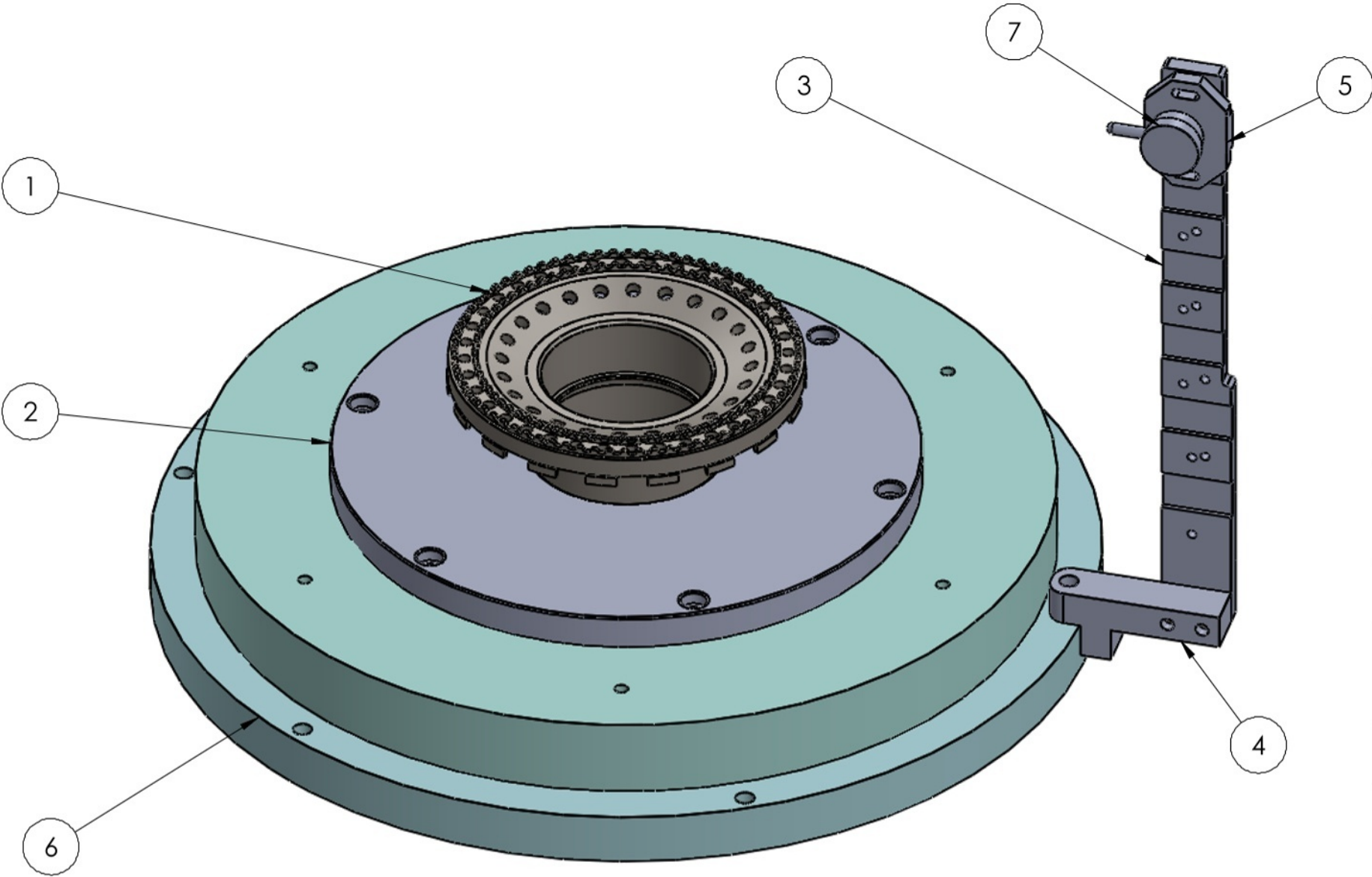


REVISIONS			
REV	DESCRIPTION	APPROVED	DATE



ITEM NO.	SHEET	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
1	3		Modified HPC Front Stub Shaft	EN40B STEEL	1
2	4		Rotary Table Chuck	MILD STEEL	1
3	6		Gauge Plate	MILD STEEL	1
4	7		Gauge Plate Mount	MILD STEEL	1
5	8		Dial Gauge Adapter	MILD STEEL	1
6	N/A	2C6625	Dummy Rotary Table	N/A	1
7	N/A	XUT29811	Dummy Gauge	N/A	1
8	N/A	MC - 91253A628	Hex Drive Flat Head Screw 3/8"-16 Thread 1-1/2" L	BLACK-OXIDE ALLOY STEEL	2

