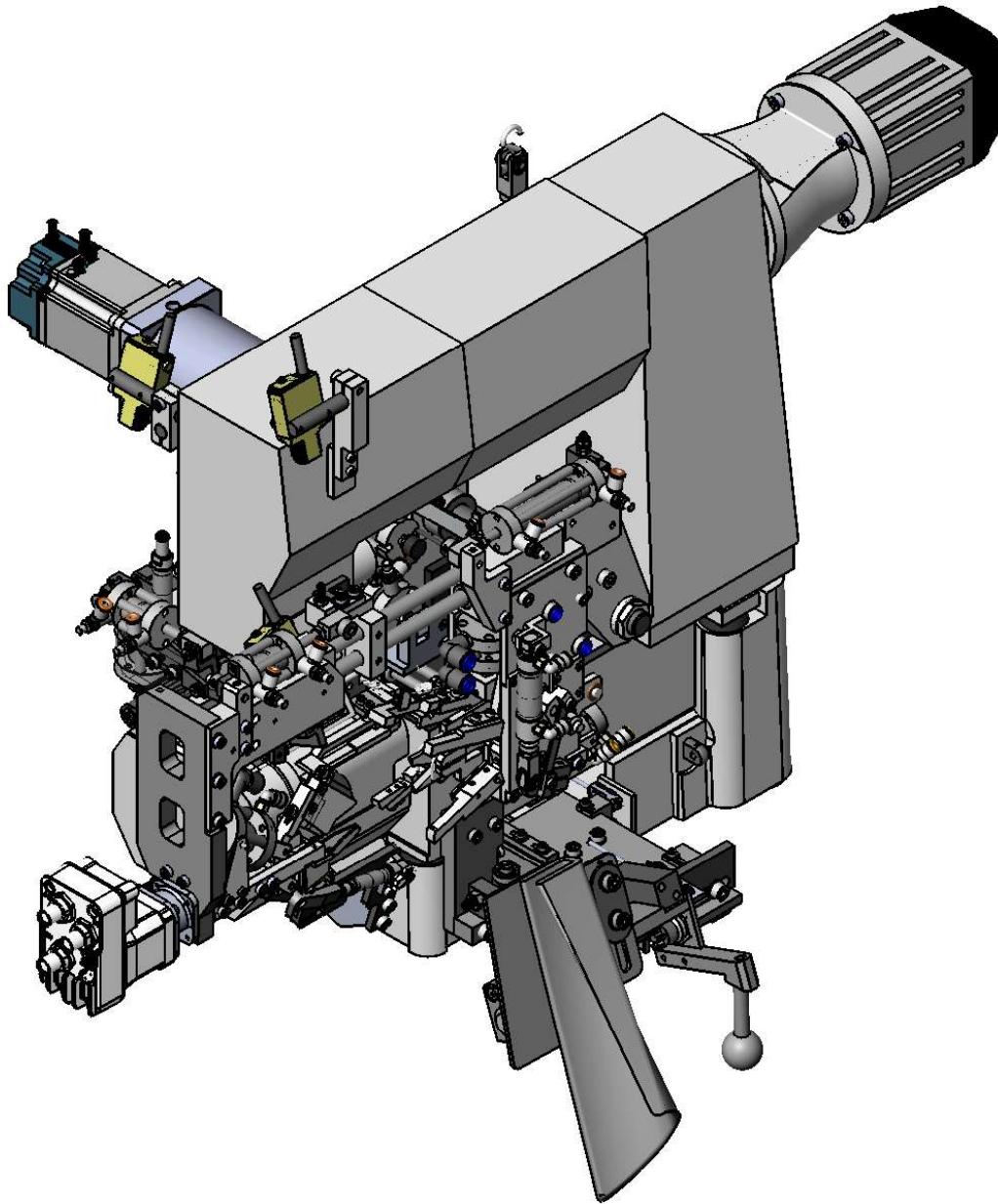


# GTN1828 ASSEMBLY GUIDE

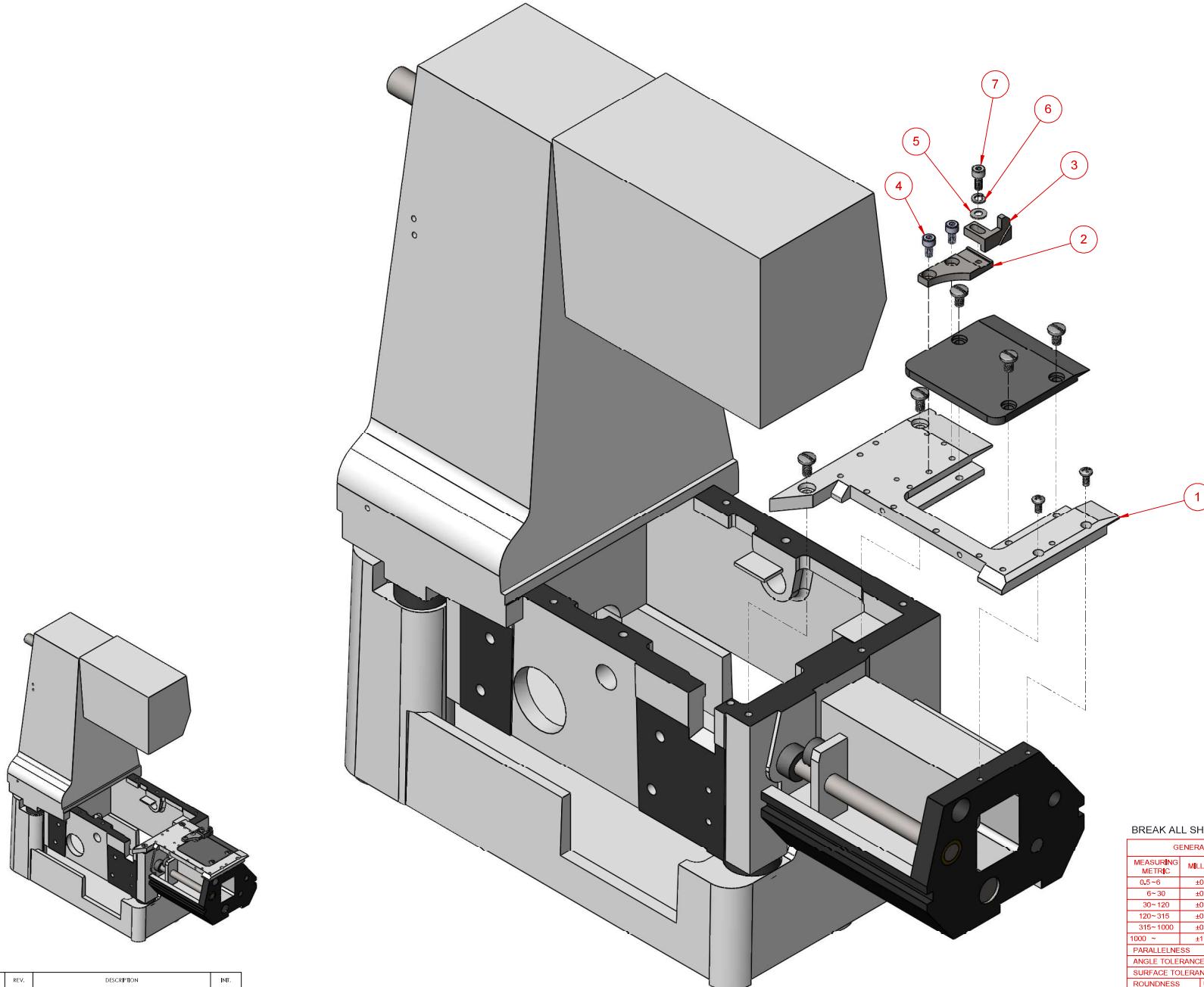


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012789A	THROAT PLATE BASE (W10-4A)	1
2	G012798	SUPPORT, BOTTOM SLOTTED (W10-4B)	1
3	G012799	SUPPORT, TOP (W10-4B)	1
4	GSSC318	SHCS M3 X 18	1
5	GSSC316	SHCS M3 X 16	1
6	G012797A	ROD, THREADED (11A)	1
7	GWF0500	M5 FW	3
8	GWF0501	M5 FW (OD 15mm)	1
9	GN00500	NUT, M5 HEX	1
10	G012801	CRANK (W10-4C)	1
11	G012800	JOINT (W10-4CB)	1
12	G012802	SHORT PIN W FLATS (11B)	1
13	GSSS304	SET SCREW (M3 X .4	1
14	2489K28	ONE-WAY BEARING (11C)	3
15	G012803	GEAR (W10-4D)	1
16	GSSS508	M5 X .8 SHSS, 8MM LONG	3
17	G012804	PLATE, MOUNTING (W10-4D)	1
18	G012805	LONG PIN W FLATS (11D)	1
19	G012809	ROLLER BEARING (W11-1A+1E)	1
20	7421K1	THRUST WASHER (W11-1A+1F)	2
21	GSSC412	M4 X 12 SHCS	2
22	G012811	PLATE, SMALL MOUNT (W10-4E)	1
23	G012812	ANGLE, ADJUSTABLE (W10-4E)	1
24	GSSC408	M4 X 8 SHCS	2
25	GWF0400	FLAT WASHER M4	1
26	GWL0400	LW M4	1
27	GSSC410	SHCS M4 X 10	1
28	G013650	COVER (W10-6A)	1
29	G013660	GUIDE, COVER (W10-4F)	1
30	GWF0300	FW M3	2
31	G014043	DBL NUT	1
32	GSSC308	SHCS M3 X 8	2
33	G013976	MODIFIED CASTING MOUNT (W11-6B)	1
34	G013978	MODIFIED COUPLING (W11-6C)	1
35	DC1200	EFLKA MOTOR	1
36	G013980	MOTOR MOUNT	1
37	GSSC515	M5 X 15 SHCS	2
38	GSSC525	MSX25 SHCS	4
39	G013982	WHEEL (W10-6E)	1
40	GSSC450	SHCS M4 X 50	1
41	G013981	COVER (W11-6F)	1

Tracking No. V0005445

GENERAL TOLERANCE						
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard Dpth,
6~30	±0.2	±0.25	±0.5	Heat Trmt.		Model No.,
30~120	±0.3	±0.45	±0.7	Finish		3021001B
120~315	±0.5	±0.6	±1.0	Material		CARBARIT
315~1000	±0.8	±1.1	±1.5			Customer
1000 ~	±1.2	±1.8	-			Part No.,
PARALLELNESS						
			1/100			Assy No.,
ANGLE TOLERANCE						
			1/100			Date
SURFACE TOLERANCE						
	0.2/100					Scale : 1:2
ROUNDNESS						
	UNDER 30% TOLERANCE					Size : " D"
SURFACE FINISH NOT TO EXCEED						
	83	UNLESS OTHERWISE SPECIFIED				

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	



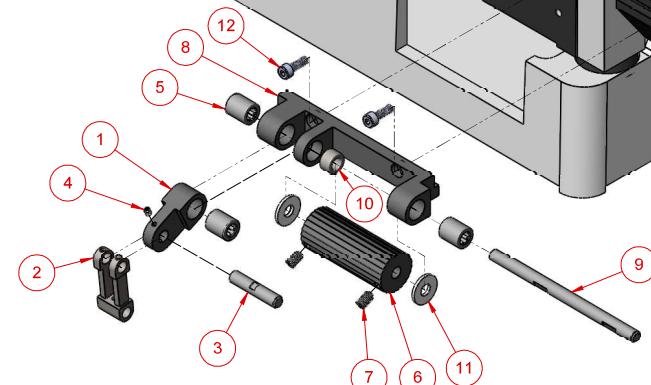
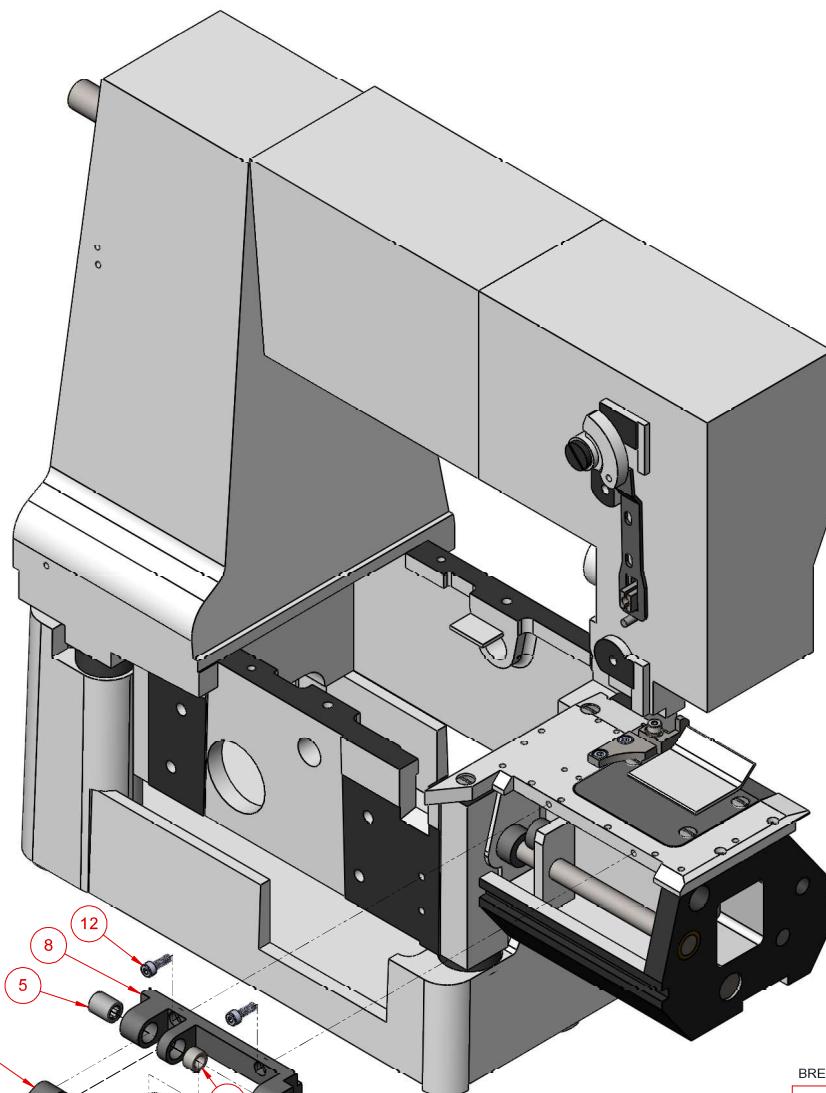
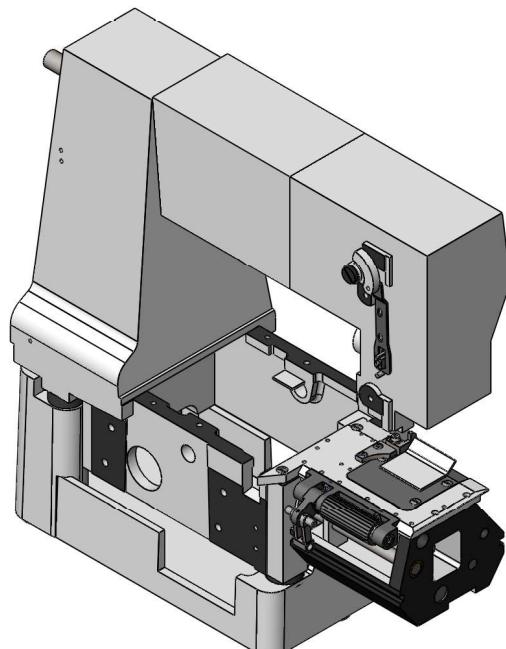
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012789A	THROAT PLATE BASE (W10-4A)	1
2	G012811	PLATE, SMALL MOUNT (W10-4E)	1
3	G012812	ANGLE, ADJUSTABLE (W10-4EB)	1
4	GSSC408	M4 X 8 SHCS	2
5	GWF0400	FLAT WASHER M4	1
6	GWL0400	LW M4	1
7	GSSC410	SHCS M4 x 10	1

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				Hard Dpth,	
0.5~6	±0.2	±0.2	±0.4	Hardness			Model No.,	GTN1928
6~30	±0.2	±0.25	±0.5	Heat Trmt.			Machine No.,	3022001B
30~120	±0.3	±0.45	±0.7	Finish			Customer	CARHARITI
120~315	±0.5	±0.6	±1.0	Material			Part No.,	G013916EX1
315~1000	±0.8	±1.1	±1.5				Assy No.,	G013812
1000 ~	±1.2	±1.8	-				Date :	3/17/15
PARALLELNESS			1/100				Scale :	1:1 Size : "D"
ANGLE TOLERANCE			1/100					
SURFACE TOLERANCE			0.2/100					
ROUNDNESS			UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED	83	UNLESS OTHERWISE SPECIFIED		TZ				

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012801	CRANK (W10-4C)	1
2	G012800	JOINT (W10-4CB)	1
3	G012802	SHORT PIN W FLATS (W1-1A-1B)	1
4	GSSS304	SET SCRW M3 X 4	1
5	2489K28	ONE WAY BEARING (W1-1A-1B)	3
6	G012803	GEAR (W10-4D)	1
7	GSSS508	M5 X .8 SHSS, 8MM LONG	2
8	G012804	PLATE, MOUNTING (W10-4DB)	1
9	G012805	LONG PIN W FLATS (W1-1A-1D)	1
10	G012809	ROLLER BEARING (W11-1A-1E)	1
11	7421K1	THRUST WASHER (W11-1A-1F)	2
12	GSSC412	M4 X 12 SHCS	2



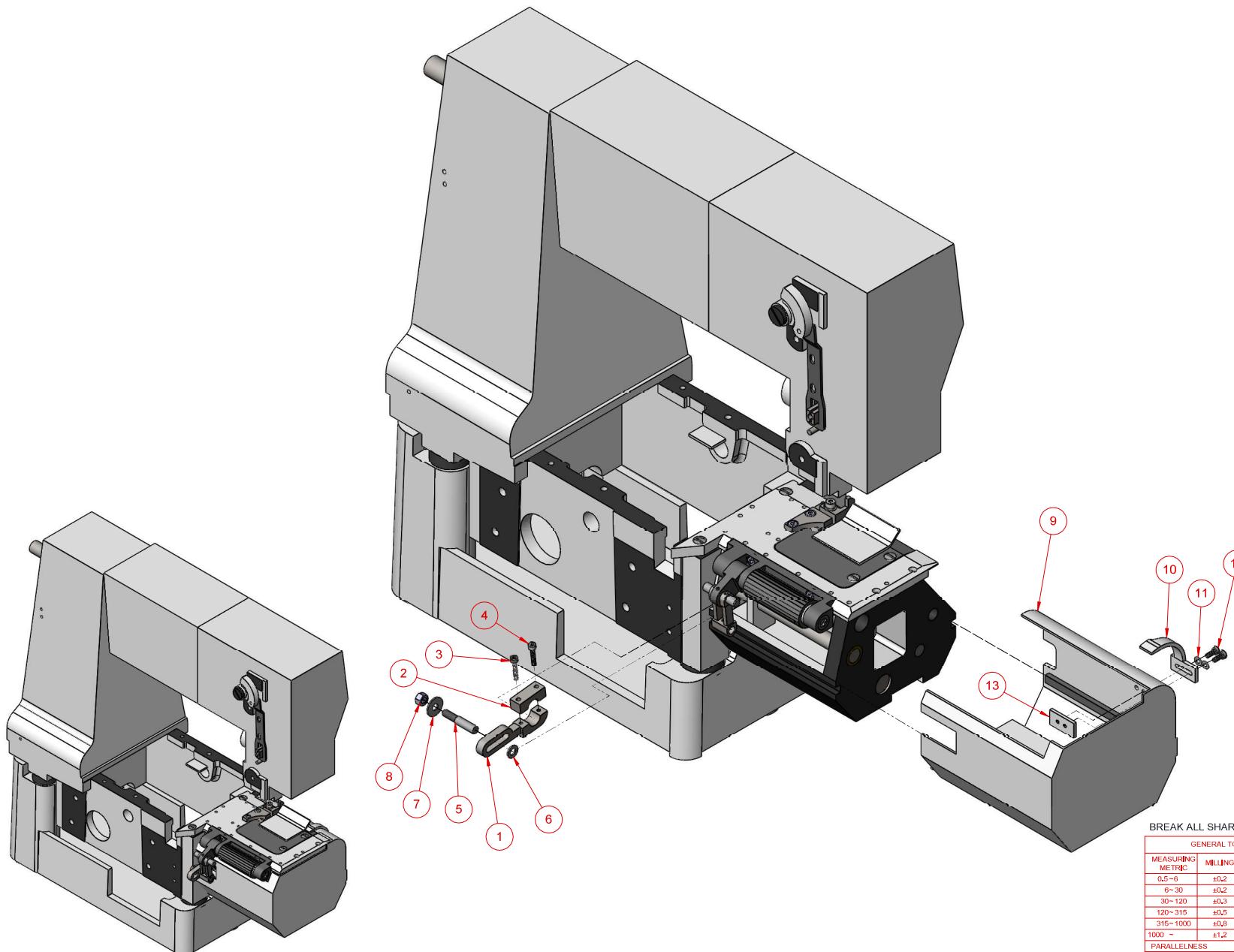
BREAK ALL SHARP EDGES

GENERAL TOLERANCE					
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.
0.5~6	±0.2	±0.2	±0.4	Hardness	
6~30	±0.2	±0.25	±0.5	Heat Trmt.	
30~120	±0.3	±0.45	±0.7	Finish	
120~315	±0.5	±0.6	±1.0	Material	
315~1000	±0.8	±1.1	±1.5	Part/Assy Name	
1000 ~	±1.2	±1.8	-		
PARALLELNESS			1/100		
ANGLE TOLERANCE			1/100		
SURFACE TOLERANCE			0.2/100	Drawn By	Checked By
ROUNDNESS			UNDER 30% TOLERANCE		Approved
SURFACE FINISH NOT TO EXCEED	83	UNLESS OTHERWISE SPECIFIED		TZ	

Tracking No. V0005445

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

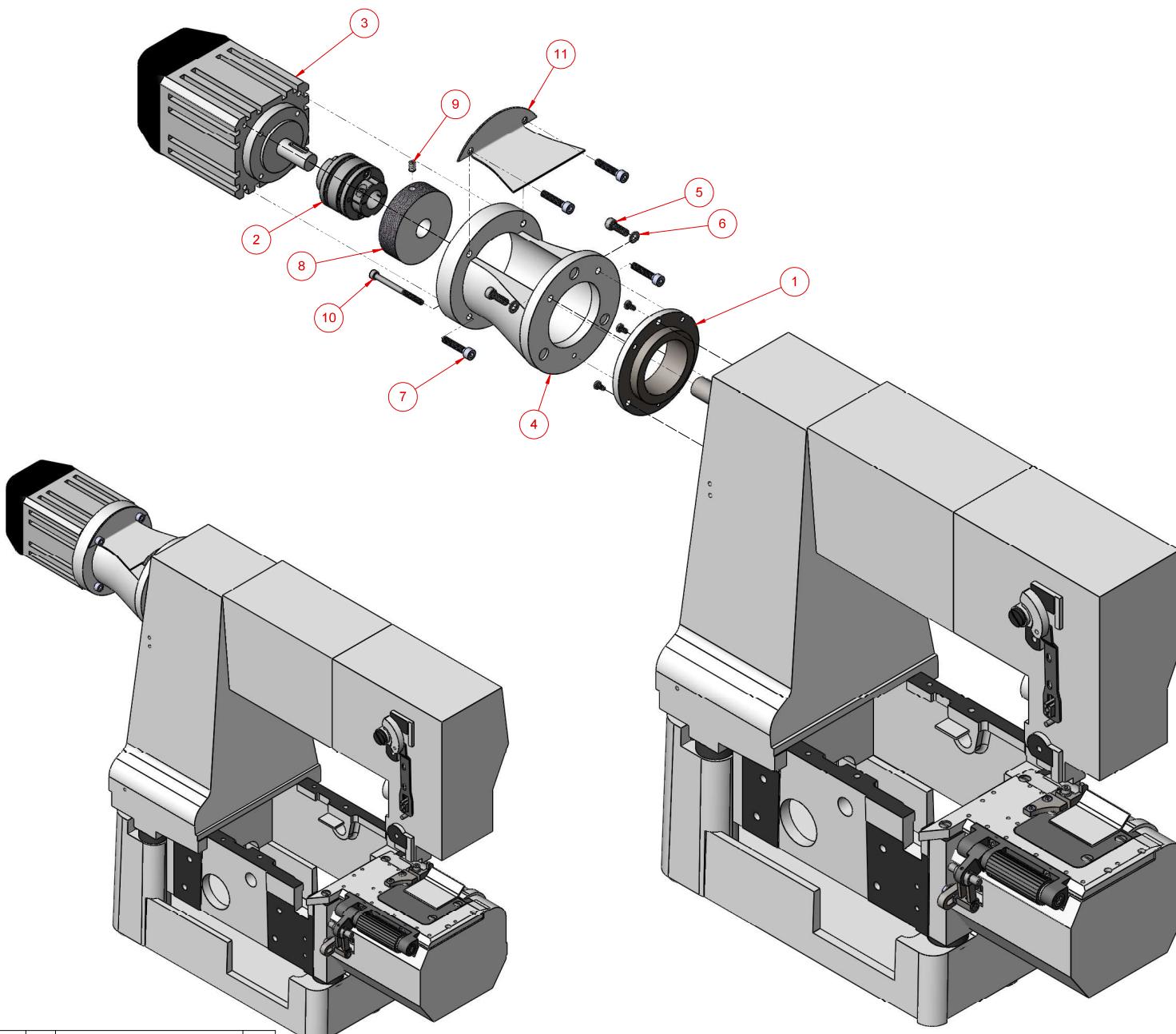
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012798	SUPPORT, BOTTOM SLOTTED (W10-4B)	1
2	G012799	SUPPORT, TOP (W10-4BB)	1
3	GSSC318	SHCS M3 X 18	1
4	GSSC316	SHCS M3 X 16	1
5	G012797A	ROD, THREADED (11A)	1
6	GWF0500	M5 FW	1
7	GWF0501	M5 FW (OD 15mm)	1
8	GH00500	NUT, M5 HEX	1
9	G013850	COVER (W10-6A)	1
10	G013860	GUIDE, COVER (W10-4F)	1
11	GWF0300	FW M3	2
12	GSSC308	SHCS M3 X 8	2
13	G014043	DBL NUT	1



GENERAL TOLERANCE		Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING		
0.5~6	±0.2	±0.2	±0.4	Hardness	
6~30	±0.2	±0.25	±0.5	Heat Trmt.	
30~120	±0.3	±0.45	±0.7	Finish	
120~315	±0.5	±0.6	±1.0	Material	
315~1000	±0.8	±1.1	±1.5		
1000 ~	±1.2	±1.8	-	Part/Assy Name	
PARALLELNESS			1/100		
ANGLE TOLERANCE			1/100		
SURFACE TOLERANCE			0.2/100	Drawn By	Checked By
ROUNDNESS			UNDER 30% TOLERANCE		Approved
SURFACE FINISH NOT TO EXCEED	83	UNLESS OTHERWISE SPECIFIED		TZ	

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

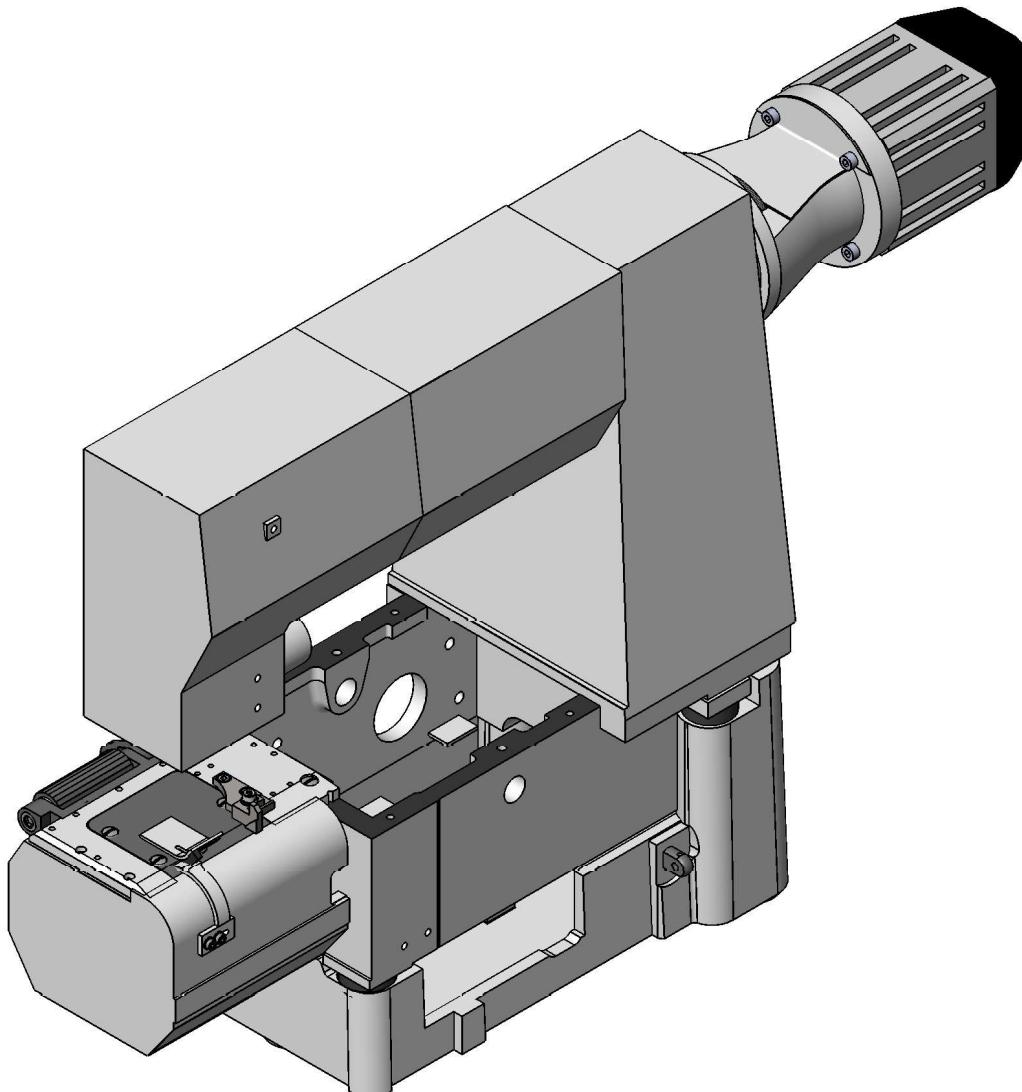
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013976	MODIFIED CASTING MOUNT (W11-6B)	1
2	G013978	MODIFIED COUPLING (W11-4C)	1
3	DC1200	EFLKA MOTOR	1
4	G013980	MOTOR MOUNT	1
5	GSSC515	M5 x 15 SHCS	2
6	GWP0500	M5 PW	2
7	GSSC525	M5x25 SHCS	4
8	G013982	WHEEL (W10-6E)	1
9	GSSS508	M5 X .8 SHSS, 8MM LONG	1
10	GSSC450	SHCS M4 x 50	1
11	G013981	COVER (W11-4F)	1



GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.	
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard Dpth.		
6~30	±0.2	±0.25	±0.5	Heat Trmt.		Model No.	GTN1928	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	3022001B	
120~315	±0.5	±0.6	±1.0	Material		Customer	CARHARITI	
315~1000	±0.8	±1.1	±1.5			Part No.	G013916EX4	
1000 ~	±1.2	±1.8	-			Assy No.	G013812	
PARALLELNESS			1/100			Date	3/17/15	
ANGLE TOLERANCE			1/100			Scale	: 1:1	Size : 1" D"
SURFACE TOLERANCE			0.2/100					
ROUNDNESS			UNDER 30% TOLERANCE			Drawn By	Checked By	Approved
SURFACE FINISH NOT TO EXCEED	83	UNLESS OTHERWISE SPECIFIED		TZ				

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

STEP 1: G013916

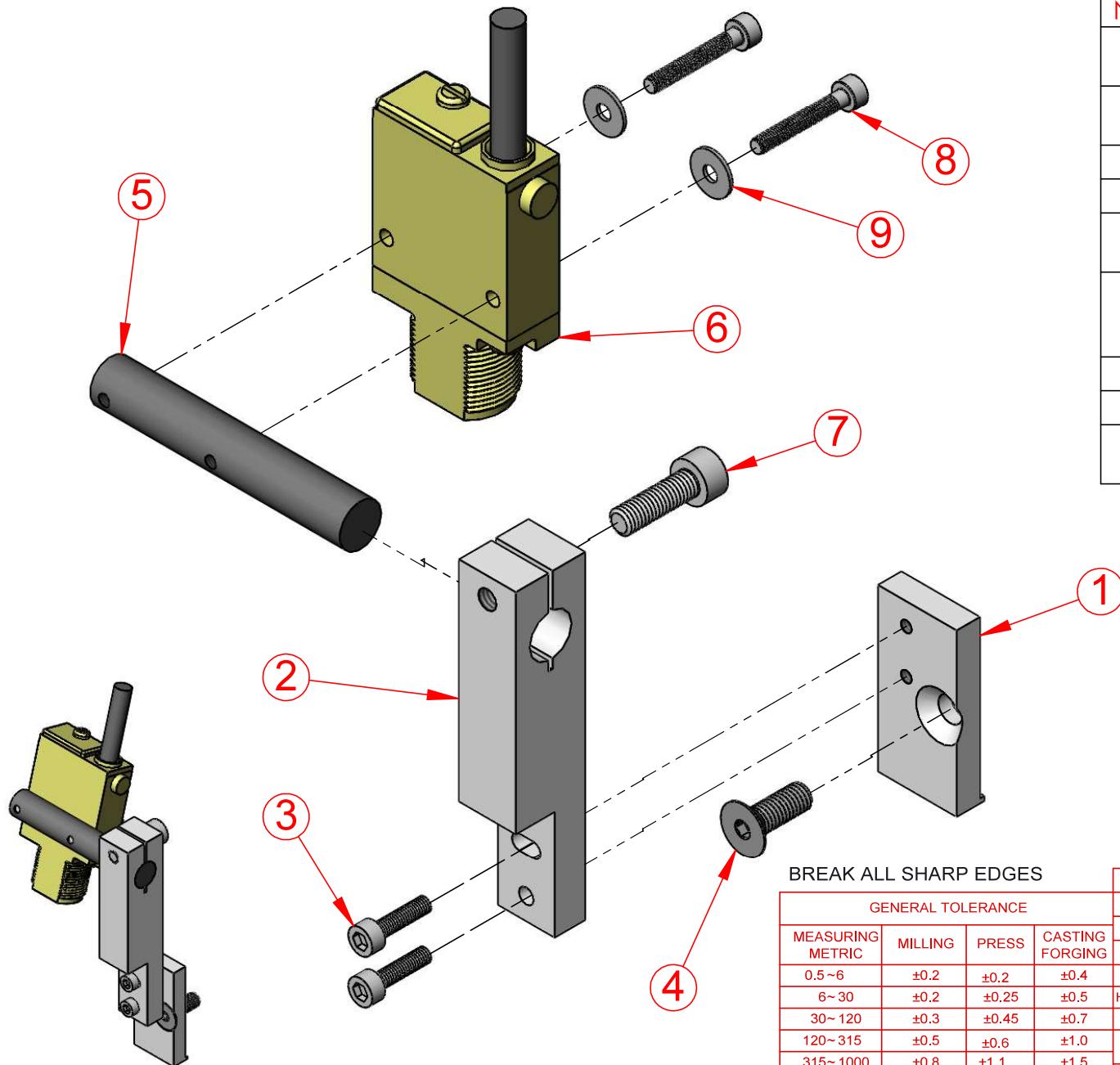


GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Hard Dpth.	Init.
0.5~6	+0.2	+0.2	+0.4	Hardness				
6~30	+0.2	+0.25	+0.5	Heat Trmt.				
30~120	+0.3	+0.45	+0.7	Finish				
120~315	+0.5	+0.6	+1.0	Material				
315~1000	+0.8	+1.1	+1.5					
1000 ~	+1.2	+1.8	-					
PARALLELNESS			1/100					
ANGLE TOLERANCE			1/100					
SURFACE TOLERANCE			0.2/100					
ROUNDNESS			UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED	$\sqrt{3}$		UNLESS OTHERWISE SPECIFIED	TZ				

GTN 1828  
G013919  
9/22/15  
Scale : 1:1.3 Size : 1" D"

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013693	SENSOR BLOCK (32A)	1
2	G013694	PEC MOUNT (W10-5BB)	1
3	GSSC312	M3 X 12 SHCS	2
4	GSSF514	M5 X 14 FHCS	1
5	G013696	PEC SHAFT (15C)	1
6	G013695	BANNER SENSOR (W10-5D)	1
7	GSSC516	M5 X 16 SHCS	1
8	GSSC320	M3 X 20 SHCS	2
9	GWF0300	FLAT WASHER, M3	2



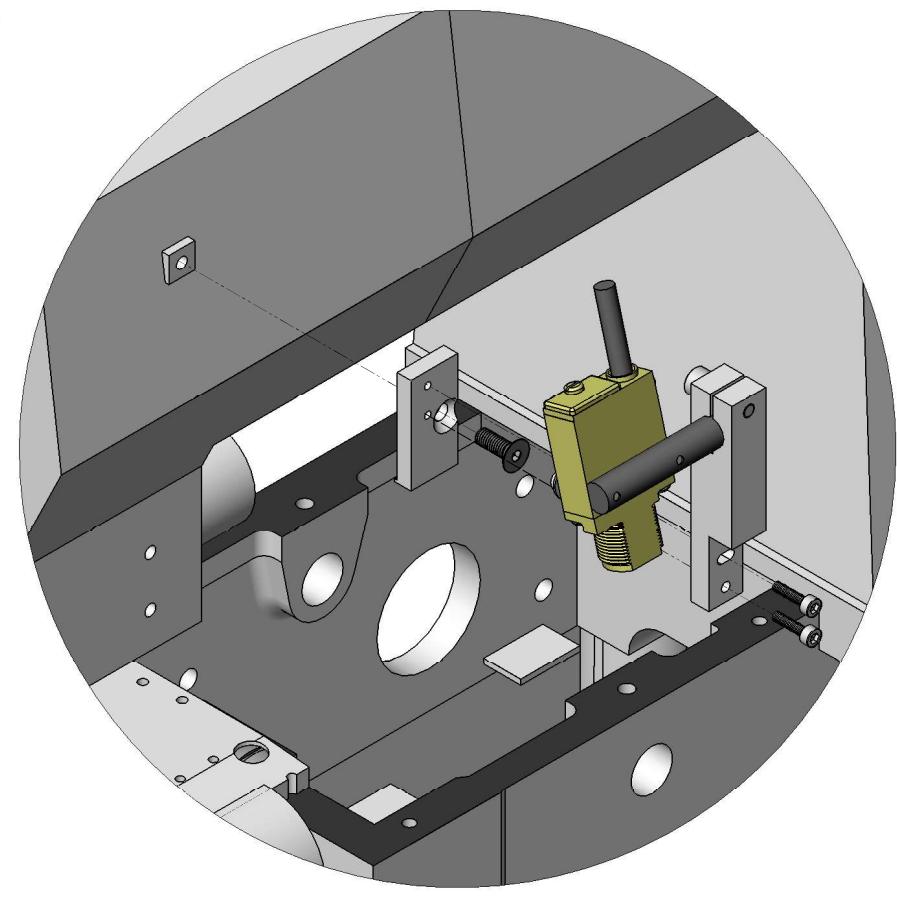
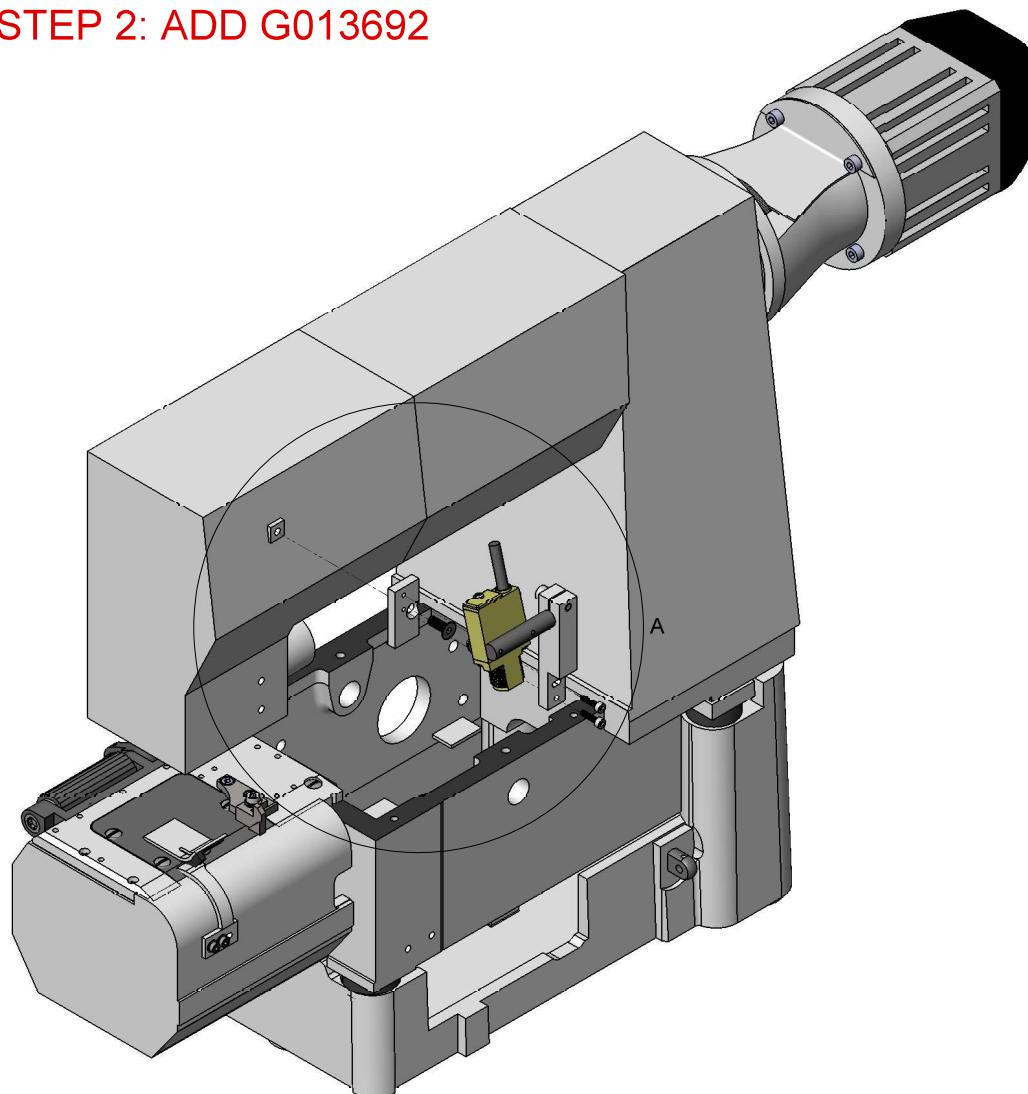
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5~6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.			Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material			Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5	Part/ Ass'y Name	FRONT UPPER SENSOR ASM		Part No.	G013692EX
1000 ~	±1.2	±1.8	-				Ass'y No.	G013692
PARALLELNESS				Date			Date	12/3/14
ANGLE TOLERANCE							Scale :	1:1
SURFACE TOLERANCE							Size :	''A''
ROUNDNESS				Drawn By	Checked By	Approved		
SURFACE FINISH NOT TO EXCEED				TZ				
63 UNLESS OTHERWISE SPECIFIED								

