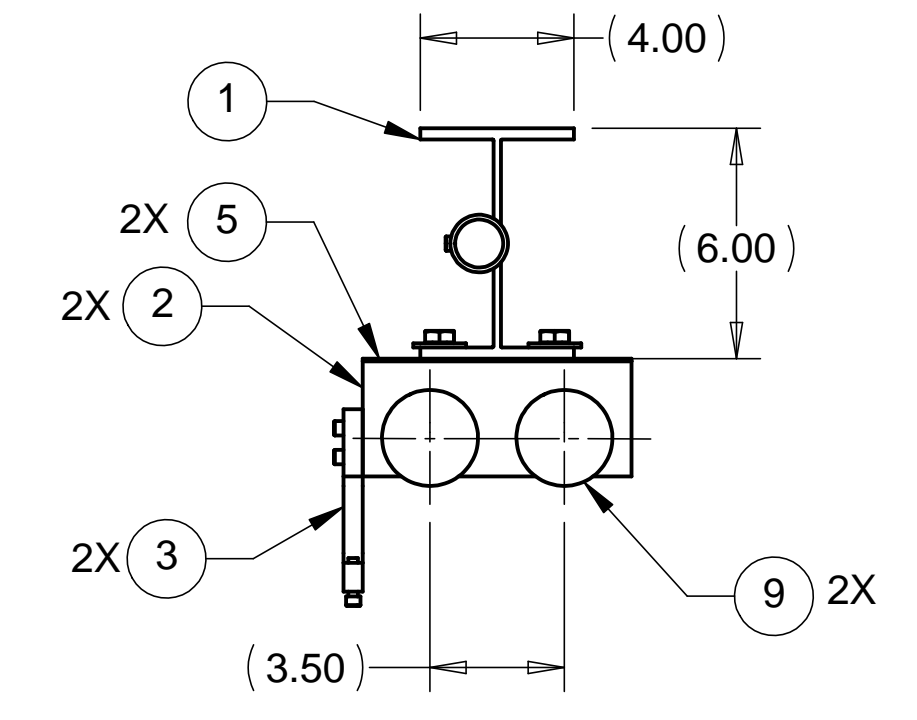
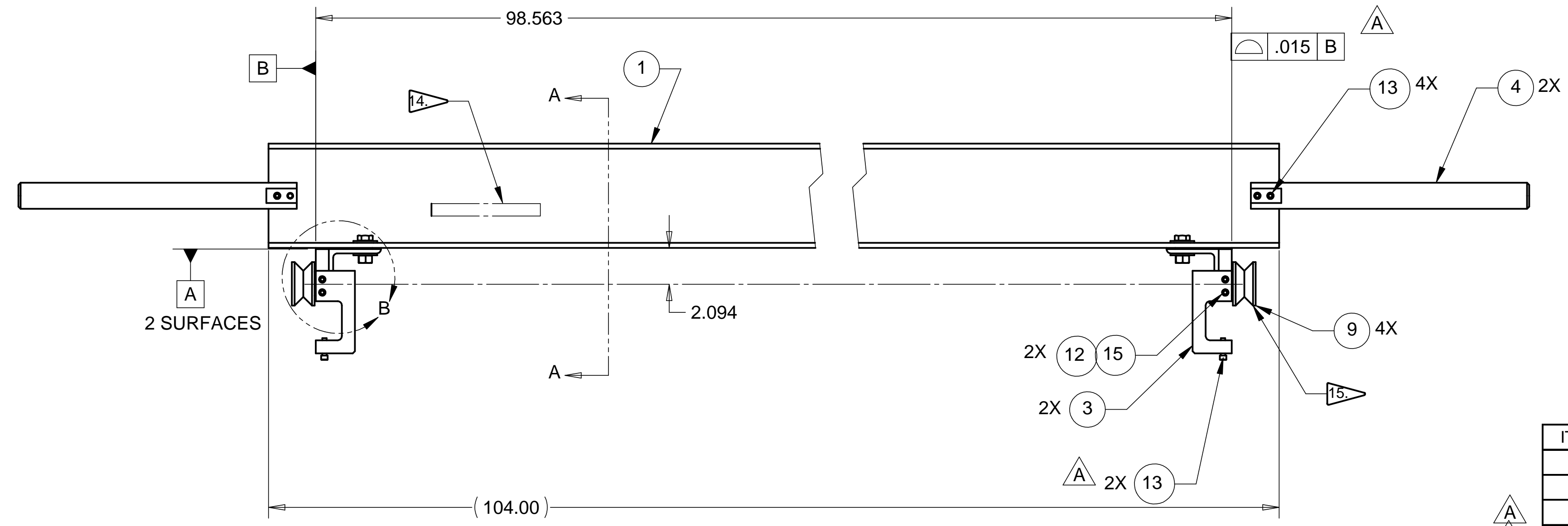
