



NOTES:

- APPROXIMATE WEIGHT OF TOOL EXCLUDING PRODUCTION PART(S) = 632 KG
- SHIPPING ENVELOPE (L X W X H): 1720 MM X 1215 MM X 1183.8 MM
- PAINT SPEC: MACHINE GRAY ENAMEL
- SEE SHEET 2 FOR BOM
- SEE SHEET 3 FOR INSPECTION DIMENSIONS (TOLERANCE: $\pm .38$ MM)
- SEE SHEET 3 FOR ISO VIEW

UNSPECIFIED TOLERANCES SHOWN BELOW REF ISO 2700-1																				1. STAMP TOOL AND LOOSE PARTS WITH TOOL NUMBER. 2. BREAK ALL CORNERS NOT REQUIRED TO BE SHARP. 3. REFER TO J0V-24 FOR TOOL DESIGN STANDARDS.										ORIGINAL PART NO. SHEET SIZE: A MASS K6=632.6										VJ CORESOFT PVT. LTD CONFIDENTIAL AND PROPRIETARY. TO VJ CORP. UNAUTHORIZED USE, DISCLOSURE OR REPRODUCTION WITHOUT COPYRIGHT © VJ CORP.'S ALL RIGHTS RESERVED.																																																	
UNSPECIFIED MACHINING DIMENSIONS:																														DATE										JULY12										SHEET NO										1 OF 2																													
1.0±0.13 2.5±0.08 0.008±0.0015±0.001 0.008±0.0015±0.001 0.008±0.0015±0.001 0.008±0.0015±0.001																														DESIGN CONTROL:										DRAWN										ENT										TOOL DESCRIPTION										750J BELLY PAN TACK																			
UNSPECIFIED NON-MACHINED DIMENSIONS:																														TOLERANCES DO NOT ACCUMULATE. DO NOT SCALE DRAWING FOR DIMENSIONS.										SCALE										1:1										TOOL NUMBER										IMD103129																			
1.0±0.13 2.5±0.08 0.008±0.0015±0.001 0.008±0.0015±0.001 0.008±0.0015±0.001 0.008±0.0015±0.001																														EXCEPT AS NOTED TOLERANCES SHALL BE										METRIC										REFERENCES:										JDS-G113																													
MODEL RL 0 DRW RL DRW RE										LETTER A ENT										DATE JULY12										SHEET DECISION										REVISION NEW																																																	
±0.02 BETWEEN HOLES ±0.1 TO SCREW HOLES, NON ACCUMULATIVE																																																																																									