- NOTES:**
- MC - #: ORDERED FROM MCMASTER CARR OR EQUIVALENT
  - TO BE USED WITH BUILD TABLE PSE-641D-1B

DRAWN BY  
C. MCNEILL

DATE  
07/29/22

TITLE  
**RB211 GT HPC BLADE MEASUREMENT JIG**

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES AND  
TOLERANCES ARE::  
DIMENSIONS X.X± 0.05  
                  X.XX± 0.01  
                  X.XXX± 0.005  
ANGLES ±2

4

3

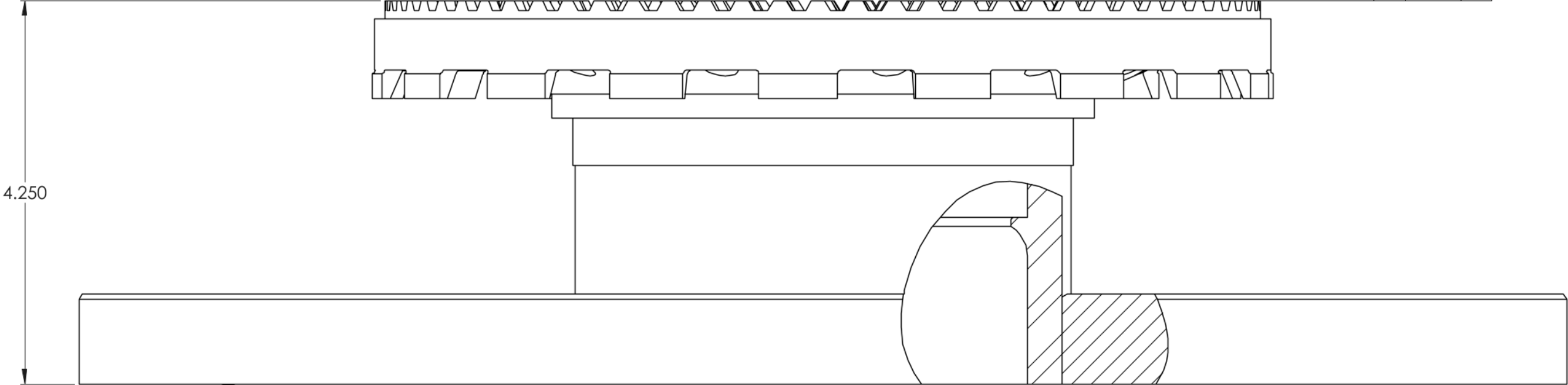
2

1

ROTARY TABLE CHUCK AND CURVIC ASSEMBLY

REVISIONS			
REV	DESCRIPTION	APPROVED	DATE

// .005 A



A

- NOTES:**
- ITEM 1 (LW16279) TO BE MODIFIED TO HEIGHT INDICATED (SHEET 3) AND MATED TO ITEM 2 VIA INTERFERENCE PRESS FIT

DRAWN BY  
C. MCNEILL

DATE  
07/29/22

TITLE  
RB211 GT HPC BLADE  
MEASUREMENT JIG

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES AND  
TOLERANCES ARE::  
**DIMENSIONS** X.X± 0.05  
                  X.XX± 0.01  
                  X.XXX± 0.005  
**ANGLES** ±2

