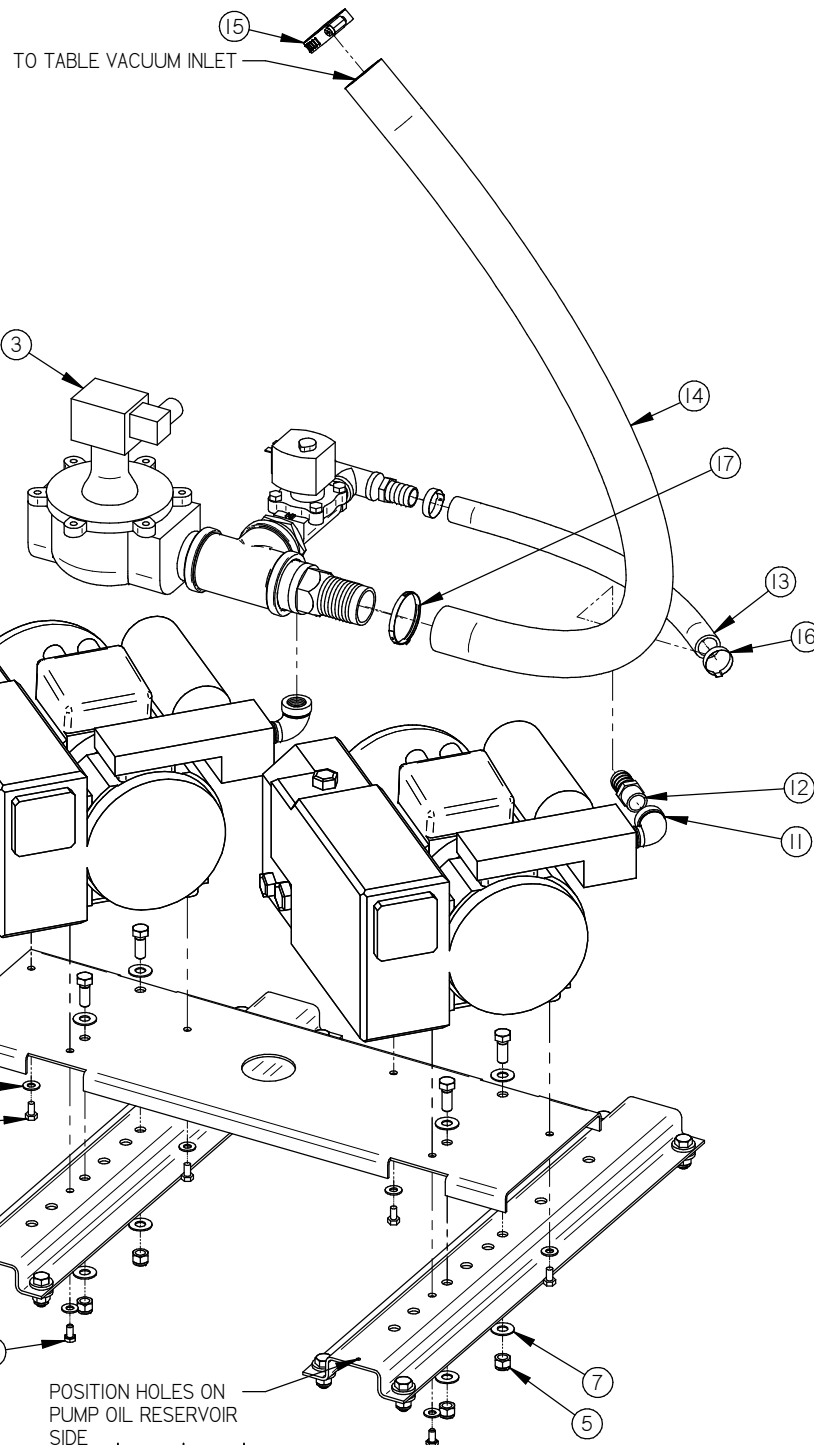


-OPTION - 40M³, 63M³ & 100M³ PUMP

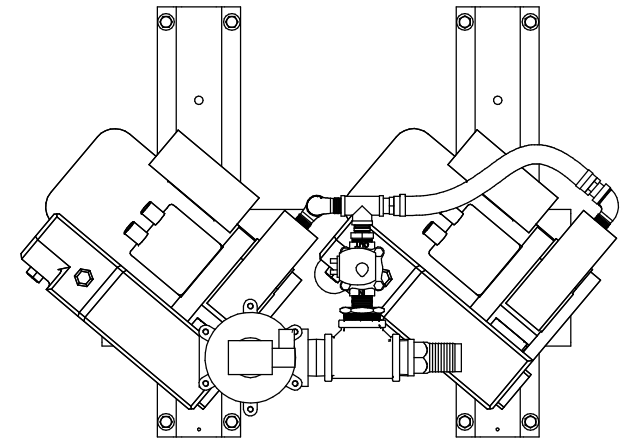
MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	
PART		VACUUM / ATMOSPHERE VALVE ASSY.		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		SOUDEAGE	± 0.5	± 0.020"	N.T.S.
DATE		13-09-19		DEPT.		M-I	QTY. 1
NO.		004B1404					

LET.	MODIFICATION	DATE	INT.
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004A4121



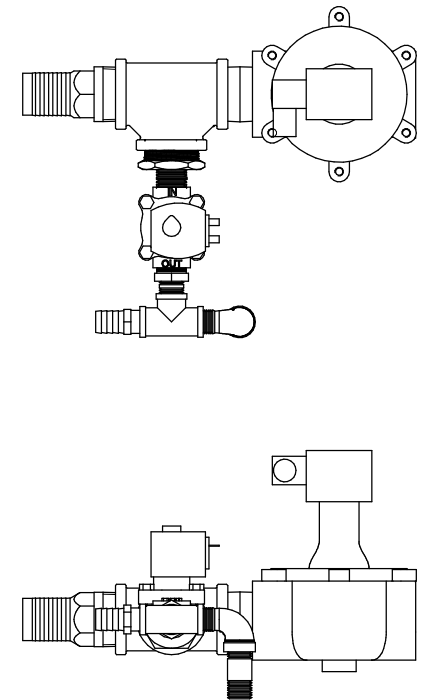
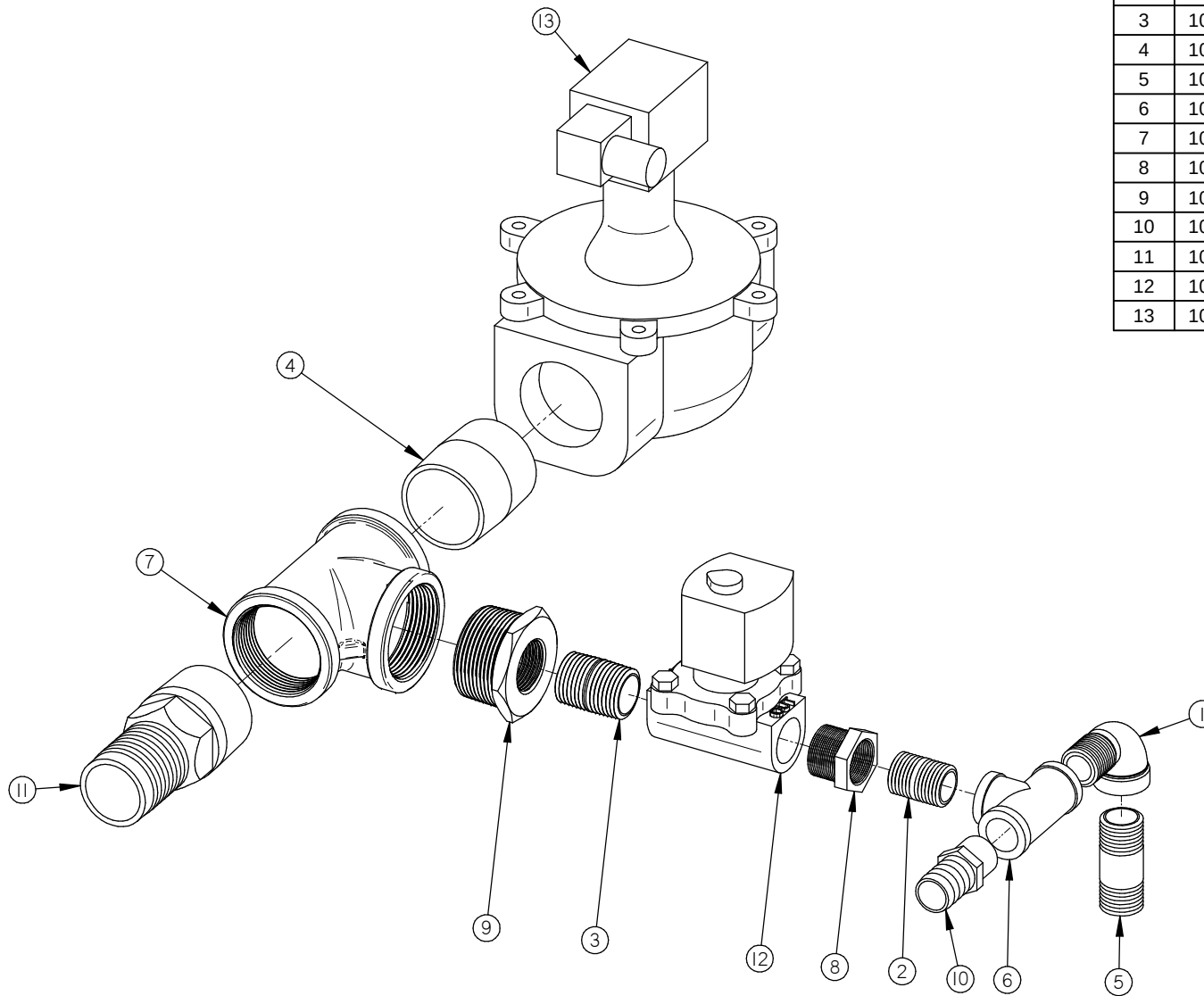
ITEM	PART #	DESCRIPTION	QT.
1	001A6589	PUMP SUPPORT	2
2	001A6590	KB-0020 TRANSVERSE PUMP SUPPORT	1
3	004A4153	VACUUM/ATMOSPHERE VALVE ASSY (2X KB0020)	1
4	051-0360	BOLT 3/8"-16nc. X 1" S/S	12
5	051-0622	NUT 3/8"-16nc. NYLON LOCK S/S	12
6	051-0740	WASHER 1/4" FLAT S/S	6
7	051-0780	WASHER 3/8" FLAT S/S	8
8	051-0783	WASHER 3/8" FLAT THICK S/S	16
9	051-0930	BOLT M6 x 10 S/S	4
10	051-0948	BOLT M6 x 12 SS	2
11	100-0075	STREET ELBOW 1/2" NPT SS	2
12	100-1205	STRAIGHT 1/2"MNPTx3/4" HOSE BARB S/S	1
13	104-0110	HOSE 3/4" ID VACUUM TIGERFLEX (1.02')	1
14	104-0125	HOSE 1-1/2" ID VACUUM POLYWIRE (3')	1
15	105-0110	SCREW CLAMPS 1-1/16" TO 2" ALL S/S	1
16	105-0238	EAR CLAMP 23.9-27.1 SS	2
17	105-0250	EAR CLAMP 1-1/2" S/S	1
18	125-1020	BUSCH KB-0020 115V/1PH/60HZ	2
19	125-1021	BUSCH KB-0020 220-240V/1PH/50-60HZ	2



