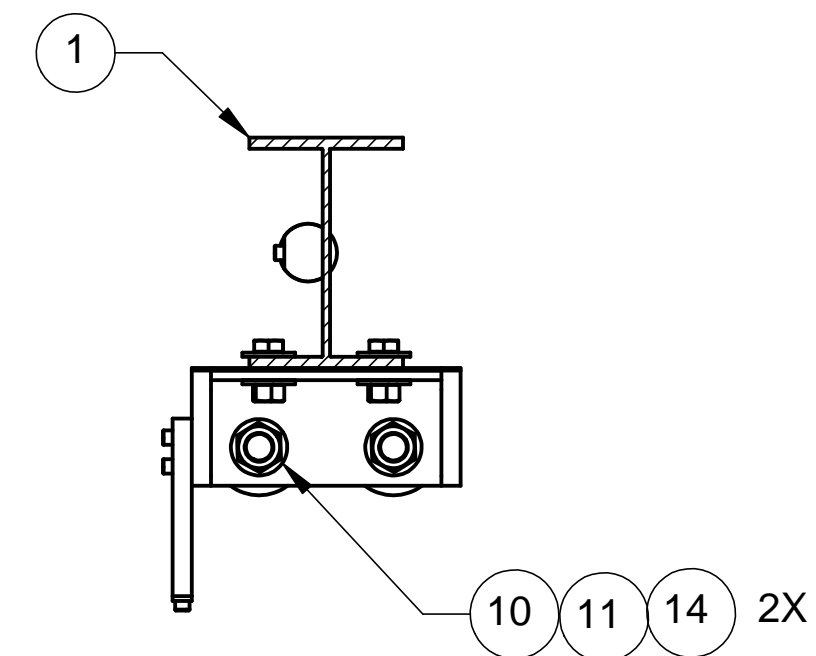
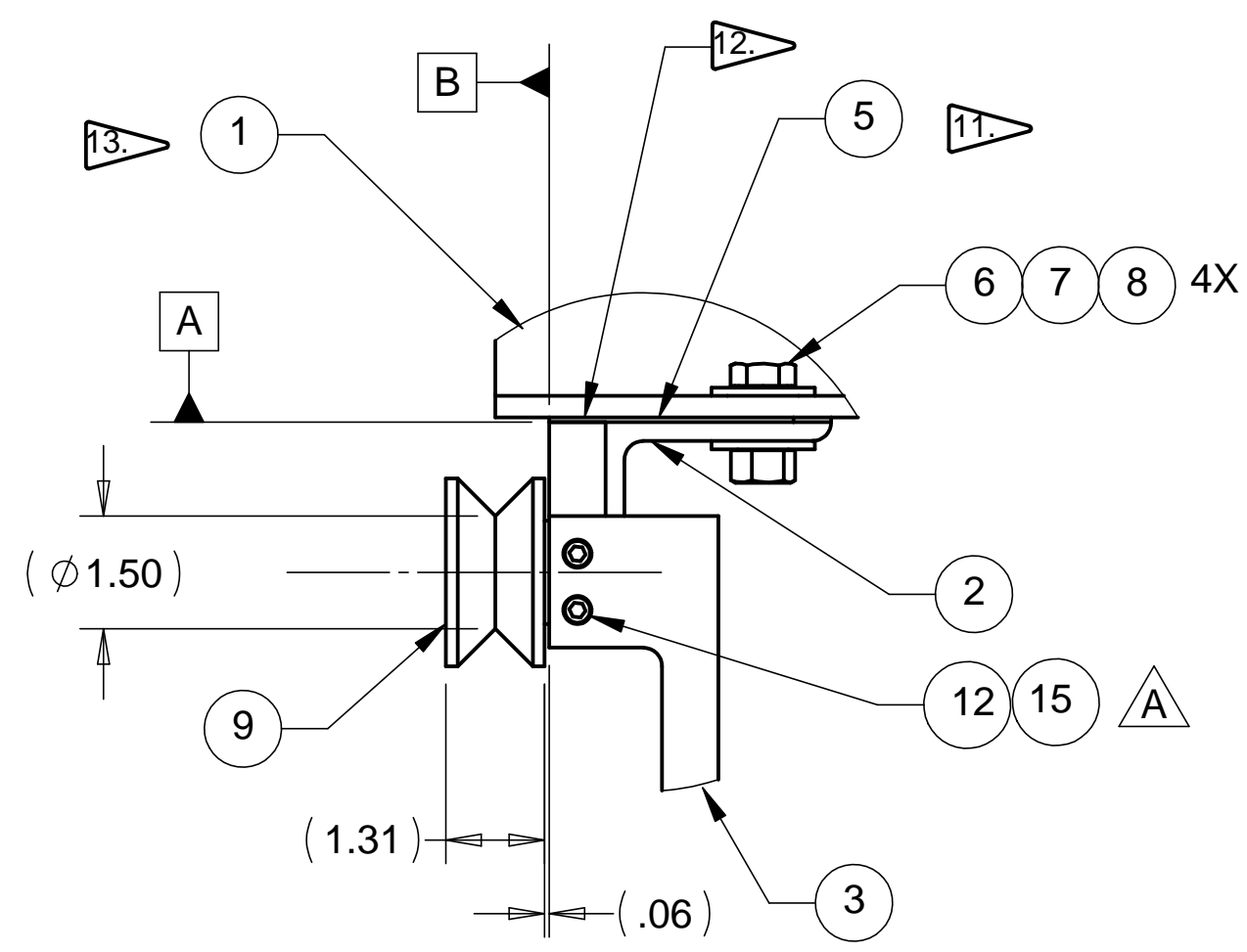