4

3

2

1

B

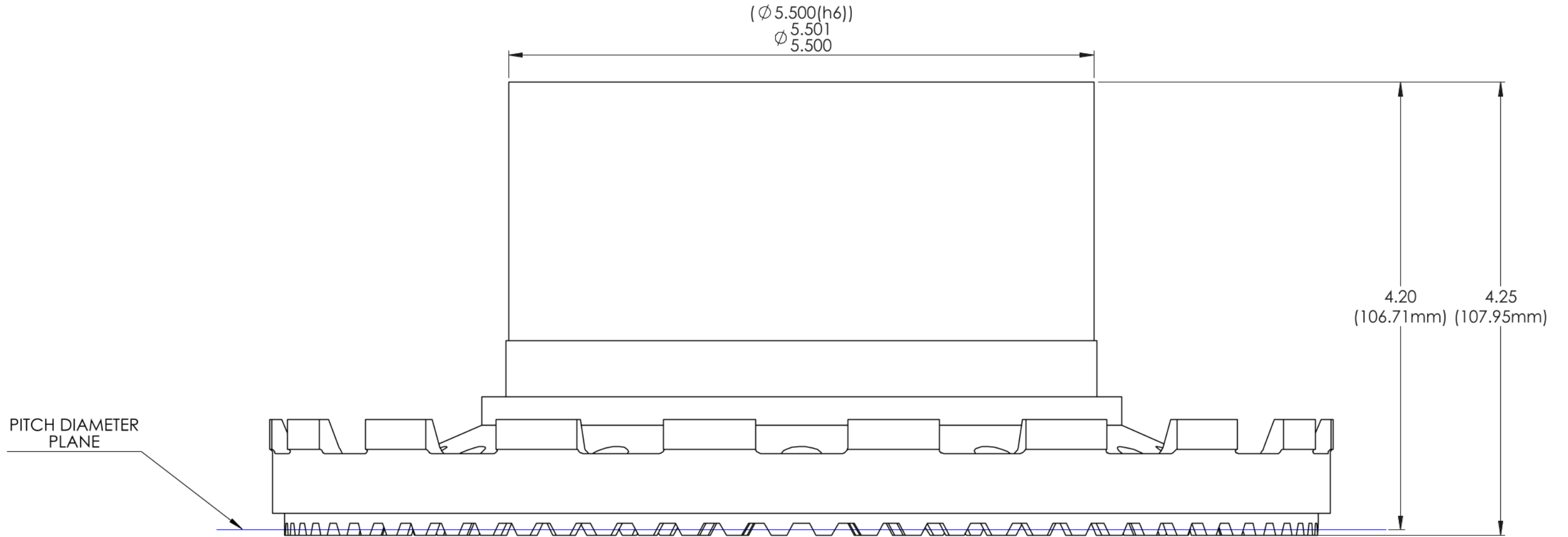
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A

A

ITEM 1: MODIFIED HPC FRONT STUB SHAFT

REVISIONS			
REV	DESCRIPTION	APPROVED	DATE



NOTES:

- REMOVE ALL BURRS AND BREAK SHARP EDGES (MAX 0.05 X 45°)
- ITEM 1 (LW16279) TO BE MODIFIED TO HEIGHT INDICATED AND MATED TO ITEM 2 VIA INTERFERENCE PRESS FIT
- MATERIAL: EN40B STEEL

