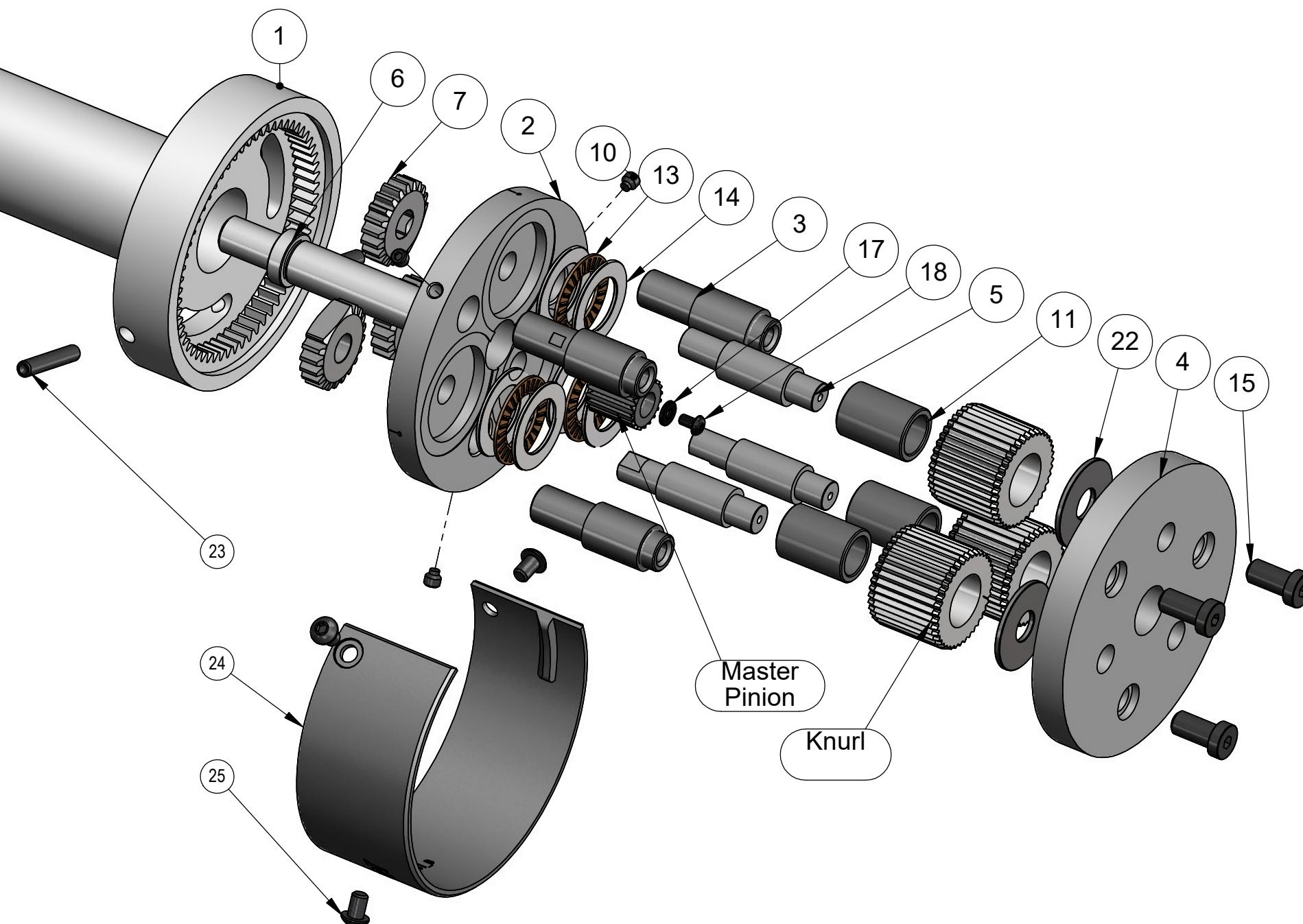


NOTE: All Knurls and Master Pinion are application specific and are sold separately.
The Knurls and Master Pinion included within the diagram are for reference purposes only.