LET.	MODIFICATION	DATE	INT.
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MACHINE		420A		DEPT. TOL.		METRIC		INCH			
PART		PUMP "BUSCH" 2X 20M ³		USINAGE		± 0.1		± 0.004"			
				TOLERIE		± 0.5		± 0.020"			
				SOUDEAGE		± 0.5		± 0.020"			
ITEM		CNC						N.T.S.			
MAT.				DWG BY		SBU		DATE		14-01-28	
				APP. BY				DATE			
								NO.		004A4121	
								DEPT.		M	
										QTY. 1	

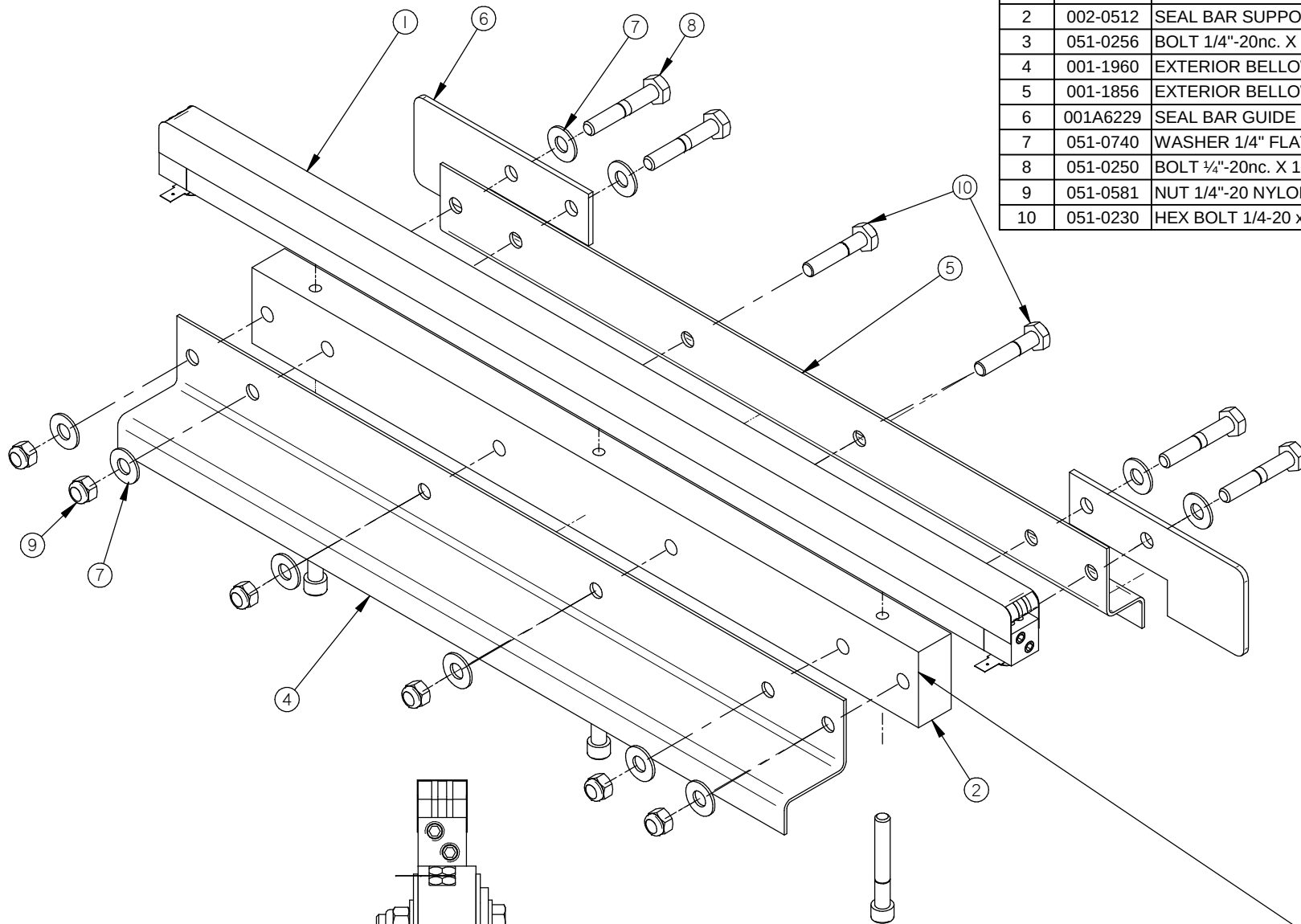
004A4153



ITEM	PART #	DESCRIPTION	QT.
1	100-0075	STREET ELBOW 1/2" NPT SS	1
2	100-0230	CLOSE NIPPLE 1/2" npt, S/S	1
3	100-0235	CLOSE NIPPLE 3/4"npt, S/S	1
4	100-0250	CLOSE NIPPLE 1-1/2"NPT S/S	1
5	100-0325	NIPPLE 1/2"npt. X 2" S/S	1
6	100-0465	TEE 1/2"npt. S/S	1
7	100-0485	TEE 1-1/2" NPT S/S	1
8	100-0520	RED.BUSH.3/4"NPT x 1/2"NPT S/S	1
9	100-0553	REDUCING BUSH. 1-1/2" NPT X 3/4" NPT SS	1
10	100-1205	STRAIGHT 1/2"MNPTx3/4" HOSE BARB S/S	1
11	100-1230	STRAIGHT 1-1/2"MNPT x1-1/2" HOSE BARB	1
12	106-0030	VALVE 2WAY 24V 3/4"NPT(G95) 60Hz	1
13	106-0051	VALVE 2WAY 24V 1-1/2"NPT60Hz	1

MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	
PART		VACUUM/ATMOSPHERE VALVE ASSY (2X KB0020)		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		DATE	14-01-28	NO.	1
LET.		MODIFICATION		DATE		INT.	
						004A4153	

005A1355



ITEM	PART #	DESCRIPTION	QT.
1	004-0352	SEAL BAR PRE-ASSEMBLY	1
2	002-0512	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	3
4	001-1960	EXTERIOR BELLOWS COVER	1
5	001-1856	EXTERIOR BELLOWS COVER	1
6	001A6229	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	10
8	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	6
10	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	2

-ITEM #2 ÉGAL AVEC L'ITEM #4 & #5.
-ITEM #2 FLUSH WITH ITEM #4 & #5.

-CE COTÉ DU SUPPORT ÉGAL AVEC DE LA BARRE DE SCELLAGE.
-THIS SIDE OF SUPPORT TO FIT FLUSH W/ SEAL BAR.