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C. MCNEILL

DATE  
07/29/22

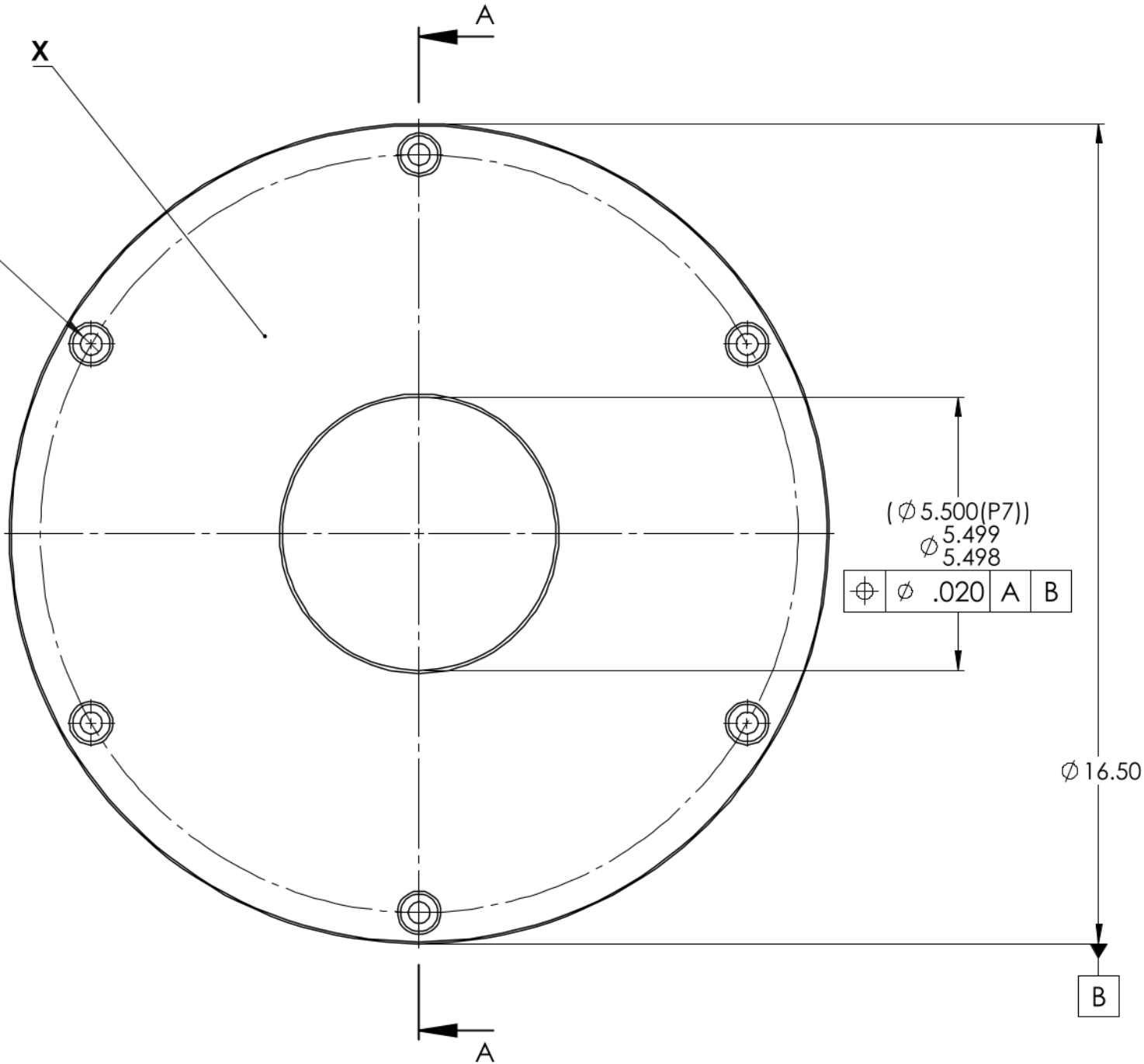
TITLE

RB211 GT HPC BLADE  
MEASUREMENT JIG

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES AND  
TOLERANCES ARE::  
**DIMENSIONS** X.X± 0.05  
                  X.XX± 0.01  
                  X.XXX± 0.005  
**ANGLES** ±2

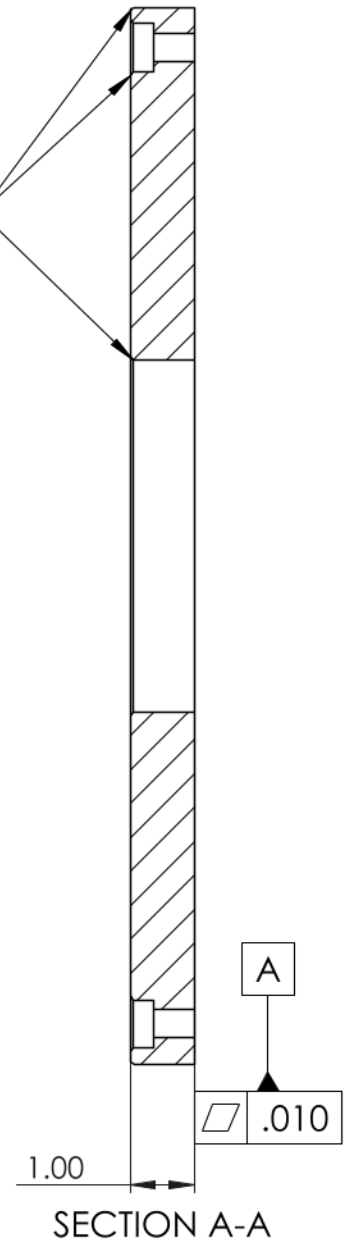
ITEM 2: ROTARY TABLE CHUCK

6 X Ø 0.44 THRU  
□ Ø0.75 ▽ 0.38  
EQUI-SPACED  
ON 15.25 BCD



(Ø 5.500(P7))  
5.499  
Ø 5.498  
⊕ Ø .020 A B

0.063 X 60°  
ALL EDGES ON FACE



NOTES:

- REMOVE ALL BURRS AND BREAK SHARP EDGES (MAX 0.05 X 45°)
- STAMP 'TCT5715-2' ON PART INDICATED BY X
- MATERIAL: MILD STEEL