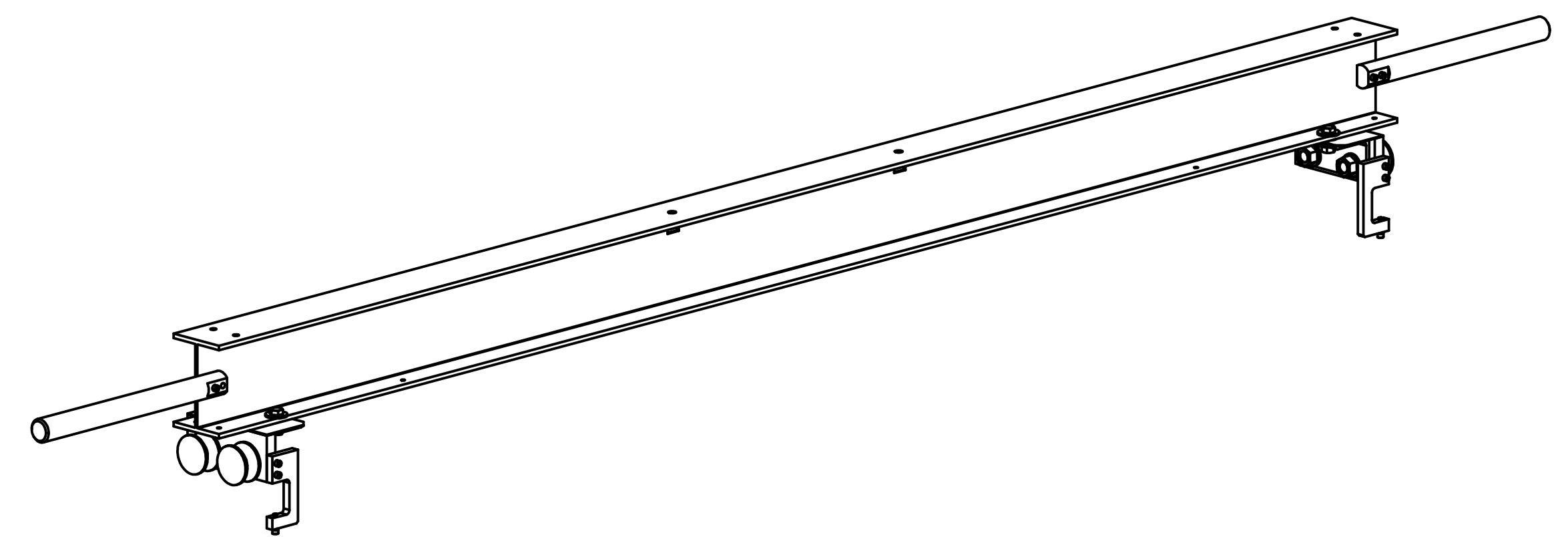