8 7 6 5 4 3 2 1

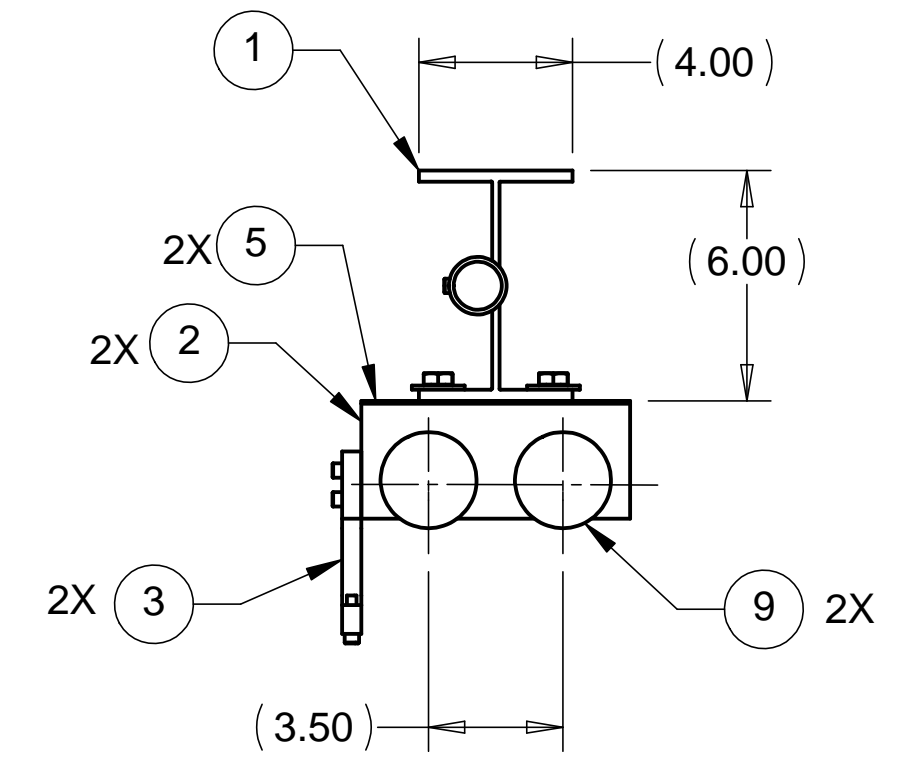
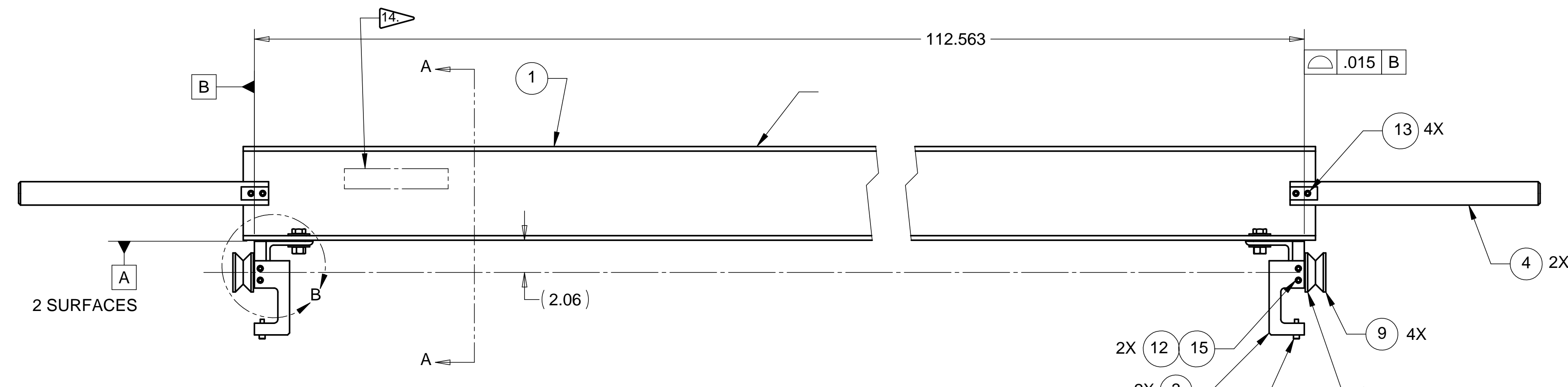