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C. MCNEILL

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07/29/22

TITLE

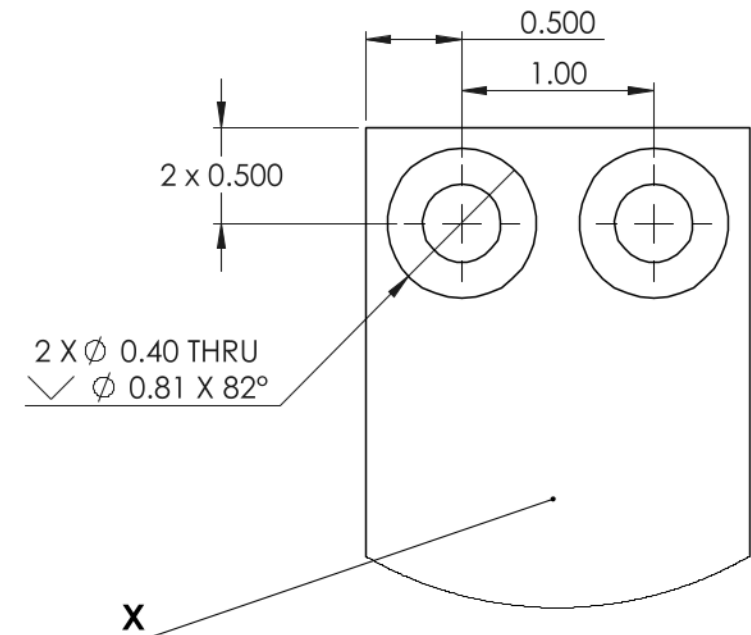
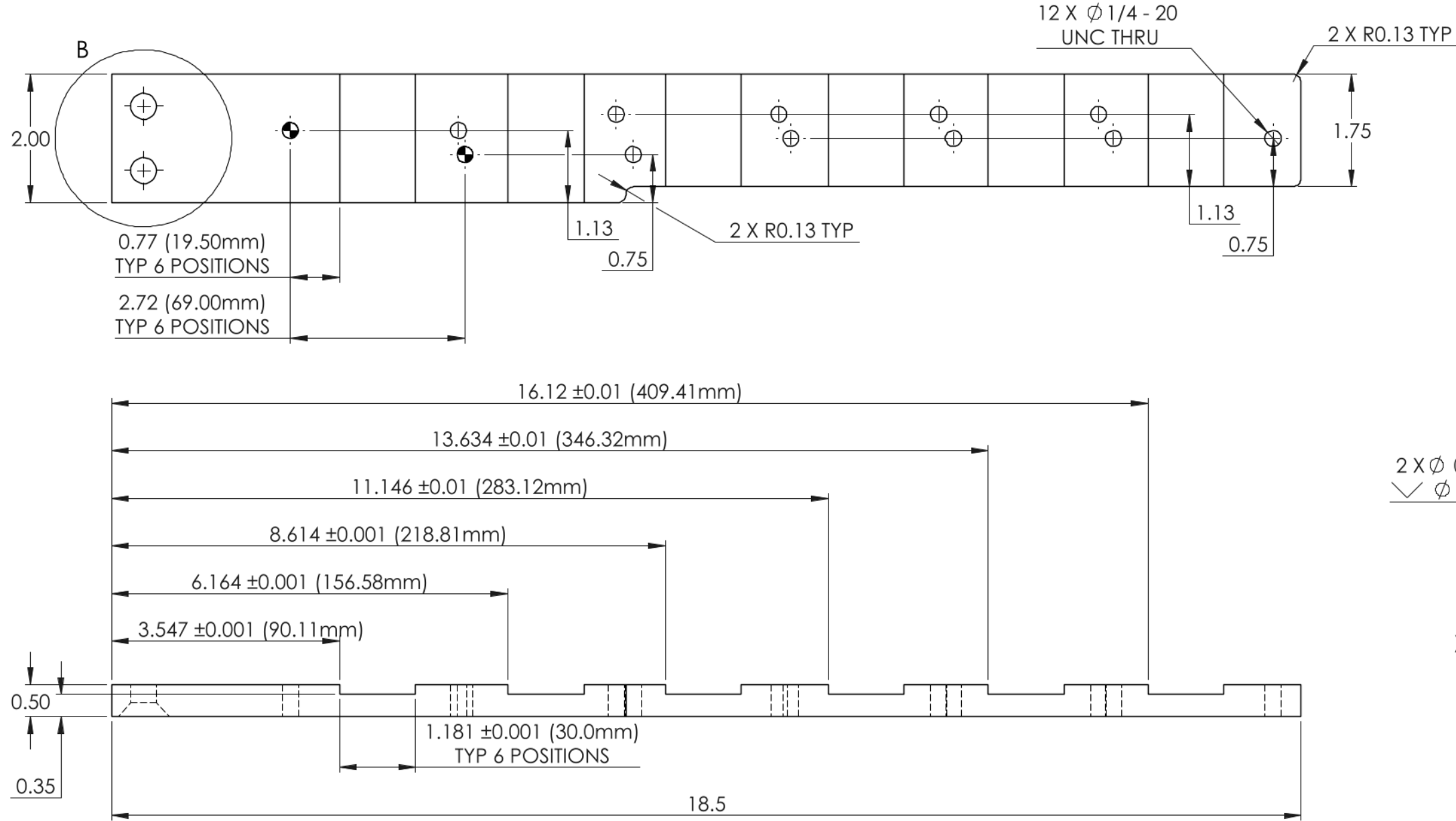
RB211 GT HPC BLADE  
MEASUREMENT JIG