NOTES	DETAIL	SHEET	DESCRIPTION	QTY	ROUGH STOCK SIZE / SPEC	MATERIAL	MASS (KG)	HARD	PUR
	1	4	BURNOUT	1	BL GRD 25.4±.13//.13 X 1215.0 X 1720.0	1020	402.518		
	2	1	CLAMP	7	CQ-915-ATM	WOLVERINE	2.923		X
	3	9	PLATE	1	50.8 X 76.2 X 89.0	1020	2.18		
	4	9	PLATE	1	50.8 X 88.9 X 101.0	1020	3.018		
	5	1	6.5MM SHIM PACK	1	RM42-M89-M73-M11-M18-M27-M35-1C2D2E	RENTAPEN	0.265		X
	5-S	1	SHIM PACK - EXTRA	1	RM42-M89-M73-M11-M18-M27-M35-1C1D1E	RENTAPEN	0.265		X
	6	9	PLATE	1	50.8 X 127.0 X 103.0	1020	4.601		
	7	11	LOCATING PIN	2	Ø 31.8 X 67.0	A2	0.214	R/C 50-54	
	8	10	PLATE	2	25.4 X 38.1 X 51.0	1020	0.24		
	9	11	DIAMOND PIN	2	Ø 22.2 X 88.0	A2	0.146	R/C 50-54	
	10	9	PLATE	2	38.1 X 50.8 X 70.0	1020	0.76		
	11	9	PLATE	1	19.1 X 50.8 X 180.0	1018	1.248		
	12	10	PLATE	2	31.8 X 63.5 X 60.0	1020	0.725		
	13	1	6.5MM SHIM PACK	2	RM43-M60-M28-M11-M14-M10-M20-M20-1C2D2E	RENTAPEN	0.055		X
	13-S	1	SHIM PACK - EXTRA	1	RM43-M60-M28-M11-M14-M10-M20-M20-2C2D2E	RENTAPEN	0.055		X
	14	6	WELDMENT	2			2.186	NORM	
	14-A	6	PLATE	2	19.1 X 76.2 X 100.0	1020	1.14		
	14-B	6	BAR	2	31.8 X 50.8 X 108.0	1020	1.367		
	15	8	WELDMENT	1			1.406	NORM	
	15-A	8	PLATE	1	19.1 X 76.2 X 60.0	1020	0.684		
	15-B	8	PLATE	1	25.4 X 63.5 X 75.0	1020	0.881		
	15-C	8	BAR	1	9.5 X 25.4 X 70.0	1020	0.133		
	16	1	CLAMP PLATE	6	PCW30-15-100	MISUMI	0.303		X
	17	1	6.5MM SHIM PACK	4	RM42-M100-M30-M11-M15-M13-M74-1C2D2E	RENTAPEN	0.131		X
	17-S	1	SHIM PACK - EXTRA	1	RM42-M100-M30-M11-M15-M13-M74-4C4D4E	RENTAPEN	0.131		X
	18	1	SHCS	8	M10 X 120	STD	0.086		X
	19	10	PLATE	4	38.1 X 102.0 X 101.6	1020	2.794		
	20	7	WELDMENT	2			2.255	NORM	
	20-A	7	PLATE	2	19.1 X 88.9 X 120.0	1020	1.595		
	20-B	7	TUBE	2	50.8 X 50.8 X 3.2 X 63.0	STD	0.286		
	20-C	7	PLATE	2	19.1 X 76.2 X 76.2	1020	0.868		
	21	1	ALIGNMENT COUPLER	2	EAC-080M	E & E	0.251		X
ALTER	22	8	CLAMP	2	C-131-ATM	WOLVERINE	0.545		X
	23	6	WELDMENT	1			3.514	NORM	
	23-A	6	PLATE	1	19.1 X 76.2 X 100.0	1020	1.14		
	23-B	6	BAR	1	31.8 X 50.8 X 176.0	1020	2.228		
	23-C	6	PLATE	2	12.7 X 50.8 X 63.5	1020	0.322		
	24	1	HANDLE	4	CLM-200-SH-S	CARRLANE	0.048		X
	25	7	WELDMENT	2			2.582	NORM	
	25-A	7	PLATE	2	19.1 X 88.9 X 120.0	1020	1.595		
	25-B	7	TUBE	2	50.8 X 50.8 X 3.2 X 135.0	STD	0.613		
	25-C	7	PLATE	2	19.1 X 76.2 X 76.2	1020	0.868		
	26	5	WELDMENT	4			23.861	NORM	
	26-A	5	PLATE	4	25.4 X 127.0 X 200.0	1020	5.065		
	26-B	5	TUBE	4	101.6 X 101.6 X 6.4 X 755.0	STD	13.723		
	26-C	5	PLATE	4	25.4 X 152.4 X 200.0	1020	6.077		
	27	11	ROUND	1	Ø 38.1 X 103.0	1020	0.804		
	28	1	REST PAD	7	AST8	MISUMI	0.044		X
	29	1	SHCS	1	M8 X 120	STD	0.055		X
	30	8	WELDMENT	1			1.406	NORM	
	30-A	8	PLATE	1	19.1 X 76.2 X 60.0	1020	0.684		
	30-B	8	PLATE	1	25.4 X 63.5 X 75.0	1020	0.881		
	30-C	8	BAR	1	9.5 X 25.4 X 70.0	1020	0.133		
	31	9	PLATE	1	19.1 X 50.8 X 180.0	1018	1.248		
	32	1	CLAMP PLATE	8	PCW30-15-50	MISUMI	0.127		X
