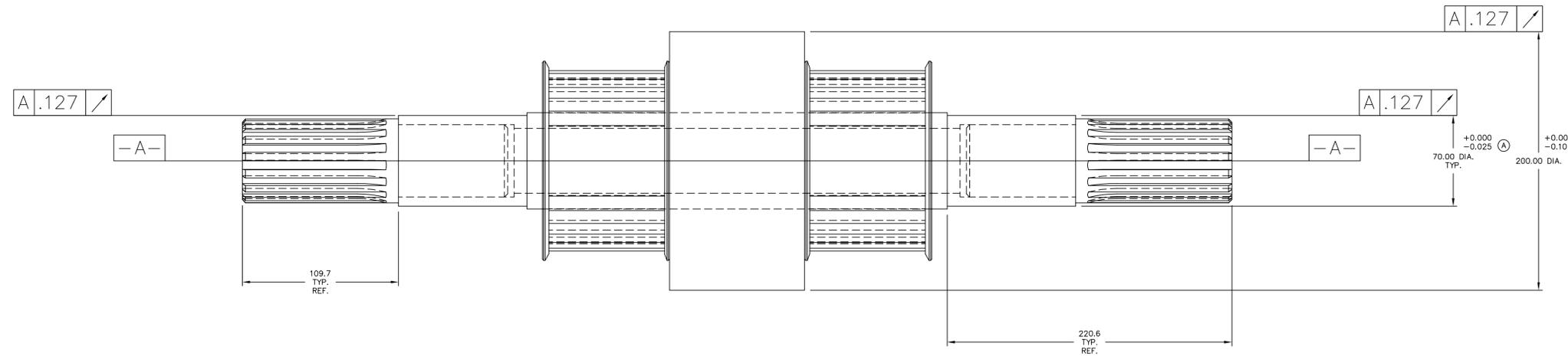
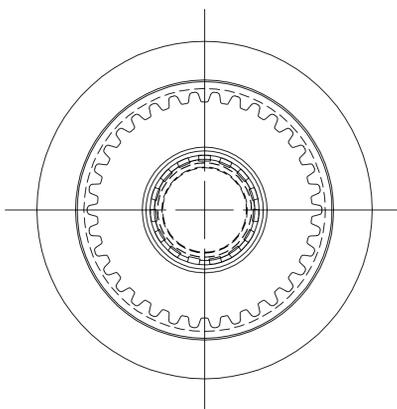
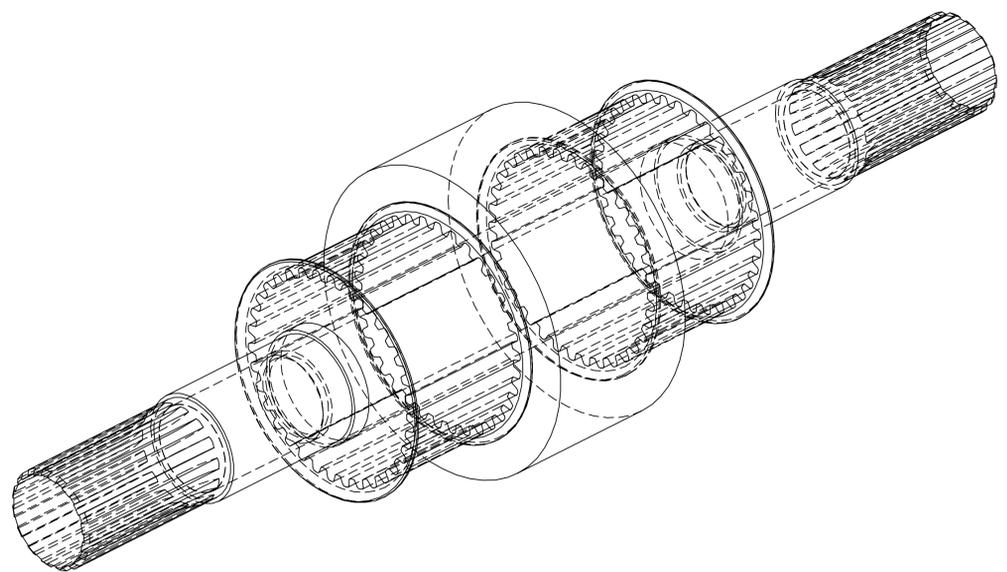


DATE	SYM	REVISIONS	CHK'D BY
5/30/07	REL		9623
5/31/07	A	-0.025 TOL WAS -.25	9623
03SEP14	B	VACAP-N903146 WAS N903146	3787



-43 VACAP-N903146
DRIVE ROLLER ~ ALTER PUR.
STK: (\$246452) DUGOMRULLI DRIVE ROLLER

Total Approx. Weight =122#

METRIC TOLERANCES

NOTE:
UNLESS OTHERWISE SPECIFIED:
MAXIMUM ALLOWABLE ROUGHNESS OF ALL:
1 PLACE FINISH DIMENSIONS TO BE 6 MICRONS
2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS
3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS

EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING: ±0.3 mm
2 PLACE FABRICATION: ±1.5 mm
3 PLACE: ±.08 mm BETWEEN MACHINED SURFACES
±.03 mm BETWEEN SINGLE DOWEL AND A HEEL SURFACE
±.03 mm BETWEEN DOWELS ON THE SAME PLANE
±.10 mm BETWEEN DOWELS ON DIFFERENT PLANES
±.13 mm TO SCREW HOLES, NON ACCUMULATIVE

DOWEL HOLE TOLERANCES
FOR PRESS FIT USE M6
FOR SLIP FIT USE F7

DOWEL TOLERANCE
M6

ALL MACHINING SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN OR COLD ROLLED SURFACES.
ALL WELDED JOINTS SHALL BE STRESS RELIEVED AND HAVE A TRAPPED AIR CAVITY WILL BE VENTED DURING FABRICATION.

UNIT NO. W999-0S001

(VACAP-N903146 DRIVE ROLLER)

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MODEL NO.	9623	SHEET	39	SHEETS	9623	DRAWING NO.	W999-0S001
DES. BY	9623	DET. BY	9623	TITLE COMAU STANDARD PRODUCTS VERSA SHUTTLE CENTER BASE (4 SERVING 7)			
CHECKED BY	9623	SAFETY OK					
APPROVED BY	3381	DATE	5/30/07	SCALE	.500	COMAU SOUTHFIELD MI.	

DO NOT SCALE