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES AND  
TOLERANCES ARE::  
DIMENSIONS X.X± 0.05  
X.XX± 0.01  
X.XXX± 0.005  
ANGLES ±2

ITEM 3: GAUGE PLATE

REVISIONS

REV	DESCRIPTION	APPROVED	DATE



NOTES:

- REMOVE ALL BURRS AND BREAK SHARP EDGES (MAX 0.05 X 45°)
- STAMP 'TCT5715-3' ON PART INDICATED BY X
- MATERIAL: MILD STEEL
- PATTERNED HOLES ON FACE ARRANGED IN OFFSET PAIRS INDICATED BY -●- AND EACH PAIR DIMENSIONED AS SHOWN

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C. MCNEILL

DATE  
07/29/22

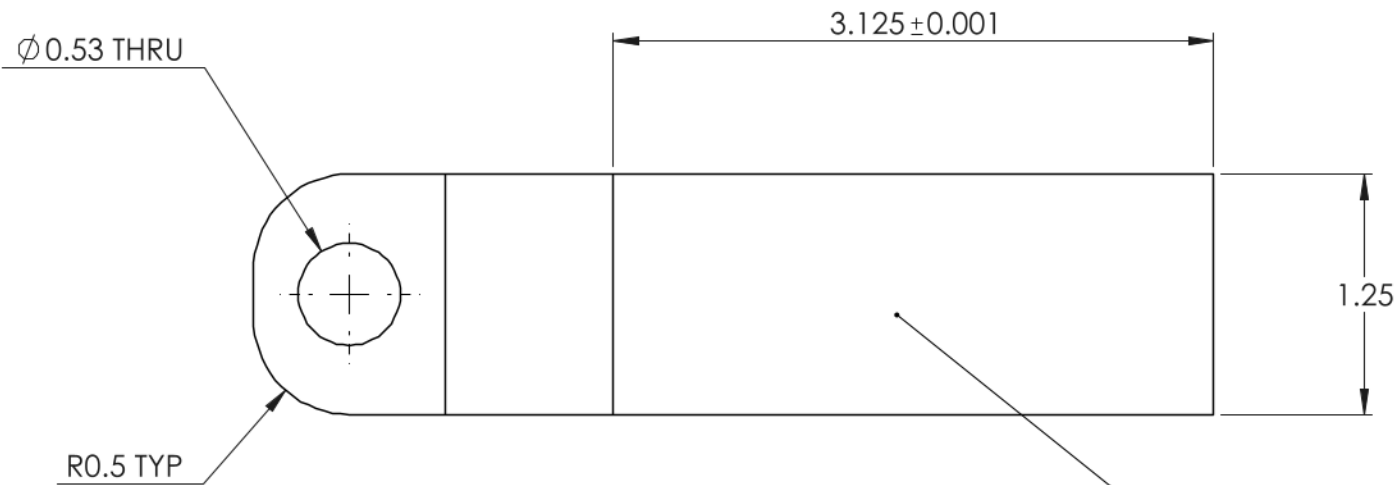
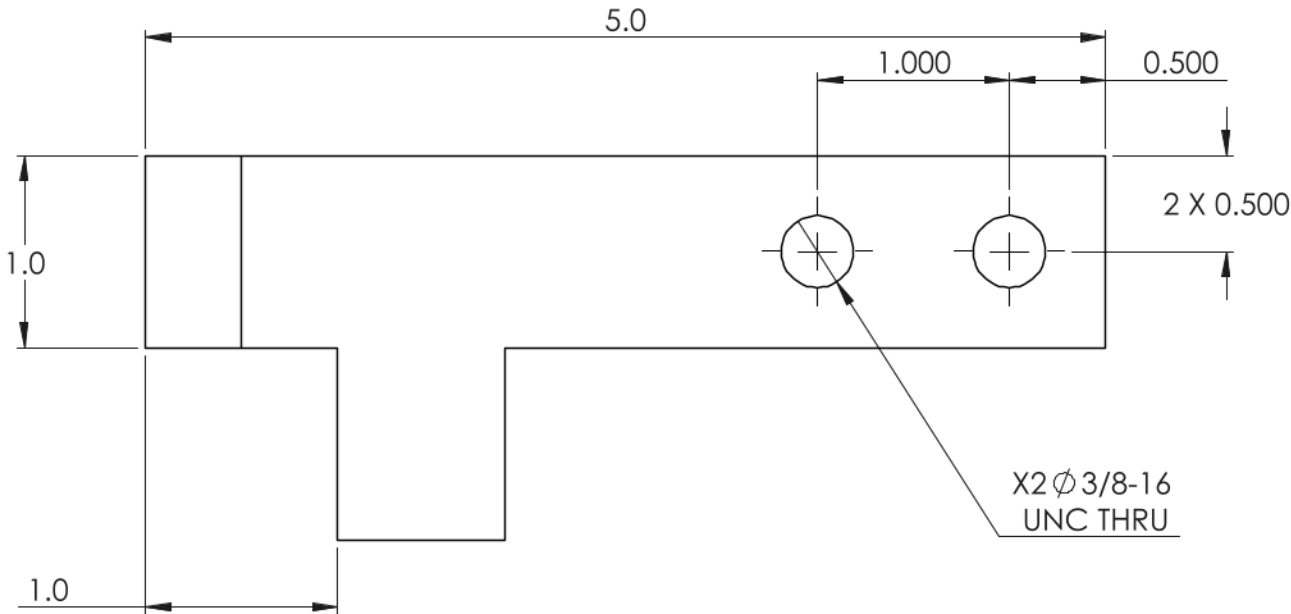
TITLE