	33	1	6.5MM SHIM PACK	8	RM42-M50-M30-M11-M15-M13-M24-1C2D2E	RENTAPEN	0.055		X
	33-S	1	SHIM PACK - EXTRA	1	RM42-M50-M30-M11-M15-M13-M24-8C8D8E	RENTAPEN	0.055		X
	34	1	SHCS	4	3/8"-16 X 1.75"	STD	0.034		X
	35	1	SHCS	4	3/8"-16 X .88"	STD	0.022		X
	36	6	WELDMENT	4			2.225	NORM	
ALTER	36-A	6	HINGE PLATE ASM.	4	HIPB-1	PEERLESS	1.97		X
	36-B	6	PLATE	4	25.4 X 31.8 X 50.8	1020	0.322		
	37	1	SHCS	4	3/8"-16 X 1.5"	STD	0.031		X
	38	1	DOWEL	8	3/8" X 1.0"	STD	0.014		X
	39	10	PLATE	2	19.1 X 44.5 X 88.0	1020	0.46		
ALTER	40	1	HAND CLAMP	1	462	DESTACO	0.577		X
	41	11	ROUND	1	Ø 25.4 X 36.0	4140 PH	0.032		
	42	11	LOCATING PIN	1	Ø 63.5 X 41.0	A2	0.369	R/C 50-54	
	43	10	BAR	2	38.1 X 19.1 X 101.6	1018	0.551		
	44	11	LASER	3	Ø 50.8 X 3.2	1020	0.049		
	45	6	WELDMENT	1			3.514	NORM	
	45-A	6	PLATE	1	19.1 X 76.2 X 100.0	1020	1.14		
	45-B	6	BAR	1	31.8 X 50.8 X 176.0	1020	2.228		
	45-C	6	PLATE	2	12.7 X 50.8 X 63.5	1020	0.322		
	46	1	6.5MM SHIM PACK	7	RM03-M25-M11-1C2D2E	RENTAPEN	0.02		X
	46-S	1	SHIM PACK - EXTRA	1	RM03-M25-M11-7C7D7E	RENTAPEN	0.02		X
	47	10	PLATE	2	25.4 X 38.1 X 72.0	1020	0.376		
	48	1	SHOULDER SCREW	4	Ø 10 MM X 30 (M8 THD)	STD	0.033		X
	49	1	BUSHING	4	PM-26-16-18.00	CARRLANE	0.034		X
	50	1	6.5MM SHIM PACK	2	RM42-M60-M51-M11-M10-M15-M30-1C2D2E	RENTAPEN	0.105		X
	50-S	1	SHIM PACK - EXTRA	1	RM42-M60-M51-M11-M10-M15-M30-2C2D2E	RENTAPEN	0.105		X
	51	10	BAR	7	101.6 X 76.2 X 76.2	1018	4.323		
	52	11	DIAMOND PIN	2	Ø 76.2 X 25.0	A2	0.36	R/C 50-54	
	53	1	SET SCREW	2	M6 X 20	STD	0.004		X
	54	2	HAWK NAMEPLATE	1	HT-NP-001	HAWK	0.179		X
	55	1	SET SCREW	2	M8 X 25	STD	0.009		X
	56	1	HHCS	7	M12 X 50	STD	0.057		X
	57	1	BUSHING	4	PM-15-25-10.00	CARRLANE	0.019		X
	IM222293	1	SHCS	6	M6 X 10	STD	0.005		X
	IM222295	1	SHCS	8	M6 X 16	STD	0.007		X
	IM222301	1	SHCS	2	M8 X 20	STD	0.015		X
	IM222302	1	SHCS	6	M8 X 25	STD	0.017		X
	IM222303	1	SHCS	2	M8 X 30	STD	0.019		X
	IM222308	1	SHCS	16	M10 X 25	STD	0.029		X
	IM222309	1	SHCS	37	M10 X 30	STD	0.032		X
	IM222310	1	SHCS	4	M10 X 35	STD	0.035		X
	IM222311	1	SHCS	8	M10 X 40	STD	0.038		X
	IM222312	1	SHCS	2	M10 X 45	STD	0.041		X
	IM222333	1	SHCS	16	M16 X 45	STD	0.117		X
	IM222818	1	SHCS	2	M10 X 70	STD	0.057		X
	IM222820	1	SHCS	2	M10 X 90	STD	0.069		X
	IM222821	1	SHCS	1	M10 X 100	STD	0.075		X
	IM222822	1	SHCS	1	M12 X 60	STD	0.073		X
	IM222825	1	SHCS	1	M12 X 80	STD	0.091		X
	IM222827	1	SHCS	28	M12 X 100	STD	0.109		X
	IM223299	1	DOWEL	6	Ø6 X 14	STD	0.003		X
	IM223300	1	DOWEL	2	Ø6 X 16	STD	0.003		X
	IM223302	1	DOWEL	2	Ø6 X 20	STD	0		X
	IM223318	1	DOWEL	4	Ø8 X 24	STD	0.009		X
	IM223337	1	DOWEL	28	Ø10 X 30	STD	0.018		X
	IM223339	1	DOWEL	8	Ø10 X 35	STD	0.021		X
	IM223623	1	THIN NUT	2	M6	STD	0.002		X
	IM223624	1	THIN NUT	2	M8	STD	0.003		X
	IM223626	1	THIN NUT	1	M10	STD	0.006		X
	IM223627	1	THIN NUT	7	M12	STD	0.009		X