GTN, INC.  
1

STEP 2: ADD G013692

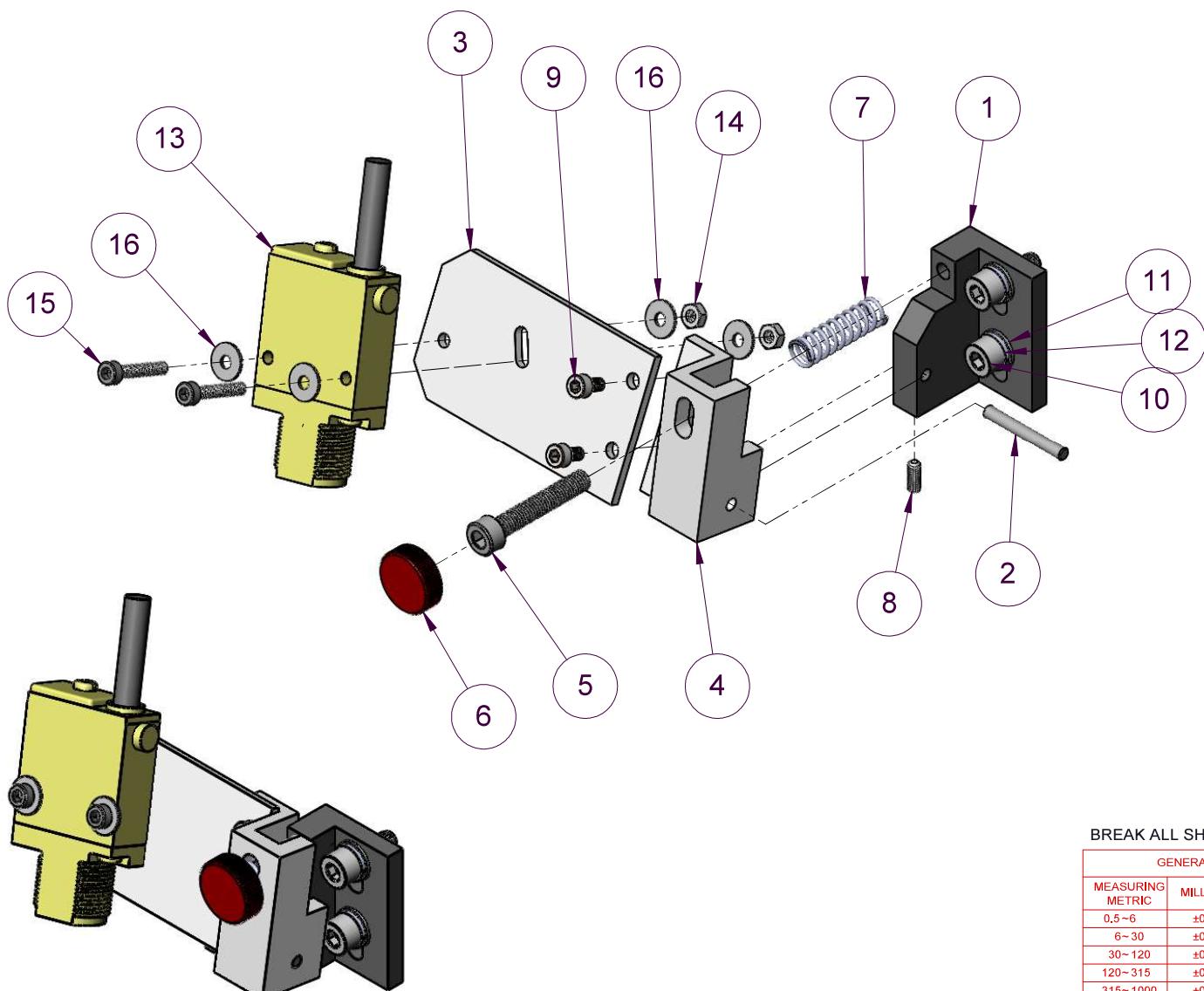


DETAIL A  
SCALE 1.5 : 1

GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Hard.Dpth.	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness				
6~30	±0.2	±0.25	±0.5	Heat Trmt.			Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	3022001B
120~315	±0.5	±0.6	±1.0	Material			Customer	CARIBARIT
315~1000	±0.8	±1.1	±1.5				Part No.	G013919
1000 ~	±1.2	±1.8	-				Assy No.	G013919
PARALLELNESS			1/100				Date	9/22/15
ANGLE TOLERANCE			1/100				Scale	: 1:1.3 Size : " D"
SURFACE TOLERANCE			0.2/100	Drawn By	Checked By	Approved		
ROUNDNESS			UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED  UNLESS OTHERWISE SPECIFIED							TZ	

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013682	PEC MOUNT (W11-5E)	1
2	98381A475	DOWEL 1/8 X 1 (62H)	1
3	G013680	PEC PLATE (35G)	1
4	G013681	PEC PIVOT	1
5	91290A254	5 X 30	1
6	91175A633	THUMB SCRW (32C)	1
7	9657K302	SPRING (32B)	1
8	GSSS308	M3 X 8 SET SCREW	1
9	GSSC306	SCREW, M3X6 SHCS	2
10	GSSC514	5MM, L14, SHCS	2
11	GWF0500	M5 FW	2
12	GWL0500	WASHER, M5 LOCK	2
13	G013695	BANNER SENSOR (W10-5D)	1
14	GN00300	HEX NUT, 3MM	2
15	GSSC318	SHCS M3 X 18	2
16	GWF0300	FLAT WASHER, M3	4



DATE	REV.	DESCRIPTION	INIT
REVISIONS			

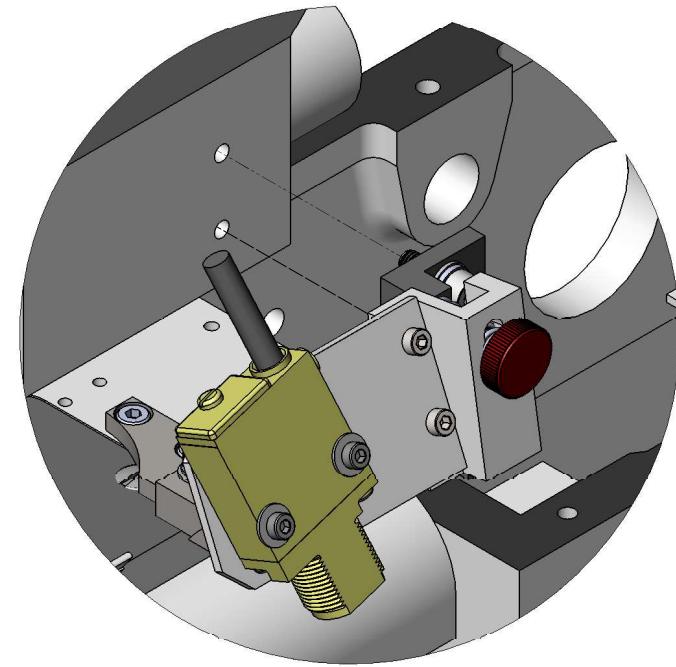
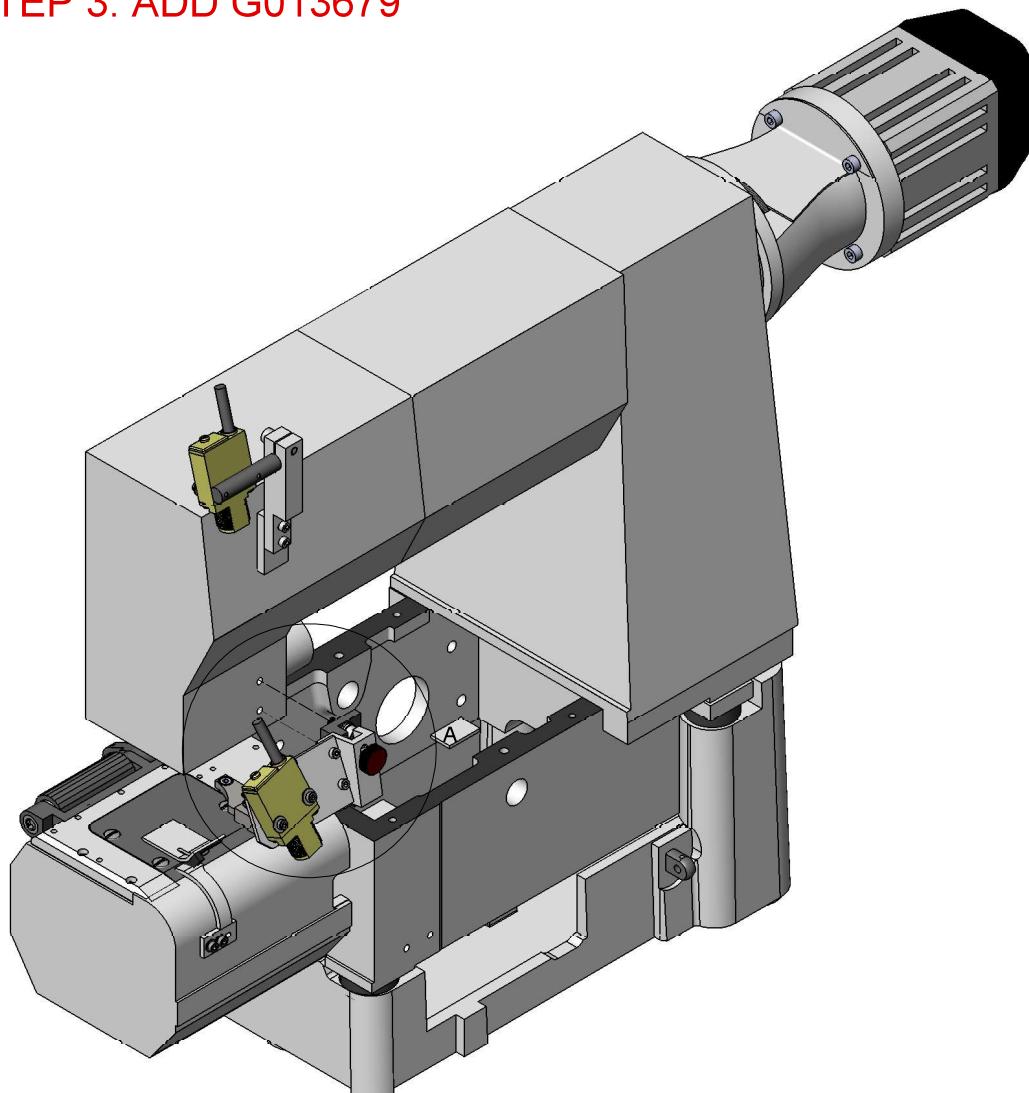
#### BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish	G013679	Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material		Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5			Part No.	G013679EX
1000 ~	±1.2	±1.8	-	Ass'y No.	G013679	Ass'y No.	
PARALLELNESS		1/100		Date	12/3/14	Scale :	1:1
ANGLE TOLERANCE		1/100		Size :	B		
SURFACE TOLERANCE	0.2/100			Drawn By	Checked By	Approved	
ROUNDNESS	UNDER 30% TOLERANCE			TZ			
SURFACE FINISH NOT TO EXCEED $63 \text{ } \mu\text{m}$ UNLESS OTHERWISE SPECIFIED				GTN, INC.			

Tracking No. W005445

GTN, INC.

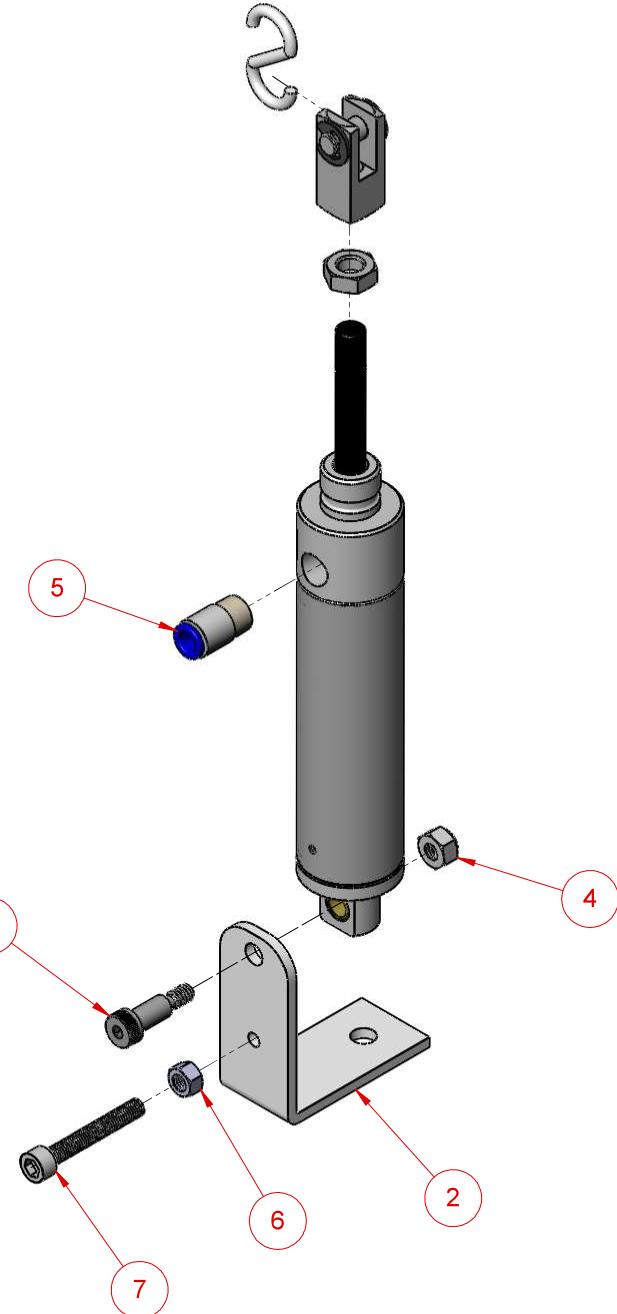
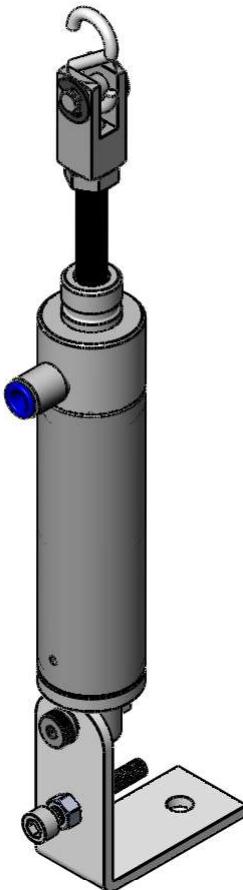
## STEP 3: ADD G013679



DETAIL A  
SCALE 2 : 1

GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.	
0.5~6	±0.2	±0.2	±0.4	Hardness				
6~30	±0.2	±0.25	±0.5	Heat Trmt.				
30~120	±0.3	±0.45	±0.7	Finish				
120~315	±0.5	±0.6	±1.0	Material				
315~1000	±0.8	±1.1	±1.5					
1000 ~	±1.2	±1.8	-					
PARALLELNESS			1/100					
ANGLE TOLERANCE			1/100					
SURFACE TOLERANCE			0.2/100					
ROUNDNESS			UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED	83		UNLESS OTHERWISE SPECIFIED	TZ				

DATE	REV.	DESCRIPTION	INFO
		REVISIONS	

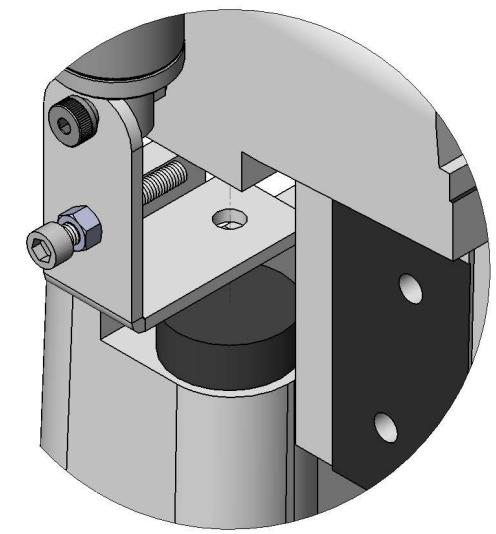
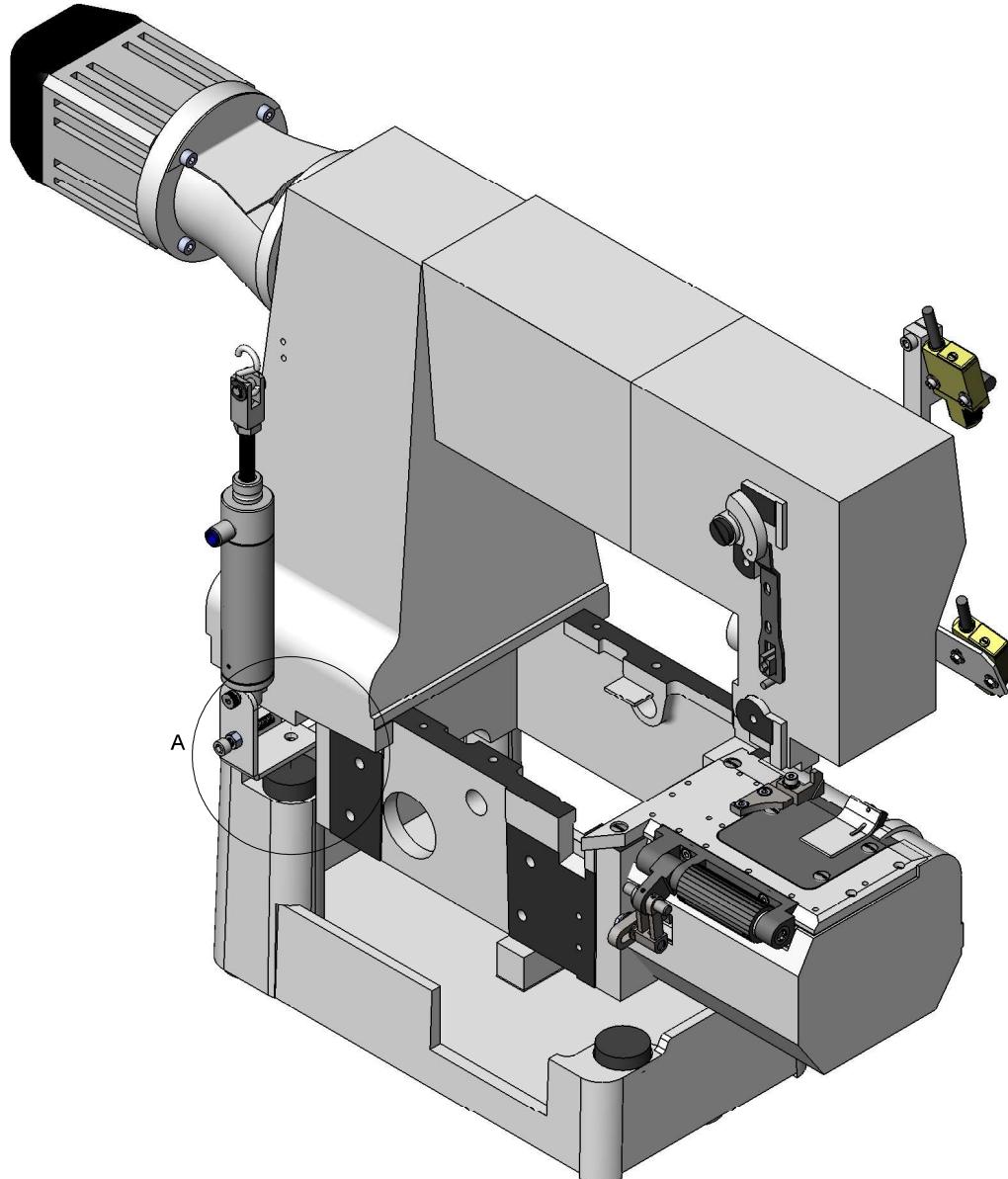


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013898	S-HOOK (31F)	1
2	G013899	PRESS FT BKT (W11-5B)	1
3	91259A537	SHLDR SCREW 1/4 X 1/2, 10-24 (61B)	1
4	GN0LK00	10-24 LOCK NUT	1
5	G013960	RND AIR FITTING, 6 MM (12B)	1
6	GN00500	M5 NUT	1
7	GSSC535	M5 X 35 SHCS, FULL THREAD (61C)	1
8	G013897	CLEVIS	1
9	G013896	AIR CYL	1

BREAK ALL SHARP EDGES				Tracking No. W005445	
GENERAL TOLERANCE					
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date Rev.No. Revisions Init.	
0.5~6	±0.2	±0.2	±0.4	Hardness	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.	Model No. GTN1828
30~120	±0.3	±0.45	±0.7	Finish	Machine No. 302U201B
120~315	±0.5	±0.6	±1.0	Material	Customer CARHARTT
315~1000	±0.8	±1.1	±1.5		Part No. G013892EX
1000 ~	±1.2	±1.8	-	Assy No. G013892	
PARALLELNESS 1/100				Date 3/6/15	
ANGLE TOLERANCE 1/100				Scale : 1:1 Size : "C"	
SURFACE TOLERANCE 0.2/100				Drawn By Checked By Approved	
ROUNDNESS UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED 63 UNLESS OTHERWISE SPECIFIED					
T2				GTN, INC.	

DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

## STEP 4: ADD G013892

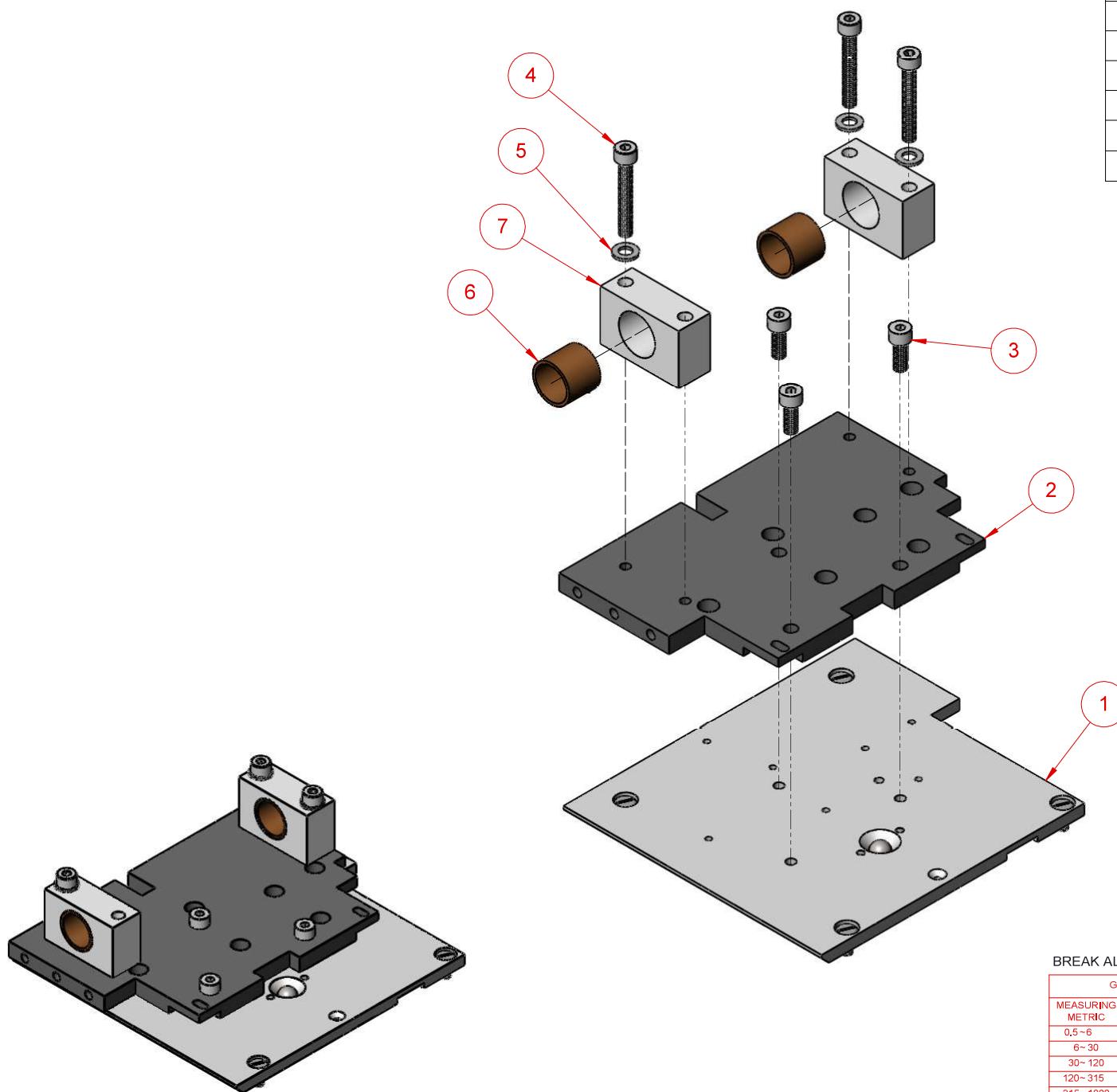


DETAIL A  
SCALE 2 : 1

GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.	
0.5~6	±0.2	±0.2	±0.4	Hardness				
6~30	±0.2	±0.25	±0.5	Heat Trmt.				
30~120	±0.3	±0.45	±0.7	Finish				
120~315	±0.5	±0.6	±1.0	Material				
315~1000	±0.8	±1.1	±1.5					
1000 ~	±1.2	±1.8	-	Pat/ Assy Name				
GTN 1828							Date	9/22/15
Scale : 1:1.3 Size : 1" D"							Approved	
SURFACE TOLERANCE	0.2/100	Drawn By	Checked By					
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	83 UNLESS OTHERWISE SPECIFIED	TZ						

DATE	REV.	DESCRIPTION	INFO
		REVISIONS	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012855	MOD MACH PLATE	1
2	G013589	PLATE (W11-3C)	1
3	GSSC616	M6 X 16 SHCS	3
4	GSSC640	M6 X 40 SHCS	3
5	GWF0600	FW M6	3
6	2868T169	BRONZE SLEEVE (17A)	1
7	G012447	BEARING BLOCK (W10-6G)	1



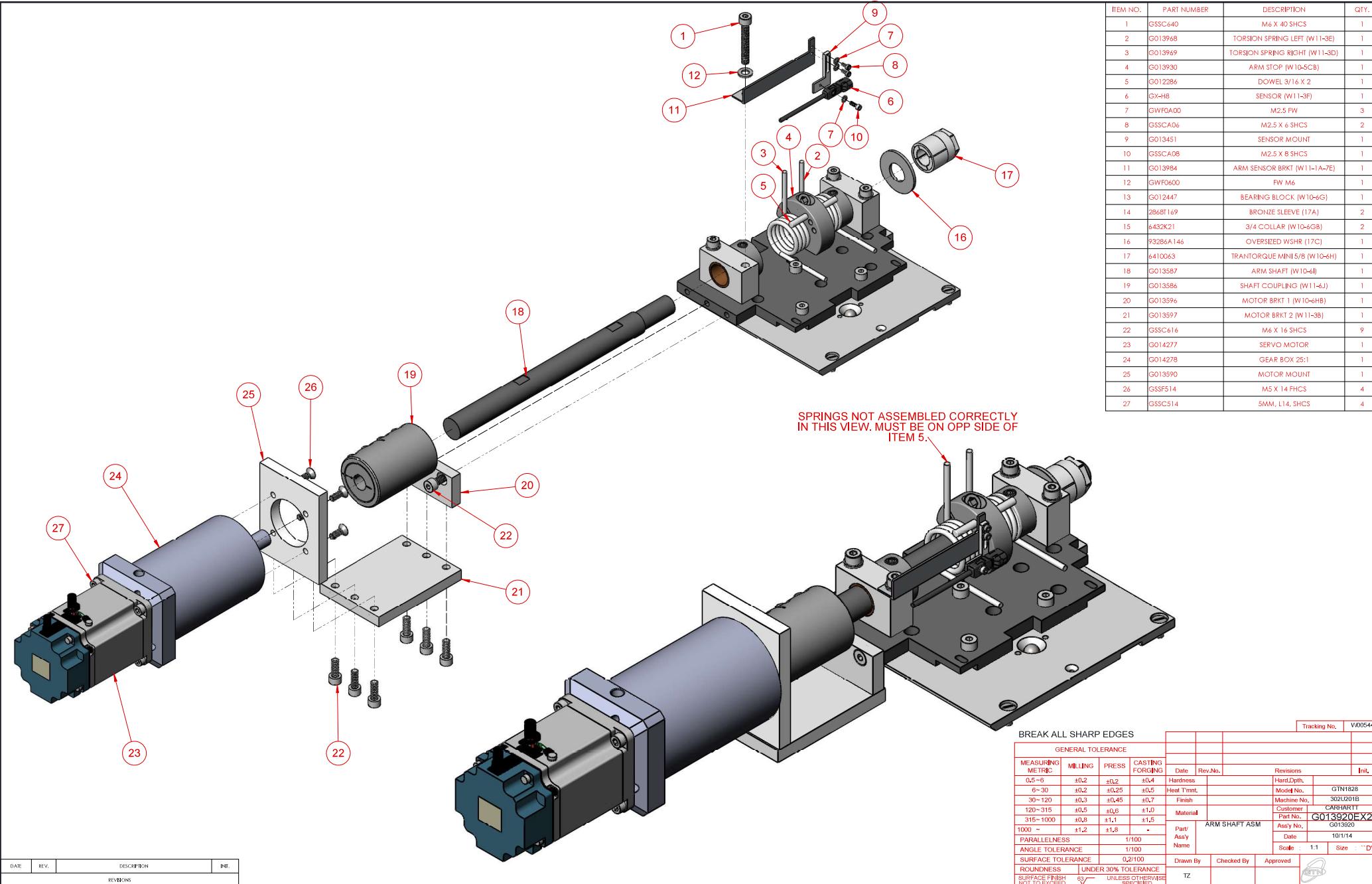
BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5~6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth,	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.			Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material			Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5				Part No.	G013920EX1
1000 ~	±1.2	±1.8	-				Assy No.	G013920
							Date	10/1/14
							Scale :	1:1 Size : "C"
ARM SHAFT ASM								
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	63	UNLESS OTHERWISE SPECIFIED			TZ			

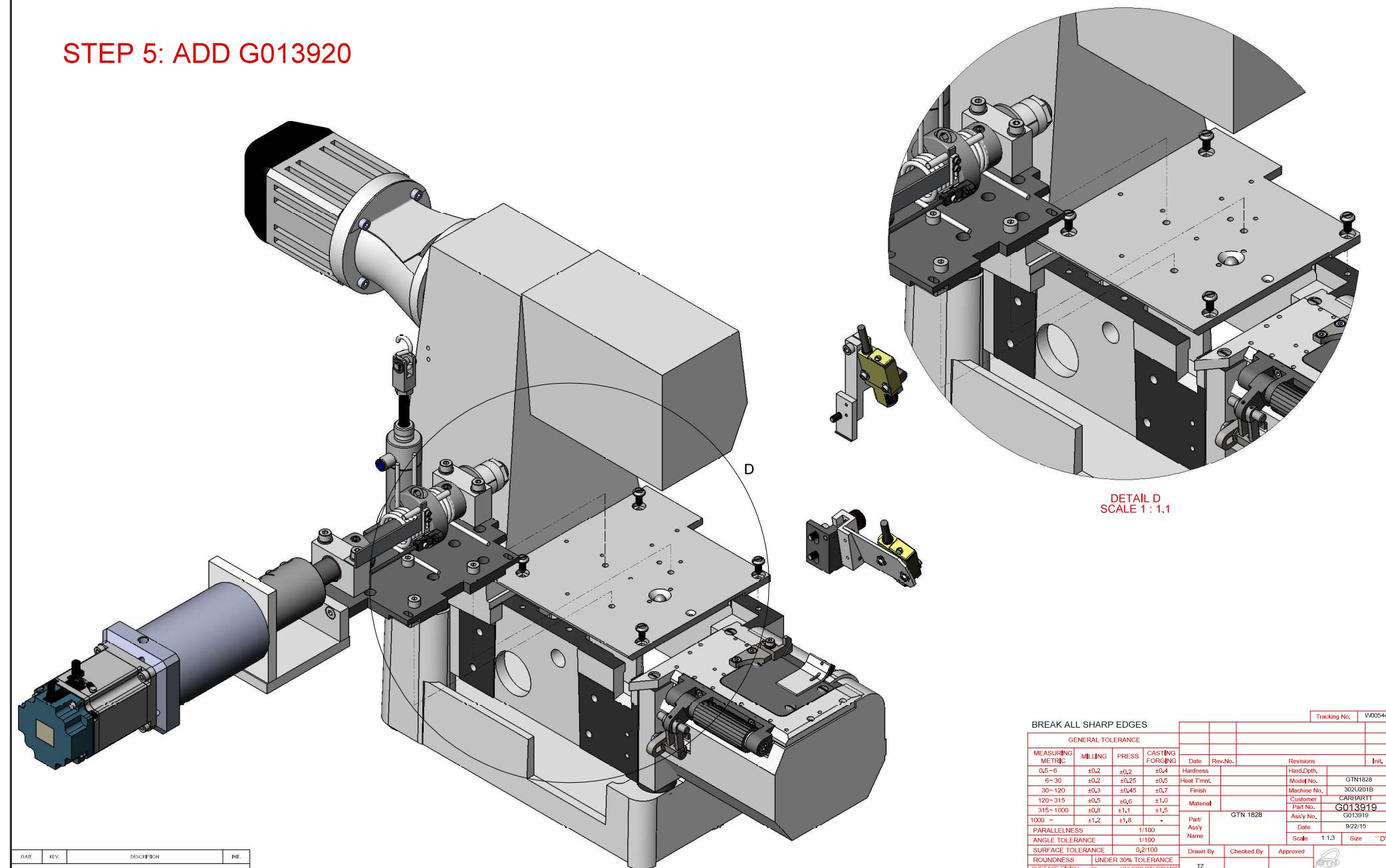
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

Tracking No. W005445

GTN, INC.