RB211 GT HPC BLADE  
MEASUREMENT JIG

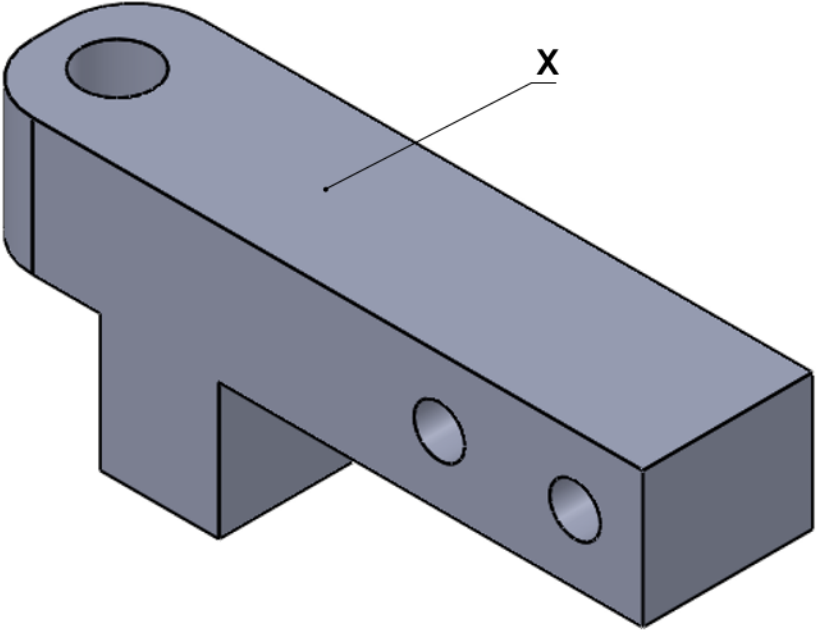
UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES AND  
TOLERANCES ARE:  
DIMENSIONS X.X ± 0.05  
X.XX ± 0.01  
X.XXX ± 0.005  
ANGLES ± 2

ITEM 4: GAUGE PLATE MOUNT

REVISIONS			
REV	DESCRIPTION	APPROVED	DATE



THIS SURFACE TO BE USED ALONG SIDE  
SLIP GAUGES TO ZERO DIAL GAUGE



NOTES:

- REMOVE ALL BURRS AND BREAK SHARP EDGES (MAX 0.05 X 45°)
- STAMP 'TCT5715-4' ON PART INDICATED BY X
- MATERIAL: MILD STEEL