-END VIEW-

-TWIN SEAL OPTION-

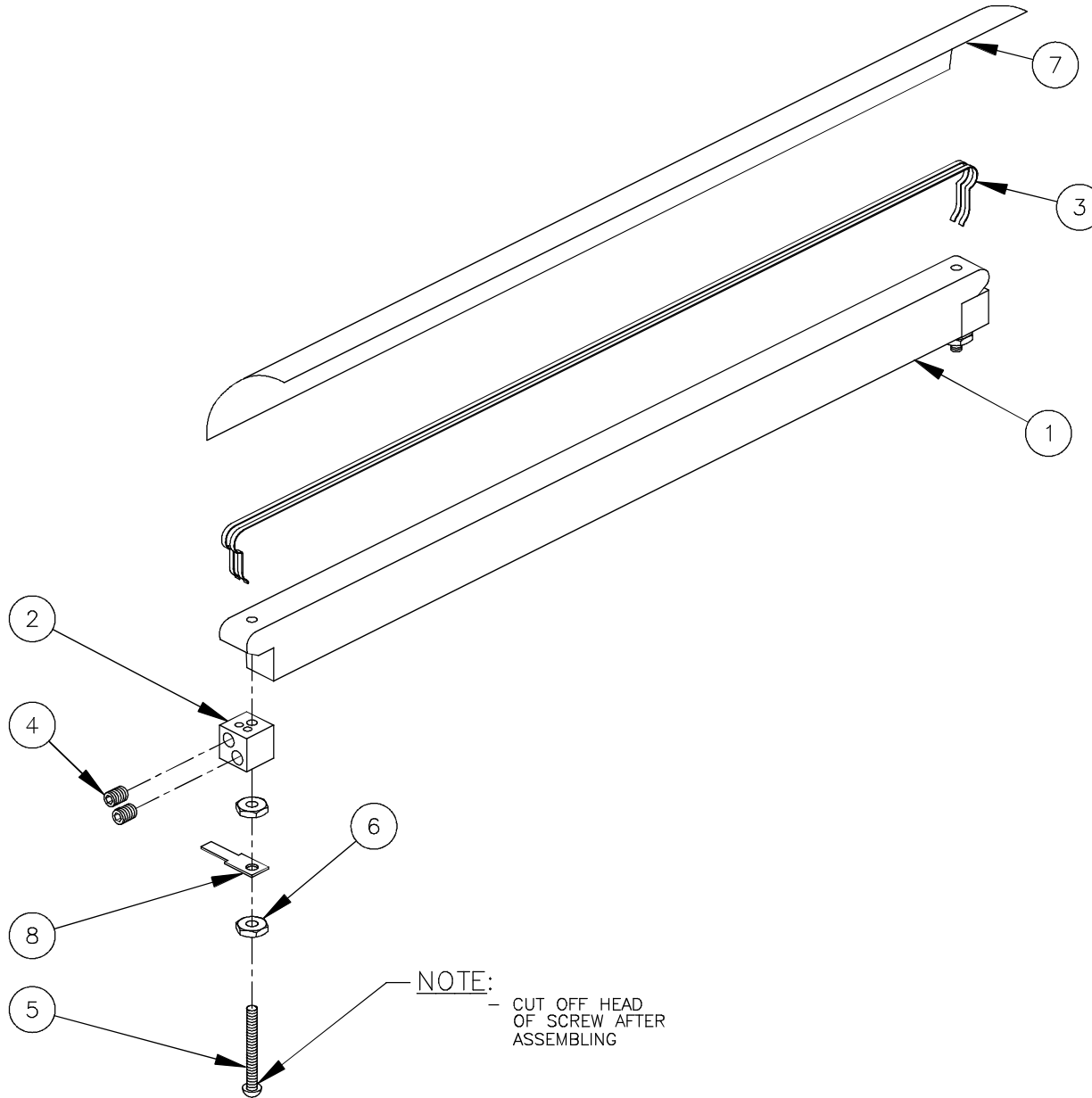
420A	4
350D	2
350	1
300D	2
300	1
MACHINE	QTY

B	AJOUT 420A ETAIT ETAIT 005B0046	14-08-21	SBU
A	REDESSINE ETAIT 005B0046	12-09-24	J.G.
LET.	MODIFICATION	DATE	INT.

MACHINE 300, 300D, 350, 350D & 420A		DEPT. TOL. METRIC	INCH		
PART SEAL BAR ASSEMBLY W/SUPP. TWIN SEAL		USINAGE TOLERIE SOUDAGE	± 0.1 ± 0.5 ± 0.5		± 0.004" ± 0.020" ± 0.020"
ITEM		PROGRAM	DEPT.		N.T.S.
MAT.		3D BY 2D BY	J.G.	DATE DATE	12-09-24
				NO.	005A1355

1004-0352

ITEM	#PART	DESCRIPTION	QT.
1	002-0481	SEAL BAR (TABLE)	1
2	002-0031	CONNECTOR	2
3	039-0200	SEALING ELEM. STD TWIN (2x626mm EA.)	4.31
4	052-0395	SCREW 1/4"-20 NC. X 5/16" SET HEX SKT OVAL PT	4
5	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	2
6	051-0550	NUT #8-32 S/S	4
7	176-0200	TEFLON TAPE 5S ADHESIVE X 2" X (496mm EA.)	0.063
8	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	2



NOTE:
- CUT OFF HEAD
OF SCREW AFTER
ASSEMBLING

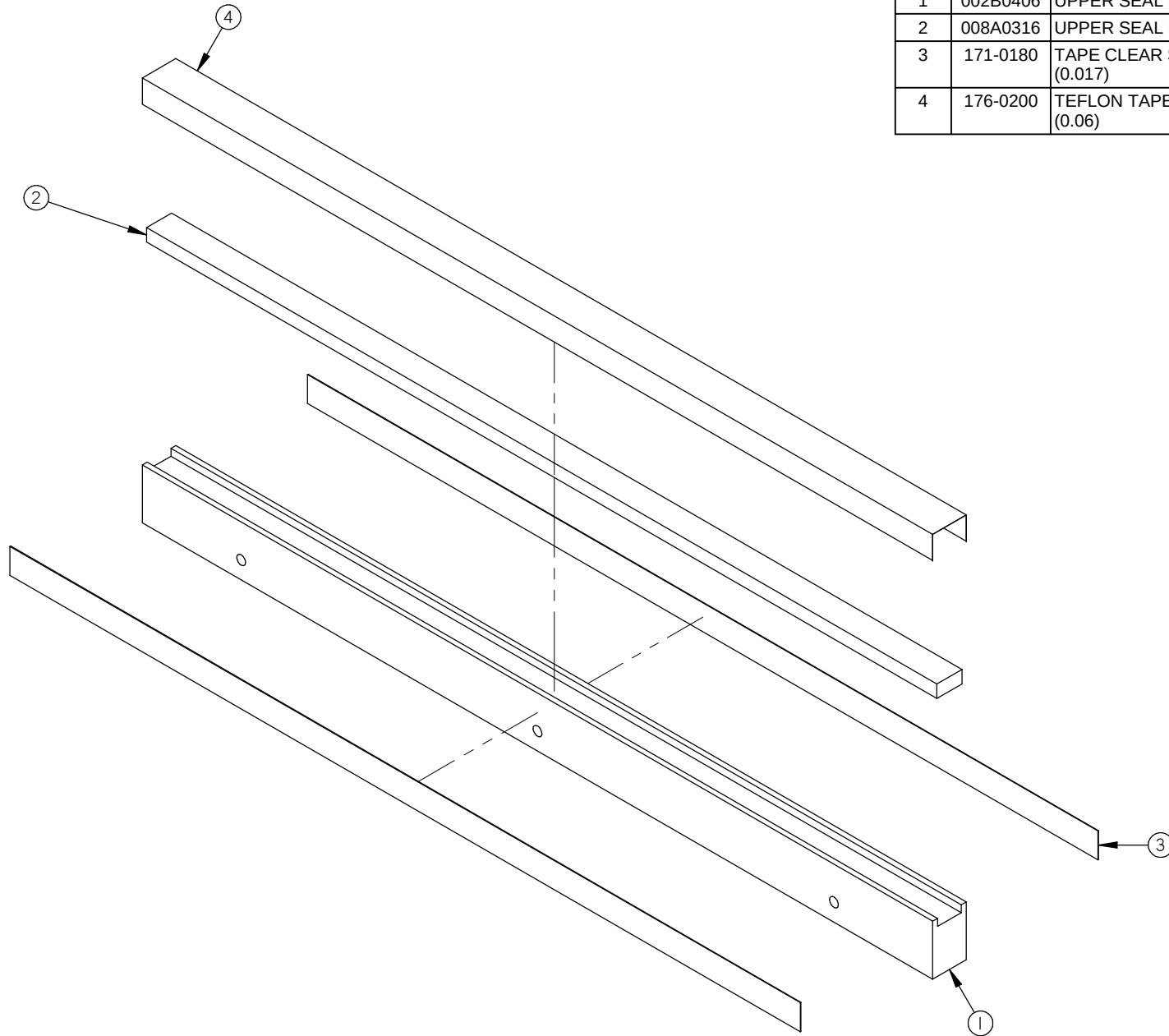
420A	4
450T	2
450A	2
400	2
350D	2
350	1
300D	2
300	1
MACHINE	QTÉ.