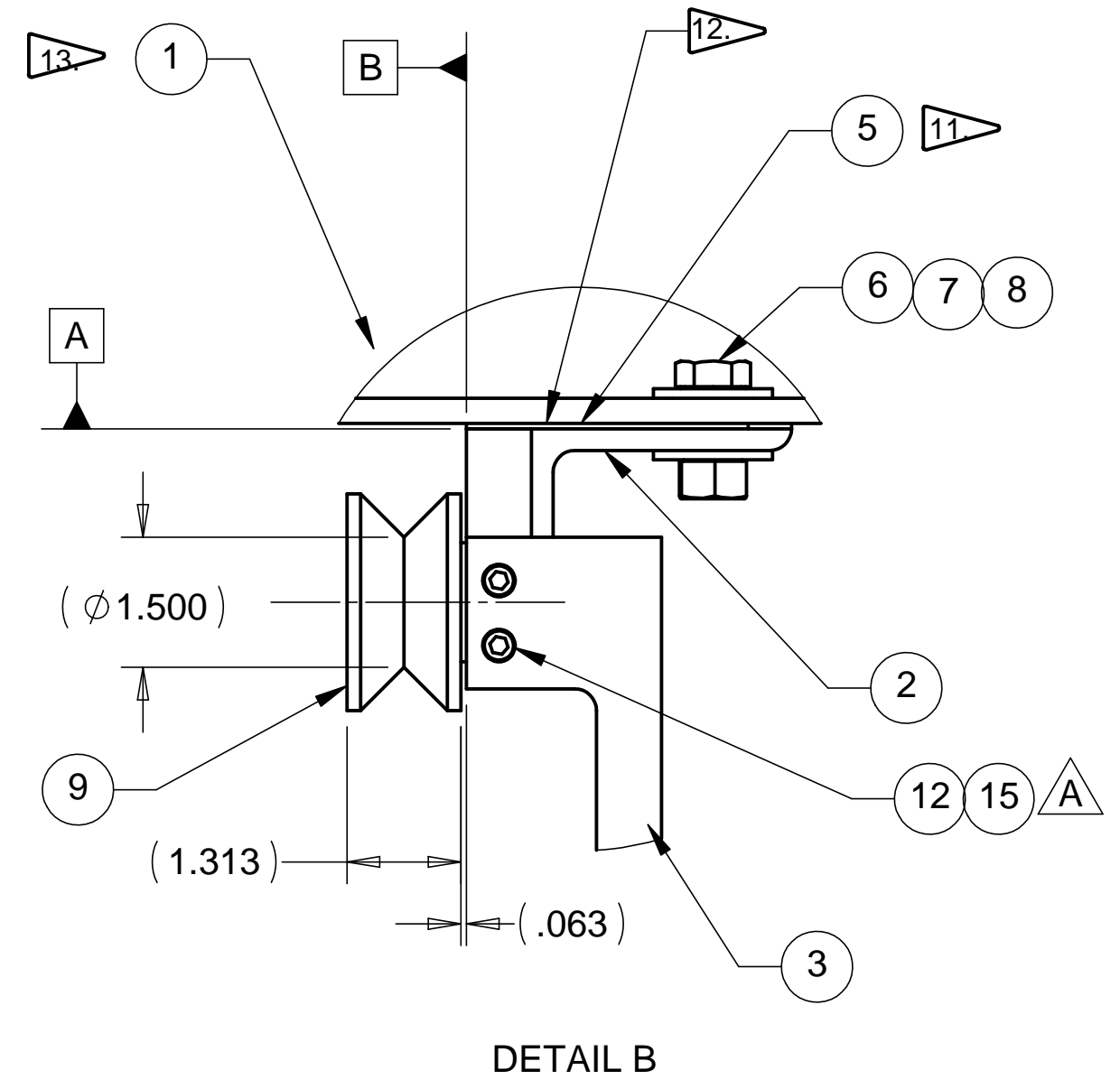
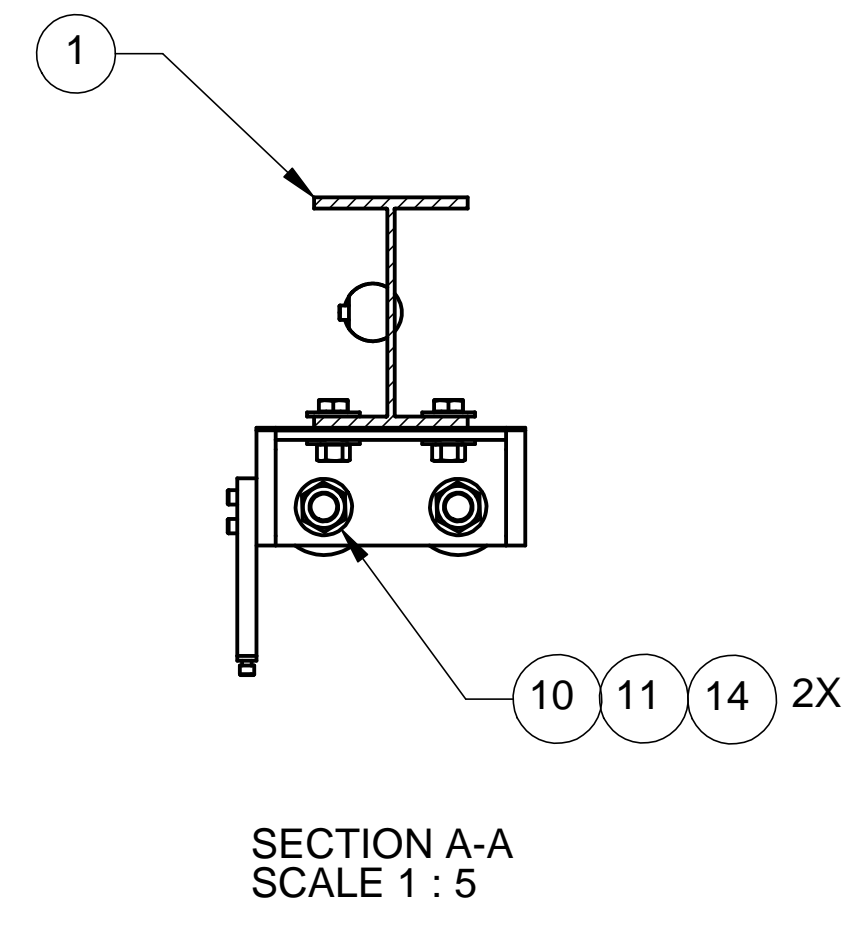