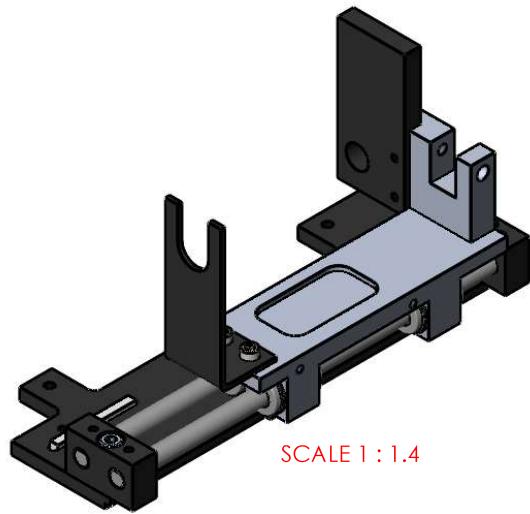
## STEP 5: ADD G013920



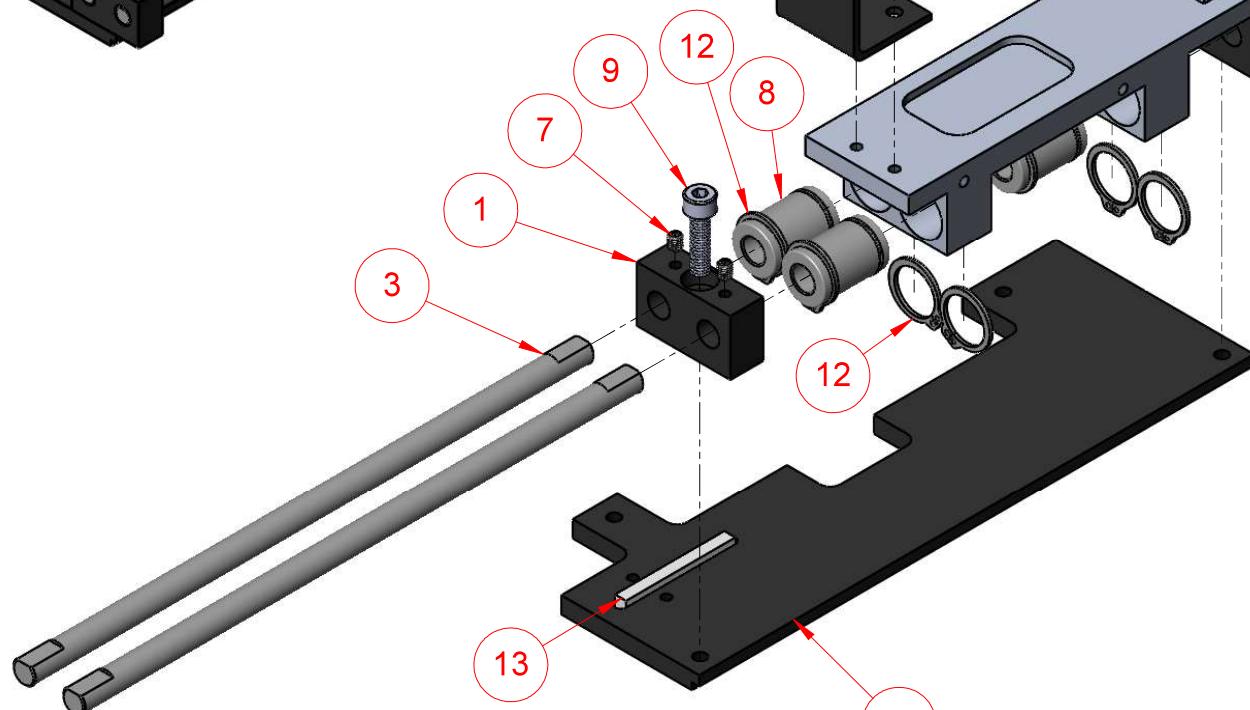
DETAIL D  
SCALE 1 : 1.1

GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.	
0.5~6	+0.2	+0.2	+0.4	Hardness				
6~30	+0.2	+0.25	+0.5	Heat Trmt.				
30~120	+0.3	+0.45	+0.7	Finish				
120~315	+0.5	+0.6	+1.0	Material				
315~1000	+0.8	+1.1	+1.5					
1000 ~	+1.2	+1.8	-					
PARALLELNESS			1/100					
ANGLE TOLERANCE			1/100					
SURFACE TOLERANCE			0.2/100					
ROUNDNESS			UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED				83	UNLESS OTHERWISE SPECIFIED	TZ		

DATE	REV.	DESCRIPTION	INFO	REVISIONS



SCALE 1 : 1.4



DATE	REV.	DESCRIPTION	INIT
REVISIONS			

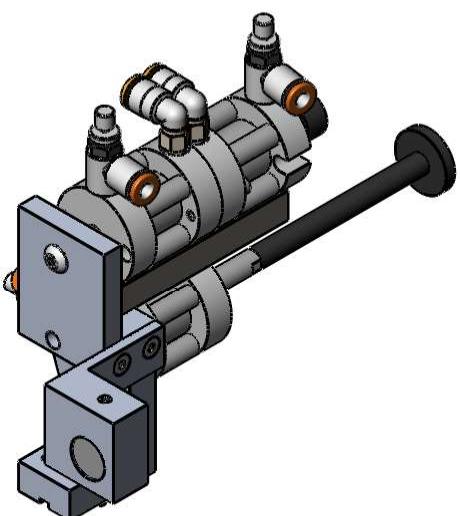
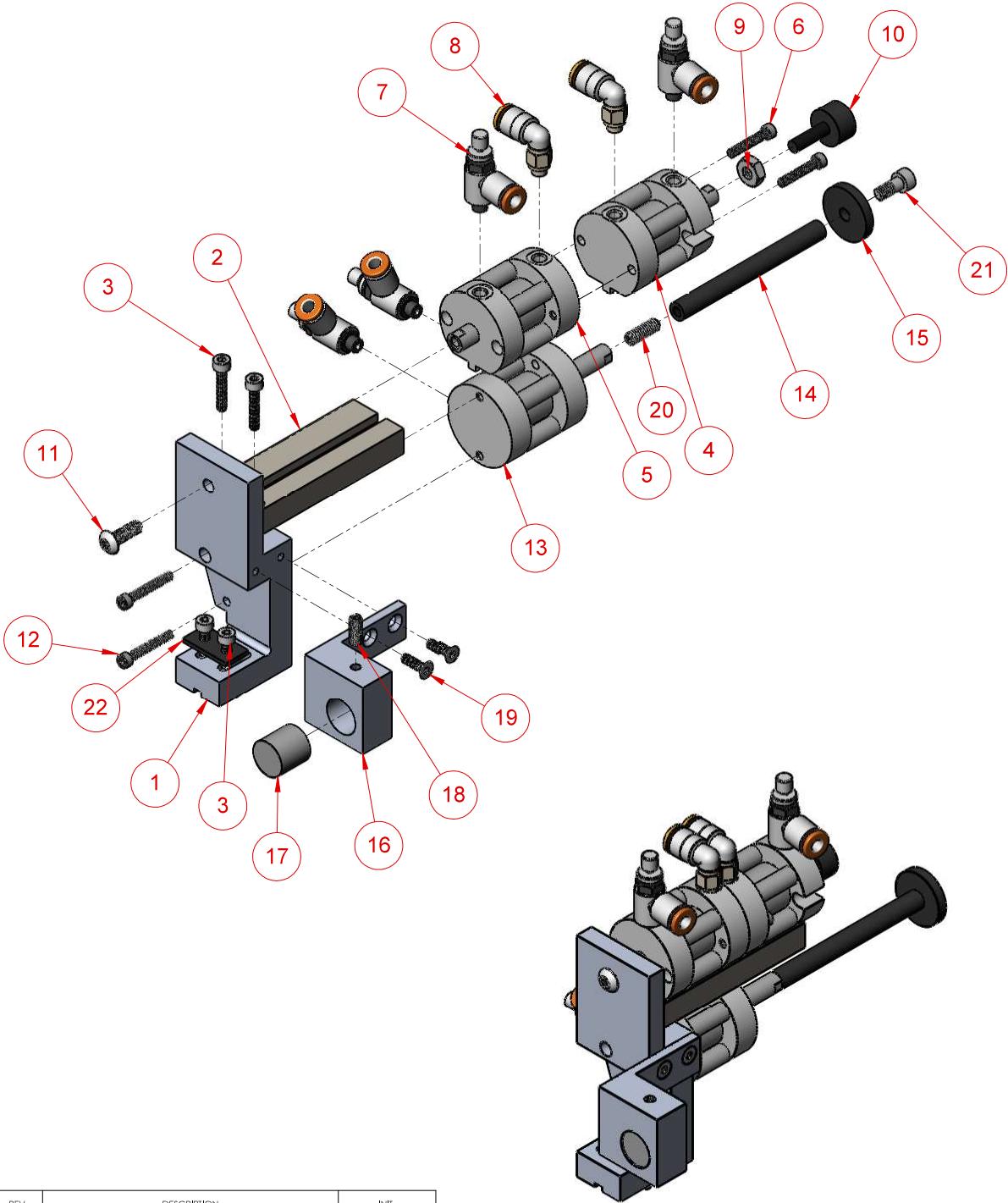
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012652	LINEAR BRG SHAFT BKT (17G)	2
2	G013622	SLIDE PLATE (W11-3G)	1
3	G013621	1/4 SHAFT W FLATS (W11-3H)	2
4	G013656	TRANSFER PLATE (W11-3I)	1
5	G012650	PUSH PLATE (25A)	1
6	G012649	MAGNET PLATE (25C)	1
7	GSSS304	SET SCRW M3 X 4	4
8	G014258	1/4" LINEAR BUSHING (W11-3HB)	4
9	GSSC416	M4 X 16 SHCS	2
10	GSSF310	FHCS M3 x 10	2
11	GSSC306	SCREW, M3X6 SHCS	2
12	97633A200	RETAINING RING (56G)	8
13	G013831	KEY (21B)	1

#### BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material		Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5	Part No.		Part No.	G013566
1000 ~	±1.2	±1.8	-	Ass'y Name		Ass'y No.	G013566
PARALLELNESS			1/100	Part/ Ass'y Name		Date	9/17/14
ANGLE TOLERANCE			1/100			Scale :	1:1
SURFACE TOLERANCE			0.2/100			Size :	B
ROUNDNESS			UNDER 30% TOLERANCE	Drawn By	Checked By	Approved	
SURFACE FINISH NOT TO EXCEED $63 \text{ } \mu\text{m}$ UNLESS OTHERWISE SPECIFIED				TZ			

Tracking No. W005445

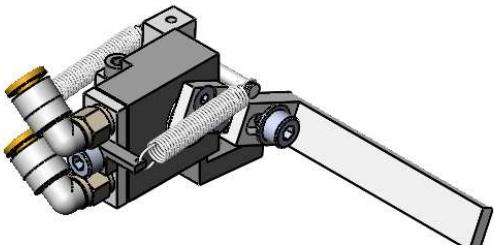
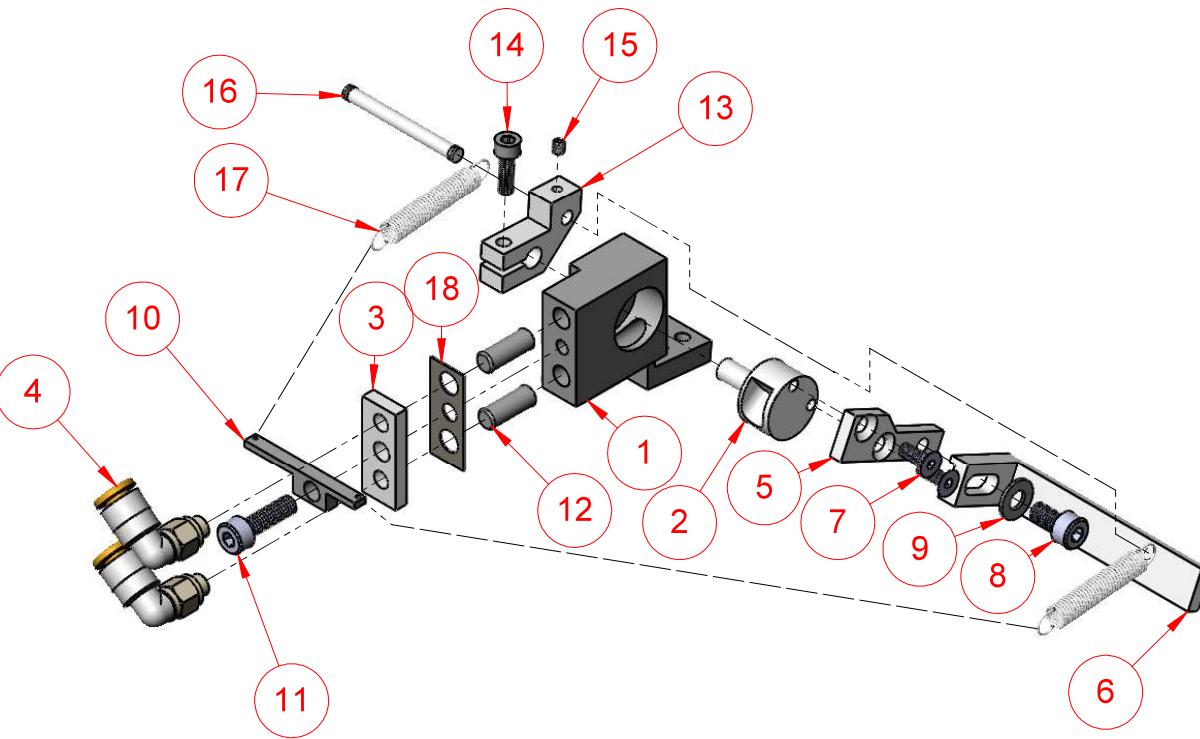
GTN, INC.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012646	CYL MOUNT (W11-3J)	1
2	G012645	CYL TRACK (W11-3JB)	1
3	GSSC316	SHCS M3 X 16	4
4	G012642	MOD AIR CYL (W11-3K)	1
5	G012641	MOD AIR CYL (W11-3KB)	1
6	GSSCE16	4-40 X 5/8 SHCS	2
7	JW000014	FITTING FLO CON (D2C7)	4
8	JW000001	ELBOW FITTING (D2C6)	2
9	GN00J00	HEX NUT, 8/32	1
10	G012644	BUMPER (21C)	1
11	GSSBJ13	8-32 X 1/2 BHCS	1
12	GSSCE19	4-40 X 3/4 SHCS	2
13	G014245	AIR CYL (W11-3FB)	1
14	G012637	CYL ROD EXT (25E)	1
15	G012638	STOP (21D)	1
16	G012639	MAGNET BKT (W11-4A)	1
17	G013569	ENCASED MAGNET (21E)	1
18	GSSS410	M4 X 10 SET SCREW	1
19	GSSF310	FHCS M3 x 10	2
20	GSSSJ13	8-32 X 1/2 SET SCREW	1
21	GSSCJ10	SCH CAP SCR, B18.3	1
22	G012648	DOUBLE WASHER (21F)	1

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				CASTING FORGING				Revisions		Init.		
MEASURING METRIC	MILLING	PRESS		Date	Rev.No.							
0.5~6	±0.2	±0.2	±0.4	Hardness				Hard.Dpth,				
6~30	±0.2	±0.25	±0.5	Heat T'mnt.				Model No.				
30~120	±0.3	±0.45	±0.7	Finish				Machine No.				
120~315	±0.5	±0.6	±1.0	Material				Customer				
315~1000	±0.8	±1.1	±1.5					Part No.				
1000 ~	±1.2	±1.8	-					Assy No.				
PARALLELNESS				1/100				G013568				
ANGLE TOLERANCE				1/100								
SURFACE TOLERANCE				0.2/100								
ROUNDNESS	UNDER 30% TOLERANCE											
SURFACE FINISH NOT TO EXCEED	63				UNLESS OTHERWISE SPECIFIED							
DATE	REV.	DESCRIPTION	INIT.	Drawn By	Checked By	Approved						
REVISIONS								GTN, INC.				



DATE	REV.	DESCRIPTION	INIT
REVISIONS			

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013635	ROTATE BLOCK (26A)	1
2	G013636	ACTUATOR (23A)	1
3	G013640	END CAP (23B)	1
4	JW000001	ELBOW FITTING (D2C6)	2
5	G013638	WIPER ARM (23C)	1
6	G013637	BAND WIPER (23D)	1
7	GSSF308	M3X8 FHCS	2
8	GSSC408	M4 X 8 SHCS	1
9	GWF0400	FLAT WASHER M4	1
10	G013641	SPRING ANCHOR (23E)	1
11	GSSC414	M4 X 14 SHCS	1
12	98381A505	DOWEL 3/16 X 1/2 (57G)	2
13	G012498	SPRING CLAMP (23F)	1
14	GSSC310	M3X10 SHCS	1
15	GSSA04	M2.5 X 4 SET SCREW	1
16	G012499	SPRING PIN (23G)	1
17	G012500	SPRING (23H)	2
18	G014232	GASKET (W12-1A-2D)	1

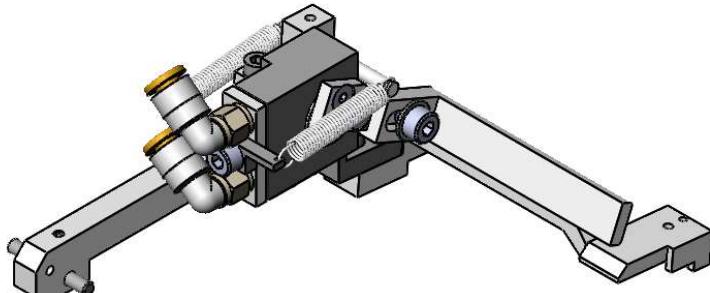
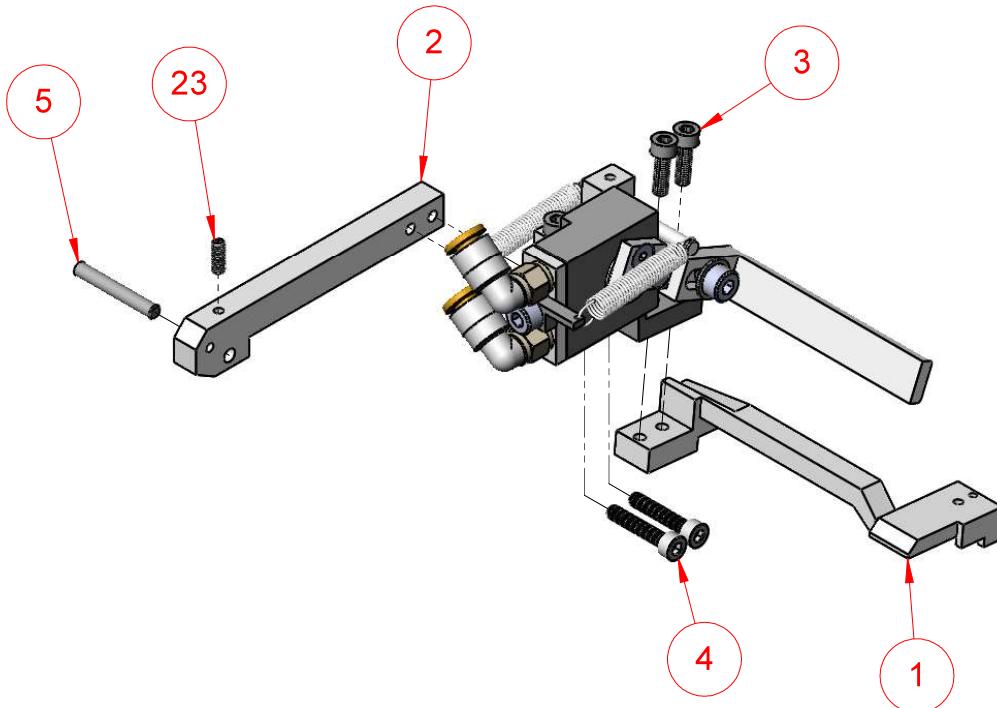
BREAK ALL SHARP EDGES

GENERAL TOLERANCE

MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions		Init.
				Hardness	Heat T'mnt.	Finish	Material	
0.5~6	±0.2	±0.2	±0.4					
6~30	±0.2	±0.25	±0.5					
30~120	±0.3	±0.45	±0.7					
120~315	±0.5	±0.6	±1.0					
315~1000	±0.8	±1.1	±1.5					
1000 ~	±1.2	±1.8	-					
PARALLELNESS		1/100						
ANGLE TOLERANCE		1/100						
SURFACE TOLERANCE		0.2/100						
ROUNDNESS		UNDER 30% TOLERANCE						
SURFACE FINISH NOT TO EXCEED $63\text{ } \mu\text{m}$ UNLESS OTHERWISE SPECIFIED								
Part/ Ass'y Name		ROT ACT ASM		Ass'y No.	Date	Scale : 1:1	Size : B	
Drawn By		Checked By		Approved				

Tracking No.

GTN, INC.



DATE	REV.	DESCRIPTION	INIT
REVISIONS			

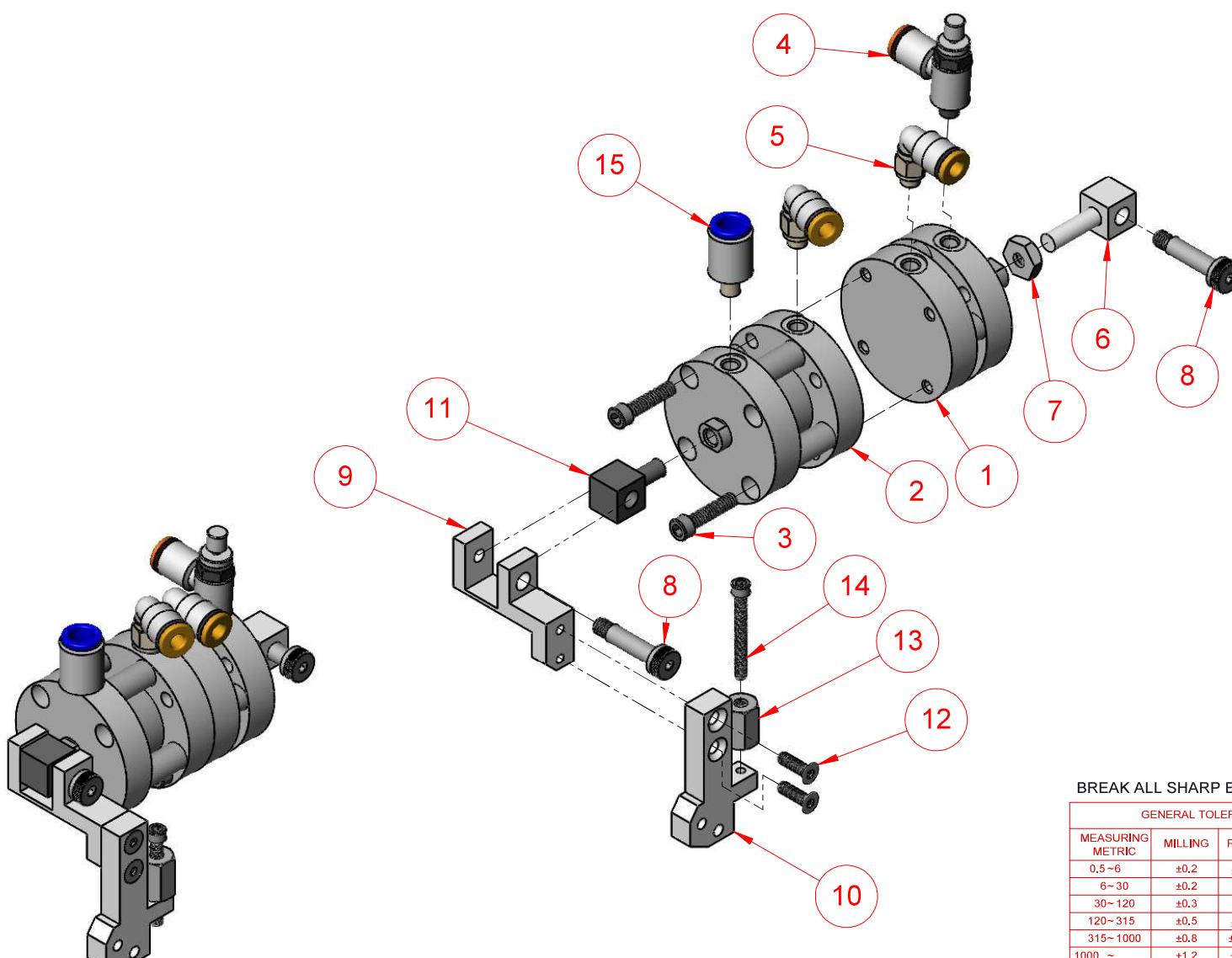
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012489	TOP GUIDE (25G)	1
2	G012488	TOP ARM (22H)	1
3	GSSC310	M3X10 SHCS	3
4	GSSC316	SHCS M3 X 16	2
5	98381A474	DOWEL 1/8 X 7/8 (57E)	1
6	G013635	ROTATE BLOCK (26A)	1
7	G013636	ACTUATOR (23A)	1
8	G013640	END CAP (23B)	1
9	JW000001	ELBOW FITTING (D2C6)	2
10	G013638	WIPER ARM (23C)	1
11	G013637	BAND WIPER (23D)	1
12	GSSF308	M3X8 FHCS	2
13	GSSC408	M4 X 8 SHCS	1
14	GWF0400	FLAT WASHER M4	1
15	G013641	SPRING ANCHOR (23E)	1
16	GSSC414	M4 X 14 SHCS	1
17	98381A505	DOWEL 3/16 X 1/2 (57G)	2
18	G012498	SPRING CLAMP (23F)	1
19	GSSA04	M2.5 X 4 SET SCREW	1
20	G012499	SPRING PIN (23G)	1
21	G012500	SPRING (23H)	2
22	G014232	GASKET (W12-1A-2D)	1
23	GSSA08	M2.5 X 8 SET SCREW	1

#### BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	
120~315	±0.5	±0.6	±1.0	Material		Customer	
315~1000	±0.8	±1.1	±1.5			Part No.	G013642
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name	TOP CLAMP SUB ASM	Ass'y No.	
PARALLELNESS		1/100				Date	
ANGLE TOLERANCE		1/100				Scale :	1:1
SURFACE TOLERANCE		0.2/100				Size :	B
ROUNDNESS	UNDER 30% TOLERANCE			Drawn By	Checked By	Approved	
SURFACE FINISH NOT TO EXCEED	63	UNLESS OTHERWISE SPECIFIED					

GTN, INC.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G014246	AIR CYL (W11-4B)	1
2	G014247	AIR CYL (W11-4BB)	1
3	91251A150	6-32 X 5/8 SHCS	2
4	JW000014	FITTING FLO CON (D2C7)	1
5	JW000001	ELBOW FITTING (D2C6)	2
6	G012507	CLEVIS (21H)	1
7	90480A011	NUT, #10-24 HEX	1
8	97345A492	SHLD R SCRW 3/16 X 5/8, 8-32 (61E)	2
9	G012508	CYL PIVOT (22A)	1
10	G013572	DRIVE (22B)	1
11	G012510	CLEVIS (13H)	1
12	GSSF310	FHCS M3 x 10	2
13	90264A410	COUPLING NUT (22D)	1
14	90044A111	4-40 X 1 SHCS	1
15	G013452	AIR FITTING, 6 MM (24B)	1



DATE	REV.	DESCRIPTION	INIT
REVISIONS			

#### BREAK ALL SHARP EDGES

#### GENERAL TOLERANCE

MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
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0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
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6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	
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30~120	±0.3	±0.45	±0.7	Finish		Machine No.	
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120~315	±0.5	±0.6	±1.0	Material		Customer	
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315~1000	±0.8	±1.1	±1.5	Part No.		G013571	
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1000 ~	±1.2	±1.8	-	Ass'y No.			
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PARALLELNESS		1/100		Date			
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ANGLE TOLERANCE		1/100		Scale :	1:1	Size :	B
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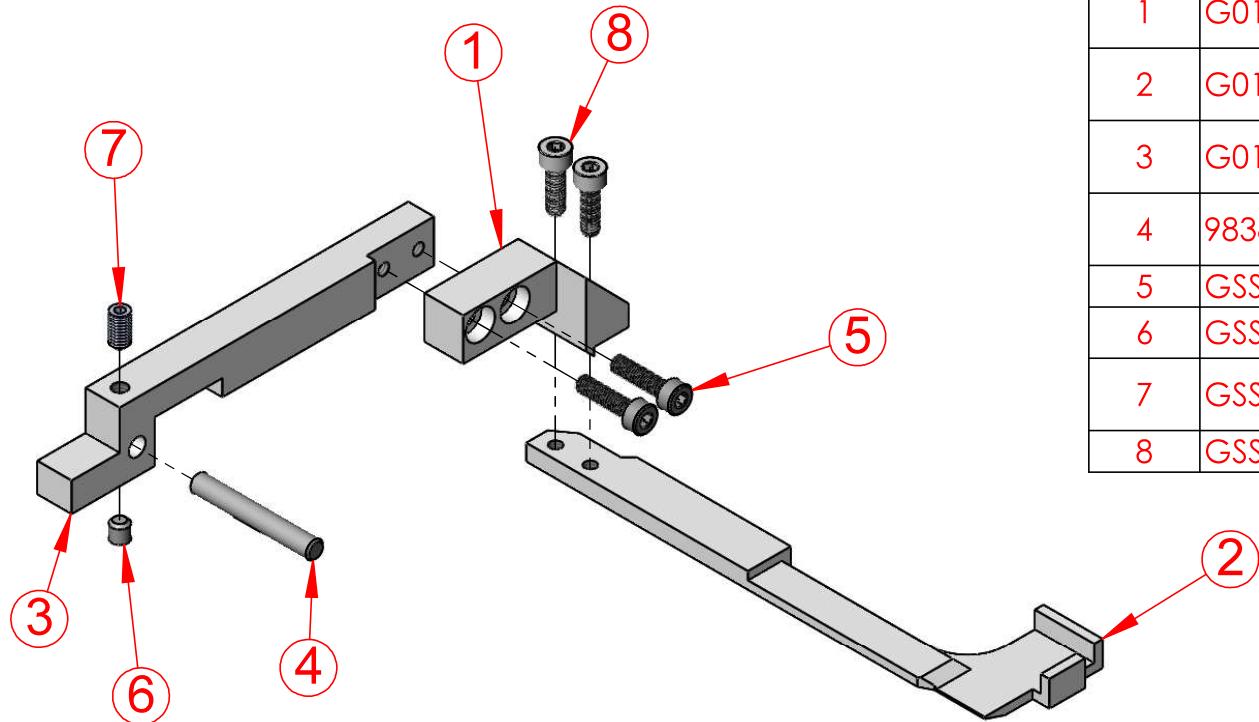
SURFACE TOLERANCE		0.2/100					
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ROUNDNESS		UNDER 30% TOLERANCE					
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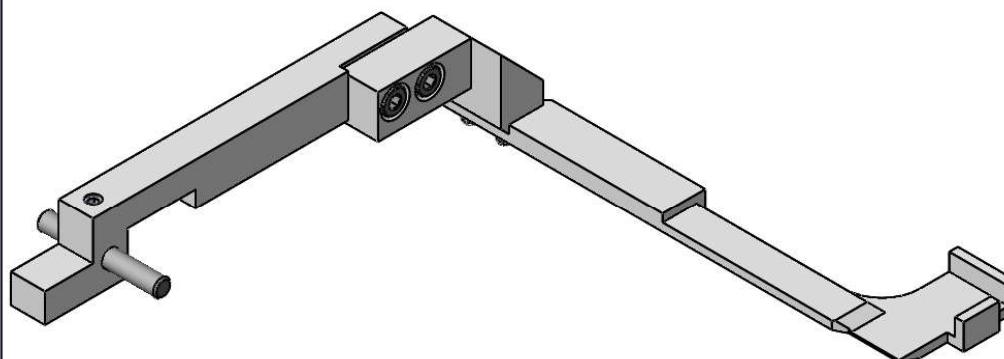
SURFACE FINISH	63	UNLESS OTHERWISE SPECIFIED					
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Tracking No.							
GENERAL TOLERANCE							
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	
120~315	±0.5	±0.6	±1.0	Material		Customer	
315~1000	±0.8	±1.1	±1.5	Part No.		G013571	
1000 ~	±1.2	±1.8	-	Ass'y No.			
PARALLELNESS		1/100		Date			
ANGLE TOLERANCE		1/100		Scale :	1:1	Size :	B
SURFACE TOLERANCE		0.2/100					
ROUNDNESS		UNDER 30% TOLERANCE					
SURFACE FINISH	63	UNLESS OTHERWISE SPECIFIED					

GTN, INC.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012484	BOTTOM GUIDE BKT (22E)	1
2	G012483	BOTTOM GUIDE (25E)	1
3	G013582	BOTTOM ARM (22F)	1
4	98381A474	DOWEL W FLAT 1/8 X 7/8 (57C)	1
5	GSSCA10	SCREW GSSCA10	2
6	GSSS303	SCREW, M3X3 SET	1
7	GSSS306	SCREW, M3 X 6 SET	1
8	GSSCA08	M2.5 X 8 SHCS	2

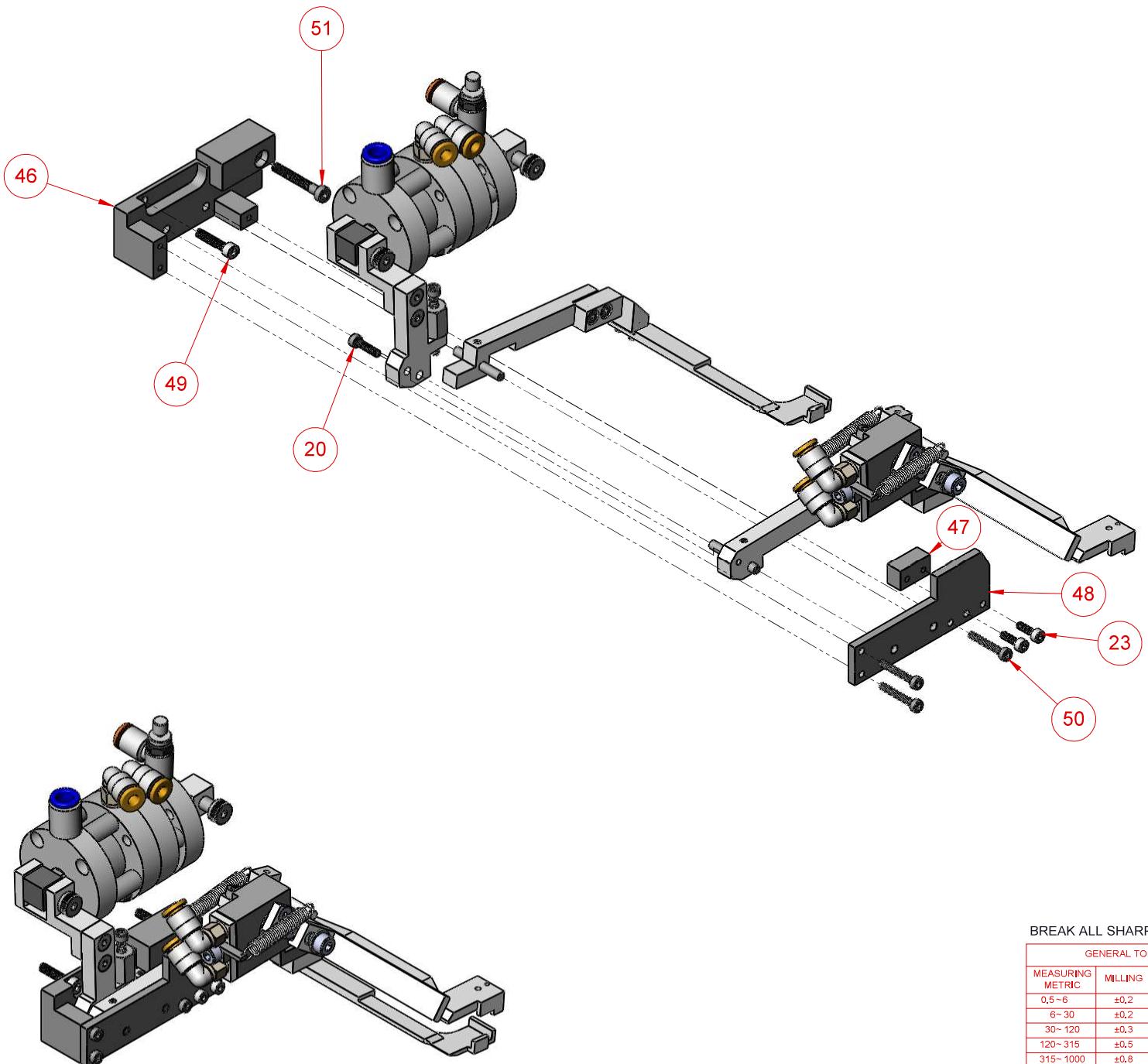


DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

#### BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5~6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.			Model No.	
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	
120~315	±0.5	±0.6	±1.0	Material			Customer	
315~1000	±0.8	±1.1	±1.5				Part No.	G013583
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name			Ass'y No.	
PARALLELNESS				Date			Date	
ANGLE TOLERANCE				Scale : 1:1			Size : "A"	
SURFACE TOLERANCE				Drawn By	Checked By	Approved		
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	63	UNLESS OTHERWISE SPECIFIED						

GTN, INC.  
1



DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G014246	AIR CYL (W11-4B)	1
2	G014247	AIR CYL (W11-4BB)	1
3	91251A150	6-32 X 5/8 SHCS	2
4	JW000014	FITTING FLO CON (D2C7)	1
5	JW000001	ELBOW FITTING (D2C6)	4
6	G012507	CLEVIS (21H)	1
7	90480A011	NUT, #10-24 HEX	1
8	97345A492	SHLDR SCRW 3/16 X 5/8, 8-32 (61E)	2
9	G012508	CYL PIVOT (22A)	1
10	G013572	DRIVE (22B)	1
11	G012510	CLEVIS (13H)	1
12	GSSF310	FHCS M3 x 10	2
13	90264A410	COUPLING NUT (22D)	1
14	90044A111	4-40 X 1 SHCS	1
15	G013452	AIR FITTING, 6 MM (24B)	1
16	G012484	BOTTOM GUIDE BKT (22E)	1
17	G012483	BOTTOM GUIDE (25E)	1
18	G013582	BOTTOM ARM (22F)	1
19	98381A474	DOWEL W FLAT 1/8 X 7/8 (57C)	1
20	GSSCA10	SCREW GSSCA10	3
21	GSSS303	SCREW, M3X3 SET	1
22	GSSS306	SCREW, M3 X 6 SET	1
23	GSSCA08	M2.5 X 8 SHCS	4
24	G012489	TOP GUIDE (25G)	1
25	G012488	TOP ARM (22H)	1
26	GSSC310	M3X10 SHCS	3
27	GSSC316	SHCS M3 X 16	2
28	98381A474	DOWEL 1/8 X 7/8 (57E)	1
29	GSSSA08	M2.5 X 8 SET SCREW	1
30	G013635	ROTATE BLOCK (26A)	1
31	G013636	ACTUATOR (23A)	1
32	G013640	END CAP (23B)	1
33	G013638	WIPER ARM (23C)	1
34	G013637	BAND WIPER (23D)	1
35	GSSF308	M3X8 FHCS	2
36	GSSC408	M4 X 8 SHCS	1
37	GWF0400	FLAT WASHER M4	1
38	G013641	SPRING ANCHOR (23E)	1
39	GSSC414	M4 X 14 SHCS	1
40	98381A505	DOWEL 3/16 X 1/2 (57G)	2
41	G012498	SPRING CLAMP (23F)	1
42	GSSSA04	M2.5 X 4 SET SCREW	1
43	G012499	SPRING PIN (23G)	1
44	G012500	SPRING (23H)	2
45	G014232	GASKET (W12-1A-2D)	1
46	G013630	ARM BLOCK (W11-4A-B)	1
47	G012635	BOTTOM ARM SPACER (24A)	1
48	G012636	ARM BLOCK COVER (26C)	1
49	GSSC314	SHCS M3 X 14	1
50	GSSCA16	M2.5 X 16 SHCS	3
51	GSSC322	M3 X 22 SHCS	1

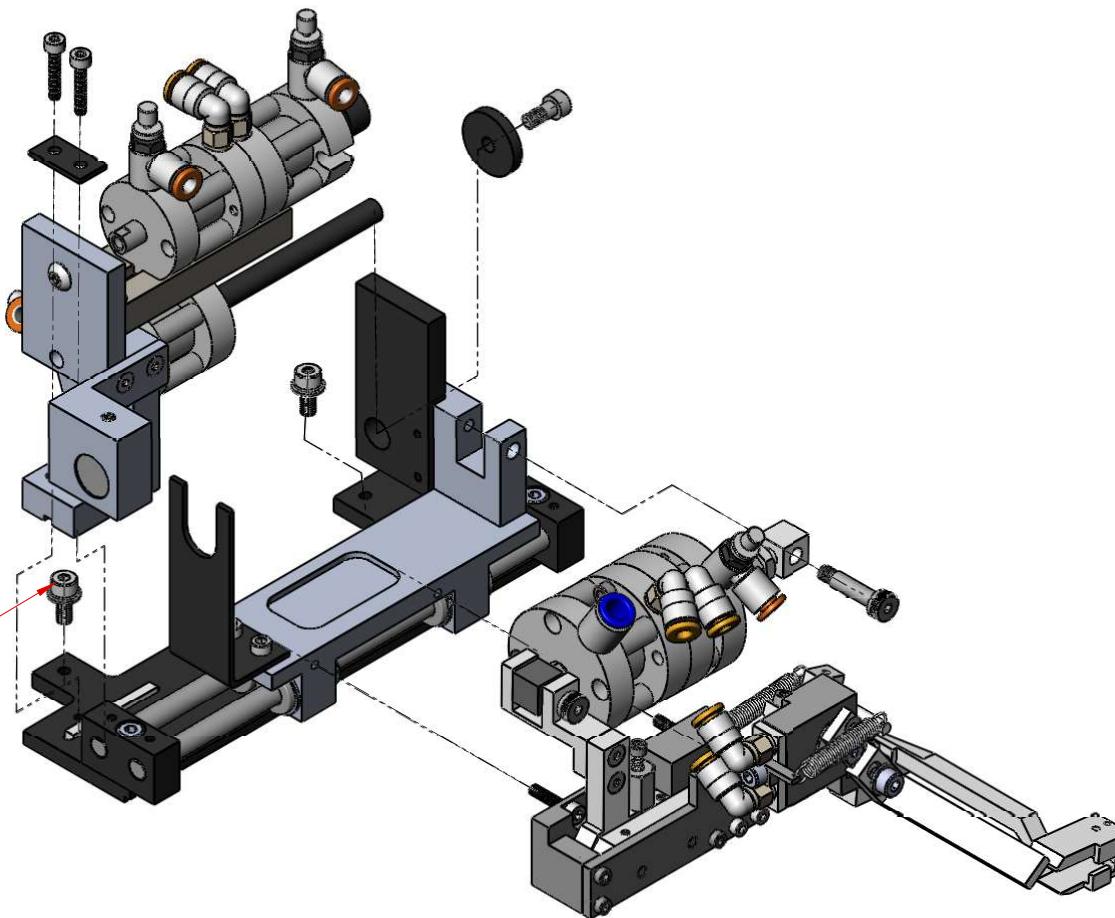
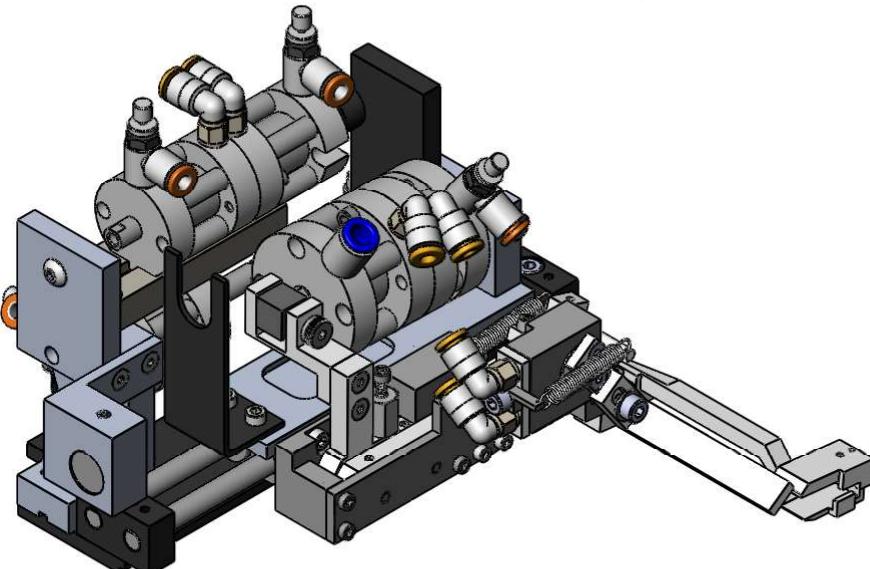
BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5~6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth,	
6~30	±0.2	±0.25	±0.5	Heat Tmnt.			Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material			Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5				Part No.	G013570
1000 ~	±1.2	±1.8	-				Assy No.	G013570
PARALLELNESS				1/100			Date	9/17/14
ANGLE TOLERANCE				1/100			Scale :	1:1
SURFACE TOLERANCE				0.2/100			Size :	"C"
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	63 ✓ UNLESS OTHERWISE SPECIFIED			TZ				

Tracking No. W005445

GTN, INC.