G	ADDED 420A WAS 005-0267	14-08-21	SBU
F	ADDED 300, 300D, 350 & 350D WAS 005-0267	12-09-24	J.G.
E	ADDED 450T WAS 005-0377	08-05-26	D.A.
D	MODIFICATION #A-0398 (CONNECTEUR)	04-04-19	J.G.
C	ADDED 400	99-05-06	S.L.
B	REDRAWN	98-02-10	A.P.
LET.	MODIFICATION	DATE	INT.

MACHINE	VOIR LISTE		TOLERANCE	
PART	SEAL BAR PRE-ASSEMBLY		USINAGE	± 0.1
ITEM:	CNC:	DATE	TOLERIE	± 0.5
MAT:	A. P.	98-02-10	SOUDAGE	± 0.5
	APP.	DATE		± 0.020"
				N.T.S.
DEPT.	M-I	QT.	2	
004-0352				

004B0126

ITEM	PART #	DESCRIPTION	QT.
1	002B0406	UPPER SEAL BAR	1
2	008A0316	UPPER SEAL BAR RUBBER	1
3	171-0180	TAPE CLEAR SUPER BOND 3/4" 600mm (0.017)	2
4	176-0200	TEFLON TAPE,PRESS.SENSITIVE 2" 600mm (0.06)	1

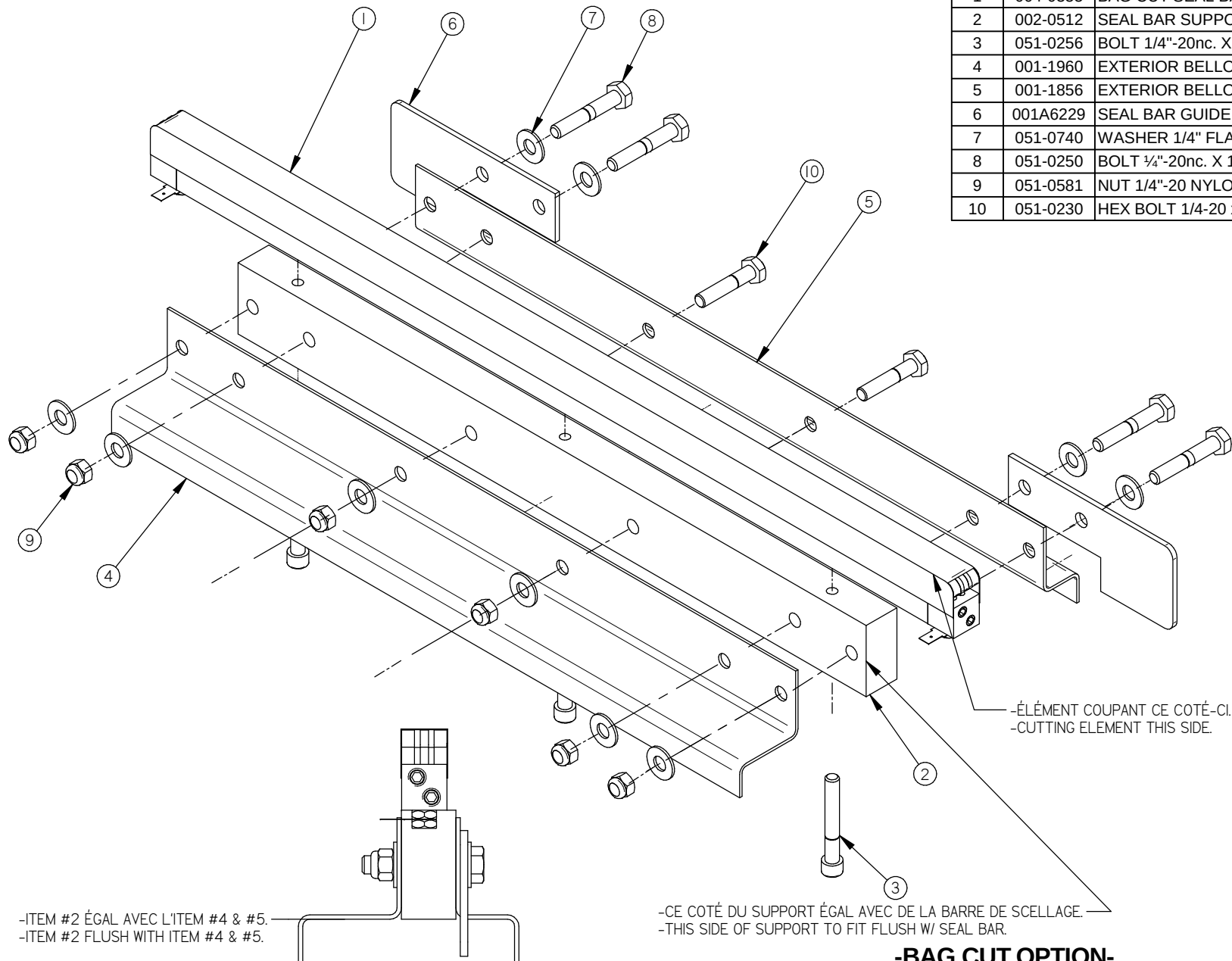


MACHINE		420A		DEPT. TOL.	METRIC	INCH	
PART		UPPER SEAL BAR ASSY		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		SOUDEGE	± 0.5	± 0.020"	N.T.S.
DATE		14-01-29		DEPT.		M	QTY. 2
NO.		004B0126					

LET.	MODIFICATION	DATE	INT.
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005A1356

ITEM	PART #	DESCRIPTION	QT.
1	004-0355	BAG CUT SEAL BAR PRE-ASSEMBLY	1
2	002-0512	SEAL BAR SUPPORT	1
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	3
4	001-1960	EXTERIOR BELLOWS COVER	1
5	001-1856	EXTERIOR BELLOWS COVER	1
6	001A6229	SEAL BAR GUIDE	2
7	051-0740	WASHER 1/4" FLAT S/S	10
8	051-0250	BOLT 1/4"-20nc. X 1 1/2" S/S	4
9	051-0581	NUT 1/4"-20 NYLON LOCK S/S	6
10	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	2



-END VIEW-

-BAG CUT OPTION-

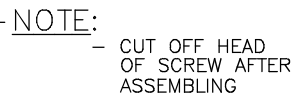
420A	4
350D	2
350	1
300D	2
300	1
MACHINE	QTY

B	AJOUT 420A ÉTAIT 005B0558	14-08-21	SBU
A	REDESSINE ÉTAIT 005B0558	12-09-24	J.G.
LET.	MODIFICATION	DATE	INT.

MACHINE	300, 300D, 350, 350D & 420A	DEPT. TOL. METRIC	INCH
PART	SEAL BAR ASSEMBLY W/SUPP. BAG CUT	USINAGE	± 0.1 ± 0.004"
ITEM		TOLERIE	± 0.5 ± 0.020"
MAT.		SOUDEAGE	± 0.5 ± 0.020"
PROGRAM		N.T.S.	
3D BY	J.G.	DATE	12-09-24
2D BY		DATE	
DEPT.	M-I-(M)	QTY	LIST
005A1356			



ITEM	#PART	DESCRIPTION	QT.
1	002-0481	SEAL BAR	1
2	002-0031	CONNECTOR	2
3	039-0230	REFLEX BAND 2.5MM (626mm EA.)	0.063
4	039-0270	"T" PROFILE CUT. ELEM. (626mm EA.)	0.063
5	052-0395	SCREW 1/4"-20 NC. X 5/16" SET HEX SKT OVAL PT	4
6	052-0250	SCREW #8-32 X 1 1/2" RND SLOT BRASS	2
7	051-0550	NUT #8-32 S/S	4
8	176-0200	TEFLON TAPE 5S ADHESIVE X 2" X (496mm EA.)	0.063
9	027-0400	CONNECTOR ADAPTOR 1/4" X #10 STUD	2