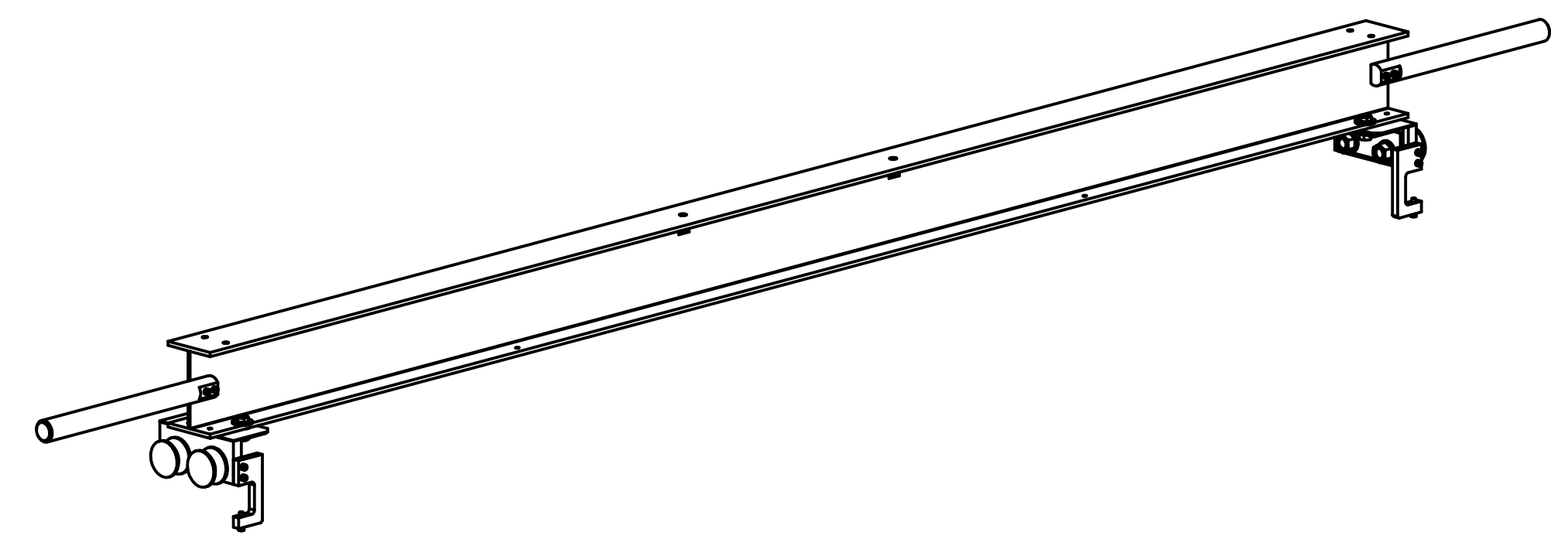
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	CHANGED GD&T, BOM QUANTITIES	3-16-98	WKM