2-M4 X 10 SHCS  
W/ FW & LW



DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

#### BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard,Dpth,	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material		Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5			Part No.	G013565
1000 ~	±1.2	±1.8	-			Assy No.	G013565
PARALLELNESS				1/100			
ANGLE TOLERANCE				1/100			
SURFACE TOLERANCE				0.2/100			
ROUNDNESS	UNDER 30% TOLERANCE						
SURFACE FINISH NOT TO EXCEED	63	UNLESS OTHERWISE SPECIFIED			TZ		
Drawn By				Checked By	Approved		

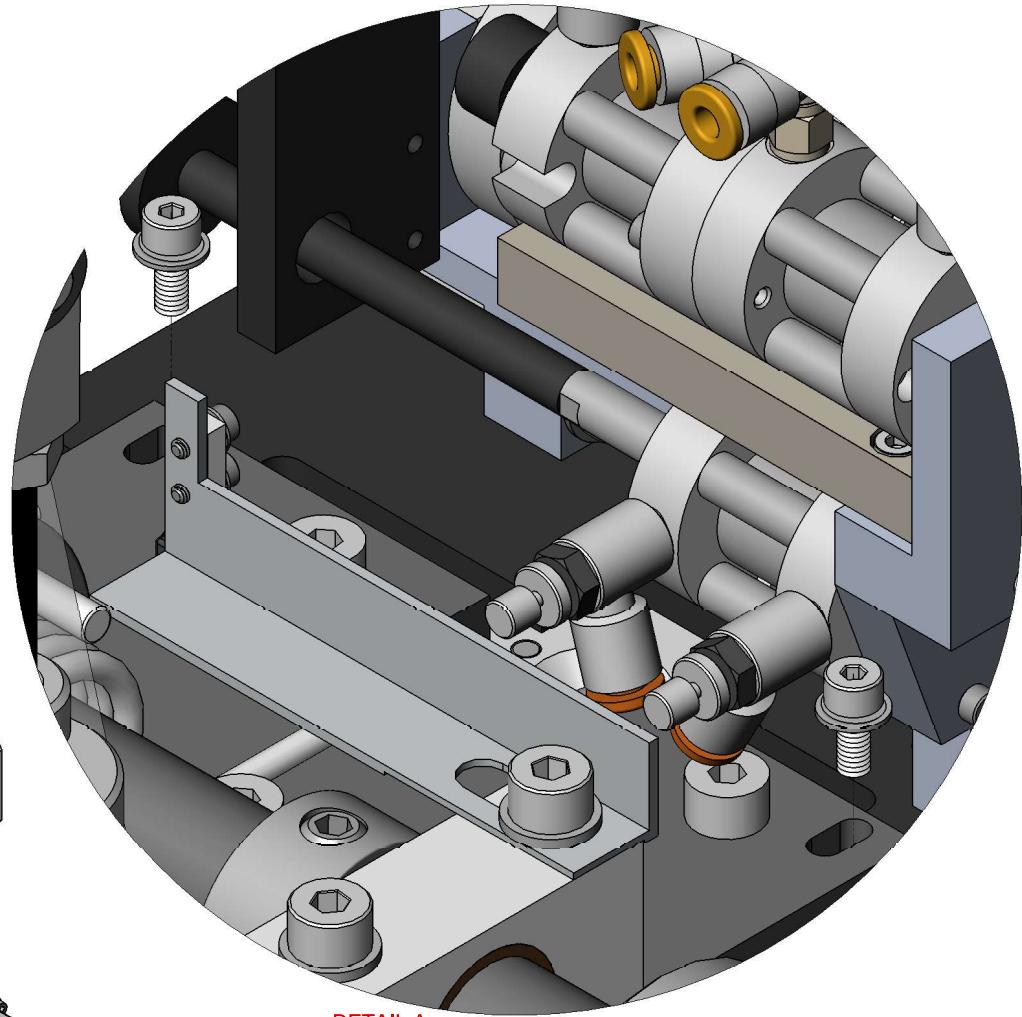
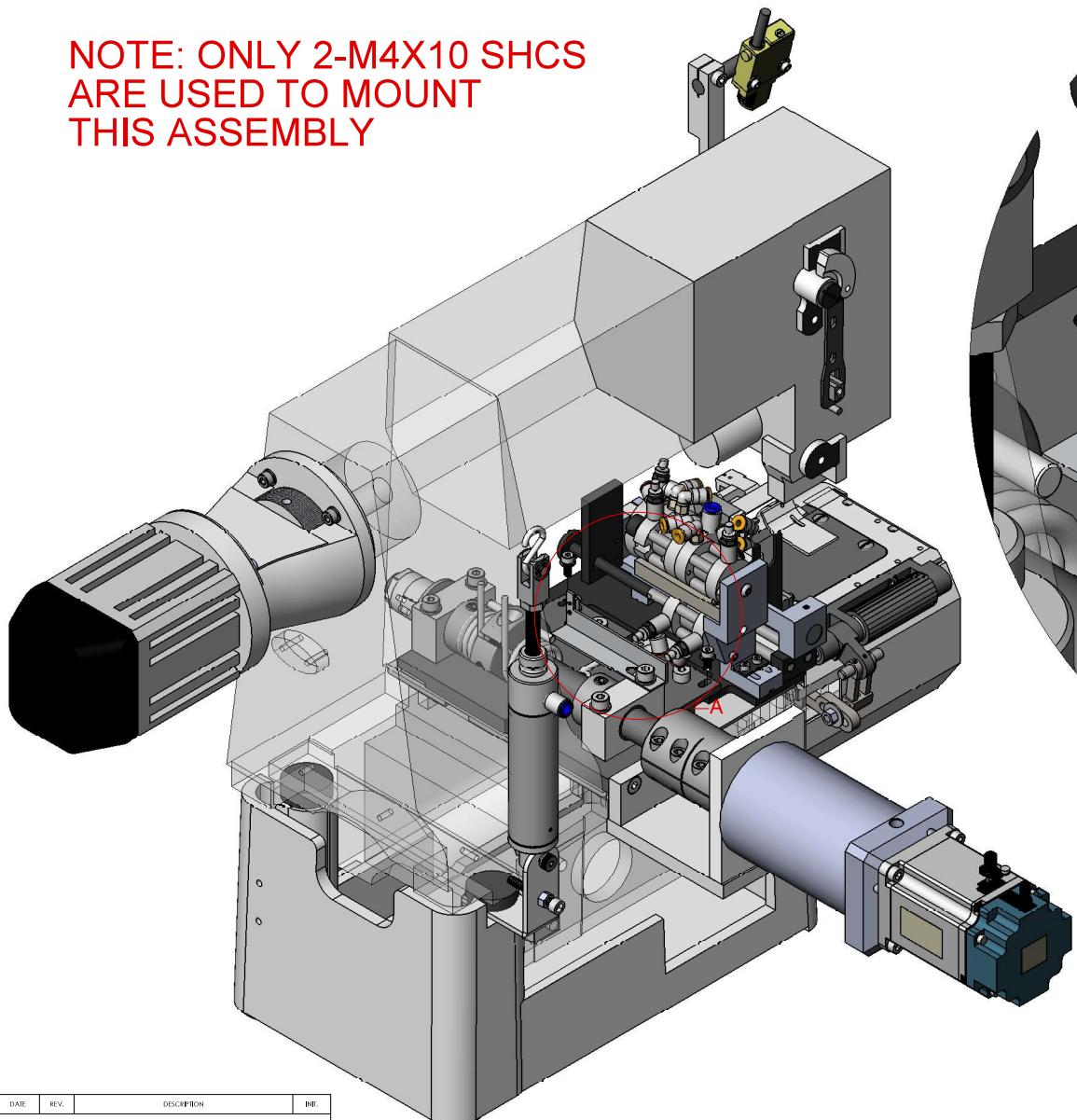
Tracking No. W005445

GTN, INC.

GTN, INC.

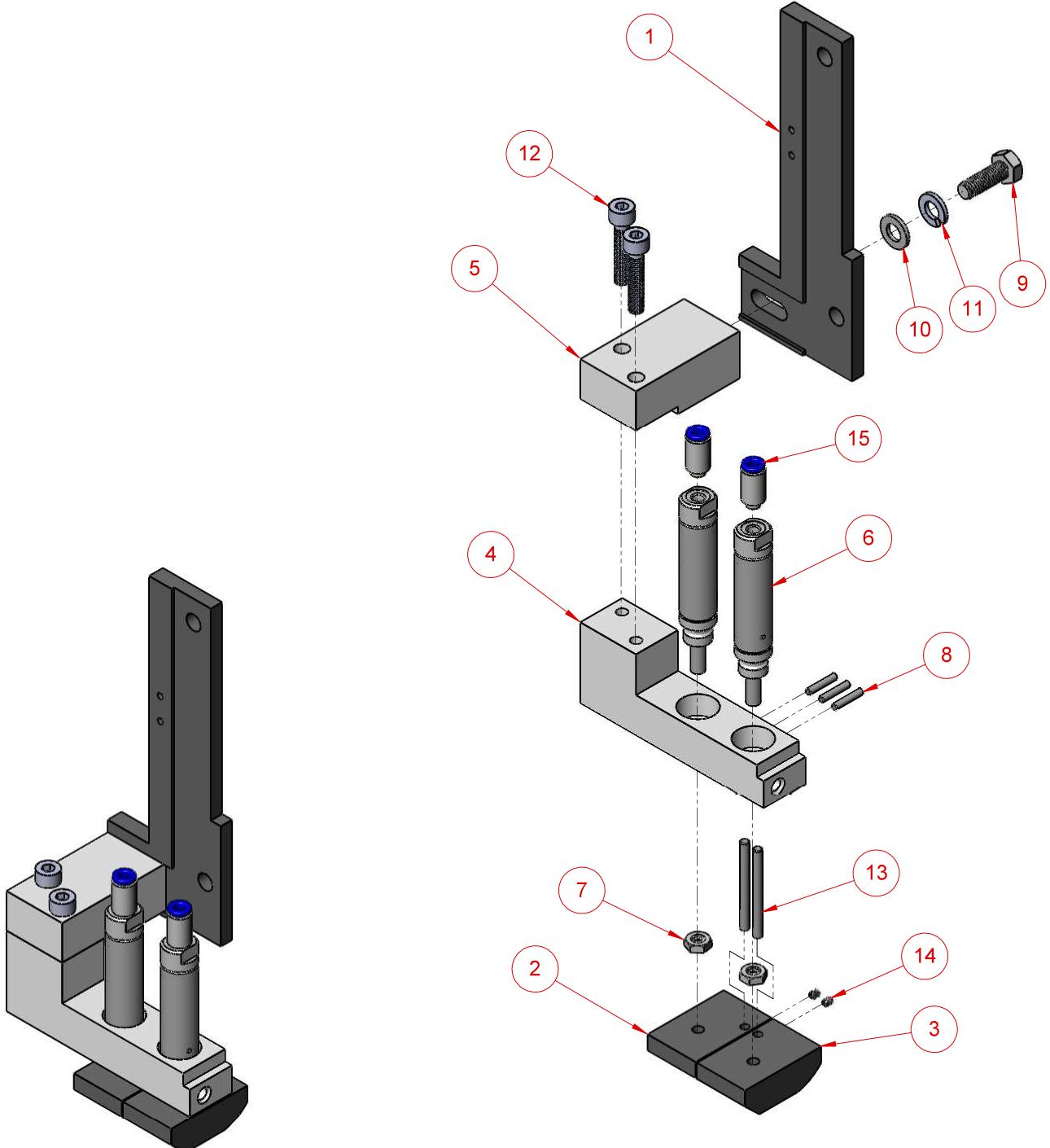
## STEP 6: ADD G013565

NOTE: ONLY 2-M4X10 SHCS  
ARE USED TO MOUNT  
THIS ASSEMBLY



GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.	
0.5~6	±0.2	±0.2	±0.4	Hardness				
6~30	±0.2	±0.25	±0.5	Heat Trmt.				
30~120	±0.3	±0.45	±0.7	Finish				
120~315	±0.5	±0.6	±1.0	Material				
315~1000	±0.8	±1.1	±1.5					
1000 ~	±1.2	±1.8	-	Part/Assy Name				
GTN 1828							Date	9/22/15
GTN 1828							Scale	1:1.3 Size : "D"
SURFACE TOLERANCE	0.2/100	Drawn By	Checked By	Approved				
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED  UNLESS OTHERWISE SPECIFIED							TZ	

DATE	REV.	DESCRIPTION	INFO
		REVISIONS	

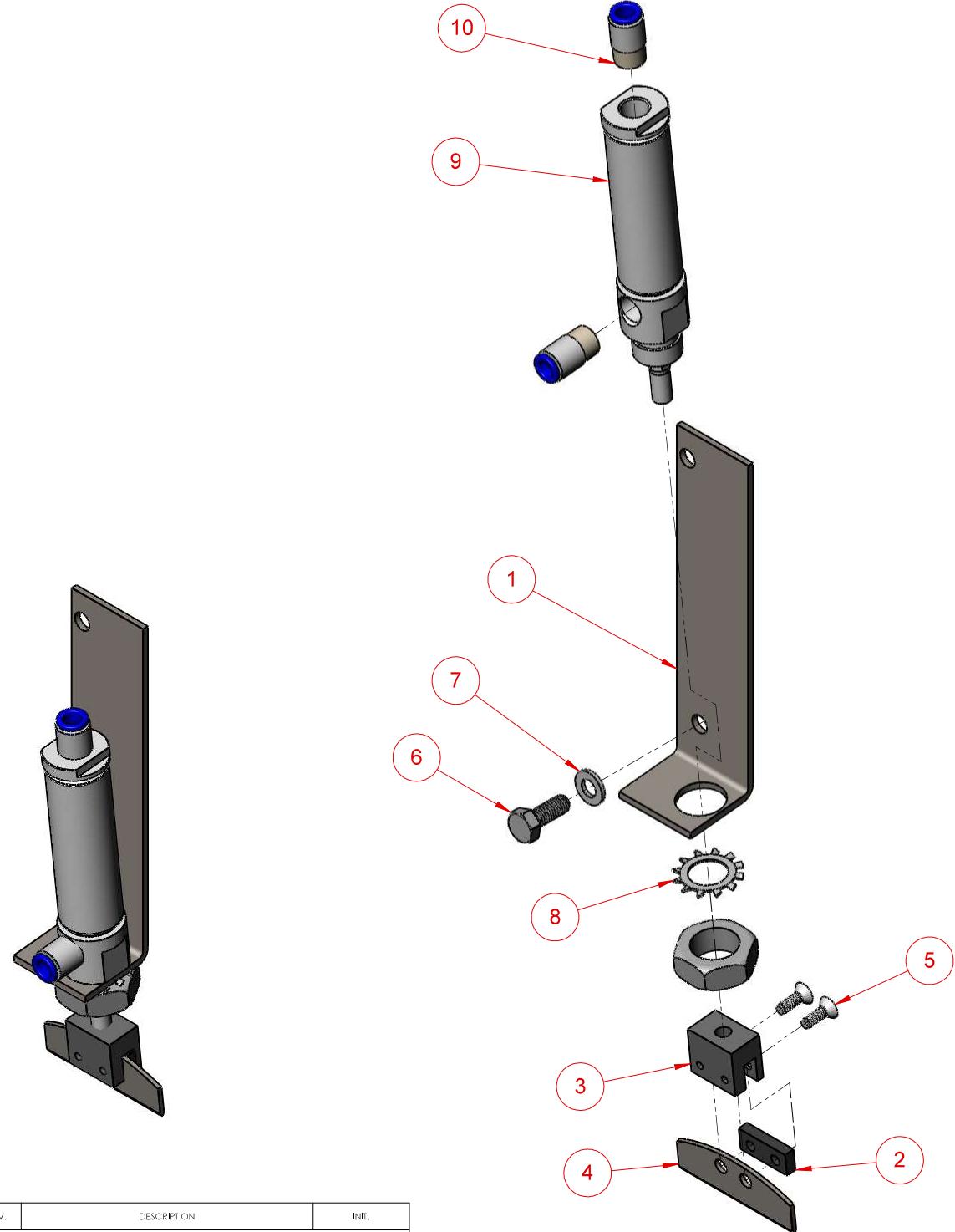


DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012840	MOUNT, MAIN (W10-4FB)	1
2	G012836	PRESSER, RIGHT (W10-4G)	1
3	G012837	PRESSER, LEFT (W10-4GB)	1
4	G012838	MOUNT, CYLINDERS (W10-4H)	1
5	G012839	EXTENSION (W10-4HB)	1
6	G014256	AIR CYL (W10-4I)	2
7	GN00L00	10-32 NUT	2
8	98381A438	DOWEL 3/32 X 1/2 (63A)	3
9	GSHC618	M6 CAP SCREW	1
10	GWF0600	FW M6	1
11	GWL0600	WSHR, LOCK M6	1
12	GSSC525	M5X25 SHCS	2
13	98381A494	DOWEL 1/8 X 1 3/8 (63B)	2
14	GSSA04	M2.5 X 4 SET SCREW	2
15	G013961	AIR FITTING, 4 MM (12A)	2

BREAK ALL SHARP EDGES				Tracking No.		
GENERAL TOLERANCE						
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard,Dpth,
6~30	±0.2	±0.25	±0.5	Heat Trmt.		Model No.,
30~120	±0.3	±0.45	±0.7	Finish		Machine No.,
120~315	±0.5	±0.6	±1.0	Material		Customer
315~1000	±0.8	±1.1	±1.5			Part No.,
1000 ~	±1.2	±1.8	-			Assy No.,
PARALLELNESS				1/100		Date
ANGLE TOLERANCE				1/100		Scale :
SURFACE TOLERANCE				0.2/100	1:1	Size : "C"
ROUNDNESS		UNDER 30% TOLERANCE				
SURFACE FINISH NOT TO EXCEED		63 ✓ UNLESS OTHERWISE SPECIFIED				
				Drawn By	Checked By	Approved

GTN, INC.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012816	MOUNT, ANGLE (W10-4IB)	1
2	G012819	INSERT, SOFT (W11-1A-1H)	1
3	G012818	SUPPORT, BLADE (W10-4J)	1
4	G012817	BLADE (W11-1A-1G)	1
5	GSSFG11	6-32 X 7/16 FHCS	2
6	GSHC616	M6 X 16 CAP SCREW	1
7	GWFO600	FW M6	1
8	GWE0U00	TOOTH LW	1
9	G014250	KNIFE AIR CYL (W10-4KB)	1
10	G013960	RND AIR FITTING, 6 MM (12B)	2

#### BREAK ALL SHARP EDGES

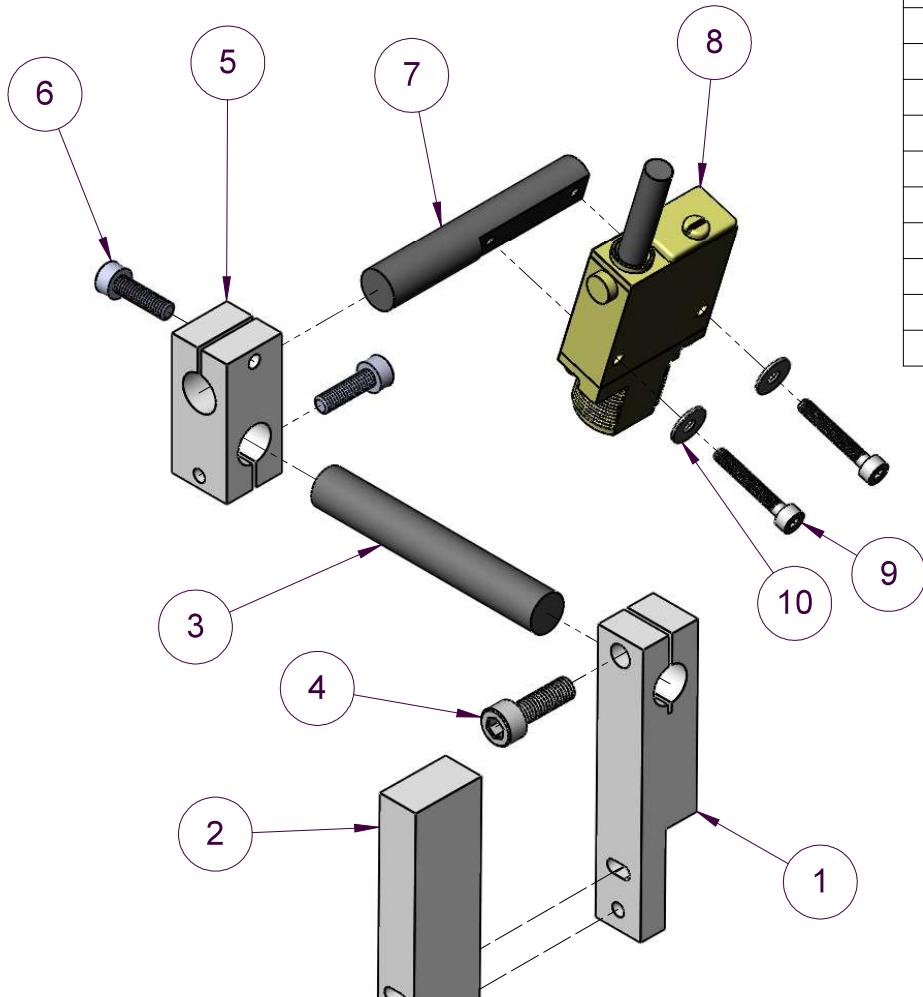
GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5~6	±0.2	±0.2	±0.4	Hardness			Hard,Dpth,	
6~30	±0.2	±0.25	±0.5	Heat Trmt.			Model No.	
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	
120~315	±0.5	±0.6	±1.0	Material			Custumer	
315~1000	±0.8	±1.1	±1.5				Part No.	
1000 ~	±1.2	±1.8	-				Assy No.	
PARALLELNESS				1/100			Date	
ANGLE TOLERANCE				1/100			Scale :	1:1
SURFACE TOLERANCE				0.2/100			Size :	"C"
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	63	UNLESS OTHERWISE SPECIFIED						

DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

Tracking No.

G012813EX2

GTN, INC.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013694	PEC MOUNT (W10-5BB)	1
2	G013751	SENSOR BLOCK (W10-5C)	1
3	G013752	SENSOR SHAFT (W11-1A-3E)	1
4	GSSC516	M5 X 16 SHCS	1
5	G013753	JOINT (W10-5B)	1
6	GSSC414	M4 X 14 SHCS	2
7	G013696	PEC SHAFT (W11-1A-5C)	1
8	G013695	BANNER SENSOR (W10-5D)	1
9	GSSC320	M3 X 20 SHCS	2
10	GWF0300	FLAT WASHER, M3	2

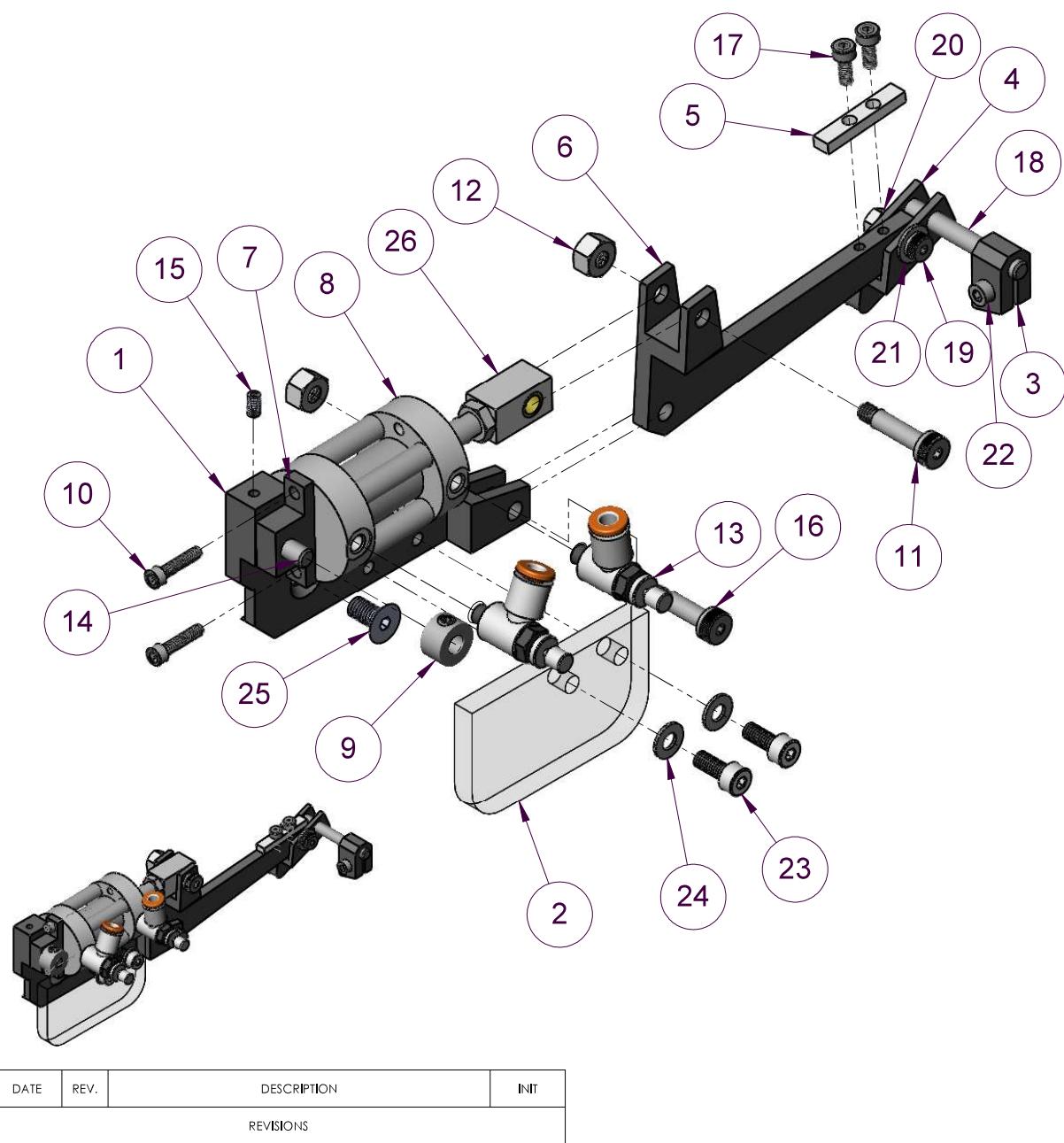
#### BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material		Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5			Part No.	G012813EX3
1000 ~	±1.2	±1.8	-			Ass'y No.	G013750
PARALLELNESS		1/100				Date	12/3/14
ANGLE TOLERANCE		1/100				Scale :	1:1
SURFACE TOLERANCE		0.2/100				Size :	B
ROUNDNESS	UNDER 30% TOLERANCE						
SURFACE FINISH	63	UNLESS OTHERWISE SPECIFIED		TZ			

DATE	REV.	DESCRIPTION	INIT
REVISIONS			

Tracking No. W005445

GTN, INC.



The diagram illustrates an exploded view of a mechanical assembly, likely a cylinder or actuator. The components are numbered 1 through 26. Key parts include a cylinder body (1), a rod (2), a bracket (3), a clevis (4), a lifter pad (5), a safety bracket (6), a limit switch (7), a lock nut (8), a clevis (9), a clevis (10), a clevis (11), a clevis (12), a clevis (13), a clevis (14), a clevis (15), a clevis (16), a clevis (17), a clevis (18), a clevis (19), a clevis (20), a clevis (21), a clevis (22), a clevis (23), a clevis (24), a clevis (25), and a clevis (26).

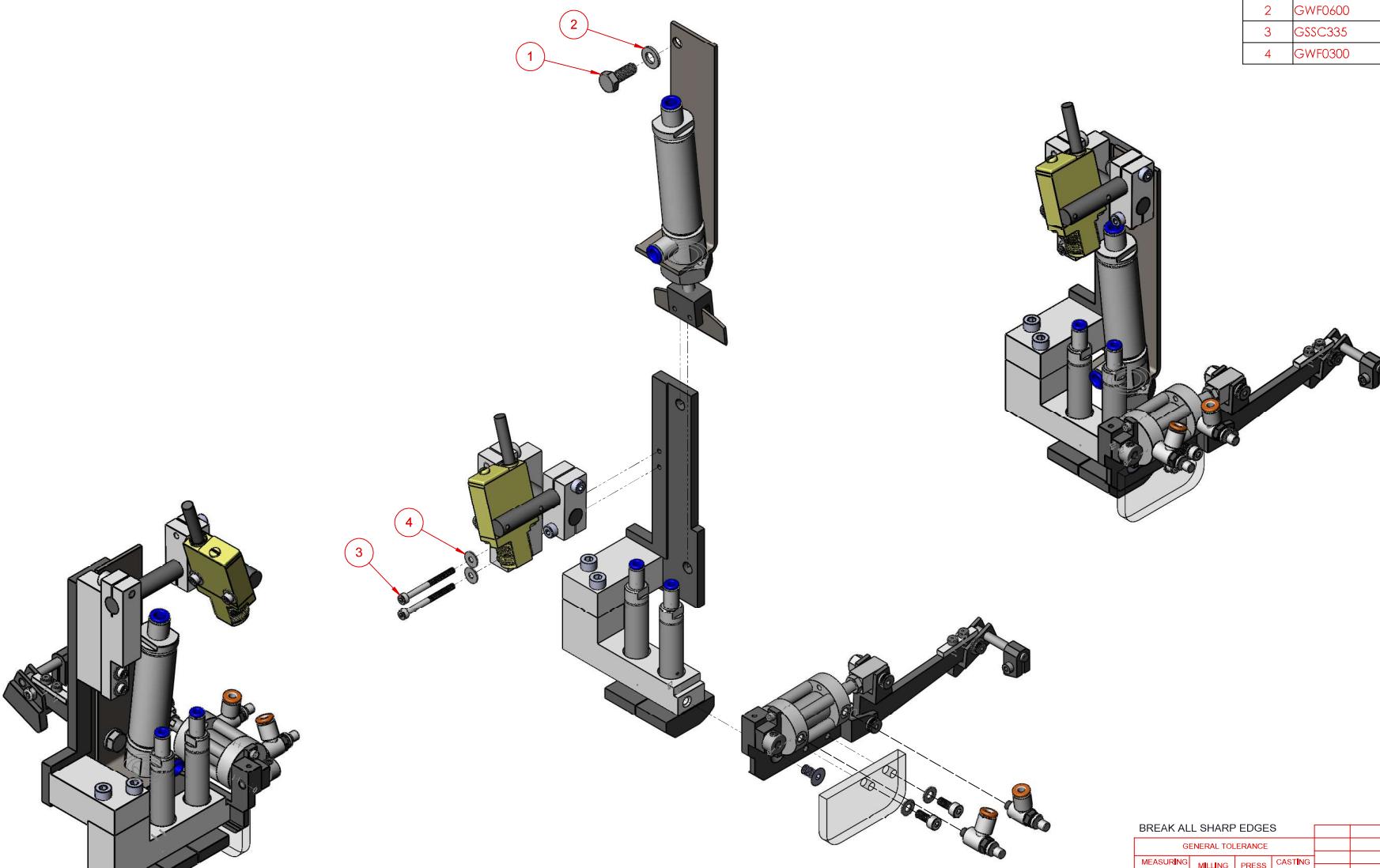
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013492	TOP CLAMP BRKT (W10-4JB)	1
2	G012821	SAFETY BRKT (W11-1A-5A)	1
3	G012826	LIFTER PAD (W11-1A-2G)	1
4	G012828	TOP PAD (W11-1A-2H)	1
5	G012829	LIMIT (W11-1A-3A)	1
6	G012830	TOP CLAMP ARM (W10-5A)	1
7	G012833	CYL BRKT (W11-1A-3B)	1
8	G014251	AIR CYL (W10-5AB)	1
9	9414T5	COLLAR 3/16 (13C)	1
10	GSSCE13	4/40 X 1/2 SHCS	2
11	97345A492	SHLDR SCRW 3/16 X 5/8, 8-32 (61E)	1
12	GN0LJ00	LOCK NUT, 8-32	2
13	JW000014	FITTING FLO CON (D2C7)	2
14	98381A509	DOWEL 3/16 X 7/8 (63C)	1
15	GSSS306	SCREW, M3 X 6 SET	1
16	91259A166	SHLDR SCRW 3/16 X 1/2, 8-32 (61D)	1
17	GSSC308	SHCS M3 x 8	2
18	98381A514	DOWEL 3/16 X 1 1/2 (63D)	1
19	91259A156	SHLDR SCRW 1/8 X 3/8, 4-40 (61G)	1
20	GN0LE00	LOCK NUT 4-40	1
21	GWFOE00	#4 FW	1
22	GSSC310	M3X10 SHCS	1
23	GSSC410	SHCS M4 x 10	2
24	GWFO400	FLAT WASHER M4	2
25	GSSF510	SCREW, M5X10 FHCS	1
26	G013428	CLEVIS (13D)	1

BREAK ALL SHARP EDGES		Tracking No. W005445					
GENERAL TOLERANCE							
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material		Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5			Part No.	G012813EX4
1000 ~	±1.2	±1.8	-			Ass'y No.	G012820
PARALLELNESS		1/100				Date	8/10/14
ANGLE TOLERANCE		1/100				Scale :	1:1
SURFACE TOLERANCE	0.2/100					Size :	B
ROUNDNESS	UNDER 30% TOLERANCE						
SURFACE FINISH	63 UNLESS OTHERWISE SPECIFIED			TZ			

REVISIONS

GTN, INC.



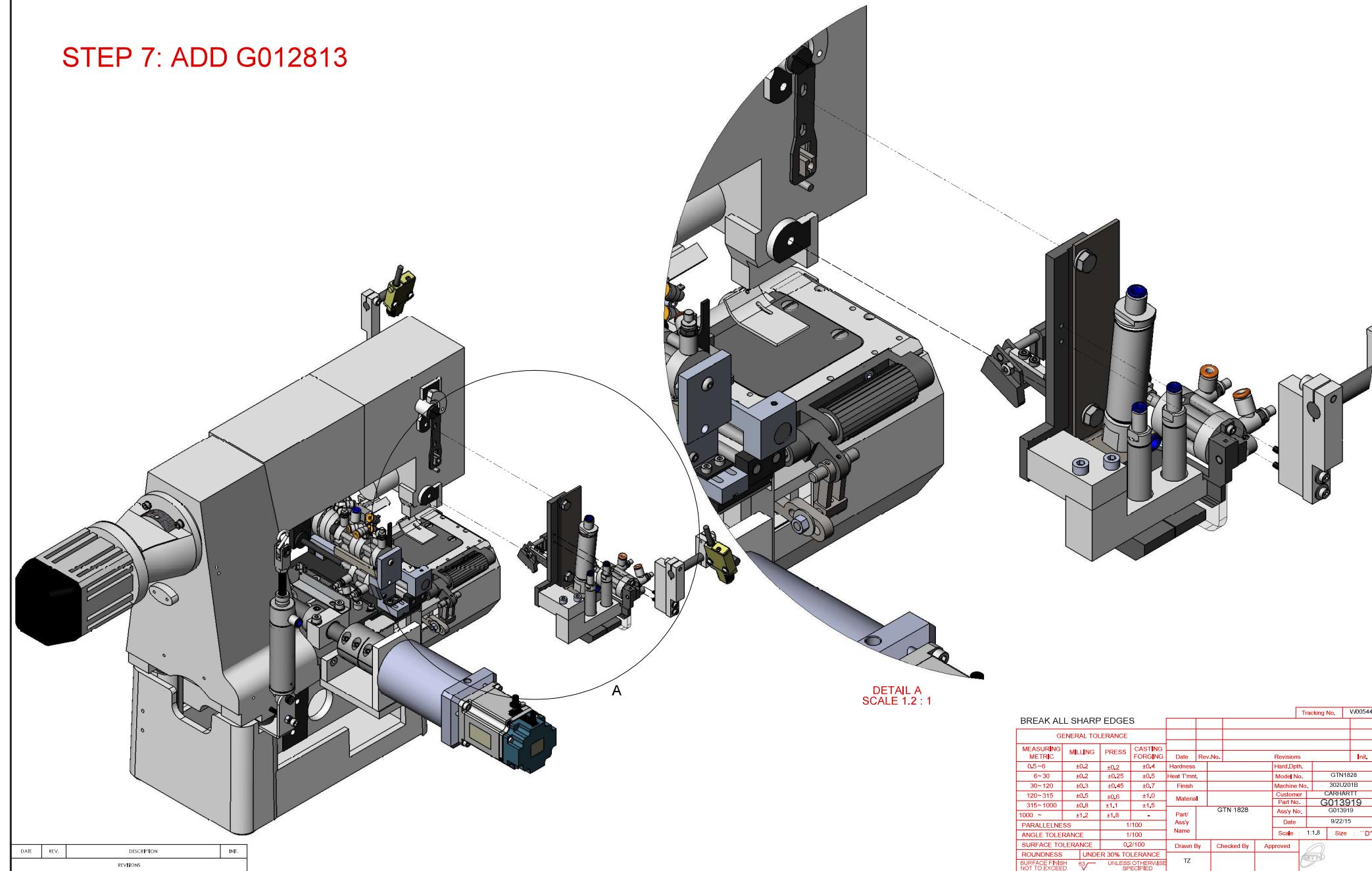
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSHC616	M6 X 16 CAP SCREW	1
2	GWF0600	FW M6	1
3	GSSC335	SHCS M3 X 35	2
4	GWF0300	FLAT WASHER, M3	2

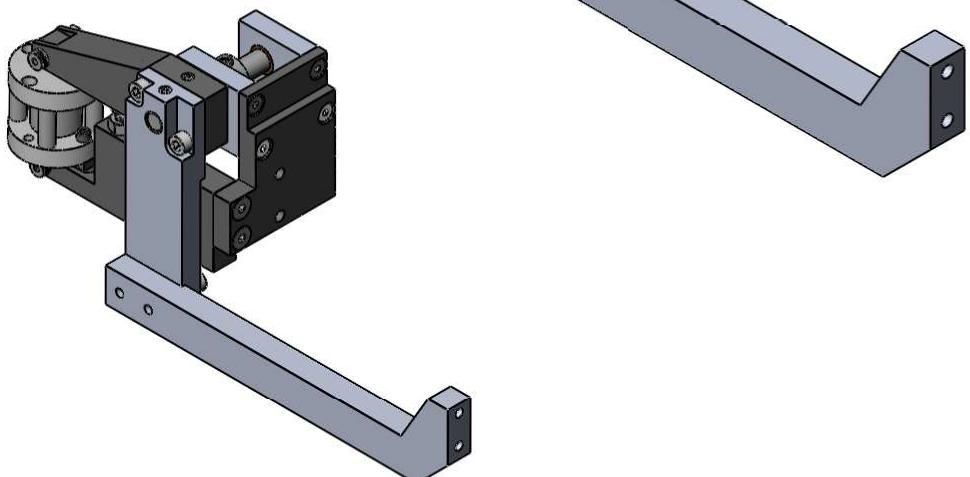
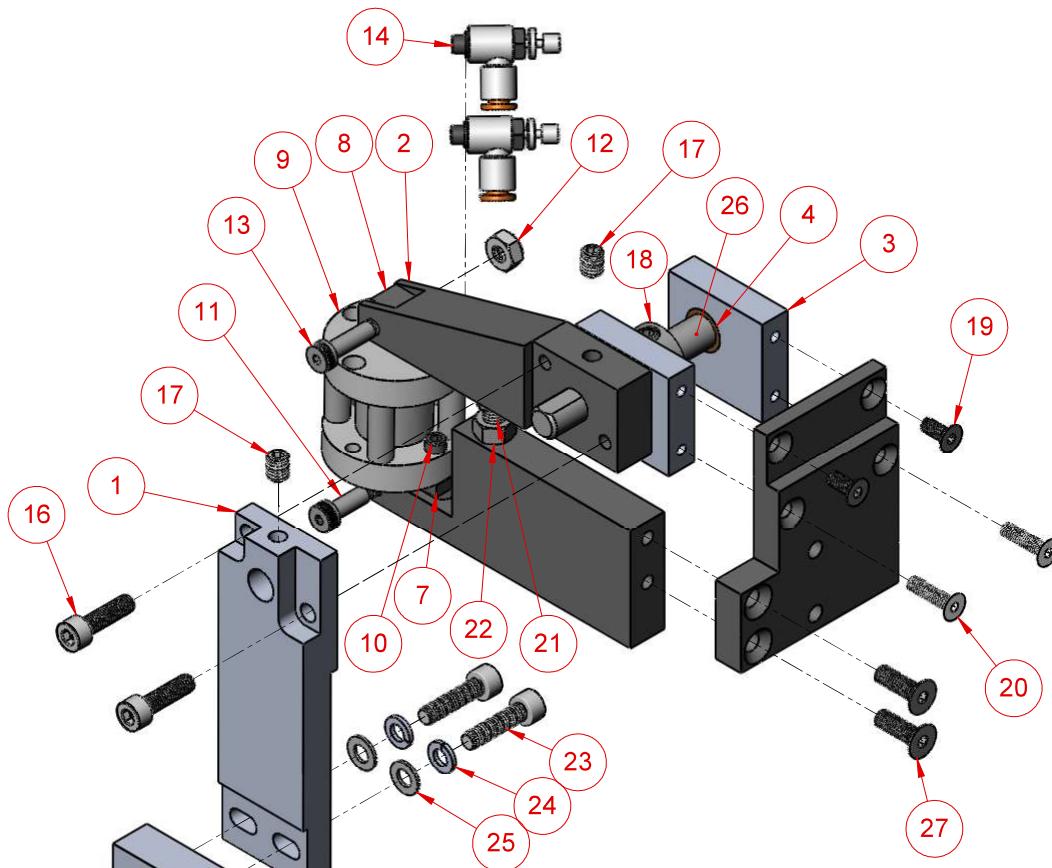
Tracking No. V0005445