REV			ZONE	ECN	REVISION DESCRIPTION	DATE	ENG
A			Released	02/11	PA
B					Added (3) 101027	06/11	PA
C					Added 192040 (1), 192041 (1), 192044 (1) 192042 (1), 836-B-6-6, 192046 (1) 192039 (3) was 192005 (3)	04/12	PA
D					5850 Added 192060 (2), 192002 Updated	03/25	PA

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	192002	Shank - Adjusting Gear	1
2	192003	Center Plate	1
3	192038	Riser 1.00 (3/8-16)	3
4	192004	Front Plate	1
5	192039	Eccentric Roll Pin (.015)	3
6	192040	Pinion Arbor	1
7	192008	Eccentric Gear	3
8	192046	Spring: Compression, .845 OD x 3.00	1
9	192041	Adjusting Sleeve (Pinion)	1
10	140280	Screw: SSS, 1/4-28 x 0.250 Half Dog Pt.	3
11	192036	Carbide Bushing	3
12	192016	Washer (Ring Style)	1
13	192017	Thrust Bearing	3
14	192018	Thrust Washer	6
15	140366	Screw: LHCS, 3/8-16 x 0.750	3
16	134205	Bolt: Hex, 3/8-16 x 1.50, Grade 8	3
17	192044	Thrust Washer	1
18	836-B-6-6	Screw: BHCS, #8-32 x .375	1
19	192047	Spline Brake	1
A 20	125156	Screw: SHCS, #8-32 x .375	1
21	192042	Spring Retainer	1
22	192050	Thrust Washer	3
23	192060	Screw: SSS, 1/4-28 x 1.500 Cup Pt.	2
24	192061	Cover, Chip Guard 192 ES-05	1
25	836-B-11-6	BHSS 1/4-28 X 3/8" LONG	3



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DRAWN BY: P. Allart
DWG DATE: 02/22/2011
ENG. APPR: P. Allart
APPR DATE: 02/22/2011
MATERIAL: SEE BOM
HEAT TRT: N/A



CJWINTER
A Brinkman International Group, Inc. Company

Spline Attachment
(1.000 OAL Roll)

DWG SIZE: B
SCALE: 1:2
SHEET 1 OF 3
DRAWING NO.
192 ES-01

REV	ZONE	ECN	REVISION DESCRIPTION	DATE	ENG
A	Released	02/11	PA

D

D

C

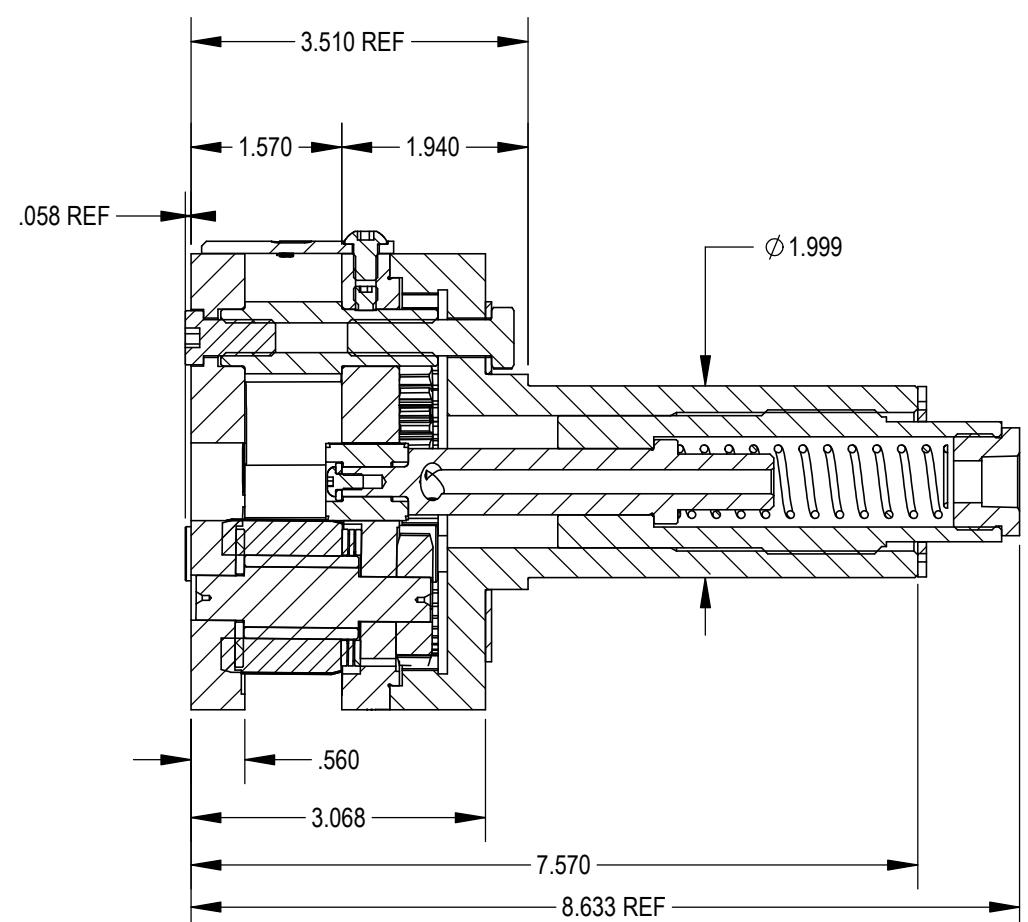
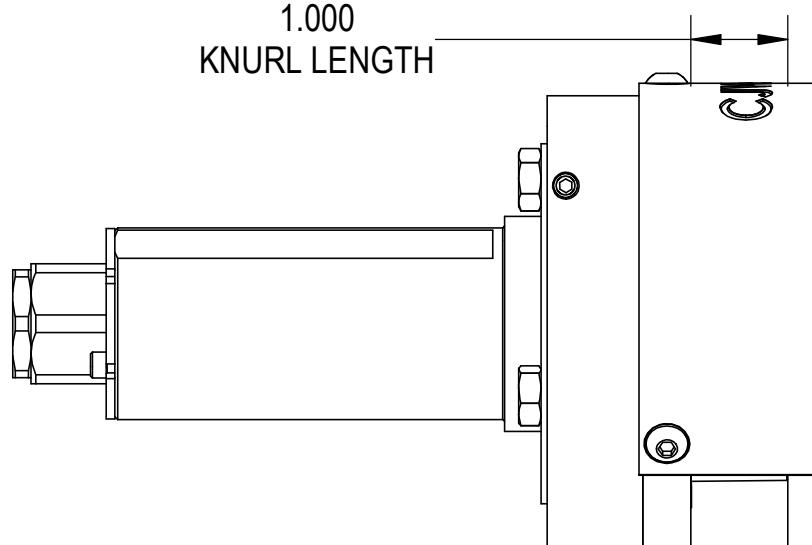
C