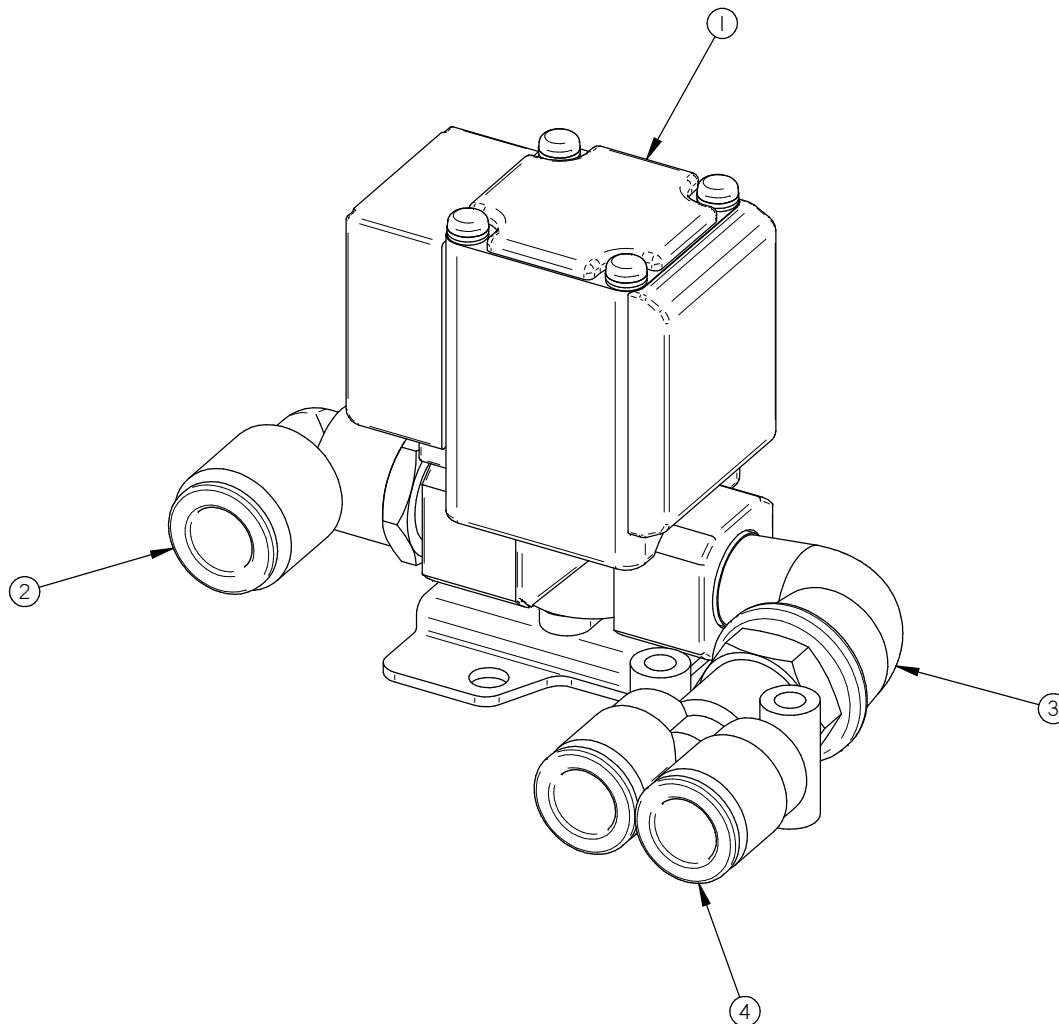


420A	4
450T	2
450A	2
400	2
350D	2
350	1
300D	2
300	1
MACHINE	QTÉ.

MACHINE		VOIR LISTE		TOLERANCE METRIC		INCH		MATERIAL		QUANTITY	
PART		SEAL BAR PRE-ASSEMBLY		USINING TOLERIE SOUDEAGE		± 0.1 ± 0.5 ± 0.5		± 0.004" ± 0.020" ± 0.020"		CM Machine Services	
ITEM: _____		CNC: _____				N.T.S.		M-I		QT. LISTE	
MAT: _____		DWG BY _____ APP. _____		A.P. _____		DATE 98-02-10		NO. 004-0355			

004B4113

ITEM	PART #	DESCRIPTION	QT.
1	106-0010	VALVE 2WAY N.C. 24VAC 1/4" NPT(SMC)	1
2	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	1
3	100-0065	STREET ELBOW 1/4" NPT SS	1
4	102-0361	Y BRANCH 1/4" MNPT X 3/8" T. QUICK	1



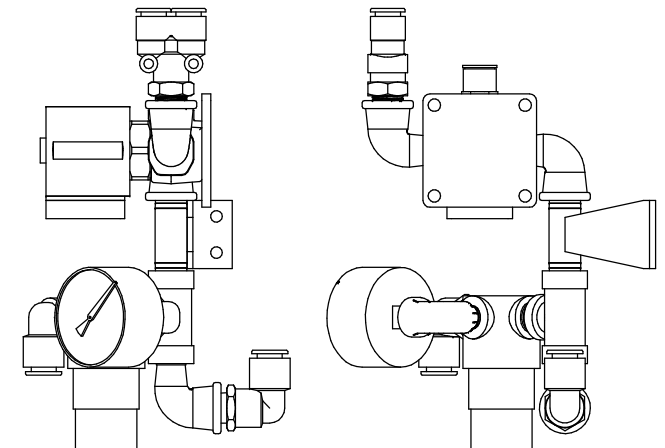
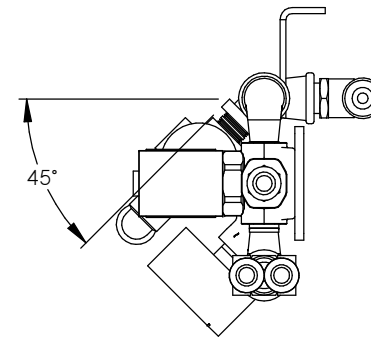
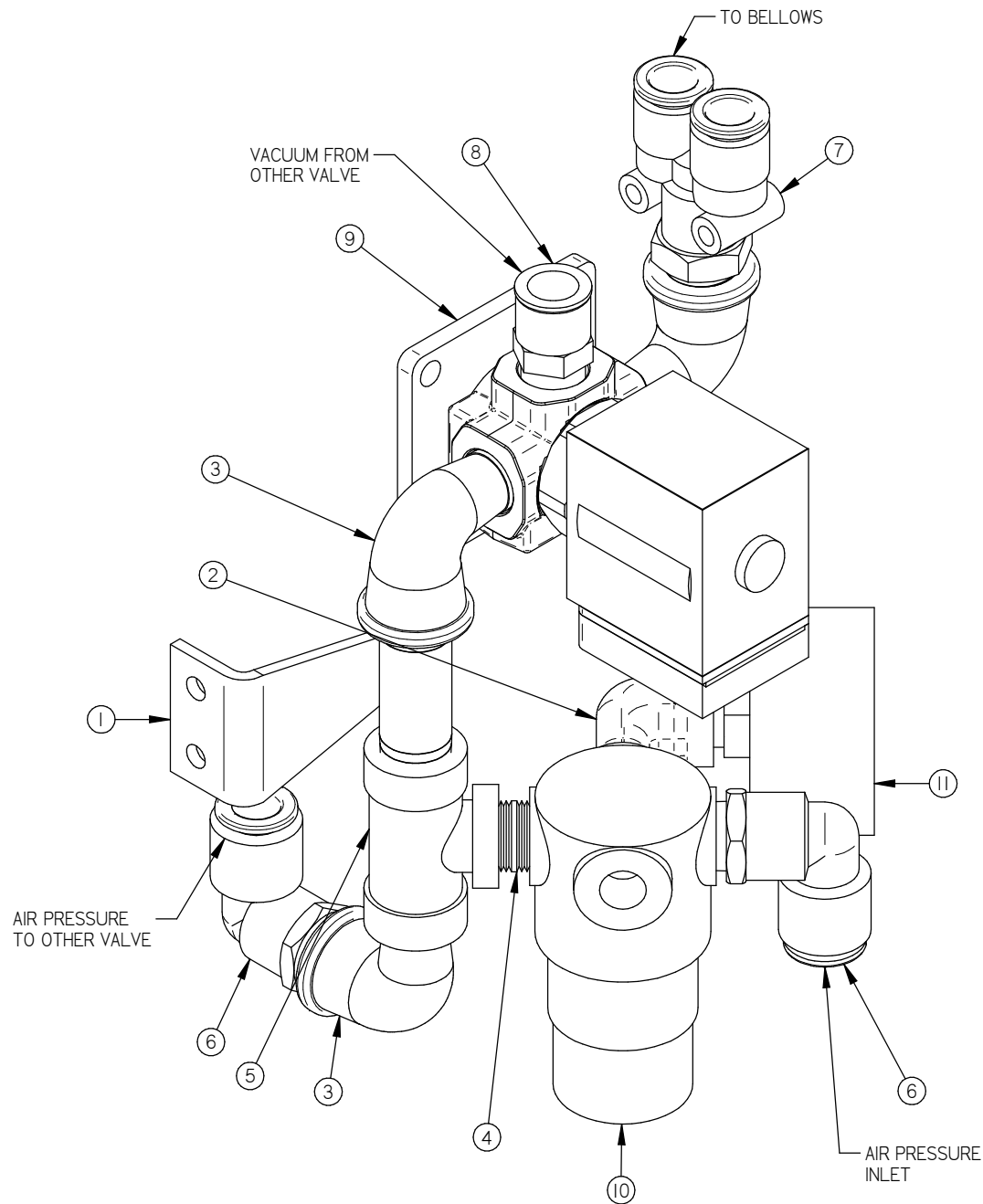
-OPTION - GAS