GENERAL TOLERANCE						
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions
0.5~6	±0.2	±0.2	±0.4	Hardness		Init.
6~30	±0.2	±0.25	±0.5	Heat Tmt.		Model No. GTN1928
30~120	±0.3	±0.45	±0.7	Finish		Machine No. 302L001B
120~315	±0.5	±0.6	±1.0	Material		Customer CARIBARIT
315~1000	±0.8	±1.1	±1.5	Part No. G012813		Assy No. G012813EX5
1000 ~	±1.2	±1.8	-	Date 3/17/15		Scale : 1:1 Size : 1" D"
SURFACE TOLERANCE	0.2/100			Drawn By	Checked By	Approved
ROUNDNESS	UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED				83	UNLESS OTHERWISE SPECIFIED	TZ

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

## STEP 7: ADD G012813

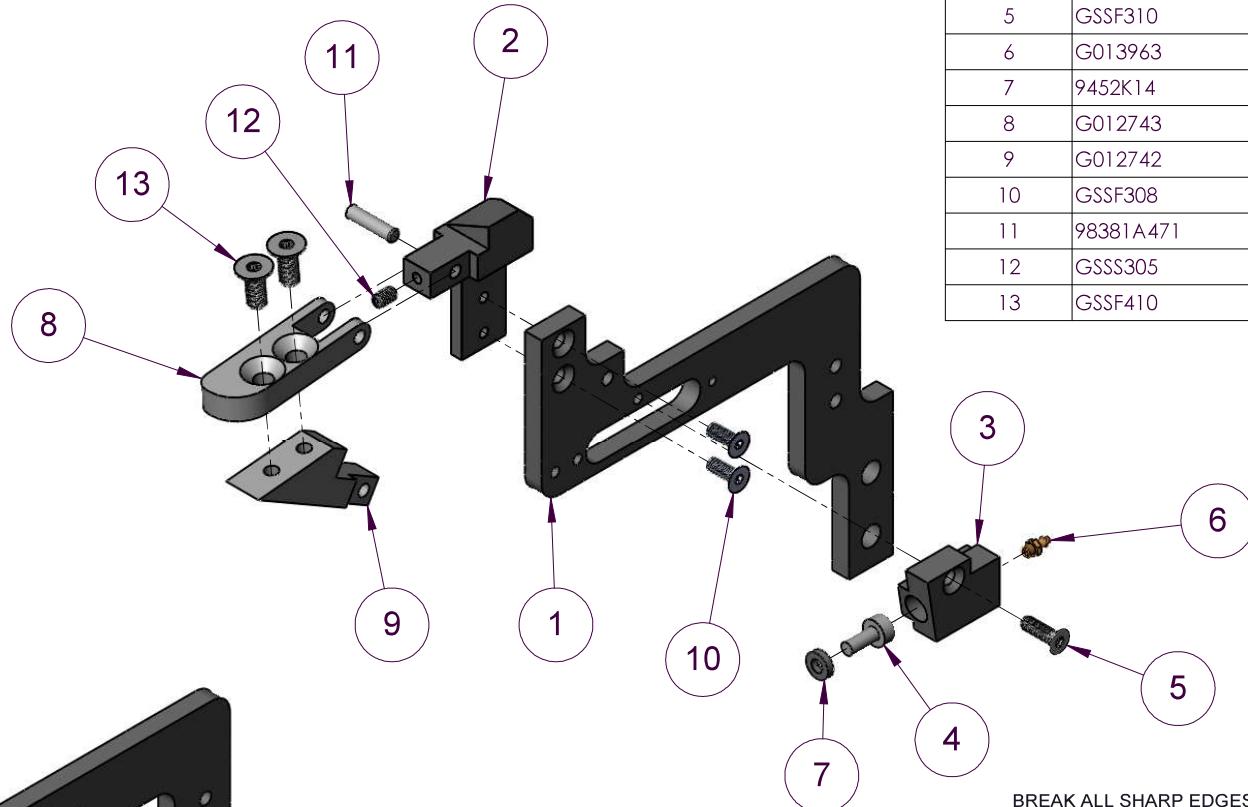




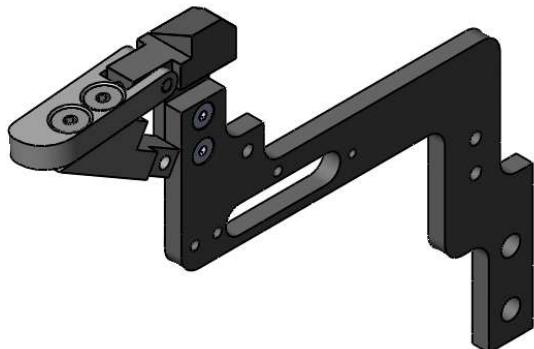
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012764	PANEL VERT ARM (W10-5E)	1
2	G012762	PANEL CLAMP DRIVE (W10-5F)	1
3	G012760	BEARING BLOCK (W10-5G)	2
4	286875	BRONZE SLEEVE (13F)	2
5	G012759	PANEL CLAMP MTG. (W10-5GB)	1
6	G012758	BOTTOM CYL BRKT (W10-5H)	1
7	G012756	CYL MOUNT (W11-1A-3G)	1
8	G012510	CLEVIS (W11-1A-3H)	1
9	G012770	AIR CYL (W10-5I)	1
10	GSSCG13	6-32 X 1/2 SHCS	2
11	91259A166	SHLDR SCRW 3/16 X 1/2, 8-32 (61D)	1
12	GN0LL00	10-32 LOCK NUT	2
13	97345A492	SHLDR SCRW 3/16 X 5/8, 8-32 (61E)	1
14	JW000014	FITTING FLO CON (D2C7)	2
15	G012755	CYL BRKT (W10-5J)	1
16	GSSC518	M5 X 18 SHCS	2
17	GSS606	M6 X 6 SET SCREW	2
18	9414T8	SHAFT COLLAR (14A)	1
19	GSSF410	M4 X 10 FHCS	2
20	GSSF416	M4 X 16 FHCS	2
21	GSHC625	M6 X 25 CAP SCREW	1
22	GN00600	NUT, M6 HEX	1
23	GSSC520	M5 X 20 SHCS	2
24	GWL0500	WASHER, M5 LOCK	2
25	GWF0500	M5 FW	2
26	G013511	PANEL SUPPORT SHAFT (16G)	1
27	GSSF516	M5 X 16 FLHD	2

BREAK ALL SHARP EDGES				Tracking No.
GENERAL TOLERANCE				
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date Rev.No. Revisions Init.
0.5~6	±0.2	±0.2	±0.4	Hardness
6~30	±0.2	±0.25	±0.5	Heat T'mnt.
30~120	±0.3	±0.45	±0.7	Finish
120~315	±0.5	±0.6	±1.0	Machine No.
315~1000	±0.8	±1.1	±1.5	Customer
1000 ~	±1.2	±1.8	-	Part No.
PARALLELNESS				Assy No.
ANGLE TOLERANCE				Date
SURFACE TOLERANCE				Scale : 1:1 Size : "C"
ROUNDNESS	UNDER 30% TOLERANCE			GTN, INC.
SURFACE FINISH NOT TO EXCEED	63	UNLESS OTHERWISE SPECIFIED		
Drawn By		Checked By	Approved	
Part/ Ass'y Name				GT013497EX1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012752	PANEL CLAMP OFFSET (W10-5K)	1
2	G012751	PANEL CLAMP PAD (W11-1A-5E)	1
3	G013506	EAR TUCK CYL (W11-1A-4D)	1
4	G013507	PISTON (W11-1A-4E)	1
5	GSSF310	FHCS M3 x 10	1
6	G013963	MINI AIR FITTING (12E)	1
7	9452K14	O-RING (21A)	1
8	G012743	EXTENSION (W11-1A-4G)	1
9	G012742	EXTENSION ARM (W11-1A-5G)	1
10	GSSF308	M3X8 FHCS	2
11	98381A471	DOWEL 1/8 X 1/2 (62A)	1
12	GSSS305	M3 X 5 SET SCREW	1
13	GSSF410	M4 X 10 FHCS	2



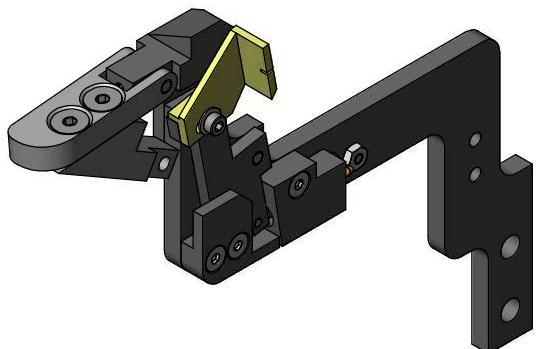
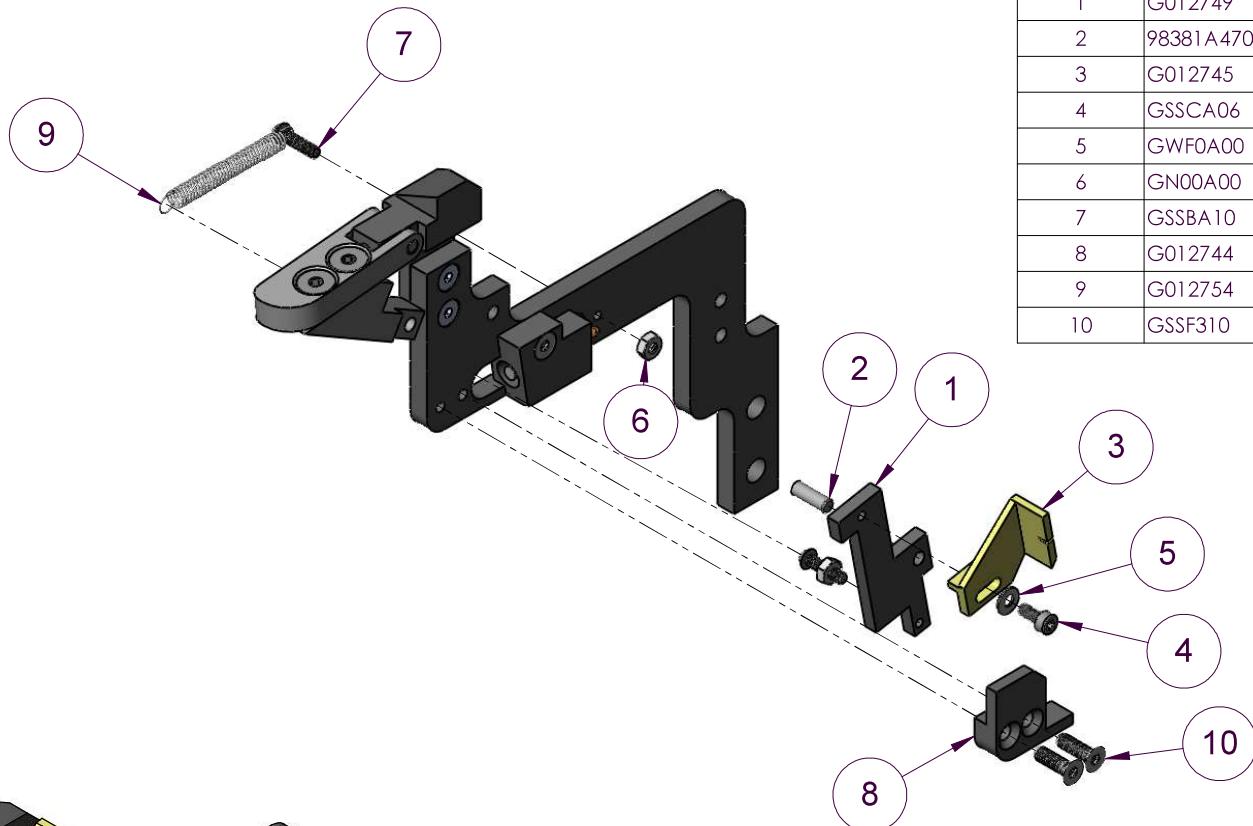
DATE	REV.	DESCRIPTION	INIT
REVISIONS			

#### BREAK ALL SHARP EDGES

#### GENERAL TOLERANCE

MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	
120~315	±0.5	±0.6	±1.0	Material		Customer	
315~1000	±0.8	±1.1	±1.5	Part No.	G013497EX2	Part No.	
1000 ~	±1.2	±1.8	-	Ass'y No.		Ass'y No.	
PARALLELNESS		1/100		Date		Date	
ANGLE TOLERANCE		1/100		Scale :	1:1	Size :	B
SURFACE TOLERANCE		0.2/100		Drawn By	Checked By	Approved	
ROUNDNESS	UNDER 30% TOLERANCE						
SURFACE FINISH NOT TO EXCEED $63 \text{ } \mu\text{m}$ UNLESS OTHERWISE SPECIFIED							

GTN, INC.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012749	EAR TUCK ARM (W11-1A-4B)	1
2	98381A470	DOWEL 1/8 X 3/8 (61F)	1
3	G012745	EAR TUCKER (W11-1A-4C)	1
4	GSSCA06	M2.5 X 6 SHCS	1
5	GWFOA00	M2.5 FW	1
6	GN00A00	M2.5 NUT	2
7	GSSBA10	M2.5 X 10 BHCS	2
8	G012744	RETAINER (W11-1A-4F)	1
9	G012754	SPRING (W11-1A-4H)	1
10	GSSF310	FHCS M3 x 10	2

#### BREAK ALL SHARP EDGES

#### GENERAL TOLERANCE

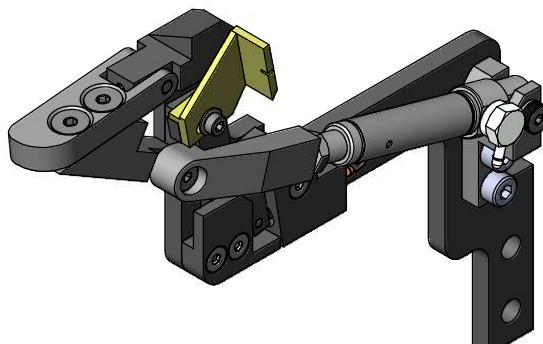
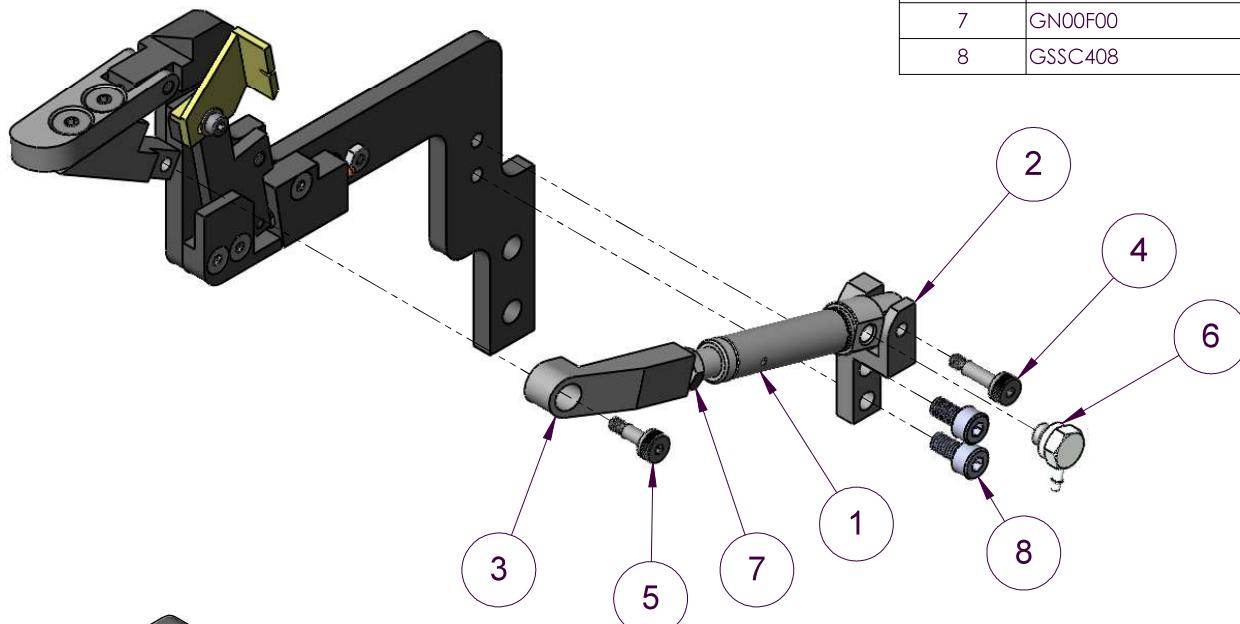
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	
120~315	±0.5	±0.6	±1.0	Material		Customer	
315~1000	±0.8	±1.1	±1.5			Part No.	G013497EX3
1000 ~	±1.2	±1.8	-			Ass'y No.	
PARALLELNESS			1/100			Date	
ANGLE TOLERANCE			1/100			Scale :	1:1
SURFACE TOLERANCE			0.2/100			Size :	B
ROUNDNESS			UNDER 30% TOLERANCE				
SURFACE FINISH NOT TO EXCEED	63		UNLESS OTHERWISE SPECIFIED				

DATE	REV.	DESCRIPTION	INIT
REVISIONS			

Tracking No.

GTN, INC.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G014248	AIR CYL (16A)	1
2	G012739	5/16 CYL MOUNT (W11-1A-6C)	1
3	G012740	LIFTER ROD END (W11-1A-6E)	1
4	91259A156	SHLDR SCRW 1/8 X 3/8, 4-40 (61G)	1
5	91259A155	SHLDR SCREW 1/8 X 1/4, 4-40 (61H)	1
6	G014249	FITTING (12F)	1
7	GN00F00	5-40 NUT	1
8	GSSC408	M4 X 8 SHCS	2



BREAK ALL SHARP EDGES

GENERAL TOLERANCE

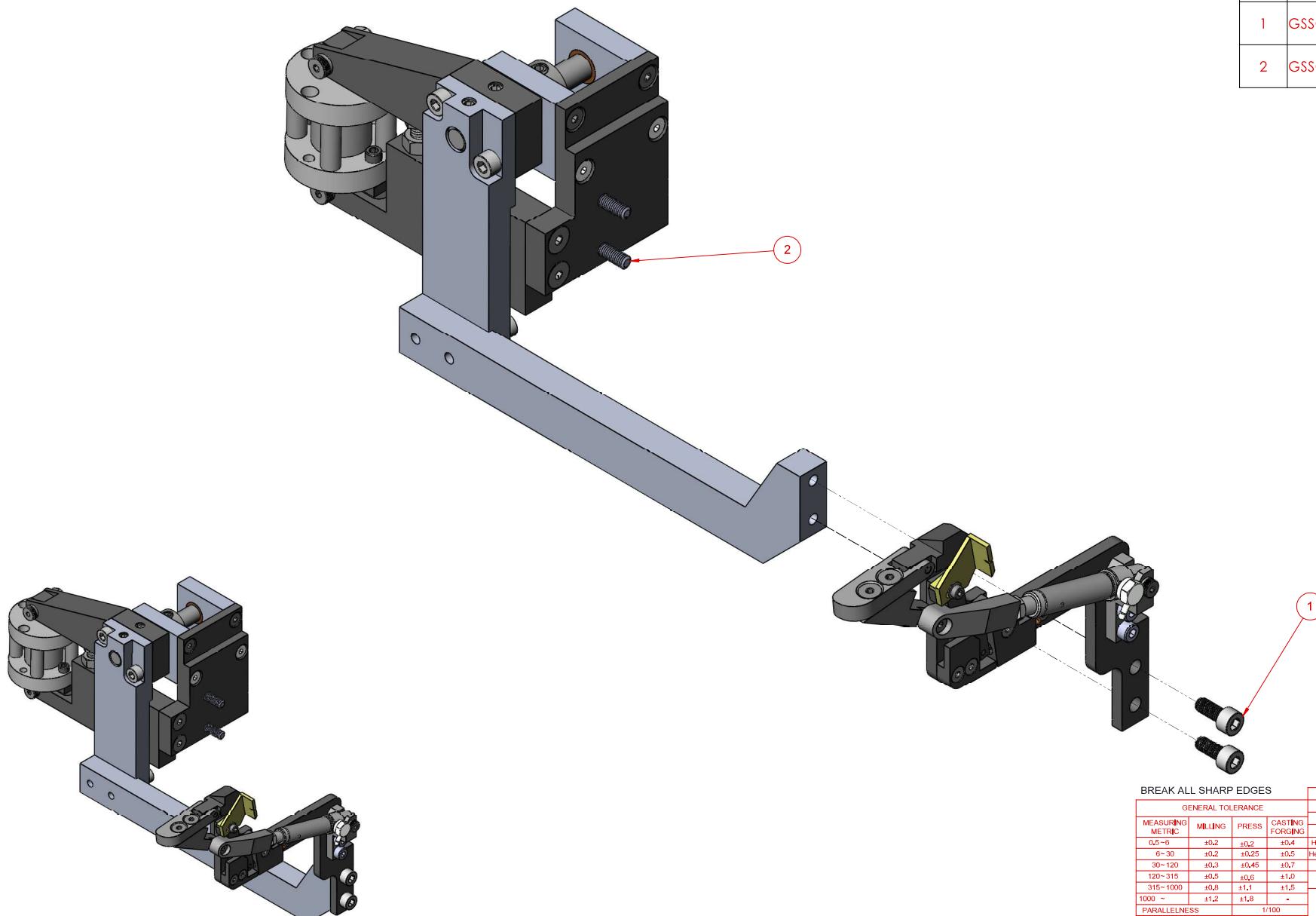
MEASURING METRIC	GENERAL TOLERANCE			Date	Rev.No.	Revisions	Init.
	MILLING	PRESS	CASTING FORGING				
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	
120~315	±0.5	±0.6	±1.0	Material		Customer	
315~1000	±0.8	±1.1	±1.5			Part No.	G013497EX4
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name	FRONT LOWER PANEL SUPPORT SUB ASM		
PARALLELNESS		1/100			Ass'y No.	Date	
ANGLE TOLERANCE		1/100			Scale :	1:1	Size : B
SURFACE TOLERANCE	0.2/100			Drawn By	Checked By	Approved	
ROUNDNESS	UNDER 30% TOLERANCE						
SURFACE FINISH	NOT TO EXCEED $63 \text{ } \mu\text{m}$ UNLESS OTHERWISE SPECIFIED						

DATE	REV.	DESCRIPTION	INIT
REVISIONS			

Tracking No. \_\_\_\_\_

GTN, INC.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSSC512	M5 X 12 SHCS	2
2	GSSCL16	10-32 X 5/8" SHCS	2

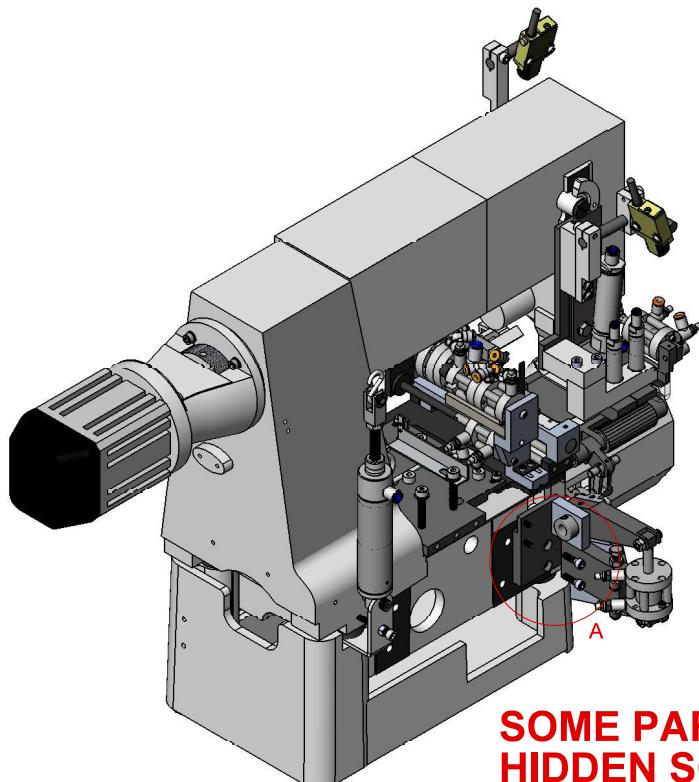


GENERAL TOLERANCE						Tracking No.	V0005445
MEASURING MEDIUM	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard Dpth.	
6~30	±0.2	±0.25	±0.5	Heat Trmt.		Model No.	GTN1928
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302L001B
120~315	±0.5	±0.6	±1.0	Material		Customer	CARHARIT
315~1000	±0.8	±1.1	±1.5	Part No.		Part No.	G013497EX5
1000 ~	±1.2	±1.8	-	Power Assy		Assy Name	G013512
PARALLELNESS			1/100	Date		Scale	8/15/14
ANGLE TOLERANCE			1/100	Drawn By	Checked By	Approved	
SURFACE TOLERANCE			0.2/100	TZ			
ROUNDNESS			UNDER 30% TOLERANCE				
SURFACE FINISH NOT TO EXCEED	83	UNLESS OTHERWISE SPECIFIED					

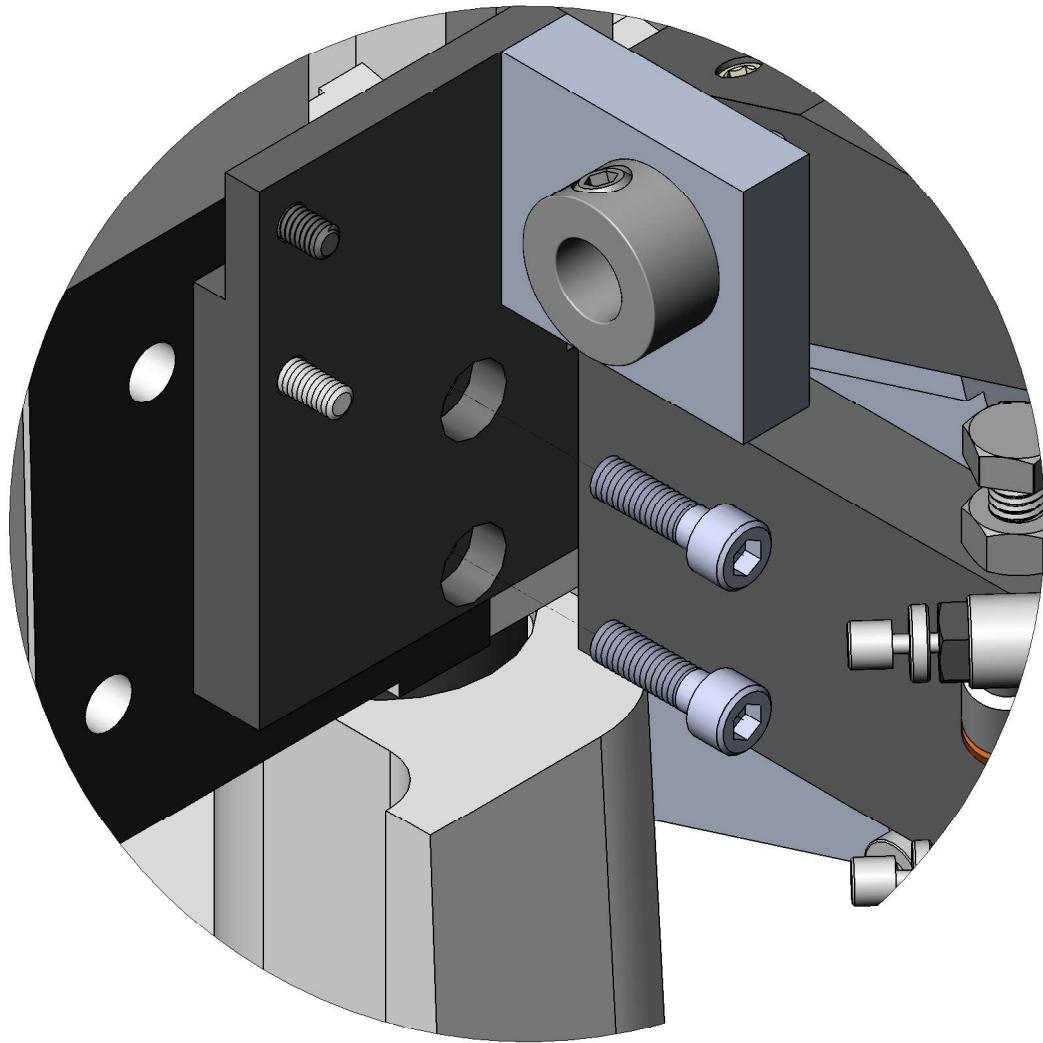
DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

STEP 8: ADD G013497

NOTE: ONLY 2-10-32X5/8 SHCS  
ARE USED TO MOUNT  
THIS ASSEMBLY



SOME PARTS IN G013497 ARE  
HIDDEN SO SCREWS CAN BE VIEWED

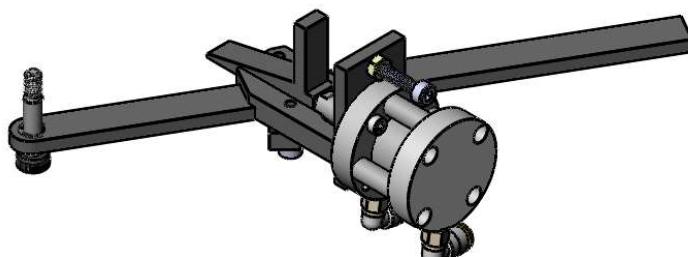
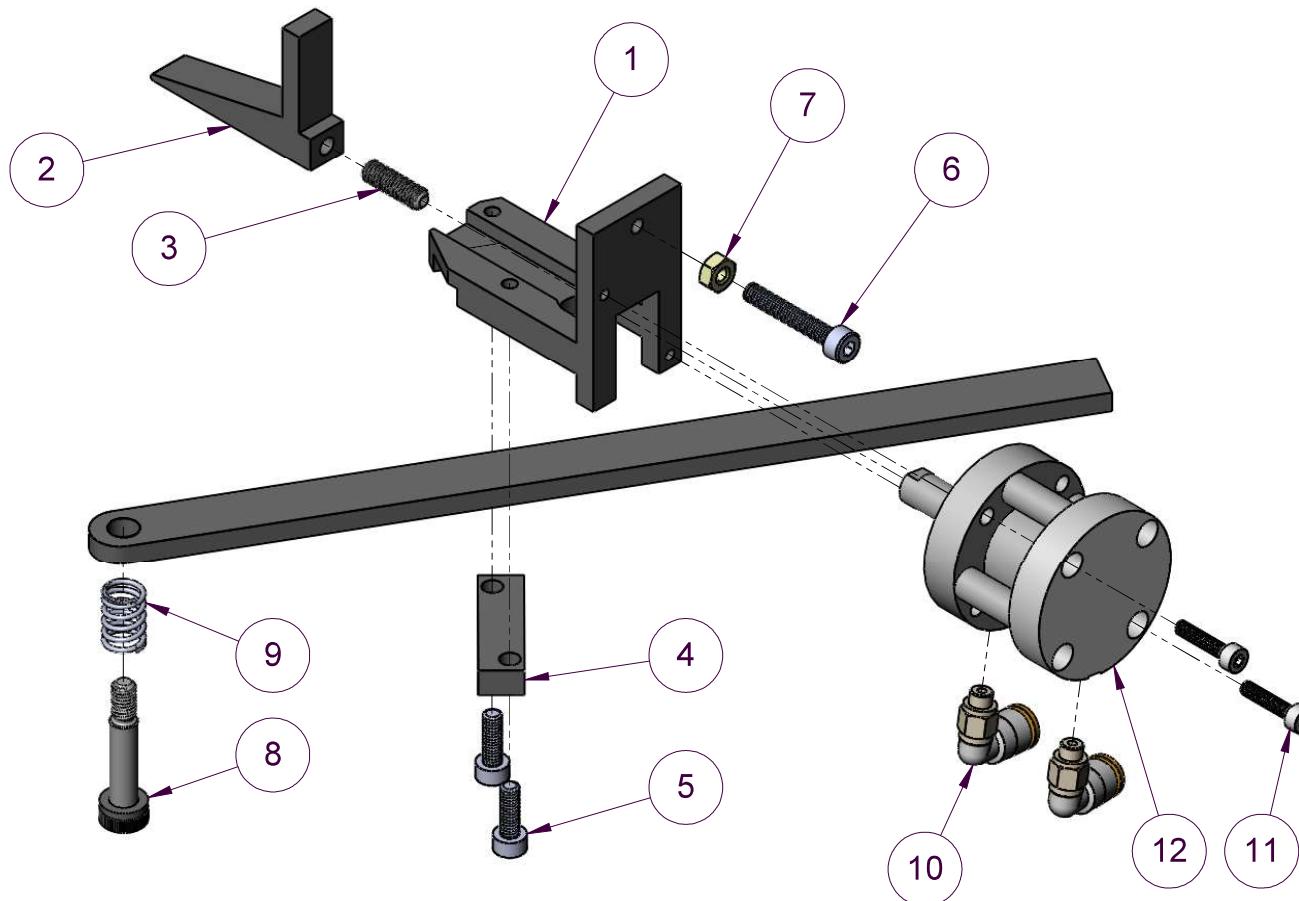


DETAIL A  
SCALE 4 : 1

GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.	
0.5~6	±0.2	±0.2	±0.4	Hardness				
6~30	±0.2	±0.25	±0.5	Heat Tmt.				
30~120	±0.3	±0.45	±0.7	Finish				
120~315	±0.5	±0.6	±1.0	Material				
315~1000	±0.8	±1.1	±1.5					
1000 ~	±1.2	±1.8	-					
PARALLELNESS			1/100					
ANGLE TOLERANCE			1/100					
SURFACE TOLERANCE			0.2/100					
ROUNDNESS			UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED		UNLESS OTHERWISE SPECIFIED		TZ				

GTN 1828

Customer: CARIBARITI  
Part No.: G013919  
Assy No.: G013919  
Date: 9/22/15  
Scale: 1:2 Size: 1" D"



DATE	REV.	DESCRIPTION	INIT
REVISIONS			

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013768	WEDGE GUIDE (W11-5D)	1
2	G013769	WEDGE (35E)	1
3	GSSSL16	10-32 X 5/8 SET SCREW	1
4	G013770	WEDGE GUIDE STRAP (31G)	1
5	GSSC412	M4 X 12 SHCS	2
6	GSSC425	M4 X 25 SHCS	1
7	GN00400	M4 NUT	1
8	92981A103	SHLDR SCRW 6 X 20, M5 (62G)	1
9	94125K631	SPRING (11H)	1
10	JW000001	ELBOW FITTING (D2C6)	2
11	GSSC314	SHCS M3 X 14	2
12	G013767	AIR CYL	1

#### BREAK ALL SHARP EDGES

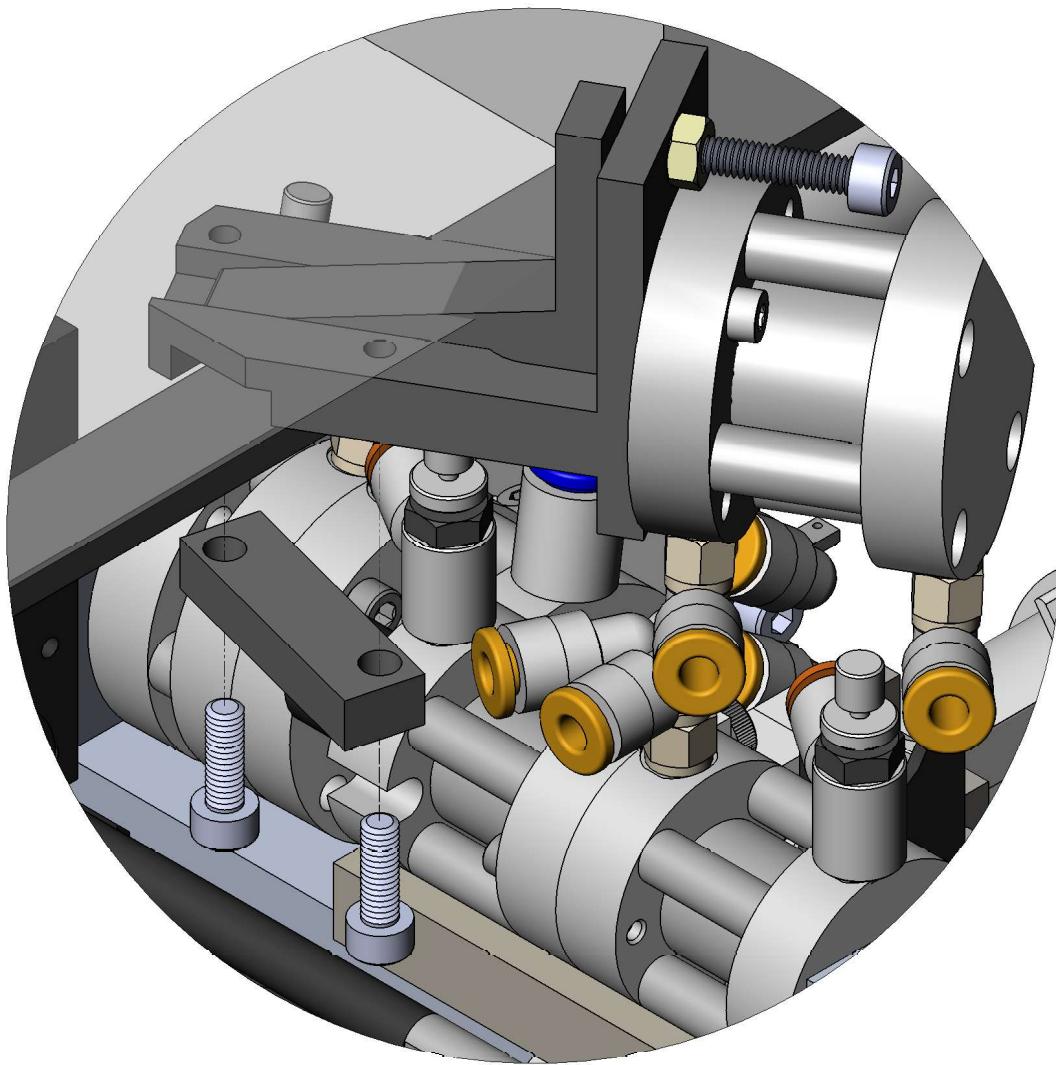
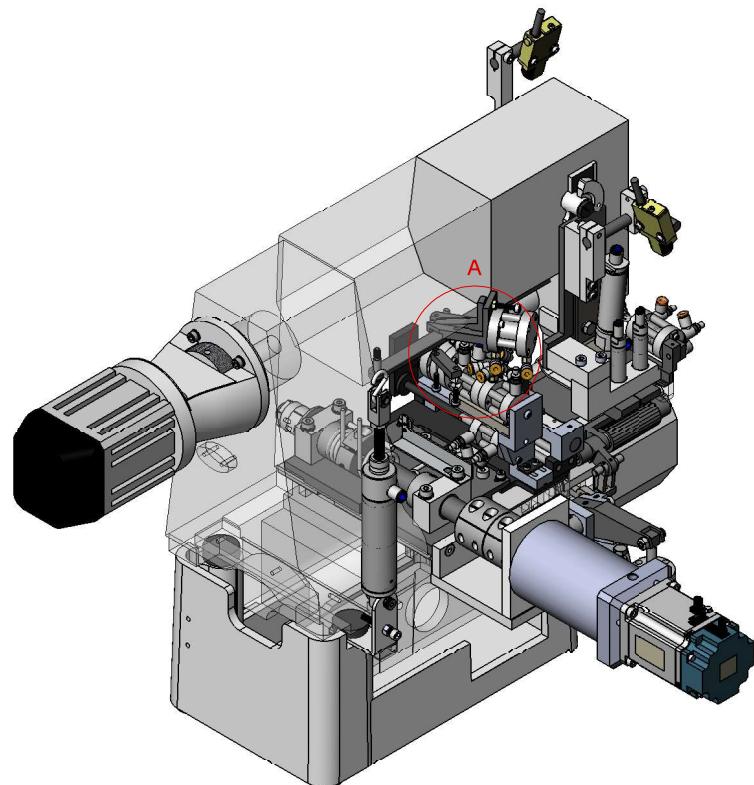
#### GENERAL TOLERANCE

MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material		Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5	Part No.	G013766	Ass'y No.	G013766
1000 ~	±1.2	±1.8	-	Ass'y Name		Date	12/11/14
PARALLELNESS		1/100				Scale :	1:1
ANGLE TOLERANCE		1/100				Size :	B
SURFACE TOLERANCE		0.2/100					
ROUNDNESS		UNDER 30% TOLERANCE					
SURFACE FINISH	63	UNLESS OTHERWISE SPECIFIED		TZ			

Tracking No. W005445

GTN, INC.