DRAWN BY  
C. MCNEILL

DATE  
07/29/22

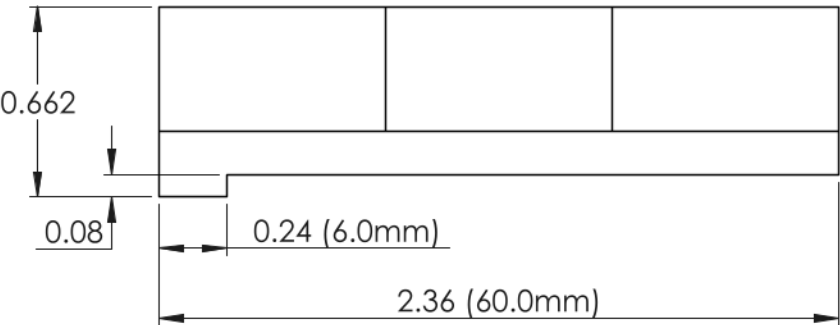
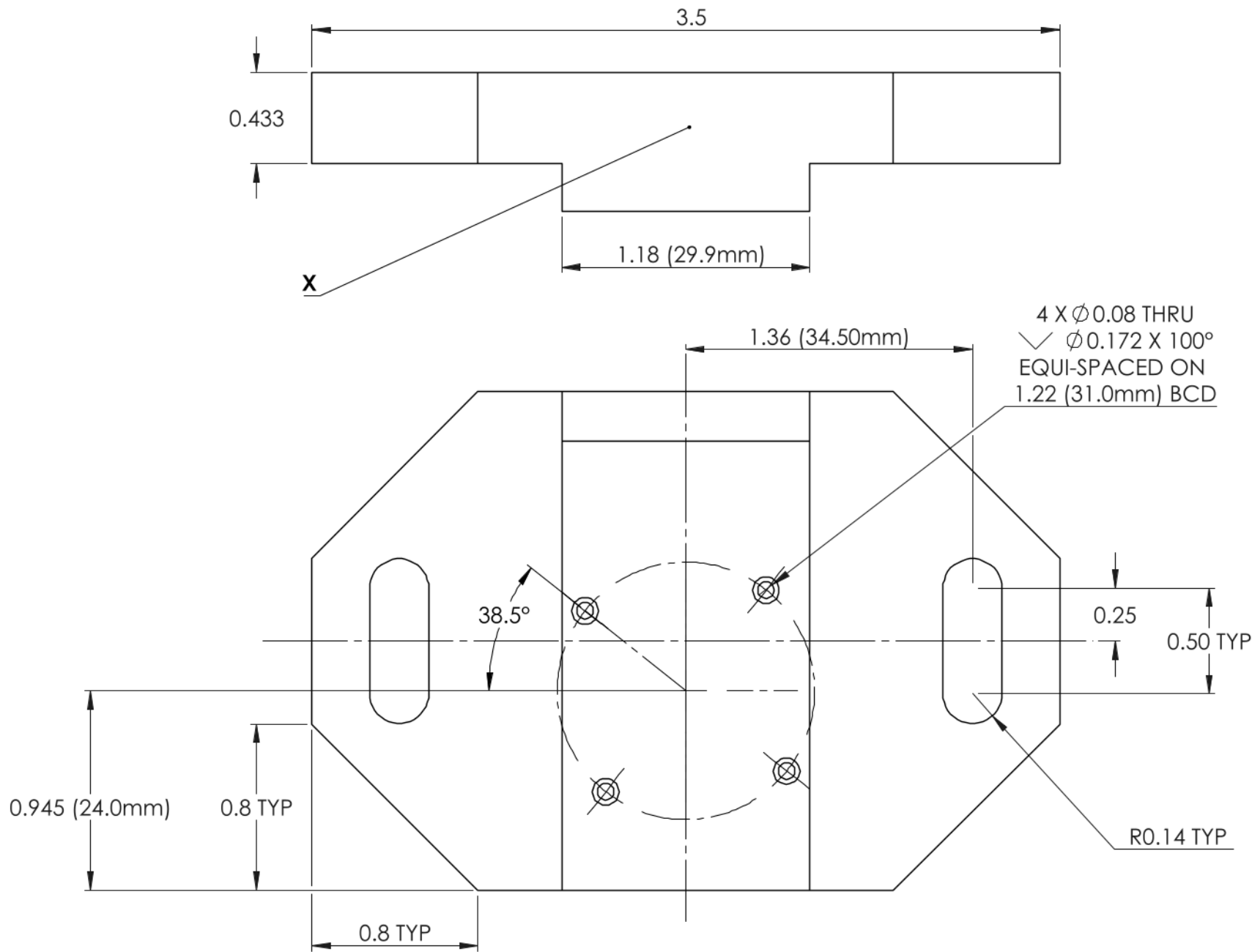
TITLE  
RB211 GT HPC BLADE  
MEASUREMENT JIG

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES AND  
TOLERANCES ARE::  
DIMENSIONS X.X ± 0.05  
X.XX ± 0.01  
X.XXX ± 0.005  
ANGLES ± 2



ITEM 5: DIAL GAUGE ADAPTER

REVISIONS			
REV	DESCRIPTION	APPROVED	DATE



- NOTES:**
- REMOVE ALL BURRS AND BREAK SHARP EDGES (MAX 0.05 X 45°)
  - STAMP 'TCT5715-5' ON PART INDICATED BY **X**
  - MATERIAL: MILD STEEL

DRAWN BY  
C. MCNEILL

DATE  
07/29/22

TITLE  
**RB211 GT HPC BLADE  
MEASURMENT JIG**

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES AND  
TOLERANCES ARE::  
**DIMENSIONS** X.X± 0.05  
X.XX± 0.01  
X.XXX± 0.005  
**ANGLES** ±2