NOTE: ALL QTY'S ARE TOTAL REQ'D FOR TOOL

UNSPECIFIED TOLERANCES SHOWN BELOW REF ISO 2768-M			
UNSPECIFIED MACHINING DIMENSIONS:			
±1.0PT0.1	±1.5mm	±0.025 (PT0.001)	±1.5mm
±0.05 (PT0.002)	±2.5mm	±0.050 (PT0.002)	±2.5mm
±0.05 (PT0.002)	±5.0mm	±0.050 (PT0.002)	±5.0mm
±0.05 (PT0.002)	±1.5mm	±0.050 (PT0.002)	±1.5mm

UNSPECIFIED NON-MACHINED DIMENSIONS:			
±1.0PT0.1	±1.5mm	±0.050 (PT0.002)	±1.5mm
±0.05 (PT0.002)	±2.5mm	±0.050 (PT0.002)	±2.5mm
±0.05 (PT0.002)	±5.0mm	±0.050 (PT0.002)	±5.0mm
±0.05 (PT0.002)	±1.5mm	±0.050 (PT0.002)	±1.5mm

TOLERANCES DO NOT ACCUMULATE. DO NOT SCALE DRAWING FOR DIMENSIONS.			
EXCEPT AS NOTED TOLERANCES SHALL BE:			
±0.02 BETWEEN DOWELS			
±0.1 TO SCREW HOLES. NON ACCUMULATIVE			

1. STAMP TOOL AND

LOOSE PARTS WITH

TOOL NUMBER.

2. BREAK ALL CORNERS

NOT REQUIRED TO BE

SHARP.

3. REFER TO JGV-24

FOR TOOL DESIGN

STANDARDS.

DESIGN CONTROL:

DATE 1JULY12

DRAWN ENT

CHECKED

SCALE 1:1

METRIC REFERENCES: JDS-G113

ORIGINAL PART NO.

SHEET SIZE: A0

MASS KG=632.6

DESIGN CONTROL:

DATE 1JULY12

DRAWN ENT

CHECKED

SCALE 1:1

METRIC REFERENCES: JDS-G113

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DESIGN CONTROL:

DATE 1JULY12

DRAWN ENT

CHECKED

SCALE 1:1

METRIC REFERENCES: JDS-G113

TOOL NUMBER

IMD103129

2 OF 2

750J BELLY PAN TACK