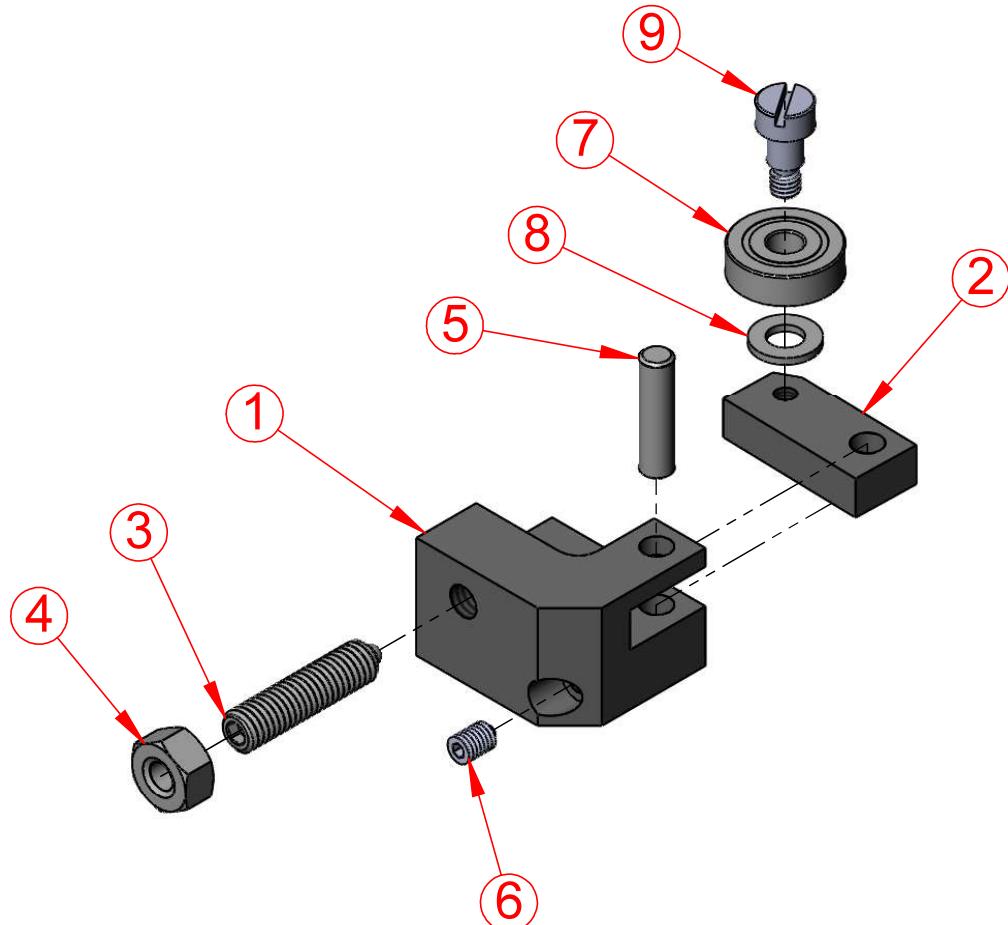
## STEP 9: ADD G013766



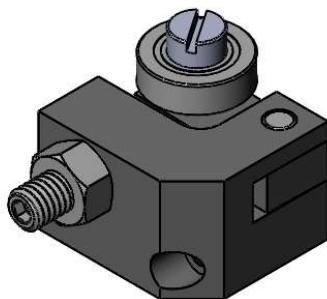
GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.	
0.5~6	±0.2	±0.2	±0.4	Hardness				
6~30	±0.2	±0.25	±0.5	Heat Trmt.				
30~120	±0.3	±0.45	±0.7	Finish				
120~315	±0.5	±0.6	±1.0	Material				
315~1000	±0.8	±1.1	±1.5					
1000 ~	±1.2	±1.8	-					
PARALLELNESS			1/100					
ANGLE TOLERANCE			1/100					
SURFACE TOLERANCE			0.2/100					
ROUNDNESS			UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED	83		UNLESS OTHERWISE SPECIFIED	TZ				

GTN 1828

Customer: CARBURIT  
Part No.: G013919  
Assy No.: G013919  
Date: 9/22/15  
Scale: 1:2 Size: 1" D"



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012711	DETENT BRKT (26E)	1
2	G012712	DETENT ARM (24F)	1
3	G012717	SPRING PLUNGER (24G)	1
4	GN00600	NUT, M6 HEX	1
5	G012284	DOWEL 3/16 X 3/4 (62C)	1
6	GSSS406	SCREW, M4X6 SET	1
7	6153K69	BEARING (31A)	1
8	91635A230	BRASS WASHER (24H)	1
9	90270A658	SHLDR SCRW 5 X 6, M4 (62B)	1

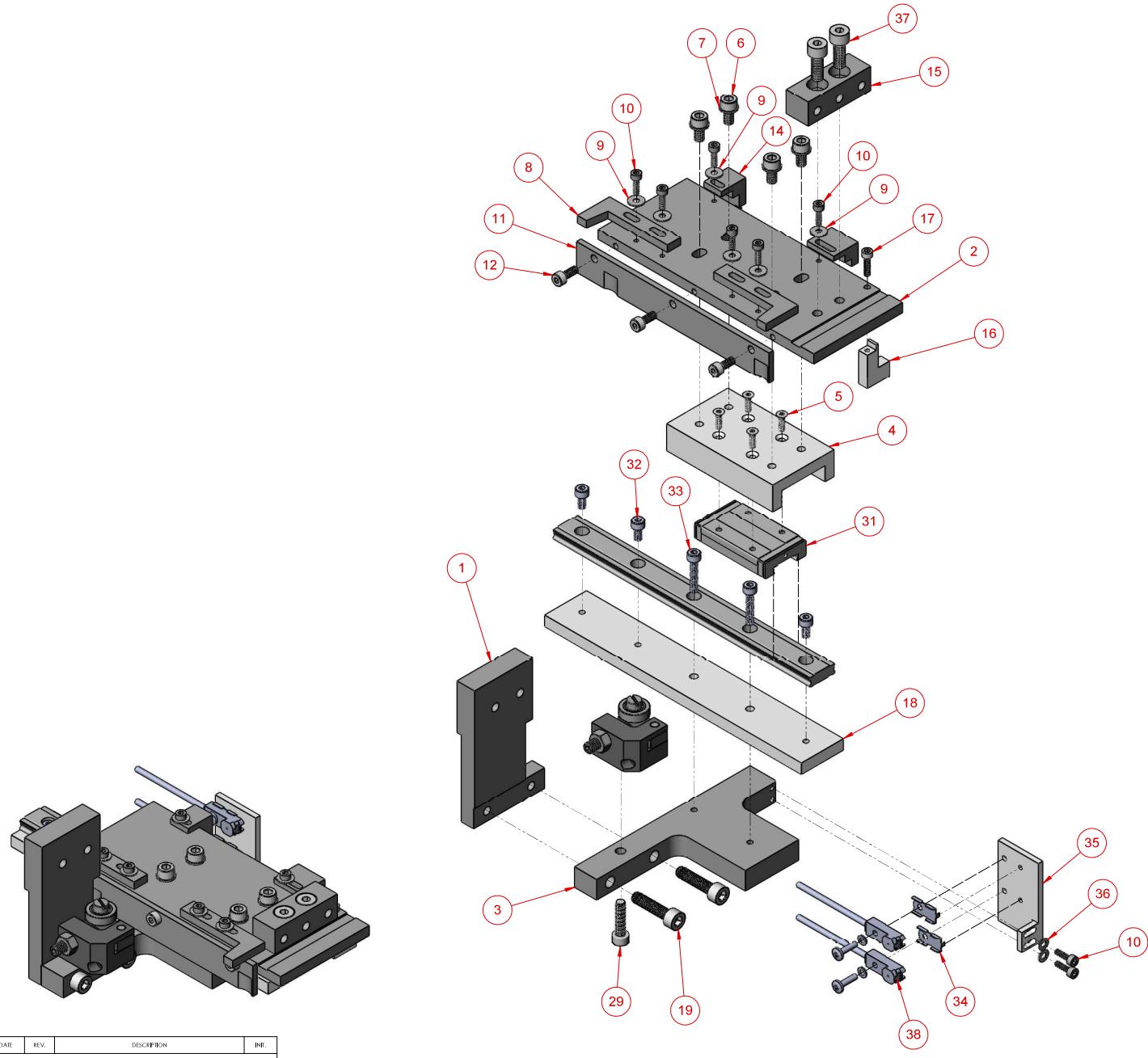


DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

#### BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.			
MEASURING METRIC	MILLING	PRESS	CASTING FORGING								
0.5~6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth.				
6~30	±0.2	±0.25	±0.5	Heat T'mnt.			Model No.				
30~120	±0.3	±0.45	±0.7	Finish			Machine No.				
120~315	±0.5	±0.6	±1.0	Material			Customer				
315~1000	±0.8	±1.1	±1.5				Part No.	G013493			
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name	ROLLER GUIDE ASM		Ass'y No.				
PARALLELNESS							Date				
ANGLE TOLERANCE							Scale :	1:1			
SURFACE TOLERANCE							Size :	"A"			
ROUNDNESS				Drawn By		Checked By	Approved				
SURFACE FINISH NOT TO EXCEED 63 UNLESS OTHERWISE SPECIFIED											

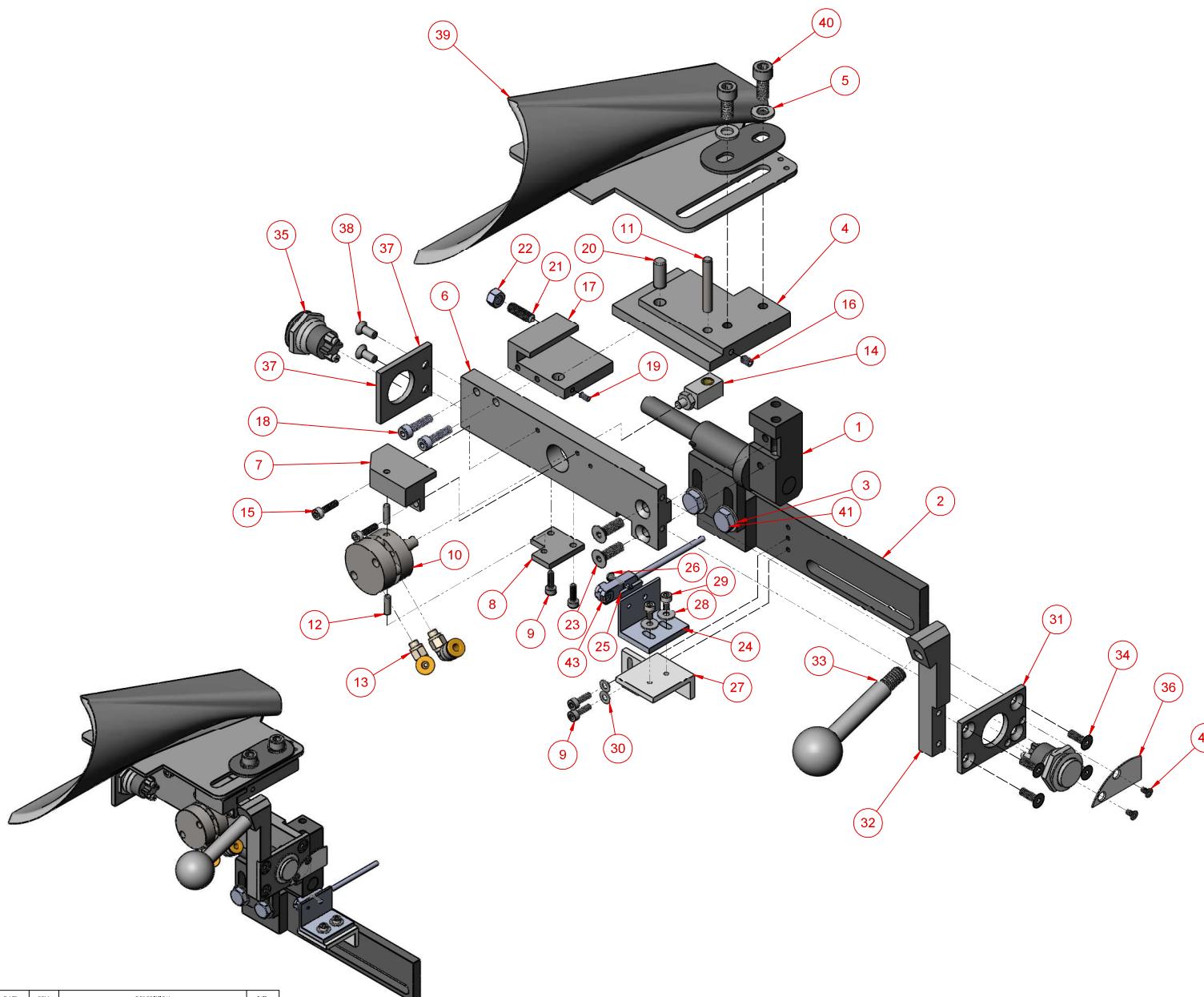
GTN, INC.  
1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013455	FRONT SLIDE MOUNT (W11-4C)	1
2	G013457	PLATE FOLDER (W11-4D)	1
3	G013456	SLIDE SUPPORT (W11-4E)	1
4	G013458	PLATE TO SLIDE MOUNT (W11-4F)	1
5	GSSF310	FHCS M3 x 10	4
6	GSSC510	M5X.8, L10 SHCS	4
7	GWF0500	M5 FW	4
8	G013459	FOLDER STOP (W11-4CB)	2
9	GWF0300	FLAT WASHER, M3	6
10	GSSC310	M3X10 SHCS	8
11	G012724	DETENT (W11-4G)	1
12	GSSC410	SHCS M4 x 10	3
13	G012720	MIDDLE FLAG (24C)	1
14	G012719	HOME FLAG (24D)	1
15	G013486	FOLDER ASM MOUNT	1
16	G013460	FOLDER IN FLAG (24E)	1
17	GSSC312	M3 X 12 SHCS	1
18	G013461	SLIDE SUPPORT (W11-4H)	1
19	GSSC625	M6 X 25 SHCS	2
20	G012711	DETENT BRKT (26E)	1
21	G012712	DETENT ARM (24F)	1
22	G012717	SPRING PLUNGER (24G)	1
23	GN00600	NUT, M6 HEX	1
24	G012284	DOWEL 3/16 X 3/4 (62C)	1
25	GSSS406	SCREW, M4X6 SET	1
26	6153K69	BEARING (31A)	1
27	91635A230	BRASS WASHER 5 X 20 (24H)	1
28	90270A658	SHLDR SCRW 5 X 6, M4 (62B)	1
29	GSSC520	M5 X 20 SHCS	1
30	G013462	MODIFIED SLIDE RAIL (W11-4I)	1
31	SHW12HRMUU_Slide12_550	RAIL CAR (W11-4FB)	1
32	GSSC408	M4 X 8 SHCS	3
33	GSSC420	M4 X 20 SHCS	2
34	MS-GXL8	SENSOR BRKT (A1G4)	2
35	G013465	SENSOR BRKT (27A)	1
36	GWF0300	FW M3	2
37	GSSC616	M6 X 16 SHCS	2
38	JZ000033	SENSOR	2

BREAK ALL SHARP EDGES										
GENERAL TOLERANCE										
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions				
0.5~6	±0.2	±0.2	±0.4	Hardness		Init.				
6~30	±0.2	±0.25	±0.5	Heat Trmt.			Mod. No.	GTN1928		
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	3022001B		
120~315	±0.5	±0.6	±1.0	Material			Customer	CARBURIT		
315~1000	±0.8	±1.1	±1.5				Part No.	G013454		
1000 ~	±1.2	±1.8	-				Assy No.	G013454		
PARALLELNESS				1/100			Date	8/3/14		
ANGLE TOLERANCE				1/100			Scale :	1:1		
SURFACE TOLERANCE				0.2/100			Size :	1" D"		
ROUNDNESS				UNDER 30% TOLERANCE			Drawn By	Checked By	Approved	
SURFACE FINISH NOT TO EXCEED				83/V	UNLESS OTHERWISE SPECIFIED		TZ			

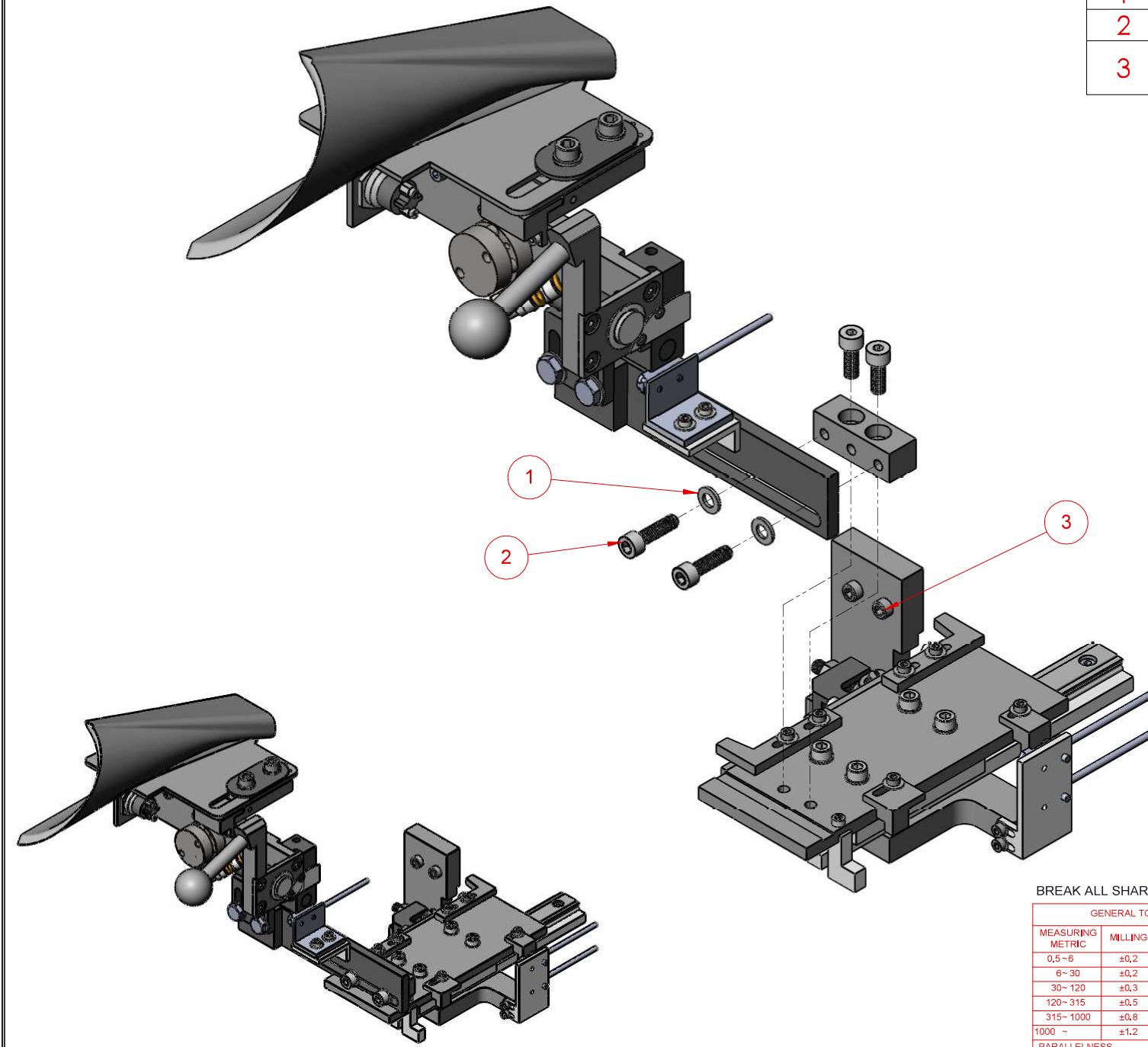
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013490	FOLDER ROT JOINT (W11-5A)	1
2	G013489	FOLDER MOUNT (W11-5A)	1
3	90107A013	1/4" FLAT	2
4	G013472	FOLDER PLATE (W11-4JB)	1
5	GWF0600	FW M6	2
6	G013471	SWITCH MOUNT (W11-4JB)	1
7	G013477	TOP CYL MOUNT (W11-4KB)	1
8	G012693	BOTTOM CYL MOUNT (31B)	1
9	GSSC310	M3X10 SHCS	4
10	G012697	MOD AIR CYL (26G)	1
11	G012354	DOWEL 3/16 X 1 1/4 (56A)	1
12	98381A218	DOWEL 1/8 X 7/16 (62E)	2
13	JW000001	ELBOW FITTING (D2C6)	2
14	G013428	CLEVIS (13D)	1
15	GSSC312	M3 X 12 SHCS	2
16	GSS406	SCREW, M4X6 SET	1
17	G013478	RETAINER (W11-4K)	1
18	GSSC416	M4 X 16 SHCS	2
19	GSSS306	SCREW, M3 X 6 SET	1
20	98381A539	DOWEL 1/4 X 5/8 (62F)	1
21	GSS516	SET SCREW	1
22	GN00500	NUT, M5 HEX	1
23	GSSF516	M5 X 16 FLHD	2
24	G013468	FOLDER SENSOR BRKT (35A)	1
25	MS-GXL8	SENSOR BRKT (A1G4)	1
26	GSSBA08	M2.5 X 8 BHCS	1
27	G013488	ADJ SENSOR BRKT (35C)	1
28	GWF0300	FLAT WASHER, M3	2
29	GSSC306	SCREW, M3X6 SHCS	2
30	GWF0300	M3 FW	2
31	G013759	SWITCH BRKT RIGHT (31D)	1
32	G013760	HANDLE BRKT (27E)	1
33	6303K44	HANDLE (27G)	1
34	GSSF412	SCREW, M4X12 FHCS	4
35	G013757	MOMENTARY SWITCH (27C)	2
36	G013487	BREAK FLAG (31E)	1
37	G013756	SWITCH BRKT LEFT (31C)	1
38	GSSF410	M4X10 FHCS	2
39	G013470	MODIFIED FOLDER ASM (W11-5A)	1
40	GSSC614	M6 X 14 SHCS	2
41	GSBCM22	1/4-20 X 7/8 CAP SCREW	2
42	GSSFA05	M2.5 X 5 FHCS	2
43	JZ000033	SENSOR	1



GENERAL TOLERANCE								
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions		
0.5~6	±0.2	±0.2	±0.4	Hardness		Init.		
6~30	±0.2	±0.25	±0.5	Heat Trmt.		Model No.	GTN1928	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302L001B	
120~315	±0.5	±0.6	±1.0	Material		Customer	CARBARIT	
315~1000	±0.8	±1.1	±1.5			Part No.	G013466	
1000 ~	±1.2	±1.8	-			Assy No.	G013468	
PARALLELNESS			1/100			Date	8/5/14	
ANGLE TOLERANCE			1/100			Scale	1:1	
SURFACE TOLERANCE			0.2/100			Size	1/16"	
ROUNDNESS			UNDER 30					
SURFACE FINISH NOT TO EXCEED						Drawn By	Checked By	Approved
UNLESS OTHERWISE SPECIFIED						TZ		

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GWF0600	FW M6	2
2	GSSC622	M6X1, L22 SHCS	2
3	GSSCL19	10-32 X 3/4 SHCS	2

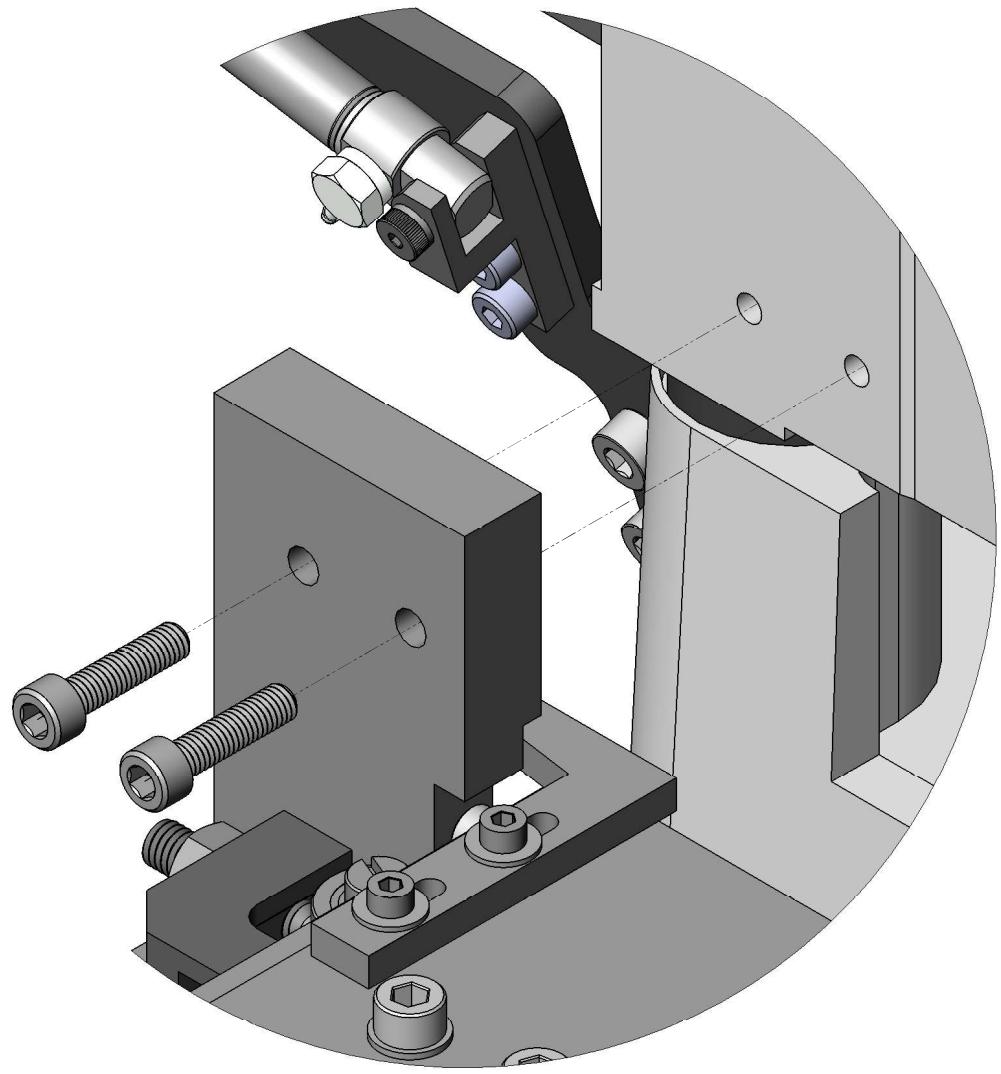
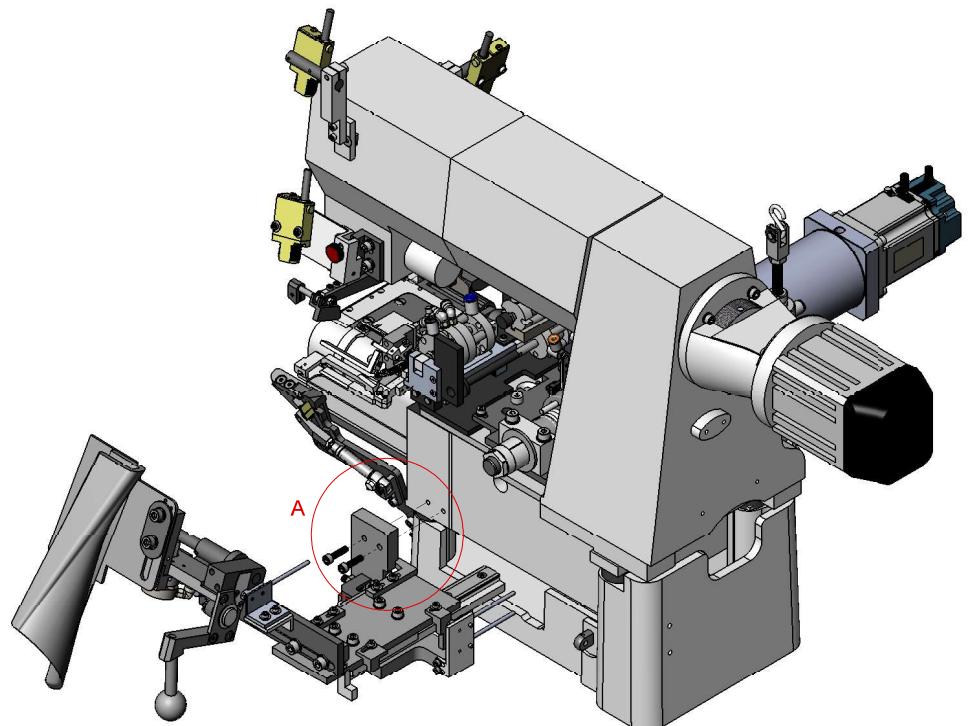


BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5~6	±0.2	±0.2	±0.4	Hardness			Hard,Dpth,	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.			Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material			Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5				Part No.	G013485
1000 ~	±1.2	±1.8	-				Assy No.	G013485
PARALLELNESS				1/100			Date	12/3/14
ANGLE TOLERANCE				1/100			Scale :	1:1.2 Size : "C"
SURFACE TOLERANCE				0.2/100				
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	63	UNLESS OTHERWISE SPECIFIED			TZ			

DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

STEP 10: ADD G013485

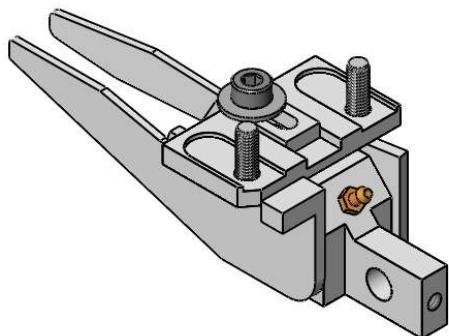
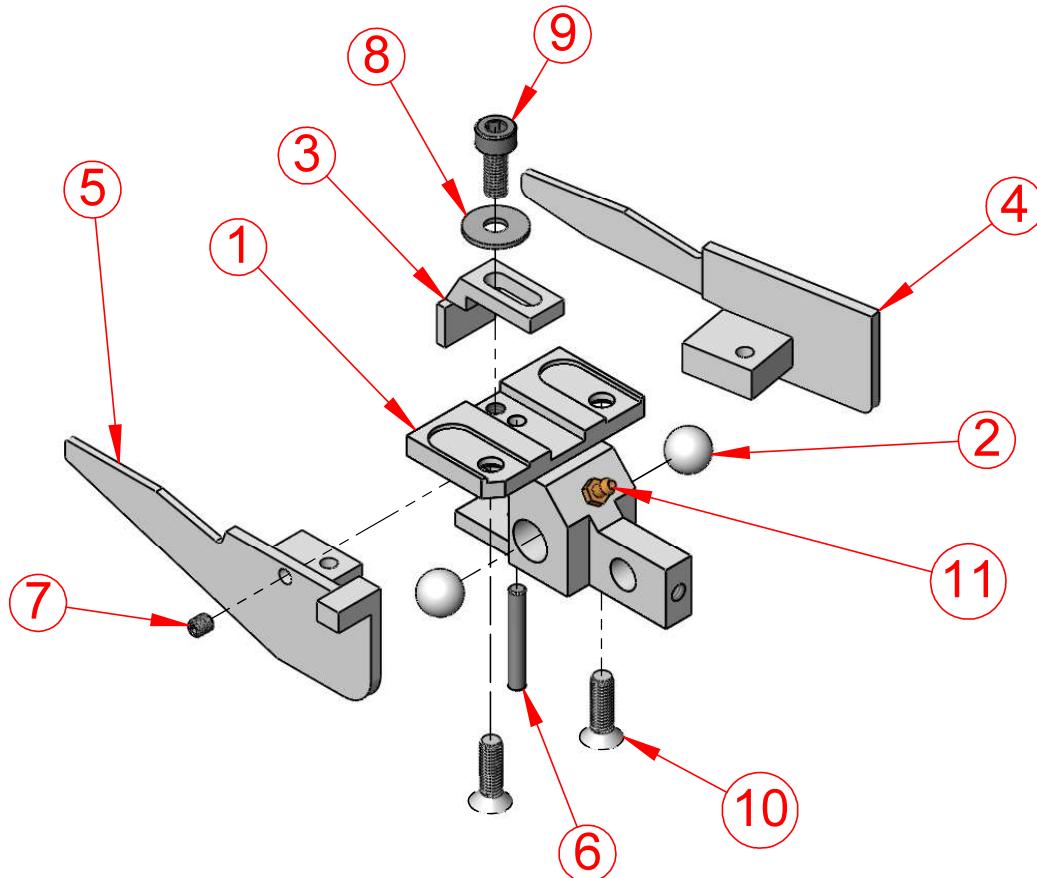


DETAIL A  
SCALE 3.5 : 1

GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Hard.Dpth.	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness				
6~30	±0.2	±0.25	±0.5	Heat Trmt.			Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	3022.001B
120~315	±0.5	±0.6	±1.0	Material			Customer	CARIBARIT
315~1000	±0.8	±1.1	±1.5				Part No.	G013919
1000 ~	±1.2	±1.8	-				Assy No.	G013919
GTN 1828							Date	9/22/15
Scale : 1:2 Size : 1" D"							Drawn By	Checked By
Approved								
REV.:								
REVISIONS								

A

DATE	REV.	DESCRIPTION	INFO



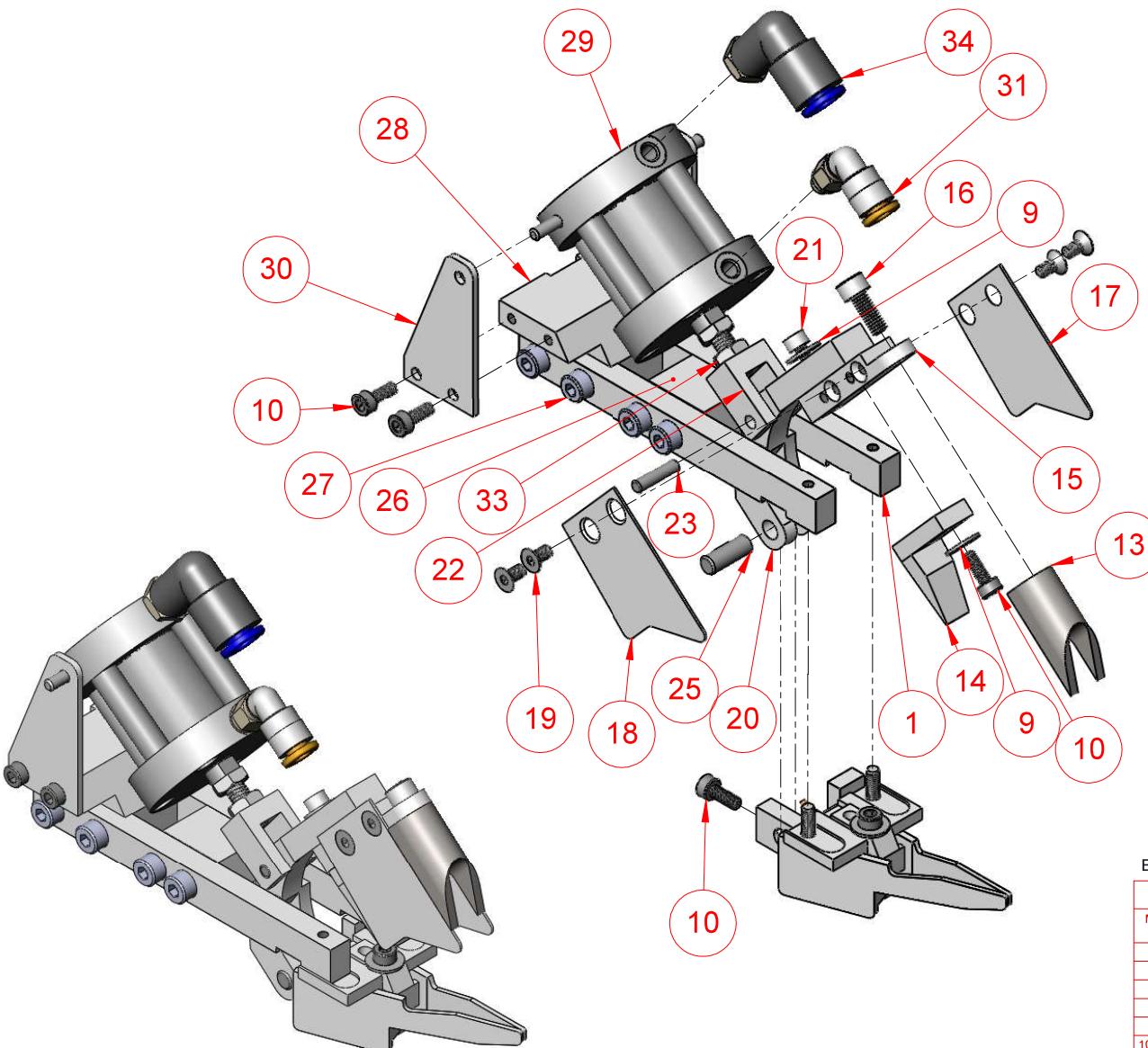
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012429	FRAME SPREADER (33E)	1
2	G013438	1/4" SS BALL (33F)	2
3	G012428	SPDR CENTER (33G)	1
4	G012426	TOP BLADE (33H)	1
5	G012427	BOTTOM BLADE (34A)	1
6	98381A440	DOWEL 3/32 X 5/8 (56E)	1
7	GSSA04	M2.5 X 4 SET SCREW	1
8	GWF0300	FLAT WASHER, M3	1
9	GSSC308	M3 X 8 SHCS	1
10	GSSF310	FHCS M3 x 10	2
11	G013963	MINI AIR FITTING (12E)	1

#### BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5~6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.			Model No.	
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	
120~315	±0.5	±0.6	±1.0	Material			Customer	
315~1000	±0.8	±1.1	±1.5				Part No.	G012425
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name			Ass'y No.	
PARALLELNESS							Date	
ANGLE TOLERANCE							Scale :	1:1
SURFACE TOLERANCE				0.2/100			Size :	"A"
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	63	UNLESS OTHERWISE SPECIFIED						
		Drawn By	Checked By	Approved				

