

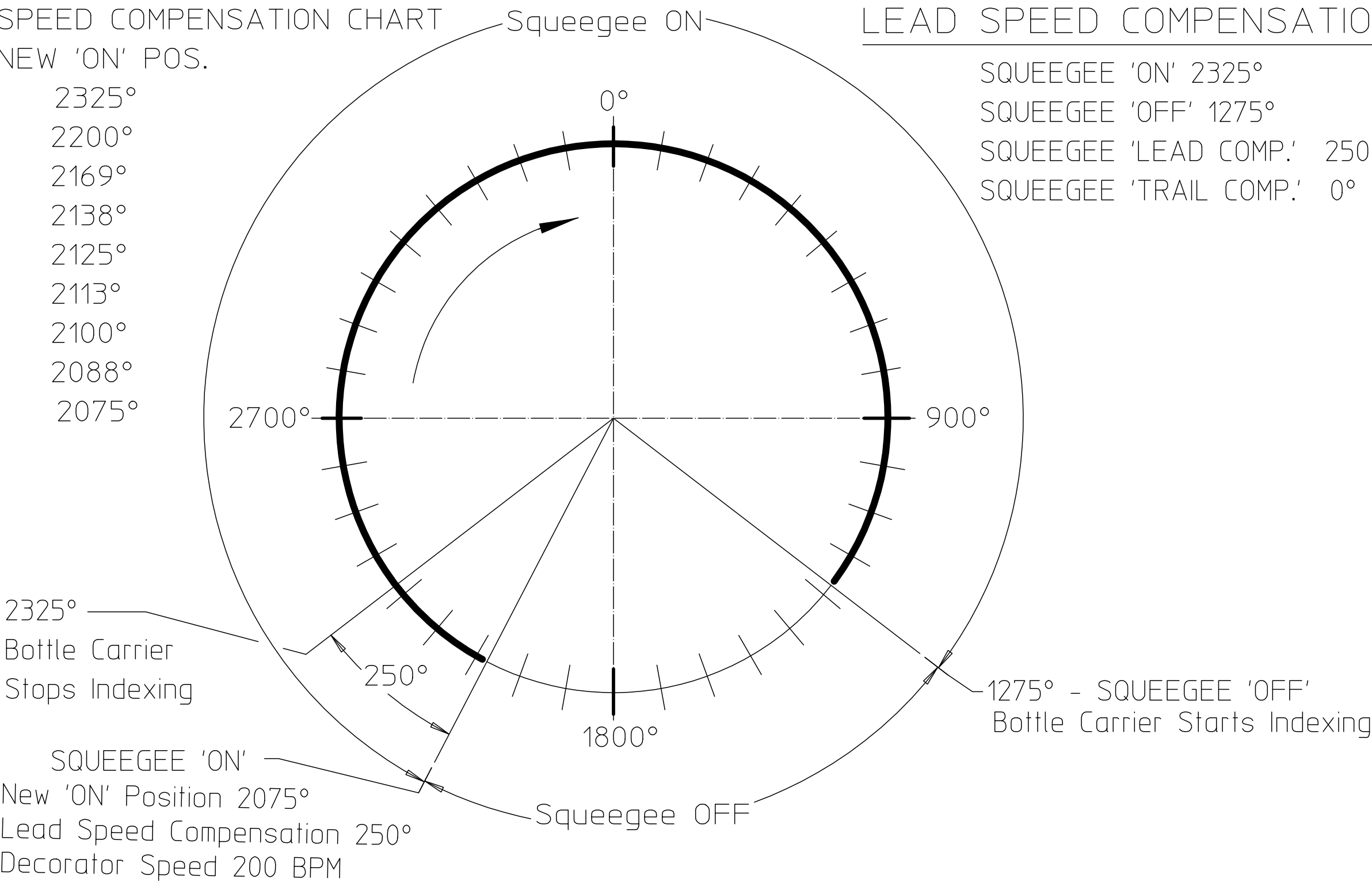
250° LEAD SPEED COMPENSATION CHART

SPEED NEW 'ON' POS.

50 BPM	2325°
100 BPM	2200°
125 BPM	2169°
150 BPM	2138°
160 BPM	2125°
170 BPM	2113°
180 BPM	2100°
190 BPM	2088°
200 BPM	2075°

LEAD SPEED COMPENSATION

SQUEEGEE 'ON' 2325°
SQUEEGEE 'OFF' 1275°
SQUEEGEE 'LEAD COMP.' 250°
SQUEEGEE 'TRAIL COMP.' 0°



CLS-200 SQUEEGEE TIMING LEAD SPEED COMP. LAYOUT

JOB ROUTING ☐ WELDING ☐ MACHINING ☐ FITTING ☐ COMMERCIAL ☐ REWORK COMMERCIAL ☐ OTHER SEE NOTE

MATR'L ORDER DESC.

MATR'L SUPPLIER

REV. | DATE | CHANGE

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DWN. <u>GMC</u> DATE <u>11/12/16</u> CHEK'D. _____ SCALE _____	
MACHINE SHOP TOLERANCES UNLESS SPECIFIED OTHERWISE	
± .015 DECIMAL DIMENSION	OTHER FINISH XX MICROINCH OR LESS
± 1/2° ANGULAR DIMENSION	BREAK SHARP EDGES .015" RAD. OR CHAM.
✓ MACHINE FINISH 80 MICROINCH	C'SINK THD. TO NOM. DIA. WITH A +.03 TOL.



Carl Strutz & Co., Inc.

Mars, PA

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