A	VALVE UPDATE	14-05-27	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	
PART		GAS VALVE ASSEMBLY (OPTION)		USINAGE	± 0.1	± 0.004"	
ITEM				TOLERIE	± 0.5	± 0.020"	
MAT.				SOUDEAGE	± 0.5	± 0.020"	
CNC				N.T.S.			
DWG BY		SBU		DATE		14-05-27	
APP. BY				DATE			
DEPT.		M		NO.		2	
						004B4113	

004A4152

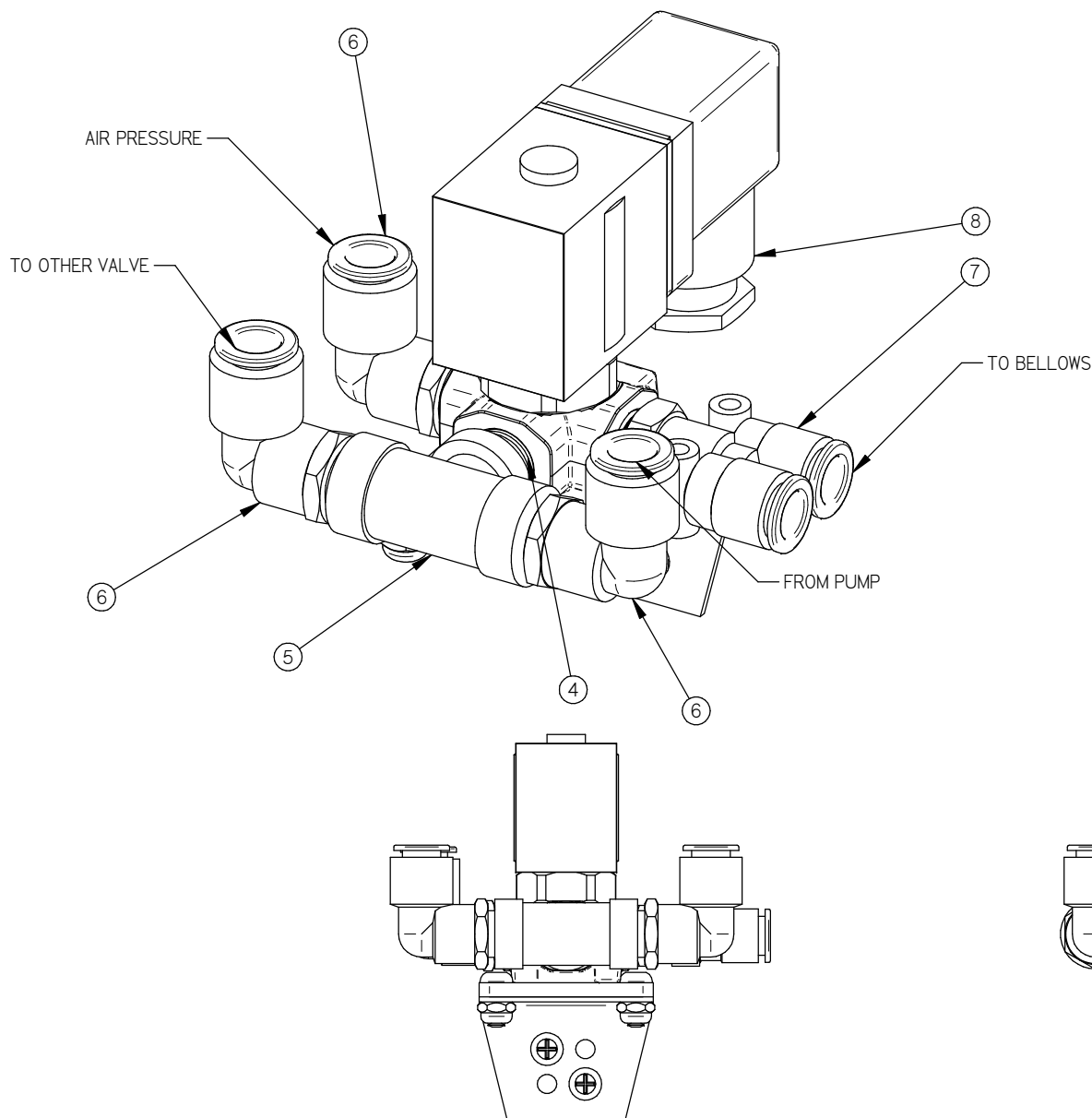
ITEM	PART #	DESCRIPTION	QT.
1	004A4140	AIR REGULATOR SUPPORT	1
2	100-0060	STREET ELBOW 1/8" NPT SS	1
3	100-0065	STREET ELBOW 1/4" NPT SS	3
4	100-0225	CLOSE NIPPLE 1/4" NPT SS	1
5	100-0463	TEE 1/4" NPT S/S	1
6	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	2
7	102-0361	Y BRANCH 1/4" MNPT X 3/8" T. QUICK	1
8	102-0410	MALE CONN.1/4"MNPTx3/8"T.QUICK	1
9	106-00701	VALVE 3WAY 24V 1/4"NPT	1
10	114-0147	PRESSURE REGUL. 0-60 PSI 1/4" NPT	1
11	114-0245	PRESSURE GAUGE 60 PSI 1/8" NPT	1



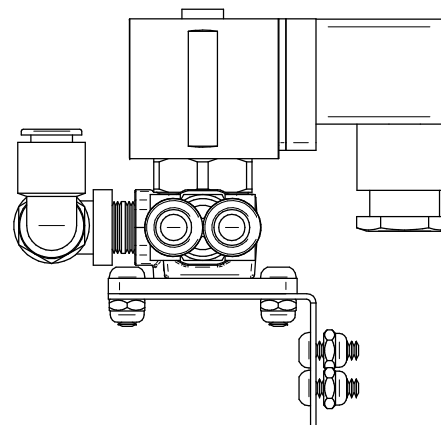
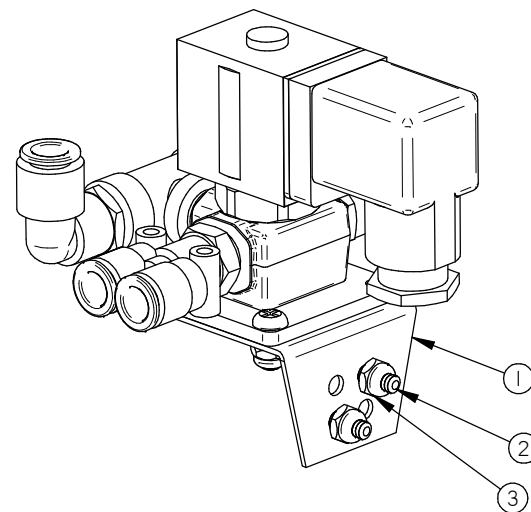
LET.	MODIFICATION	DATE	INT.
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MACHINE		420A		DEPT. TOL. METRIC INCH USINAGE ± 0.1 ± 0.004" TOLERIE ± 0.5 ± 0.020" SOUDAGE ± 0.5 ± 0.020"			
PART		AIR REGULATOR VALVE ASSY				N.T.S.	
ITEM		CNC		DEPT.		M	QTY.
MAT.		DWG BY APP. BY SBU		DATE DATE 14-01-27		NO. 004A4152	

004B4105



ITEM	PART #	DESCRIPTION	QT.
1	001B6779	VALVE SUPPORT BRACKET	1
2	051-0144	SCREW #10-24 N.C 1/2" PAN PHIL. S/S	4
3	051-0572	NUT #10-24 NYLON LOCK S/S	4
4	100-0225	CLOSE NIPPLE 1/4" NPT SS	1
5	100-0463	TEE 1/4" NPT S/S	1
6	102-0330	ELBOW 1/4" NPT X 3/8" HOSE QUICK	3
7	102-0361	Y BRANCH 1/4" MNPT X 3/8" T. QUICK	1
8	106-00701	VALVE 3WAY 24V 1/4"NPT	1