GTN, INC.  
1



DATE	REV.	DESCRIPTION	INIT
REVISIONS			

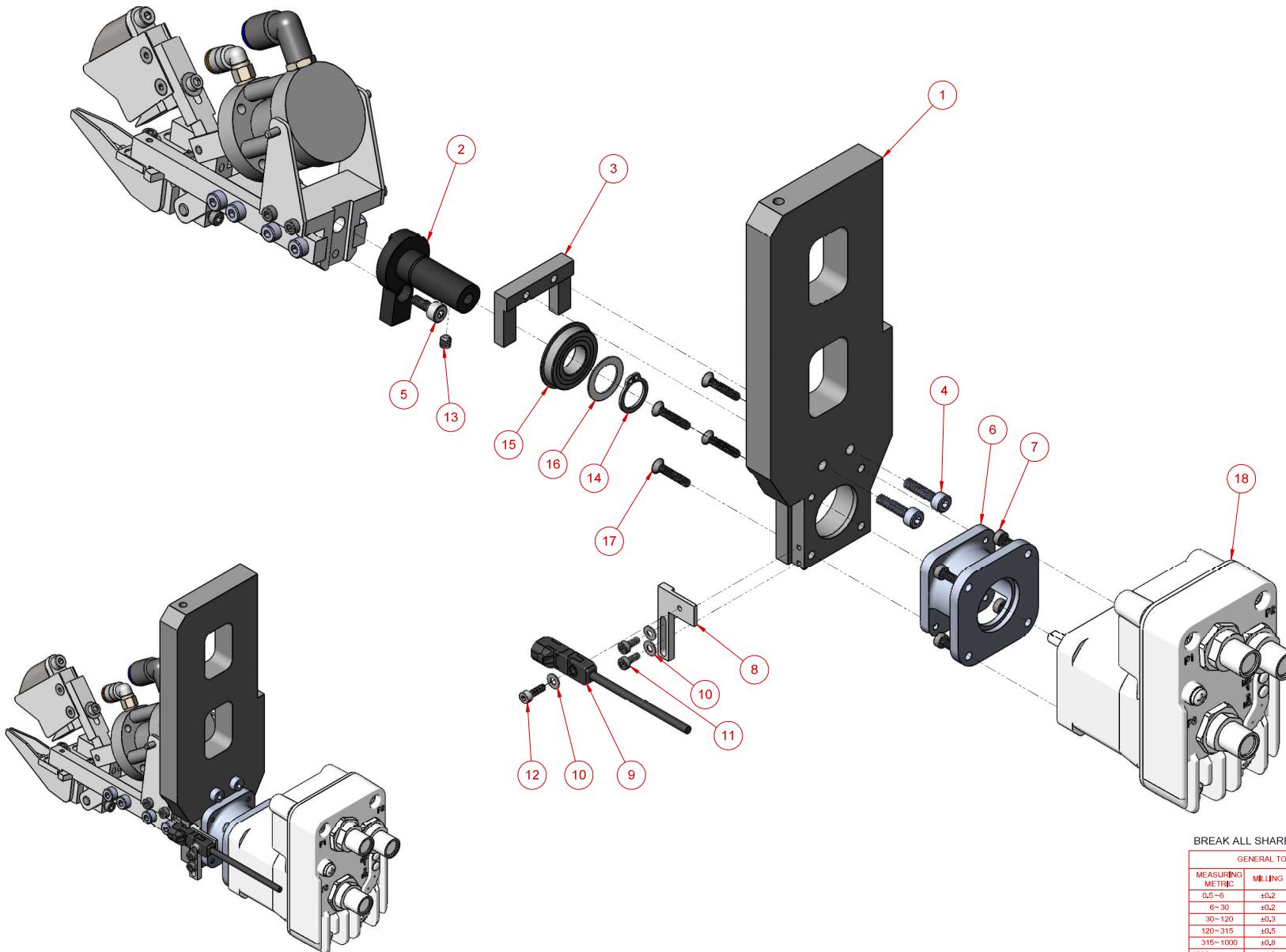
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012434	STRAP (33D)	2
2	G012429	FRAME SPREADER (33E)	1
3	G013438	1/4" SS BALL (33F)	2
4	G012428	SPDR CENTER (33G)	1
5	G012426	TOP BLADE (33H)	1
6	G012427	BOTTOM BLADE (34A)	1
7	98381A440	DOWEL 3/32 X 5/8 (56E)	1
8	GSSSA04	M2.5 X 4 SET SCREW	1
9	GWF0300	FLAT WASHER, M3	3
10	GSSC308	M3 X 8 SHCS	7
11	GSSF310	FHCS M3 x 10	2
12	G013963	MINI AIR FITTING (12E)	1
13	G013441	BULLET (34B)	1
14	G012420	EAR WIPER (34C)	1
15	G012421	BLOCK (34D)	1
16	GSSC410	SHCS M4 x 10	1
17	G012417	BOTTOM FOLD BLADE (34E)	1
18	G012418	TOP FOLD BLADE (34F)	1
19	91294A126	FLAT HEAD M3, L6	4
20	G012416	FOLD ARM (34G)	1
21	GSSC312	M3 X 12 SHCS	1
22	G012415	CLEVIS (34H)	1
23	98381A471	MOD DOWEL (41A)	1
24	GSSS306	SCREW, M3 X 6 SET	1
25	98381A505	MOD DOWEL, 3/16 X 1/2 (41B)	1
26	G012412	STOP (41C)	1
27	GSSC412	M4 X 12 SHCS	8
28	G012411	BRACKET (36G)	1
29	G013436	1 AIR CYL (W11-6BB)	1
30	G012410	CYL MOUNT (41D)	2
31	JW000001	ELBOW FITTING (D2C6)	1
32	GSSL25	SET SCREW, 10-32 X 1"	1
33	GN00L00	10-32 NUT	2
34	G014021	FITTING 10-32 TO 6mm (12C)	1

#### BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	
120~315	±0.5	±0.6	±1.0	Material		Customer	
315~1000	±0.8	±1.1	±1.5			Part No.	G014124EX
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name	SPREADER ASM	Ass'y No.	
PARALLELNESS		1/100				Date	
ANGLE TOLERANCE		1/100				Scale :	1:1
SURFACE TOLERANCE	0.2/100			Drawn By	Checked By	Approved	Size : B
ROUNDNESS	UNDER 30% TOLERANCE						
SURFACE FINISH	NOT TO EXCEED  UNLESS OTHERWISE SPECIFIED						

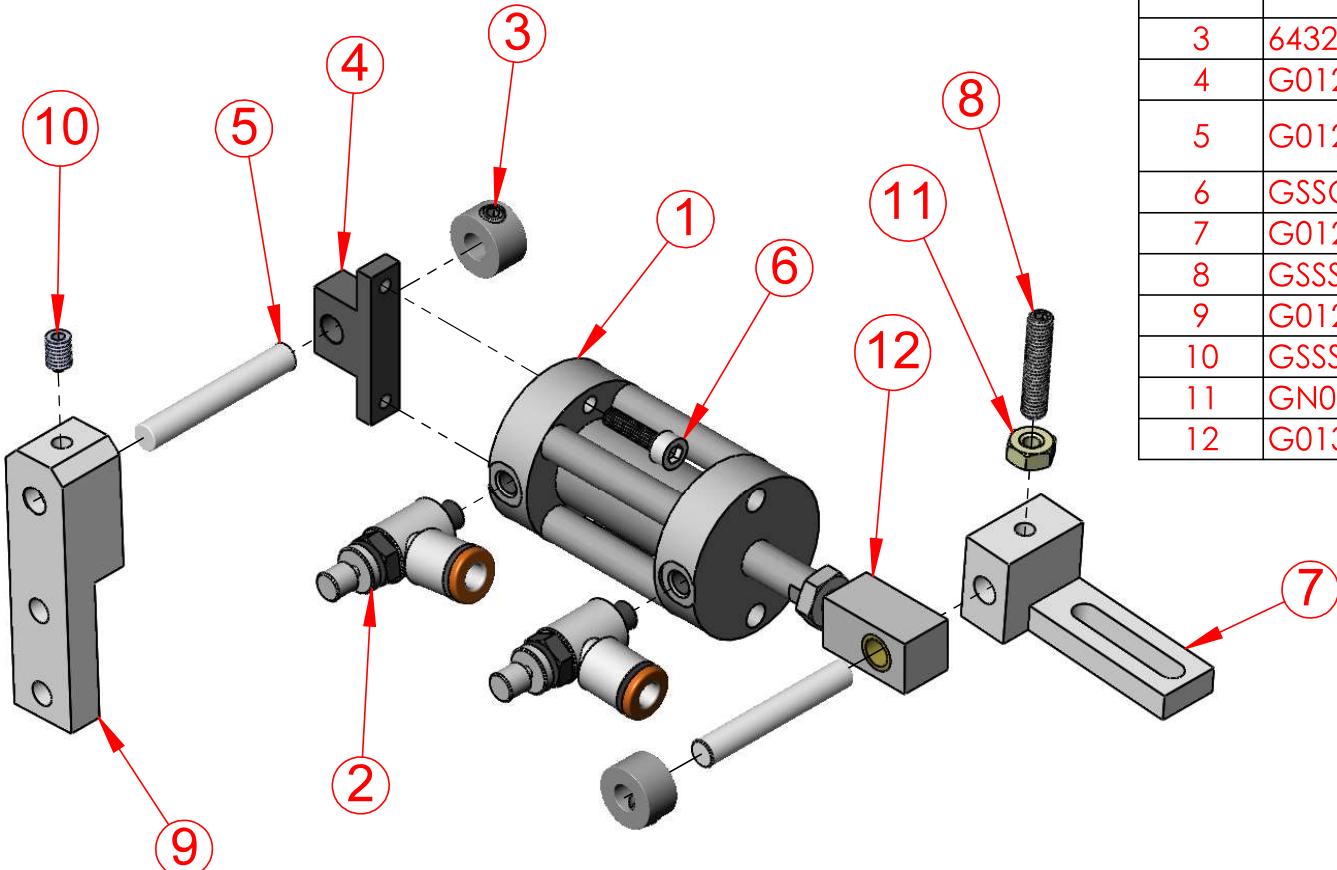
 GTN, INC.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G014117	FRAME ROTATE	1
2	G014123	DRIVE SHAFT (33C)	1
3	G013450	STOP	1
4	GSSC416	M4 X 16 SHCS	2
5	GSSC410	SHCS M4 X 10	1
6	G014126	MOTOR MOUNT (37A)	1
7	GSSC308	SHCS M3 X 8	4
8	G013451	SENSOR MOUNT	1
9	GX-HB	SENSOR (W11-3F)	1
10	GWFOA00	M2.5 FW	3
11	GSSCA06	M2.5 X 6 SHCS	2
12	GSSCA08	M2.5 X 8 SHCS	1
13	GSS404	M4 X 4 FLAT SET SCREW	1
14	98541A119	RETAINING RING (41G)	1
15	G014132	BEARING (41H)	1
16	G014133	SHIM WSHR (42A)	1
17	GSSF316	M3 X 16 FHCS	4
18	G014169	MOTOR	1

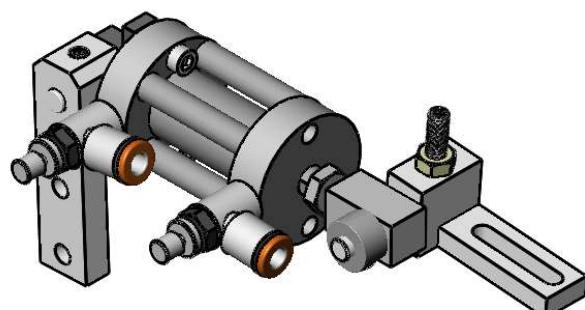


GENERAL TOLERANCE						Tracking No.:	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard Dpth.	
6~30	±0.2	±0.25	±0.5	Heat Trmt.		Model No.	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	
120~315	±0.5	±0.6	±1.0	Material		Customer	
315~1000	±0.8	±1.1	±1.5			Part No.	G014118EX
1000 ~	±1.2	±1.8	-			Assy No.	
PARALLELNESS			1/100			Date	
ANGLE TOLERANCE			1/100			Scale	1:1
SURFACE TOLERANCE			0.2/100			Size	" D"
ROUNDNESS			UNDER 30% TOLERANCE				
SURFACE FINISH NOT TO EXCEED	83		UNLESS OTHERWISE SPECIFIED				

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	



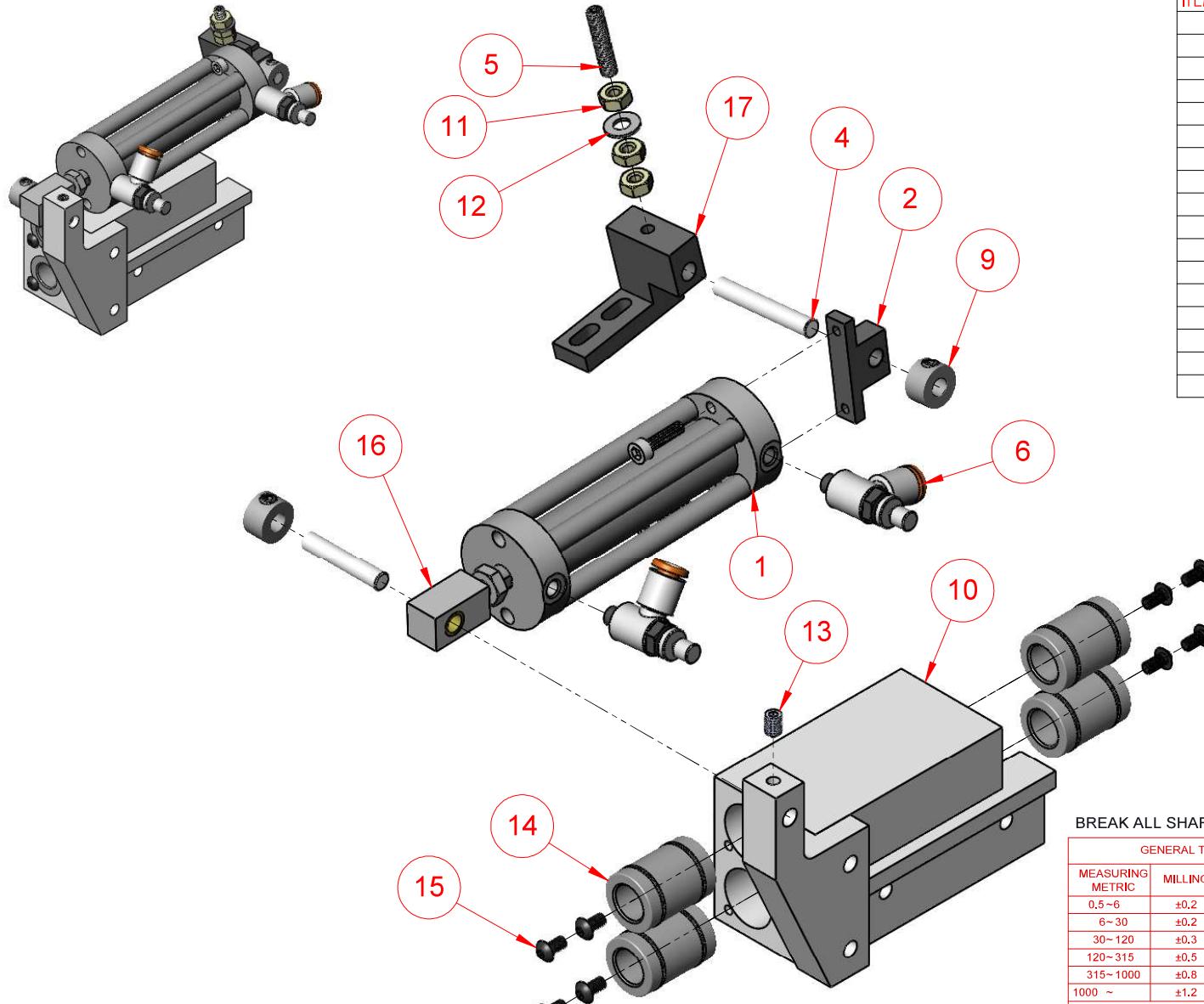
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013430	1 1/4 AIR CYL (36C)	1
2	JW000014	FITTING FLO CON (D2C7)	2
3	6432K19	3/16 COLLAR (32F)	2
4	G012353	CYL BRKT (32E)	1
5	G012354	DOWEL 3/16 X 1 1/4 (56A)	2
6	GSSC312	M3 X 12 SHCS	2
7	G012369	CYL MOUNT (32H)	1
8	GSSS420	M4 X 20 SET SCREW	1
9	G012370	SPDR PIVOT (33A)	1
10	GSSS406	SCREW, M4X6 SET	1
11	GN00400	M4 NUT	1
12	G013428	CLEVIS (13D)	1



DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0.5~6	±0.2	±0.2	±0.4	Hardness			Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.			Model No.	
30~120	±0.3	±0.45	±0.7	Finish			Machine No.	
120~315	±0.5	±0.6	±1.0	Material			Customer	
315~1000	±0.8	±1.1	±1.5				Part No.	G013431
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name			Ass'y No.	
PARALLELNESS				Date			Date	
ANGLE TOLERANCE				Scale : 1:1			Size : "A"	
SURFACE TOLERANCE				Drawn By	Checked By	Approved		
ROUNDNESS	UNDER 30% TOLERANCE							
SURFACE FINISH NOT TO EXCEED	63	UNLESS OTHERWISE SPECIFIED						



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013426	2 5/8 AIR CYL (W11-5F)	1
2	G012353	CYL BRKT (32E)	1
3	GSSC312	M3 X 12 SHCS	2
4	G012354	DOWEL 3/16 X 1 1/4 (56A)	1
5	GSSS420	M4 X 20 SET SCREW	1
6	JW000014	FITTING FLO CON (D2C7)	2
7	G013429	FRONT PIVOT (36A)	1
8	G012349	DOWEL 3/16 X 1 (56C)	1
9	6432K19	3/16 COLLAR (32F)	2
10	G013400	GRIPPER SLIDE (W11-5FB)	1
11	GN00400	M4 NUT	3
12	GWF0400	FLAT WASHER M4	1
13	GSSS406	SCREW, M4X6 SET	1
14	G013422	LINEAR BUSHING (W11-5G)	4
15	GSSB306	SCREW, M3X6 HEX BTN HD	8
16	G013428	CLEVIS (13D)	1
17	G013518	GRIP REAR PIVOT (32G)	1

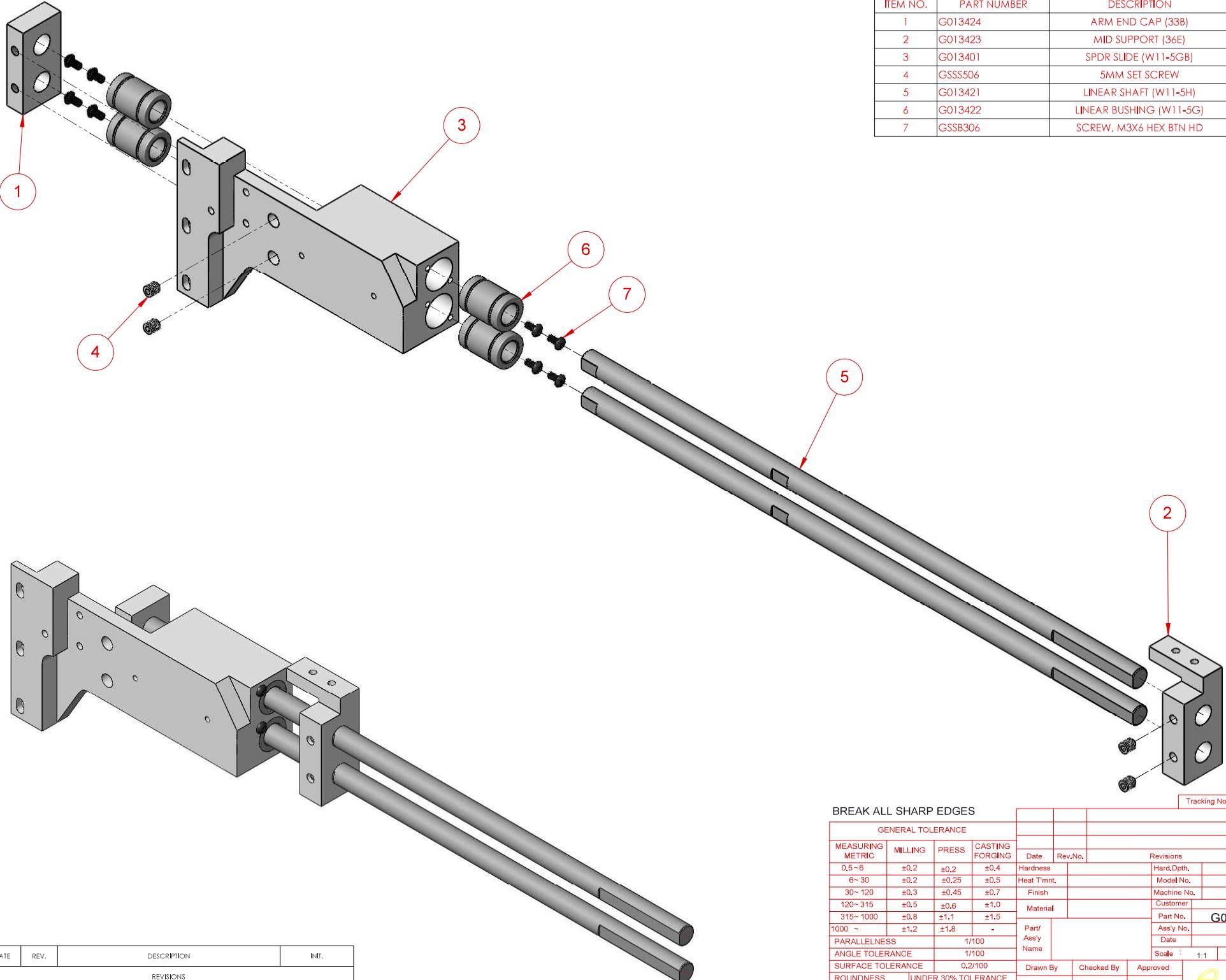
BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions	Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING				
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	
120~315	±0.5	±0.6	±1.0	Material		Customer	
315~1000	±0.8	±1.1	±1.5			Part No.	G013403
1000 ~	±1.2	±1.8	-	Part/ Ass'y Name	NEW SUB ASM. 2 5/8" STROKE AC W/ SLIDE	Ass'y No.	
PARALLELNESS		1/100				Date	
ANGLE TOLERANCE		1/100				Scale :	1:1
SURFACE TOLERANCE	0.2/100					Size :	B
ROUNDNESS	UNDER 30% TOLERANCE			Drawn By	Checked By	Approved	
SURFACE FINISH NOT TO EXCEED $63 \mu\text{m}$ UNLESS OTHERWISE SPECIFIED							

DATE	REV.	DESCRIPTION	INIT
REVISIONS			

GTN, INC.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013424	ARM END CAP (33B)	1
2	G013423	MID SUPPORT (36E)	1
3	G013401	SPDR SLIDE (W11-5GB)	1
4	GSSS506	5MM SET SCREW	4
5	G013421	LINEAR SHAFT (W11-5H)	2
6	G013422	LINEAR BUSHING (W11-5G)	4
7	GSSB306	SCREW, M3X6 HEX BTN HD	8

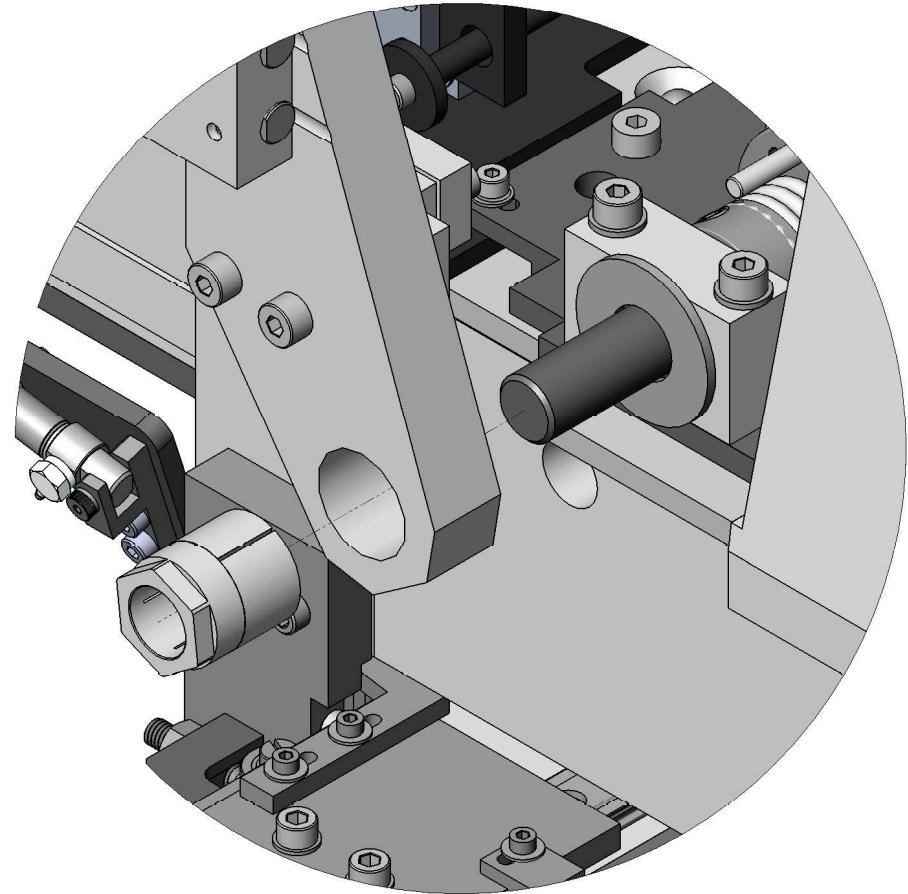
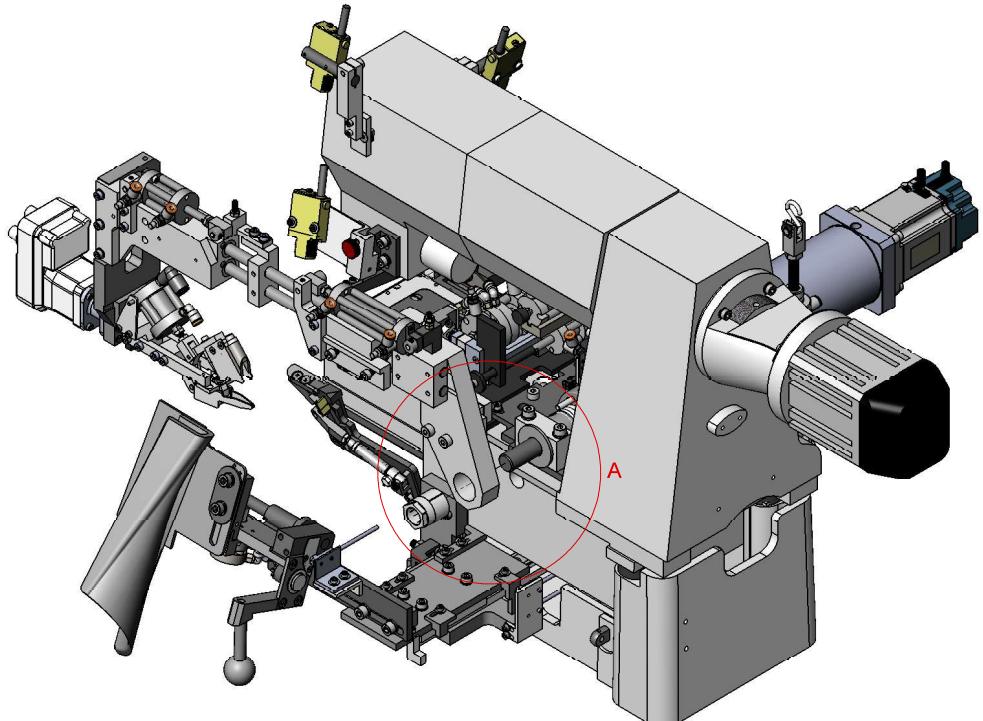


BREAK ALL SHARP EDGES

GENERAL TOLERANCE				Date	Rev.No.	Revisions		Init.
MEASURING METRIC	MILLING	PRESS	CASTING FORGING					
0,5~6	±0,2	±0,2	±0,4	Hardness			Hard,Dpth,	
6~30	±0,2	±0,25	±0,5	Heat T'mnt.			Model No.	
30~120	±0,3	±0,45	±0,7	Finish			Machine No.	
120~315	±0,5	±0,6	±1,0	Material			Customer	
315~1000	±0,8	±1,1	±1,5				Part No.	
1000 ~	±1,2	±1,8	-				Assy No.	
PARALLELNESS				1/100			Date	
ANGLE TOLERANCE				1/100			Scale :	1:1 Size : "C"
SURFACE TOLERANCE				0,2/100			Drawn By	Checked By Approved
ROUNDNESS				UNDER 30% TOLERANCE				
SURFACE FINISH NOT TO EXCEED				63 ✓ UNLESS OTHERWISE SPECIFIED				

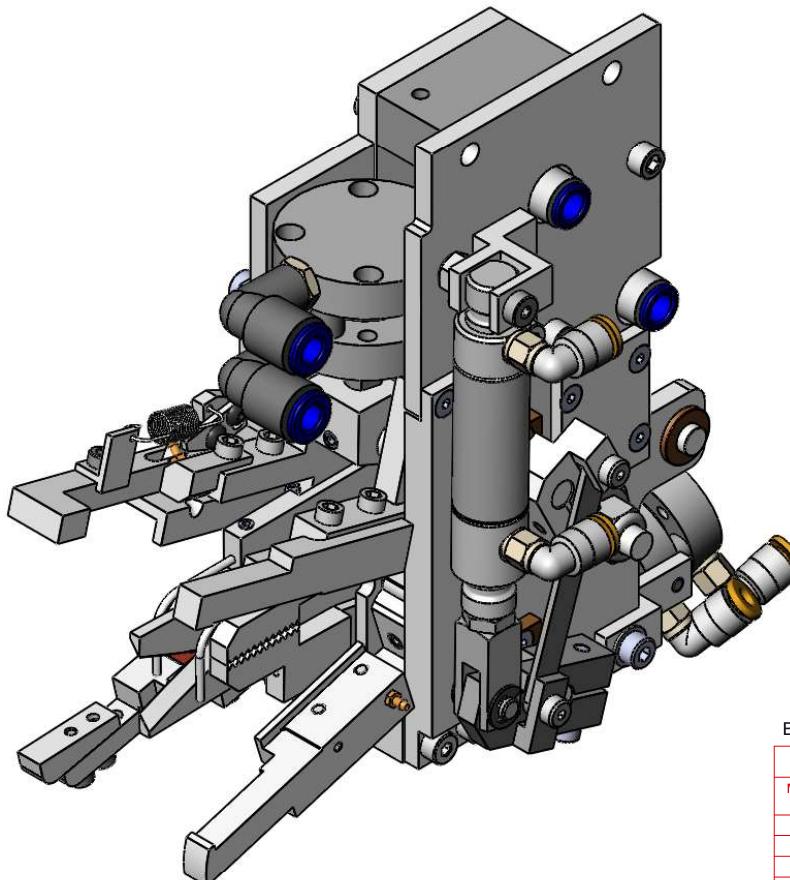
DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

## STEP 11: ADD G014151



GENERAL TOLERANCE						Tracking No.	V00544	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions		Init.
0.5-6	<u>±0.2</u>	<u>±0.2</u>	<u>±0.4</u>	Hardness		Hard/Dph.		
6-30	<u>±0.2</u>	<u>±0.25</u>	<u>±0.5</u>	Heat Tmt.		Model No.	GTN1828	
30-120	<u>±0.3</u>	<u>±0.45</u>	<u>±0.7</u>	Finish		Machine No.	302U201B	
120-315	<u>±0.5</u>	<u>±0.6</u>	<u>±1.0</u>	Material		Customer	CARTHART	
315-1000	<u>±0.8</u>	<u>±1.1</u>	<u>±1.5</u>			Part No.	G013919	
1000 ~	<u>±1.2</u>	<u>±1.8</u>	-			Asy's No.	G013919	
PARALLELNESS				1/100		Date	9/22/15	
ANGLE TOLERANCE				1/100		Scale	1.2	Size "D"
SURFACE TOLERANCE	0.2/100			Drawn By	Checked By	Approved		
ROUNDNESS	UNDER 30% TOLERANCE			TZ				
SHAFT LENGTH	NOT TO EXCEED			UNLESS OTHERWISE SPECIFIED				

ANIMATION OF ASSEMBLY: [https://www.youtube.com/watch?v=XxL\\_UQ\\_UFU8&feature=youtu.be](https://www.youtube.com/watch?v=XxL_UQ_UFU8&feature=youtu.be)



DATE	REV.	DESCRIPTION	INIT
REVISIONS			

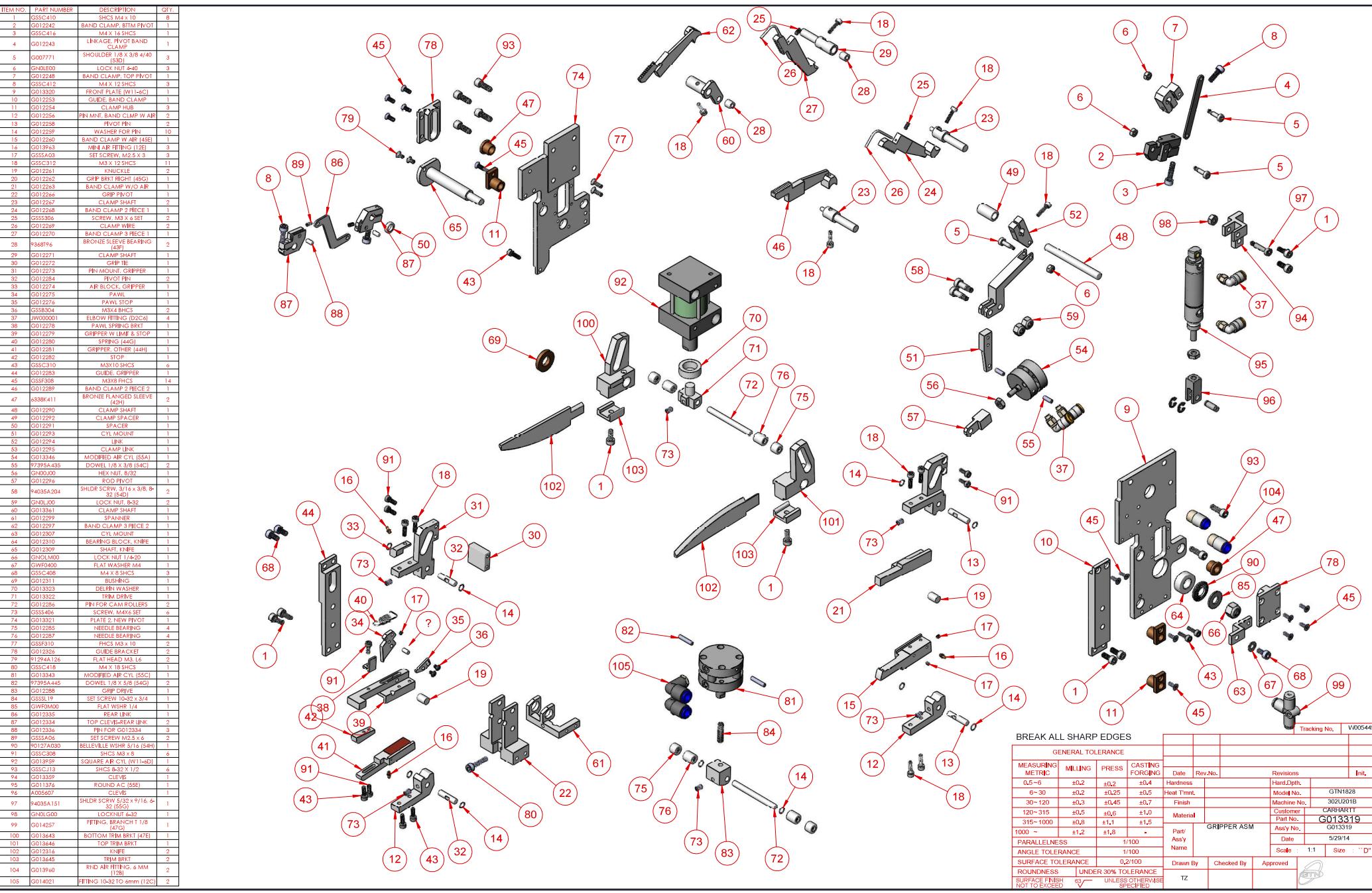
BREAK ALL SHARP EDGES

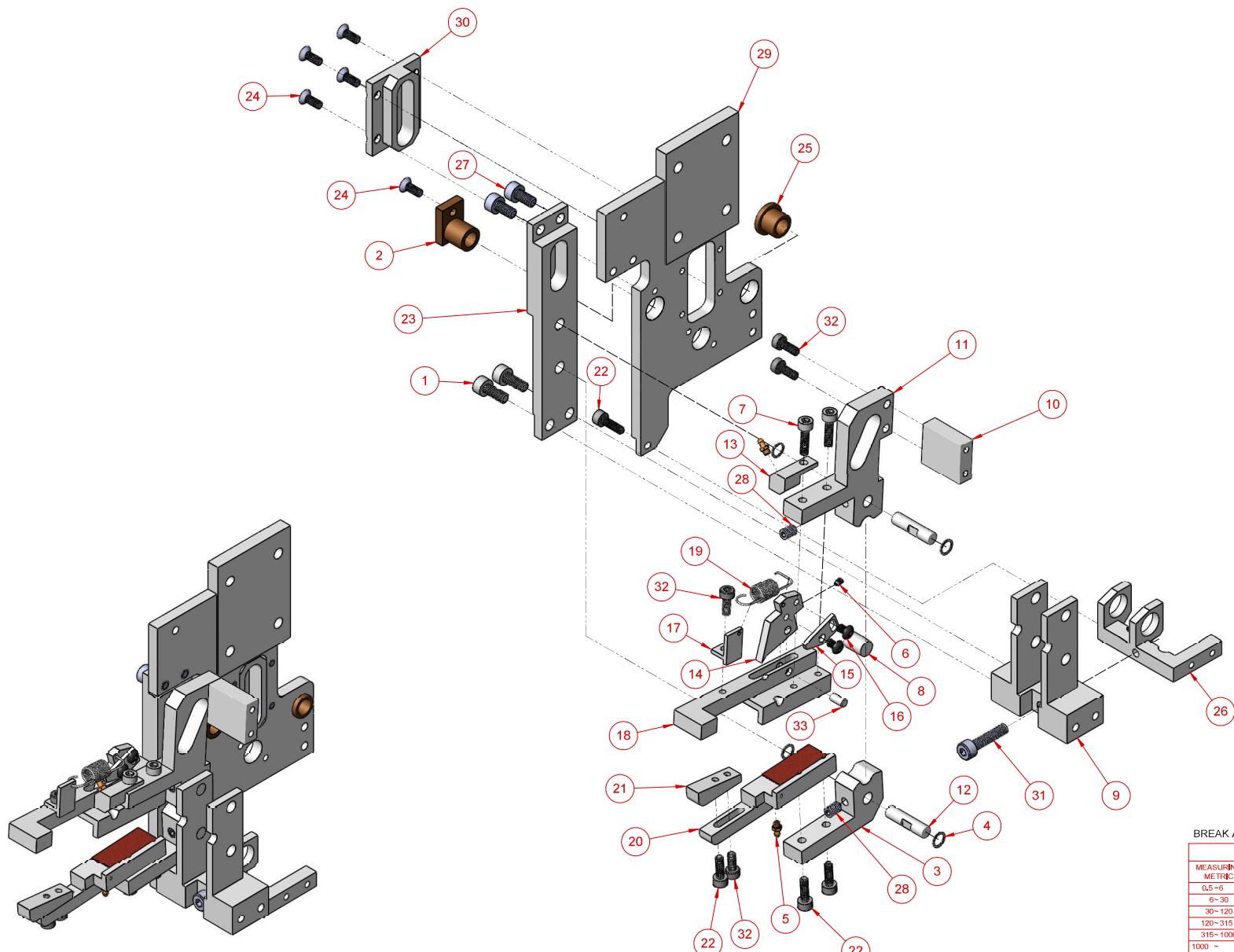
GENERAL TOLERANCE

MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard.Dpth.	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.		Model No.	GTN1828
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302U201B
120~315	±0.5	±0.6	±1.0	Material		Customer	CARHARTT
315~1000	±0.8	±1.1	±1.5			Part No.	G013319
1000 ~	±1.2	±1.8	-			Ass'y No.	G013319
PARALLELNESS			1/100			Date	5/29/14
ANGLE TOLERANCE			1/100			Scale :	1:1
SURFACE TOLERANCE			0.2/100			Size :	B
ROUNDNESS			UNDER 30% TOLERANCE				
SURFACE FINISH NOT TO EXCEED	63		UNLESS OTHERWISE SPECIFIED	TZ			

Tracking No. W005445

 GTN, INC.