8 7 6 5 4 3 2 1

REVISIONS		DATE	APPROVED
REV. A	REVISD BOM QUANTITY, CHANGED GDT	3-16-98	WKM



NOTES: UNLESS OTHERWISE SPECIFIED

1. ALL DIMENSIONS IN INCHES
2. DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
3. SURFACE TEXTURE PER ANSI/ASME B 46.1-1985
4. REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .015
5. ALL INSIDE CORNERS TO BE .015 RADIUS MAX
6. COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
7. COUNTERSINK 82 DEGREES APPROXIMATELY .015 DEEP ALL DRILLED HOLES
8. PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT, AND CHIPS.
9. PART NUMBER (DRAWING NO. PLUS DASH NO. PLUS SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF.
10. PART WEIGHS 74.1 Lbs.
11. MACHINE SHIM (PART D972955) THICKNESS TO ACHIEVE FINAL DIMENSIONS.
12. SCRIBE POSITIONAL RELATIONSHIP OF ITEMS 1, 2, AND 5 AFTER ASSEMBLY.
13. STAMP ALL ASSEMBLY PIECES WITH AN ASSEMBLY SERIAL NUMBER.
14. PAINT ON SIDE: DO NOT DISASSEMBLE ASSEMBLY.
15. USE A VAPOR DEGREASER TO REMOVE ALL GREASE FROM V-ROLLERS (ITEM 9).

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	D972941-1	HAM RAIL SYSTEM MINOR RAIL I-BEAM
2	2	D972942-1	MINOR RAIL ROLLER ANGLE BRACKET
3	2	D972943-1	MINOR RAIL LOCKDOWN BRACKET
4	2	D972945-1	HAM RAIL SYSTEM MINOR RAIL PUSH BAR
5	2	D972955-1	MINOR RAIL ANGLE BRACKET SHIM
6	4	STD HARDWARE	HEX HEAD BOLT, 1/2-13 UNC-2A X 1.25 LONG
7	4	STD HARDWARE	WASHER, 1/2 FLAT
8	4	STD HARDWARE	HEX NUT, 1/2-13 UNC-2B
9	4	PCI # VLR-2 1/2	V-GROOVE ROLLER, 2.5 O.D., KAMAN INDUSTRIES
10	4	STD HARDWARE	HEX NUT, 3/4-16 UNC-2B
11	4	STD HARDWARE	WASHER, 3/4 FLAT
12	4	STD HARDWARE	SOCKET HEAD CAPSCREW, 1/4-20 UNC-2A X 1.0 LONG
13	6	STD HARDWARE	SOCKET HEAD CAPSCREW, 1/4-20 UNC-2A X 1.5 LONG
14	4	STD HARDWARE	WASHER, 3/4 LOCK
15	4	STD HARDWARE	WASHER, 1/4 FLAT

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		HYTEC, INC TITLE HAM RAIL SYSTEM MINOR RAIL ASSEMBLY	
DECIMALS .XX = +/- .03 .XXX = +/- .010	ANGULAR = +/- 30' SURFACE FINISH = 250	SIGNATURE	DATE		
FINISH		DESIGNED W. K. MILLER	1/3/98	DWG. NO. D972887	SIZE D
PART NO. D972887-1		DRAWN W. K. MILLER	1/3/98	SHEET NO. 1 of 1	
		CHECKED HARRY SALAZAR	2/4/98	SCALE 1/5	REVISION A
		ENGR. T. THOMPSON	2/4/98		
		APPROVED T. THOMPSON	2/4/98		

8 7 6 5 4 3 2 1