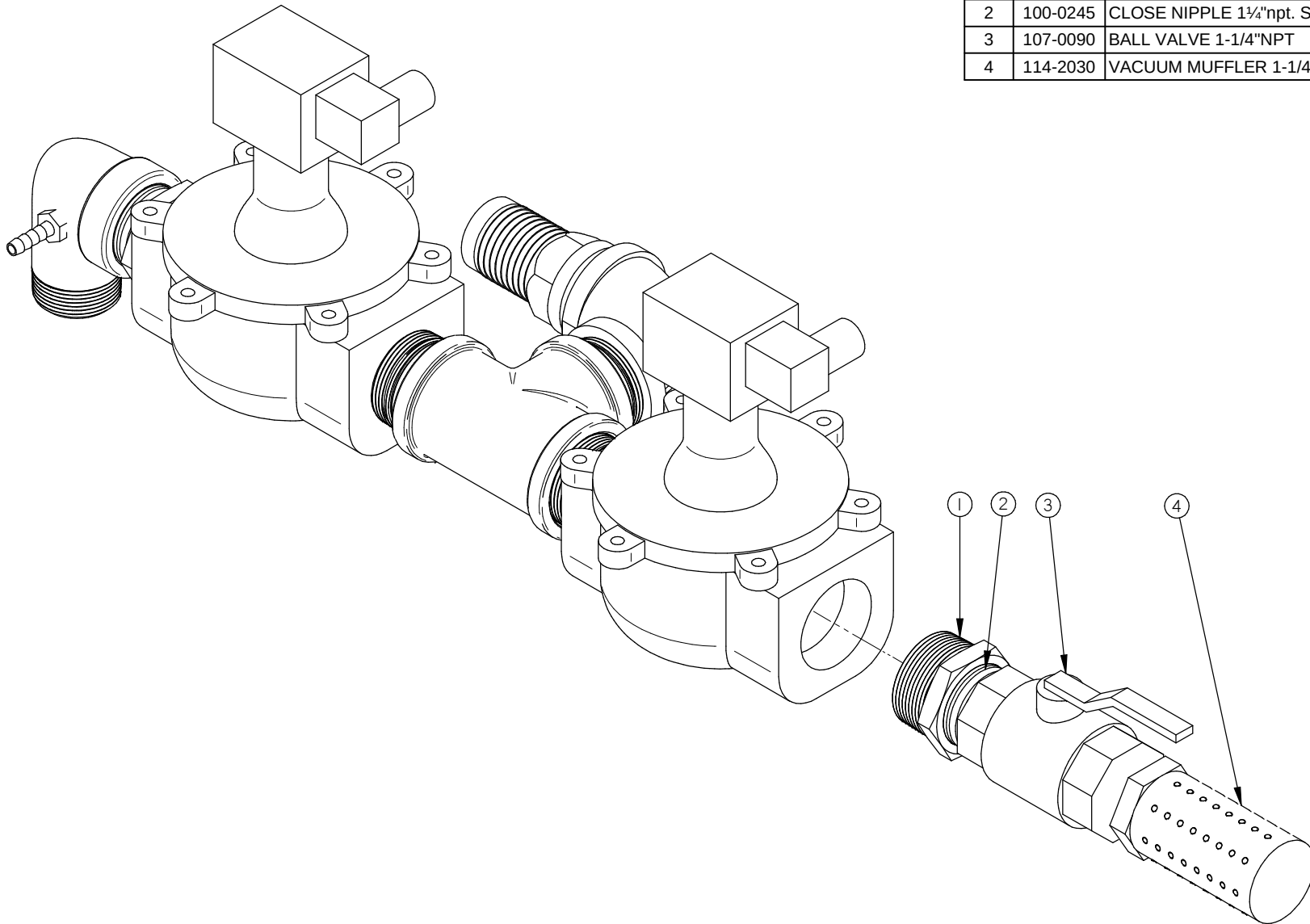
-OPTION - AIR REGULATOR

A	UPDATE VALVE	14-05-27	SBU
LET.	MODIFICATION	DATE	INT.

MACHINE		VACUUM		DEPT. TOL	METRIC	INCH	
PART		BELLOWS VALVE ASSY (OPT AIR REG)		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		SOUDEAGE	± 0.5	± 0.020"	
		DATE 14-05-27		N.T.S.		NO.	004B4105
		DATE		DEPT.		M	
						QTY.	1

004A4111

ITEM	PART #	DESCRIPTION	QT.
1	100-0555	RED.BUSH.1-1/2" x 1-1/4" NPT S/S	1
2	100-0245	CLOSE NIPPLE 1 1/4"npt. S/S	1
3	107-0090	BALL VALVE 1-1/4"NPT	1
4	114-2030	VACUUM MUFFLER 1-1/4"NPT	1



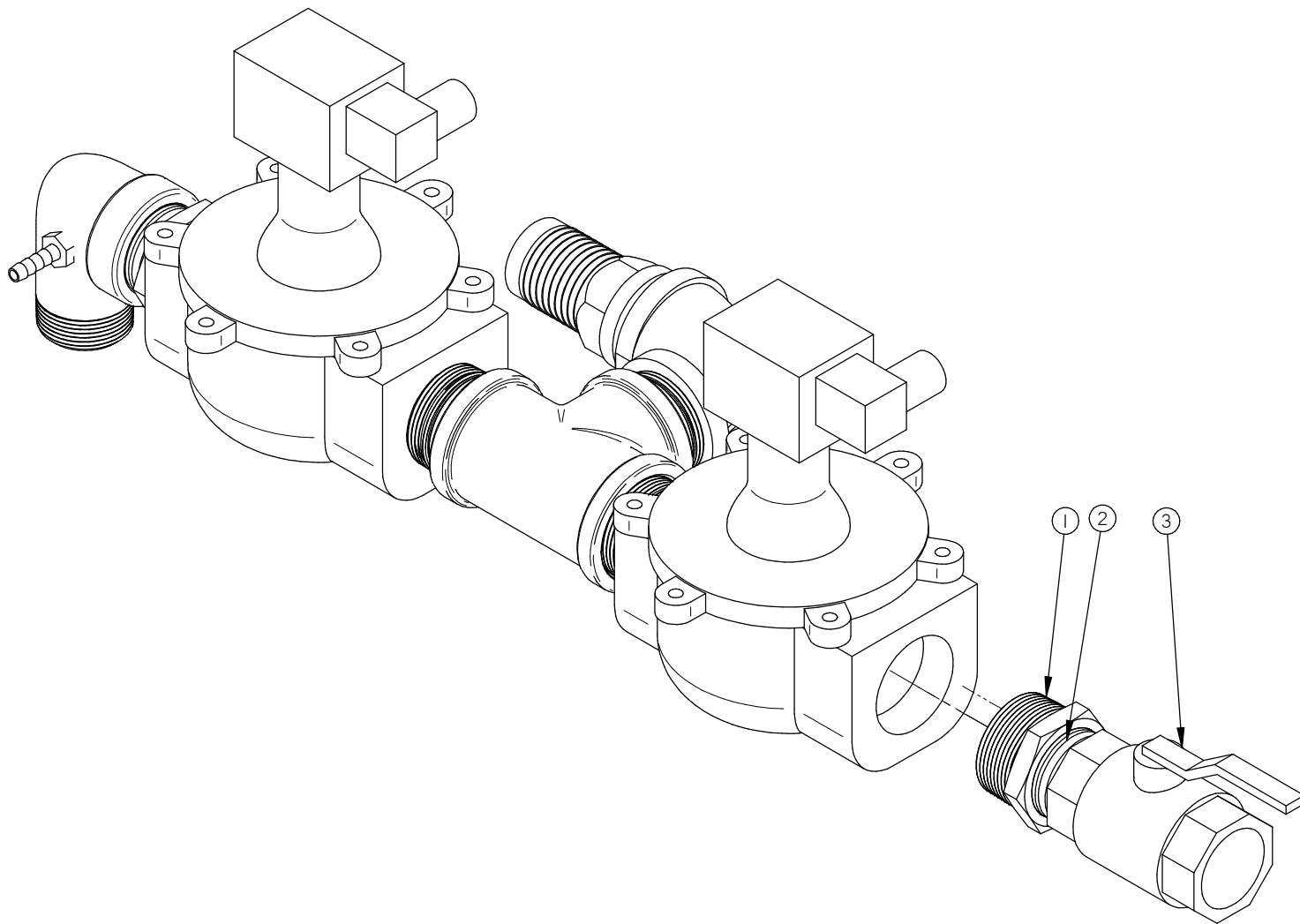
-OPTION - SOFT AIR + MUFFLER 40M³ @ 100M³

LET.	MODIFICATION	DATE	INT.
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MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	
PART		VACUUM/ATMOSPHERE VALVE (OPT SOFT AIR+MUFFLER)		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		DWG BY SBU		DATE 13-09-19		NO. 004A4111	
		APP. BY		DATE		M 1	

004A4110

ITEM	PART #	DESCRIPTION	QT.
1	100-0555	RED.BUSH.1-1/2" x 1-1/4" NPT S/S	1
2	100-0245	CLOSE NIPPLE 1 1/4"npt. S/S	1
3	107-0090	BALL VALVE 1-1/4"NPT	1