B

B

A

A



SECTION V-V
SCALE 1:2

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DIMENSIONS ARE BASIC

.020 A B C SW

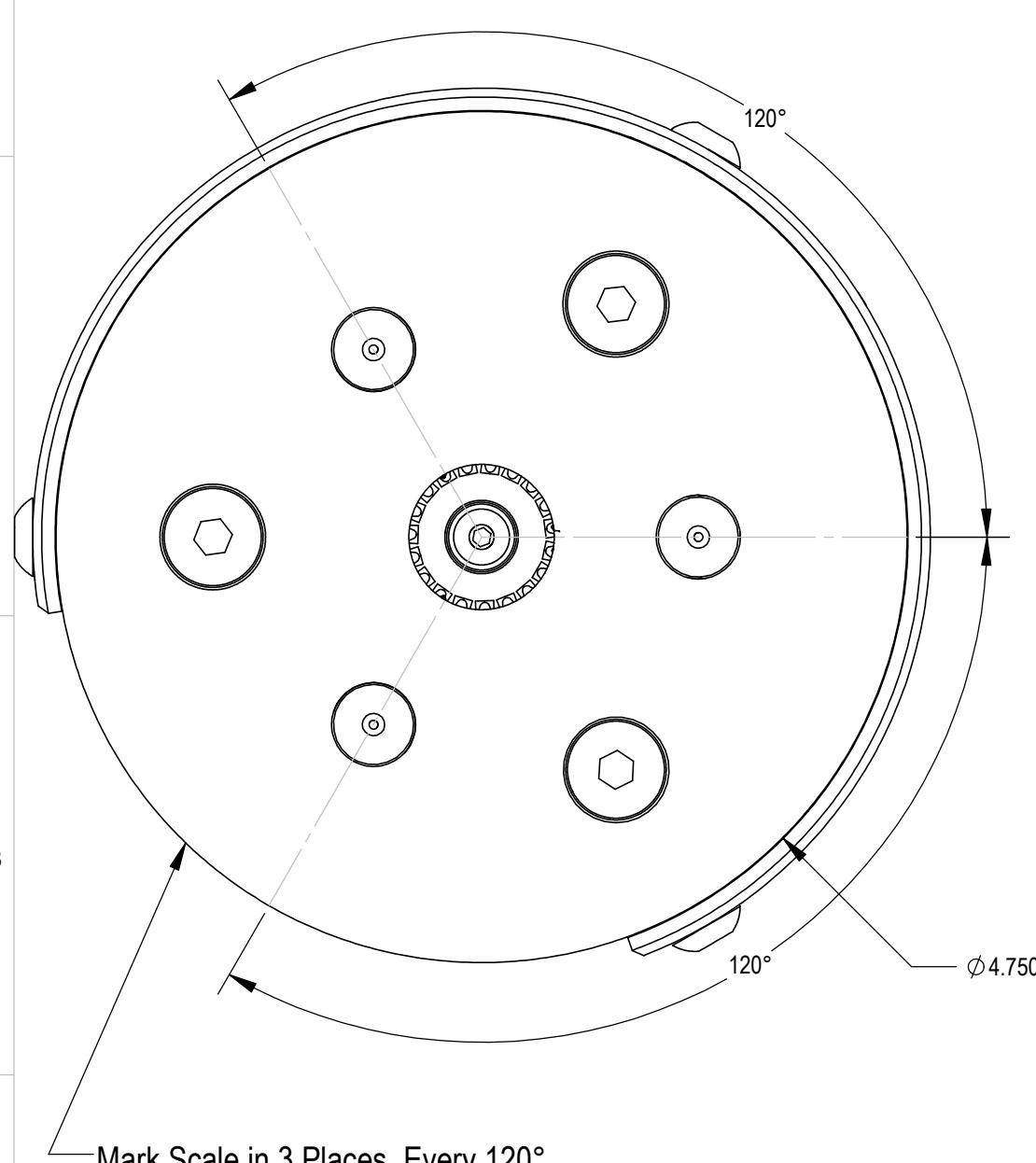
DRAWN BY: P. Allart
DWG DATE: 02/22/2011
ENG. APPR: P. Allart
APPR DATE: 02/22/2011
MATERIAL: SEE BOM
HEAT TRT: N/A