SECTION A-A
SCALE 1 : 5



DETAIL B
SCALE 2 : 5



ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	D972430-1	BSC MINOR RAIL I-BEAM
2	2	D972942-1	MINOR RAIL ROLLER ANGLE BRACKET
3	2	D972943-1	MINOR RAIL LOCKDOWN BRACKET
4	2	D972945-1	MINOR RAIL PUSHBAR
5	AR	D972955-1	MINOR RAIL ANGLE BRACKET SHIM
6	4	STD HARDWARE	HEX HEAD SST BOLT, 1/2-13 UNC-2A X 1.25 LONG
7	4	STD HARDWARE	WASHER, SST 1/2 FLAT
8	4	STD HARDWARE	SST HEX NUT, 1/2-13 UNC-2B
9	4	PCI #VLR-2 1/2	V-GROOVE ROLLER, 2.5 O.D., KAMAN INDUSTRIES
10	4	STD HARDWARE	SST HEX NUT, 3/4-16 UNC-2B
11	4	STD HARDWARE	WASHER, SST 3/4 FLAT
12	4	STD HARDWARE	SST SOCKET HEAD CAPSCREW, 1/4-20 UNC-2A X 1.0 LONG
13	6	STD HARDWARE	SST SOCKET HEAD CAPSCREW, 1/4-20 UNC-2A X 1.5 LONG
14	4	STD HARDWARE	WASHER, SST 3/4 LOCK
15	4	STD HARDWARE	WASHER, SST 1/4 FLAT1

NOTES: UNLESS OTHERWISE SPECIFIED

- ALL DIMENSIONS IN INCHES
- DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
- SURFACE TEXTURE PER ANSI/ASME B 46.1-1985
- REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .015
- ALL INSIDE CORNERS TO BE .015 RADIUS MAX
- COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
- COUNTERSINK 82 DEGREES APPROXIMATELY .015 DEEP ALL DRILLED HOLES
- PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT, AND CHIPS.
- PART NUMBER (DRAWING NO. PLUS DASH NO. PLUS SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF.
- PART WEIGHS 99.3 Lbs.

- MACHINE SHIM (PART D972955) THICKNESS TO ACHIEVE FINAL DIMENSIONS.
- SCRIBE POSITIONAL RELATIONSHIP OF ITEMS 1, 2, AND 5 AFTER ASSEMBLY.
- STAMP ALL ASSEMBLY PIECES WITH AN ASSEMBLY SERIAL NUMBER.
- PAINT ON SIDE: DO NOT DIS-ASSEMBLE ASSEMBLY.
- USE A VAPOR DEGREASER TO REMOVE ALL GREASE FROM V-ROLLERS (ITEM 9).

PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING	
DECIMALS .XX = +/- .06 .XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	<p>HYTEC, INC</p> <p>TITLE BSC RAIL SYSTEM MINOR RAIL ASSEMBLY</p>	
FINISH	DESIGNED W. K. MILLER 1/14/98	SIGNATURE	DATE
	DRAWN W. K. MILLER 1/14/98		
	CHECKED HARRY SALAZAR 2/5/98		
	ENGR. T. THOMPSON 2/5/98		
	APPROVED T. THOMPSON 2/5/98		
PART NO. D972385-1	DWG. NO. D972385	SIZE D	SHEET NO. 1 of 1
	SCALE 1/8	REVISION A	

8 7 6 5 4 3 2 1