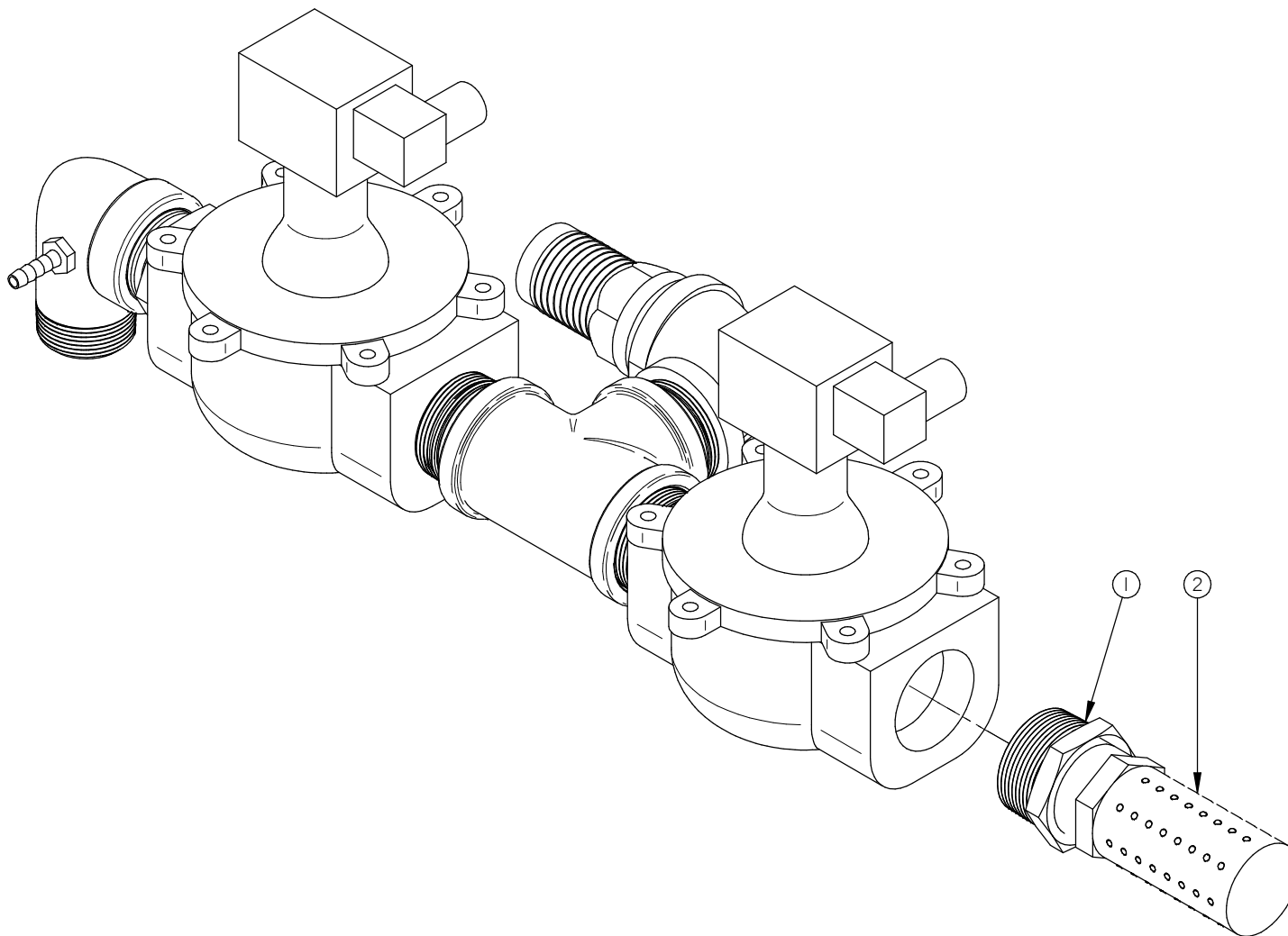
-OPTION - SOFT AIR 40M³ @ 100M³

MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	
PART		VACUUM/ATMOSPHERE VALVE (OPT SOFT AIR)		USINAGE	± 0.1	± 0.004"	
				TOLERIE	± 0.5	± 0.020"	
				SOUDEAGE	± 0.5	± 0.020"	
ITEM	CNC			N.T.S.			
MAT.	DWG BY	SBU	DATE	13-09-19	NO.		1
		APP. BY	DATE			004A4110	

LET.	MODIFICATION	DATE	INT.
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004A4109

ITEM	PART #	DESCRIPTION	QT.
1	100-0555	RED.BUSH.1-1/2" x 1-1/4" NPT S/S	1
2	114-2030	VACUUM MUFFLER 1-1/4"NPT	1

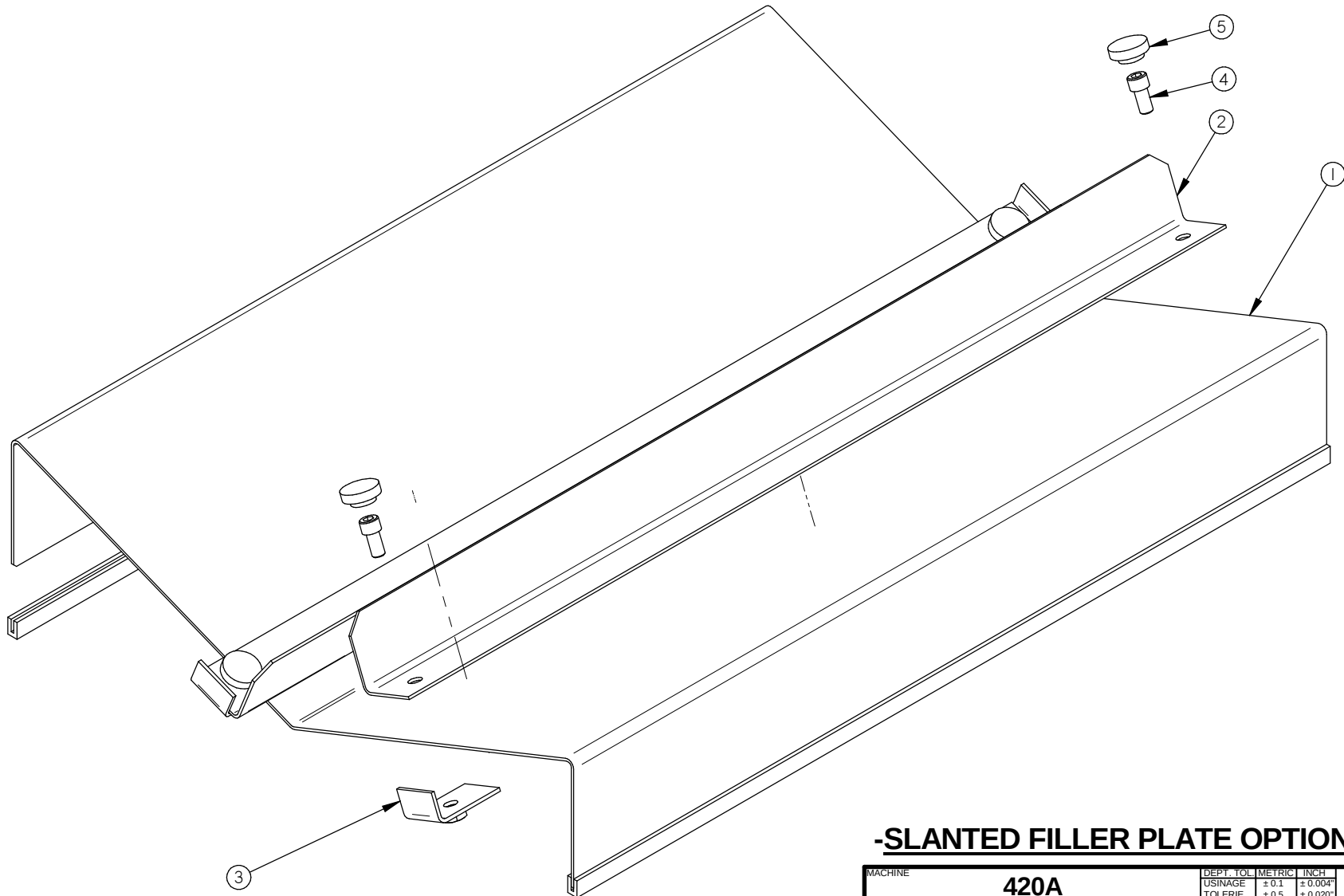


-OPTION - MUFFLER 40M³ @ 100M³

MACHINE		VACUUM		DEPT. TOL.	METRIC	INCH	
PART		VACUUM/ATMOSPHERE VALVE (OPT MUFFLER)		USINAGE	± 0.1	± 0.004"	
ITEM		CNC		TOLERIE	± 0.5	± 0.020"	
MAT.		APP. BY		DATE	13-09-19	NO.	1
LET.		MODIFICATION		DATE		INT.	
						004A4109	

005B1370

ITEM	PART #	DESCRIPTION	QT.
1	001B6292	SLANTED FILLER PLATE	1
2	001B6293	SLANTED FILLER PLATE ADJ. STOPPER	2
3	005-0187	ASS. BARRURE	4
4	051-01845	BOLT 1/4"-20 x 1/2"CAP HEX SKT.S/S	4
5	057-0004	THMB SCREW KNOB 1/4"	4
6	179-0014	RUBBER 1/4"x3/8"x1/16"U SHAPED	2



-SLANTED FILLER PLATE OPTION-

MACHINE		420A		DEPT. TOL. METRIC		INCH					
PART		SLANTED FILLER PLATE ASS'Y		USINAGE		± 0.1				± 0.004"	
ITEM		CNC		TOLERIE		± 0.5				± 0.020"	
MAT.		APP. BY		DATE		14-01-27		NO.		005B1370	
								M-I		2	

A	LENGTHEN BY 60MM	14-01-27	SBU
LET.	MODIFICATION	DATE	INT.