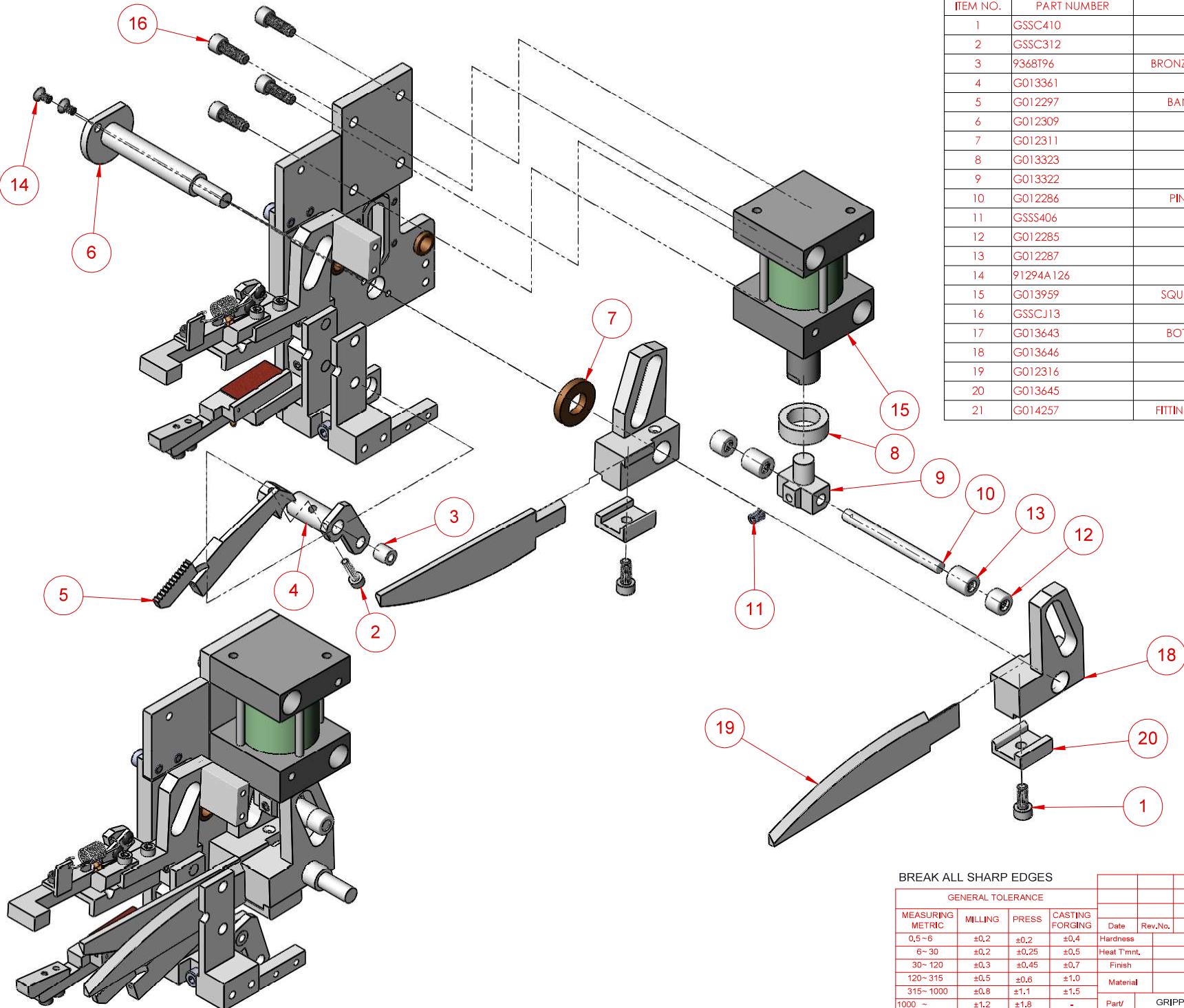


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSSC410	SHCS M4 x 10	2
2	G01254	CLAMP HUB	1
3	G012254	PIN MNT, BAND CLMP W AIR	1
4	G012259	WASHER FOR PIN	4
5	G013963	MINI AIR FITTING (1/2E)	2
6	GSSA03	SET SCREW, M2.5 X 3	1
7	GSSC312	M3 X 12 SHCS	2
8	G012261	KNUCKLE	1
9	G012266	GRIP PIVOT	1
10	G012272	GRIP TIE	1
11	G012273	PIN MOUNT, GRIPPER	1
12	G012284	PIVOT PIN	2
13	G012274	AIR BLOCK, GRIPPER	1
14	G012275	PAWL	1
15	G012276	PAWL STOP	1
16	GSSB304	M3X4 BHCS	2
17	G012278	PAWL SPRING BRKT	1
18	G012279	GRIPPER W LIMIT & STOP	1
19	G012280	SPRING (44G)	1
20	G012281	GRIPPER, OTHER (44H)	1
21	G012282	STOP	1
22	GSSC310	M3X10 SHCS	4
23	G012283	GUIDE, GRIPPER	1
24	GSSF308	M3X8 FHCS	5
25	638K411	BRONZE FLANGED SLEEVE (42H)	1
26	G012299	SPANNER	1
27	GSSC408	M4 X 8 SHCS	2
28	GSSS406	SCREW, M4X6 SET	2
29	G013321	PLATE 2, NEW PIVOT	1
30	G012326	GUIDE BRACKET	1
31	GSSC418	M4 X 18 SHCS	1
32	GSSC308	SHCS M3 x 8	4
33	G012336	DOWEL 1/8 X 1/4 (54A)	1
34	G014257	FITTING, BRANCH 1 1/8 (47G)	1

GENERAL TOLERANCE		Date		Rev.No.		Revisions	
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Hard Dpth,	Init.
0.5~6	±0.2	±0.2	±0.4	Heardress			
6~30	±0.2	±0.25	±0.5	Heat Trmt.		Model No.	GTN1928
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302L001B
120~315	±0.5	±0.6	±1.0	Material		Customer No.	CARBARITT
315~1000	±0.8	±1.1	±1.5			Part No.	G013319EX1
1000 ~	±1.2	±1.8	-			Assy No.	G013319
GRIPPER ASM				Date	5/29/14	Scale :	1:1 Size : 1" D"
SURFACE TOLERANCE	0.2/100		Drawn By		Checked By	Approved	
ROUNDNESS	UNDER 30% TOLERANCE		T2				
SURFACE FINISH NOT TO EXCEED		83		UNLESS OTHERWISE SPECIFIED			

GTN, INC.

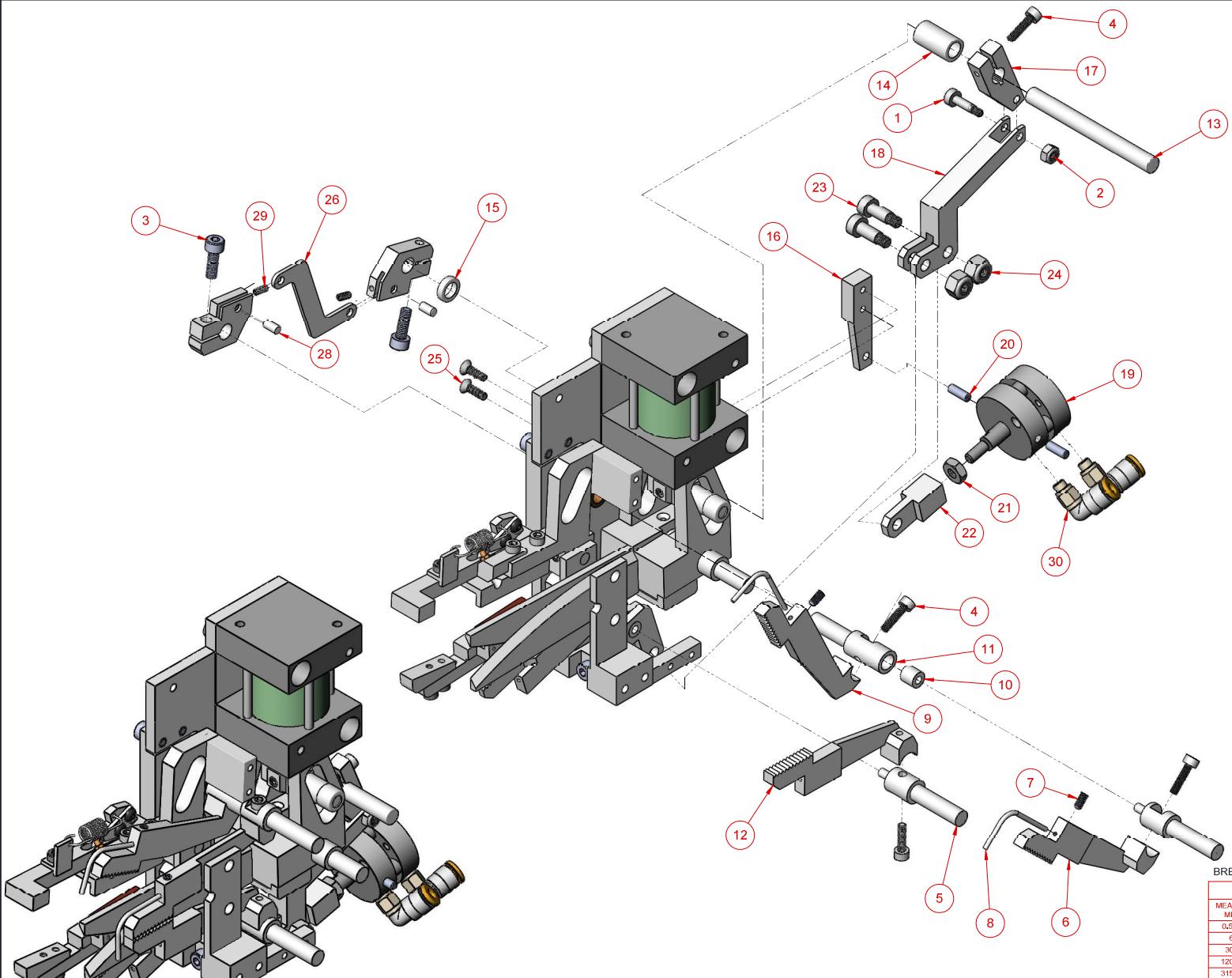
DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GSSC410	SHCS M4 x 10	2
2	GSSC312	M3 X 12 SHCS	1
3	9368196	BRONZE SLEEVE BEARING (43F)	1
4	G013361	CLAMP SHAFT	1
5	G012297	BAND CLAMP 3 PIECE	1
6	G012309	SHAFT, KNIFE	1
7	G012311	BUSHING	1
8	G013323	DELRIN WASHER	1
9	G013322	TRIM DRIVE	1
10	G012286	PIN FOR CAM ROLLERS	1
11	GSSS406	SCREW, M4X6 SET	1
12	G012285	NEEDLE BEARING	2
13	G012287	NEEDLE BEARING	2
14	91294A126	FLAT HEAD M3, L6	2
15	G013959	SQUARE AIR CYL (W11-6D)	1
16	GSSCJ13	SHCS 8-32 X 1/2	4
17	G013643	BOTTOM TRIM BRKT (47E)	1
18	G013646	TOP TRIM BRKT	1
19	G012316	KNIFE	2
20	G013645	TRIM BRKT	2
21	G014257	FITTING, BRANCH T 1/8 (47G)	1

BREAK ALL SHARP EDGES				Tracking No.	W005445
GENERAL TOLERANCE					
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.
0.5~6	±0.2	±0.2	±0.4	Hardness	
6~30	±0.2	±0.25	±0.5	Heat T'mnt.	
30~120	±0.3	±0.45	±0.7	Finish	
120~315	±0.5	±0.6	±1.0	Material	
315~1000	±0.8	±1.1	±1.5		
1000 ~	±1.2	±1.8	-		
PARALLELNESS				1/100	
ANGLE TOLERANCE				1/100	
SURFACE TOLERANCE				0.2/100	
ROUNDNESS	UNDER 30% TOLERANCE				
SURFACE FINISH NOT TO EXCEED	63	UNLESS OTHERWISE SPECIFIED			TZ
Drawn By				Checked By	Approved
GTN, INC.					
Part/ Ass'y Name				GRIPPER ASM	
Assy No.				G013319EX2 G013319	
Date				5/29/14	
Scale :				1:1	Size : "C"

DATE	REV.	DESCRIPTION	INIT.
REVISIONS			

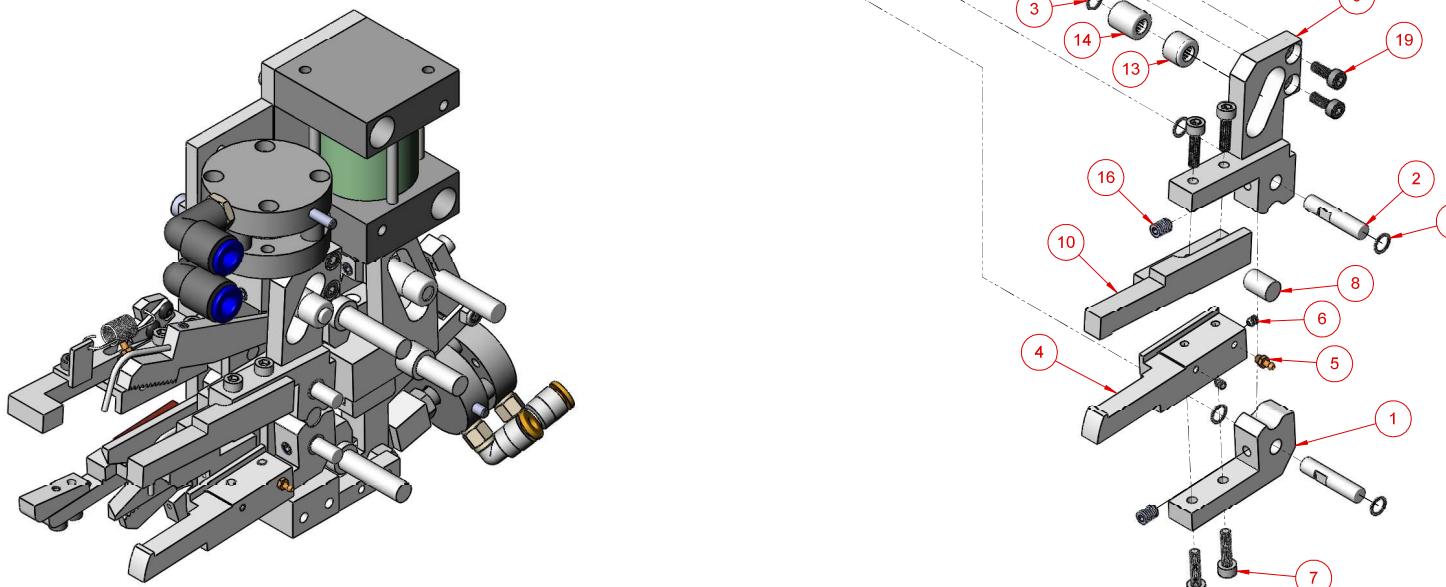
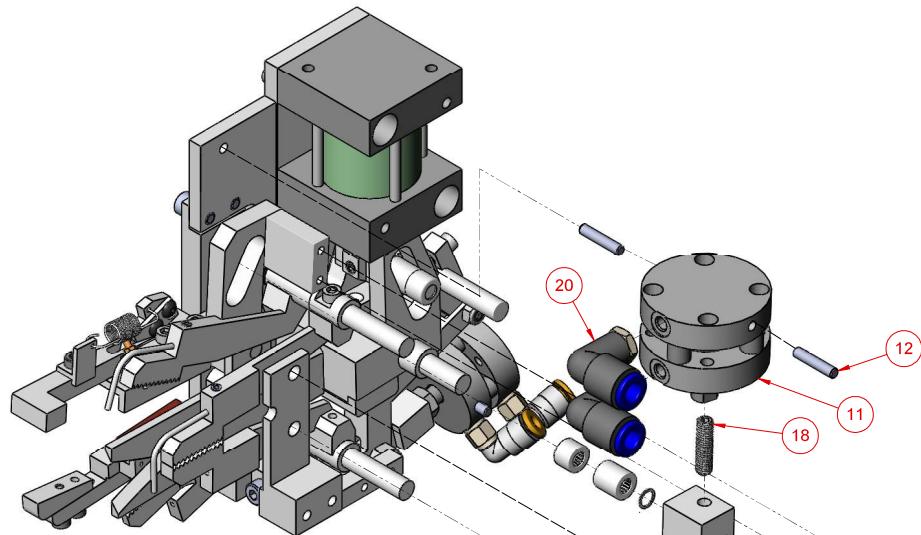


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G00771	SHOULDER 1/8 X 3/8 4/40 (S3D)	1
2	GHN0E00	LOCK NUT 4-40	1
3	GSSC412	M4 X 12 SHCS	2
4	GSSC312	M3 X 12 SHCS	4
5	G012267	CLAMP SHAFT	2
6	G012268	BAND CLAMP 2 PIECE 1	1
7	GSSS306	SCRBW. M3 X 6 SET	2
8	G012269	CLAMP WIRE	2
9	G012270	BAND CLAMP 3 PIECE 1	1
10	9368T%6	BRONZE SLEEVE BEARING (43F)	1
11	G012271	CLAMP SHAFT	1
12	G012289	BAND CLAMP 2 PIECE 2	1
13	G012290	CLAMP SHAFT	1
14	G012292	CLAMP SPACER	1
15	G012291	SPACER	1
16	G012293	CYL MOUNT	1
17	G012294	LINK	1
18	G012295	CLAMP LINK	1
19	G013346	MODIFIED AIR CYL (55A)	1
20	97395A435	DOWEL 1/8 X 3/8 (54C)	2
21	GH00J00	HEX NUT, 8/32	1
22	G012296	ROD PIVOT	1
23	94035A204	SHLDR SCRW. 3/16 x 3/8, 8-32 (54D)	2
24	GHN0J00	LOCK NUT, 8-32	2
25	GSSF310	FHCS M3 x 10	2
26	G012335	REAR LINK	1
27	G012334	TOP CLEVIS-REAR LINK	2
28	G012336	PIN FOR G012334	2
29	GSSA06	SET SCREW M2.5 x 6	2
30	JW000001	ELBOW FITTING (D206)	2

GENERAL TOLERANCE							Tracking No.	V005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions		Init.
0.5~6	±0.2	±0.2	±0.4	Hardness				
6~30	±0.2	±0.25	±0.5	Heat Trmt.				
30~120	±0.3	±0.45	±0.7	Finish				
120~315	±0.5	±0.6	±1.0	Material				
315~1000	±0.8	±1.1	±1.5					
1000 ~	±1.2	±1.8	-					
PARALLELNESS			1/100					
ANGLE TOLERANCE			1/100					
SURFACE TOLERANCE			0.2/100					
ROUNDNESS			UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED							TZ	
UNLESS OTHERWISE SPECIFIED								
REV. A								
DATE : 01/01/2024								
Customer : CARBURIT								
Part No. : G013319EX3								
Assy No. : G013319								
Date : 01/01/2024								
Scale : 1:1								
Size : 1" D"								

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G012256	PIN MNT, BAND CLMP W AIR	1
2	G012258	PIVOT PIN	2
3	G012259	WASHER FOR PIN	6
4	G012260	BAND CLAMP W AIR (45°)	1
5	G013963	MINI AIR FITTING (1/2E)	1
6	GSSSA03	SET SCREW, M2.5 X 3	2
7	GSSC312	M3 X 12 SHCS	4
8	G012261	KNUCKLE	1
9	G012262	GRIP BRKT RIGHT (45G)	1
10	G012263	BAND CLAMP W/O AIR	1
11	G013343	MODIFIED AIR CYL (55C)	1
12	97395A445	DOWEL 1/8 X 5/8 (54G)	2
13	G012285	NEEDLE BEARING	2
14	G012287	NEEDLE BEARING	2
15	G012288	GRIP DRIVE	1
16	GSSS406	SCREW, M4X6 SET	3
17	G012286	PIN FOR CAM ROLLERS	1
18	GSSSL19	SET SCREW 10-32 X 3/4	1
19	GSSC308	SHCS M3 x 8	2
20	G014021	FITTING 10-32 TO 6mm (12C)	2

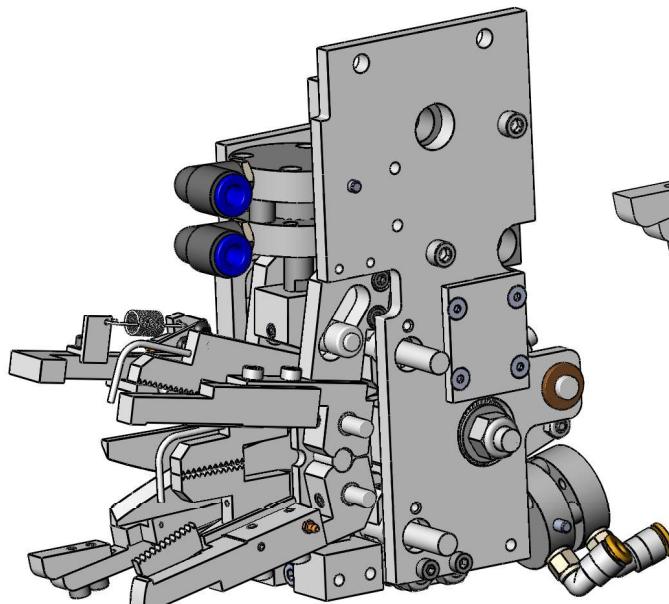
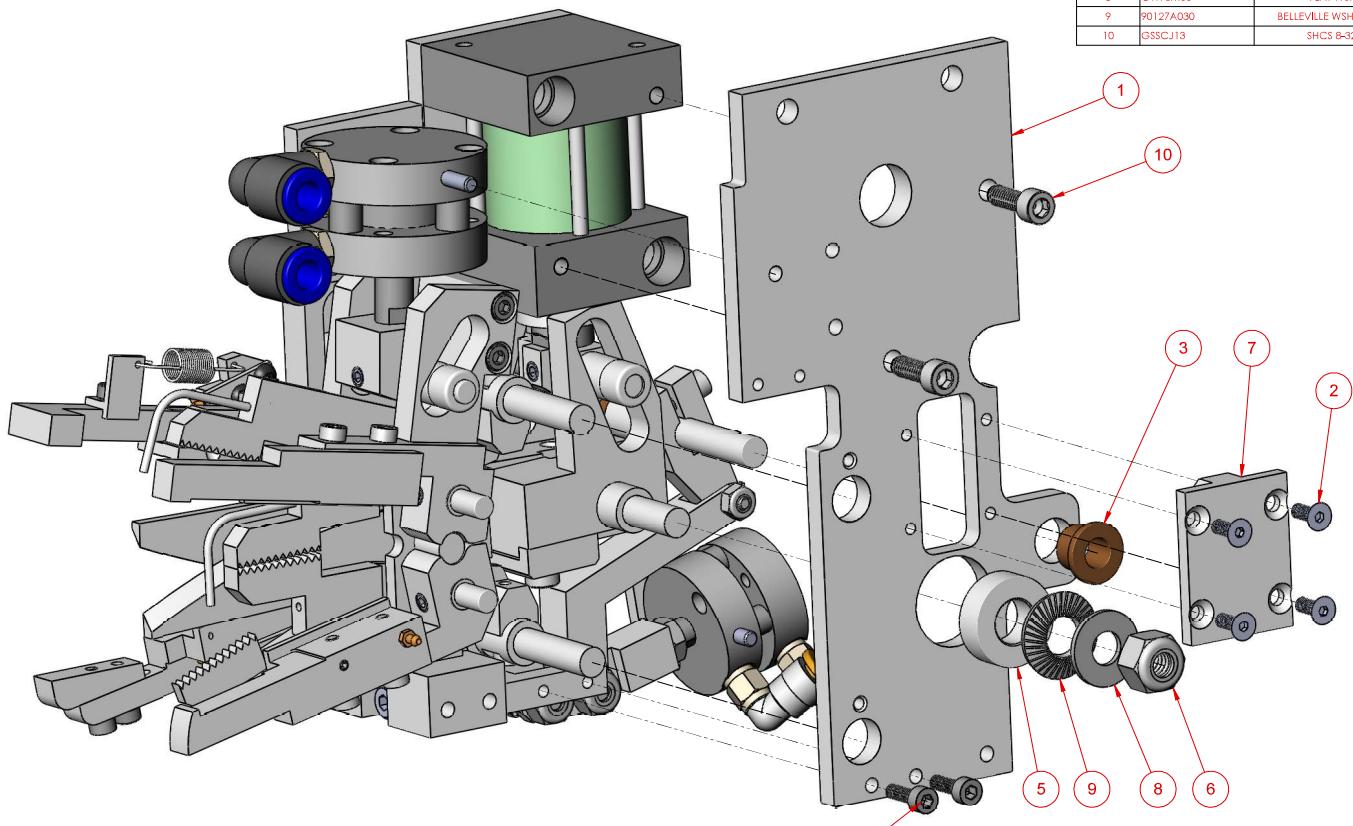


#### BREAK ALL SHARP EDGES

GENERAL TOLERANCE							
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard Dpht,	GTN1928
6~30	±0.2	±0.25	±0.5	Heat Trmt.		Model No.	
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	3021001B
120~315	±0.5	±0.6	±1.0	Material		Customer	CARIBARIT
315~1000	±0.8	±1.1	±1.5			Part No.	G013319EX4
1000 ~	±1.2	±1.8	-			Assy No.	G013319
PARALLELNESS			1/100			Date	5/28/14
ANGLE TOLERANCE			1/100			Scale :	1:1 Size : 1" D"
SURFACE TOLERANCE			0.2/100				
ROUNDNESS			UNDER 30% TOLERANCE			Drawn By	Checked By
SURFACE FINISH	83		NOT TO EXCEED UNLESS OTHERWISE SPECIFIED	TZ		Approved	

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	G013320	FRONT PLATE (W11-4C)	1
2	GSSF308	M3XB FHCS	4
3	6338K411	BRONZE FLANGED SLEEVE [42H]	1
4	GSSC310	M3X10 SHCS	2
5	G012310	BEARING BLOCK, KNIFE	1
6	GNOLM00	LOCK NUT 1/4-20	1
7	G012326	GUIDE BRACKET	1
8	GWFM00	FLAT WASHER 1/4	1
9	P0127A030	BELLEVILLE WASHER 5/16 (54H)	1
10	GSSCJ13	SHCS 8-32 X 1/2	2

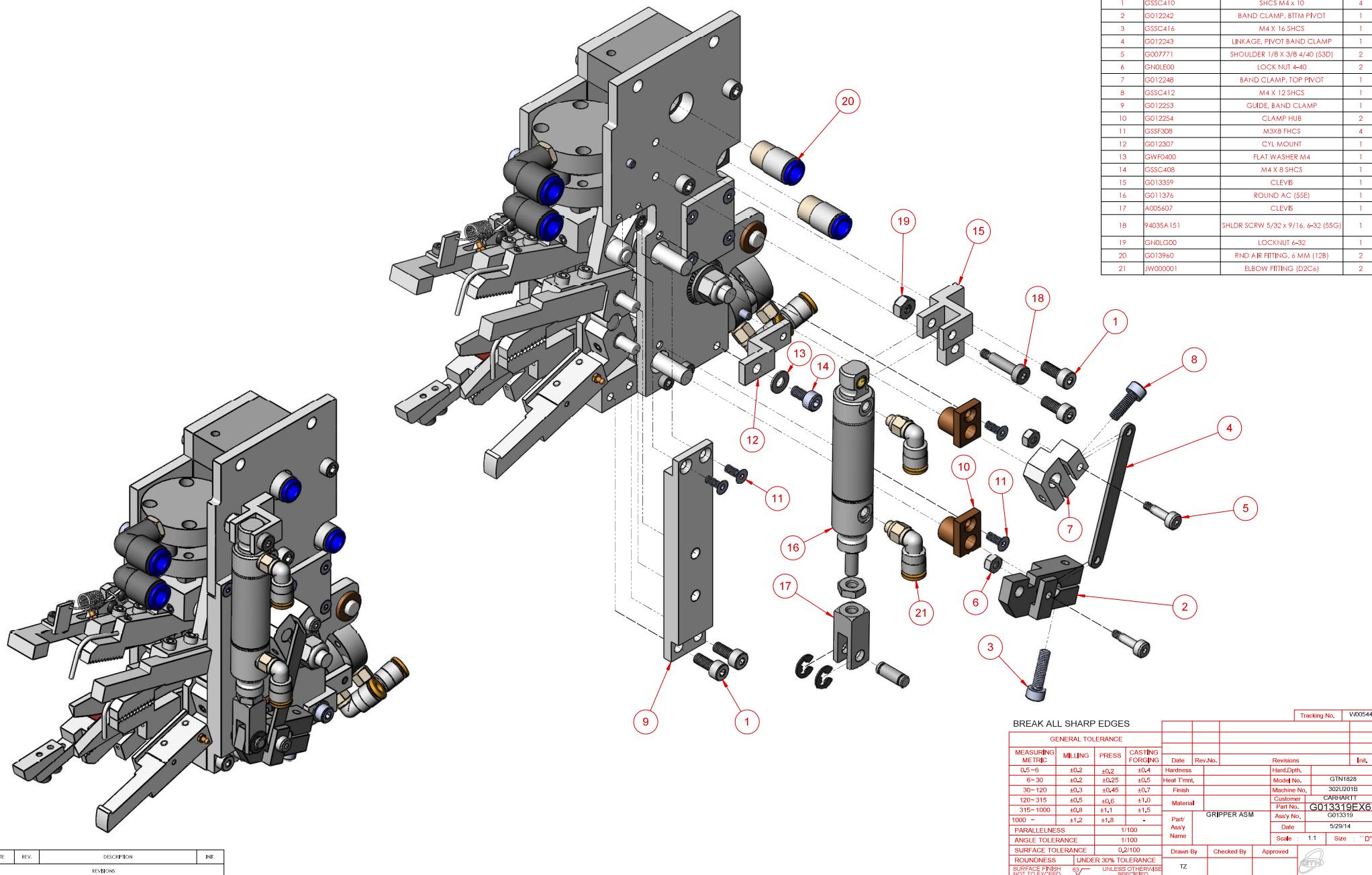


BREAK ALL SHARP EDGES

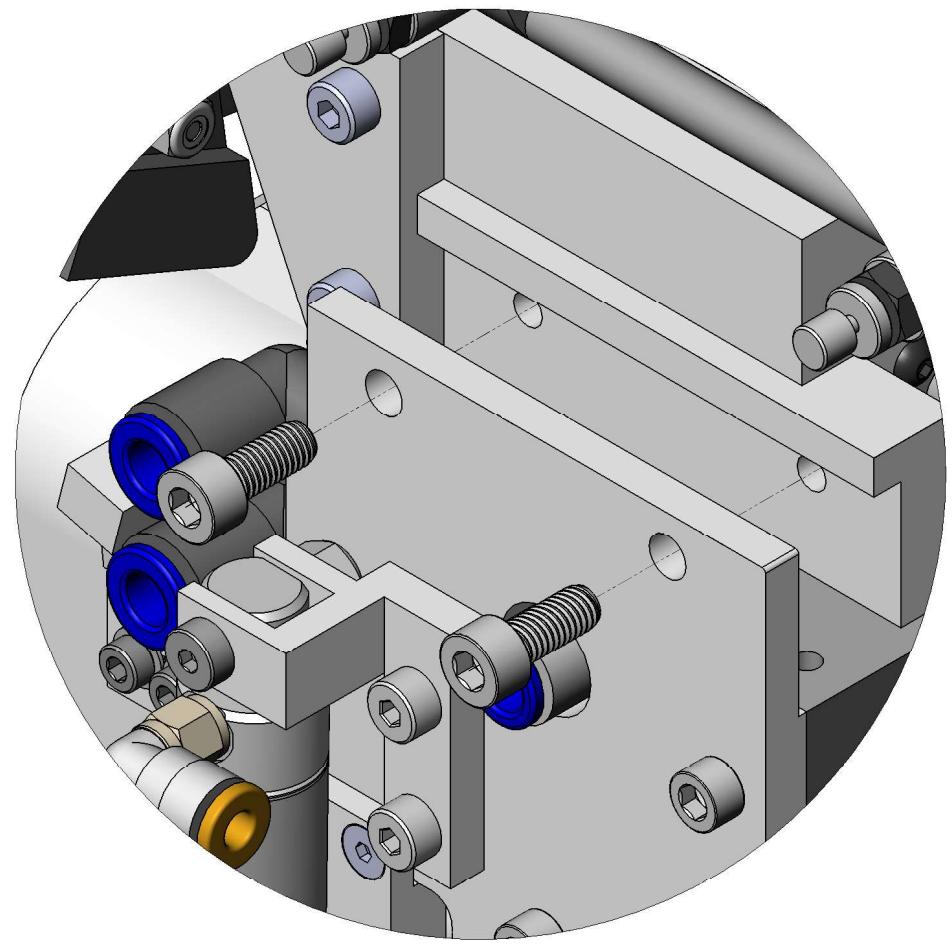
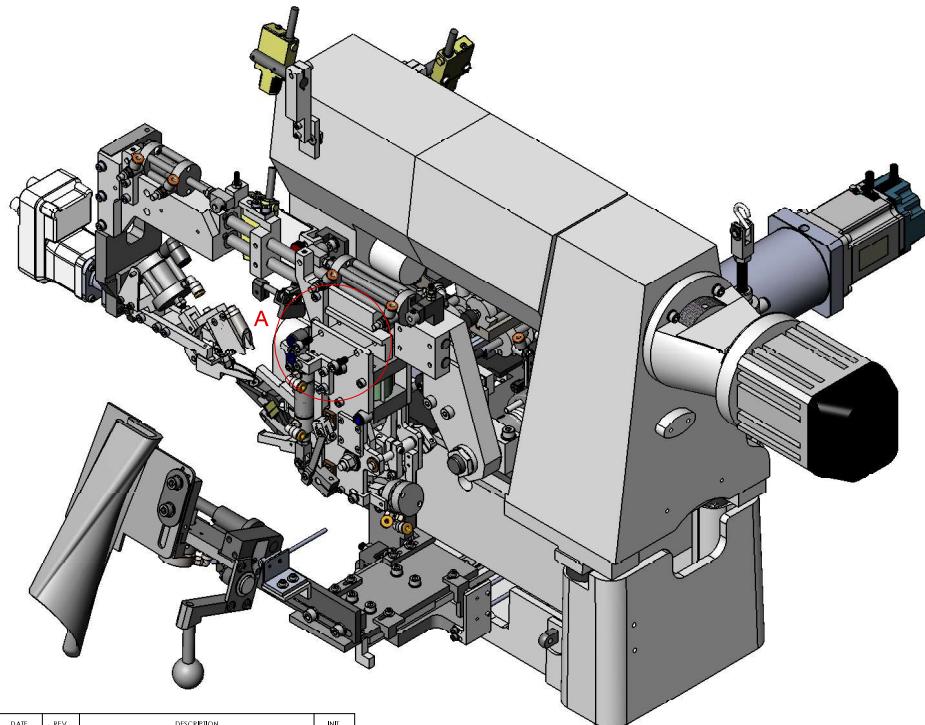
Tracking No. V0005445

GENERAL TOLERANCE						GRIPPER ASM	
MEASURING MEDIUM	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.
0.5~6	±0.2	±0.2	±0.4	Hardness		Hard Dpth.	
6~30	±0.2	±0.25	±0.5	Heat Trmt.		Model No.	GTN1928
30~120	±0.3	±0.45	±0.7	Finish		Machine No.	302L001B
120~315	±0.5	±0.6	±1.0	Material		Customer	CARIBARIT
315~1000	±0.8	±1.1	±1.5	Part No.		Assy No.	G013319EX5
1000 ~	±1.2	±1.8	-	Part/Assy Name		Date	G013319
PARALLELNESS						Scale :	1:2
ANGLE TOLERANCE						Size :	"D"
SURFACE TOLERANCE						Drawn By	Checked By
ROUNDNESS	UNDER 30% TOLERANCE					Approved	
SURFACE FINISH NOT TO EXCEED	UNLESS OTHERWISE SPECIFIED					TZ	

DATE	REV.	DESCRIPTION	IMP.
		REVISIONS	



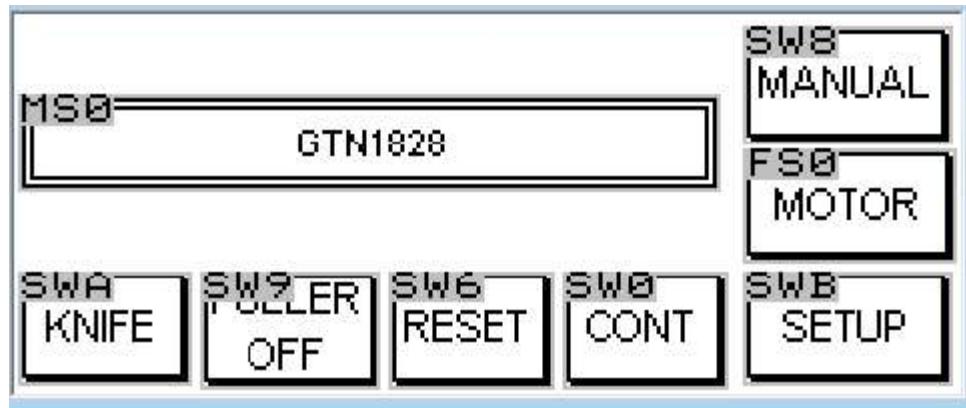
## STEP 12: ADD G013319



GENERAL TOLERANCE							Tracking No.	V0005445
MEASURING METRIC	MILLING	PRESS	CASTING FORGING	Date	Rev.No.	Revisions	Init.	
0.5~6	±0.2	±0.2	±0.4	Hardness				
6~30	±0.2	±0.25	±0.5	Heat Tmt.				
30~120	±0.3	±0.45	±0.7	Finish				
120~315	±0.5	±0.6	±1.0	Material				
315~1000	±0.8	±1.1	±1.5					
1000 ~	±1.2	±1.8	-					
PARALLELNESS			1/100					
ANGLE TOLERANCE			1/100					
SURFACE TOLERANCE			0.2/100					
ROUNDNESS			UNDER 30% TOLERANCE					
SURFACE FINISH NOT TO EXCEED	83		UNLESS OTHERWISE SPECIFIED	TZ				

# TOUCH SCREEN

## MAIN



## MOTOR



**KNIFE:** Manually triggers knife behind the needles

**PULLER OFF:** Manually turn the puller off

**RESET:** Restarts the banding cycle and homes the machine. If the folder is not pulled away from the machine the band cycle will reset but the motors will not home up.

**CONT:** If the operator accidentally allows the tape on the folder to be seen by the sensors during operator sew the foot pedal will become inactive and the machine will stop sewing. Press this button to continue sewing.

**MANUAL:** MANUAL or AUTO is displayed on this button. This sets the cycle mode to automatic or manual. The text displayed is the mode the machine is set to.

**MOTOR:** Opens MOTOR screen

**SETUP:** Opens SETUP screen

**SERVO UP:** Makes the arm go up if the folder is back and the spreader is in the center position

**SERVO DOWN:** Makes the arm go down if the folder is back

**SERVO OFF:** Turns the motor that drives the arm off

**BAND ENDING:** If the arm is down, this turns the spreader to the second fold position

**CENTER:** Turns the spreader to the center position

**BAND START:** If the arm is down, this turns the spreader to the first fold position

**ORIGIN:** Origins all motors except for the sewing motor. For the machine to orgin correctly the arm must be down and the folder back.

**MAIN:** Opens MAIN screen

## SETUP

BAND END COUNT	<u>DA0</u> STITCHES	K Y 0	7	8	9
END PRESSURE	<u>DA1</u> STITCHES		7	8	9
PULLER	<u>DA2</u> STITCHES	4	5	6	
KNIFE CUT	<u>DA3</u> STITCHES	1	2	3	
<b>FSO</b>	<b>OTHER</b>	0	E S	↓	

**BAND END COUNT:** Set how many stitches for automatic sew

**END PRESSURE:** Set how many stitches for automatic sew that the band is being clamped with pressure.

Example:

BAND END COUNT 20 STITCHES

END PRESSURE 15 STITCHES

In this case the final sew will be 20 stitches and for the last 5 stitches the clamp will provide no pressure.

**PULLER:** Set how many stitches until the puller drops. The count begins when the operator begins sewing the first fold.

**KNIFE CUT:** Set how many stitches until the knife behind the needles is activated. The count starts when the back Banner sensor can see the sensor tape. The knife will not activate on the first pair if pants.

**OTHER:** Opens OTHER screen

**MAIN:** Opens MAIN screen

## OTHER

START POSITION	<u>DA0</u> **	PUL:	7	8	9
CENTER POSITION	<u>DA1</u> **	PUL:	4	5	6
END POSITION	<u>DA2</u> **	PUL:	1	2	3
<b>FSO</b>	<b>BACK</b>		0	E S	↓

The OTHER screen is for adjusting the spreader motor. It is recommended that these settings remain at the default settings.

**START POSITION:** Set the start position

**CENTER POSITION:** Set the center position

**END POSITION:** Set the end position

**BACK:** Opens SETUP screen

**MAIN:** Opens MAIN screen

In SETUP and OTHER screen the number pad is hidden until a number is touched. Enter (bottom right button) or ESC will hide the number pad. Enter will save the new setting if it is in range and ESC will cancel the new setting.