CJWINTER
A Brinkman International Group, Inc. Company
DWG SIZE: 1:2
SCALE: 1:2
B SHEET 2 OF 3
DRAWING NO.
192 ES-01

Spline Attachment
(1.000 OAL Roll)

REV	ZONE	ECN	REVISION DESCRIPTION	DATE	ENG
A	Released	02/11	PA

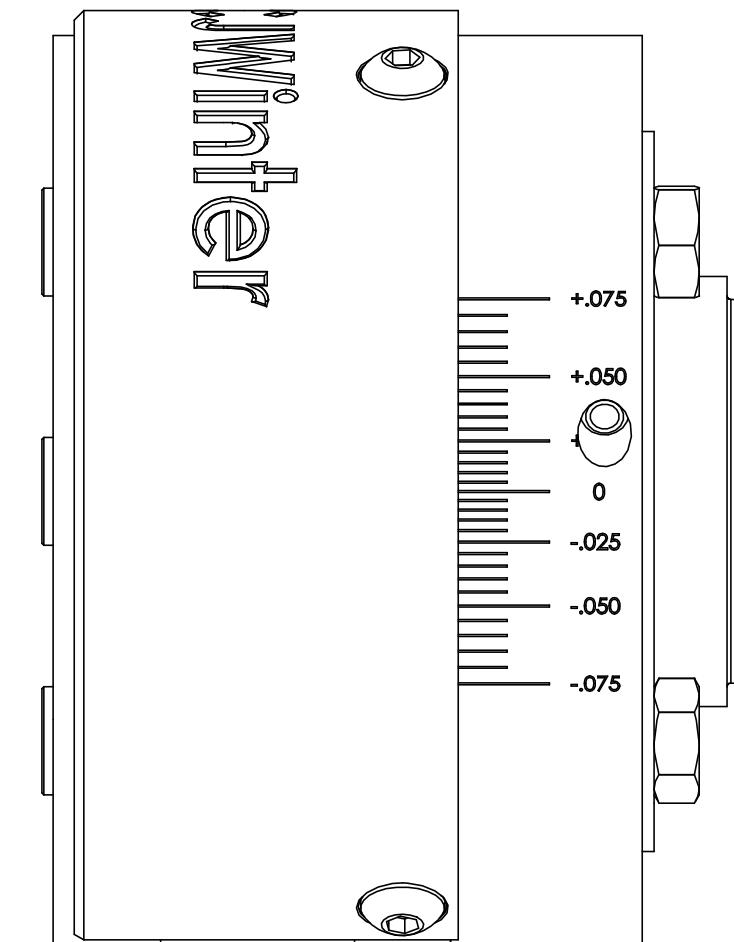
LaserMarking Detail



Mark Scale in 3 Places, Every 120°
Visually Align -0- with roll pin within +/- 10°

PRIOR TO MARKING - SET HEAD TO CENTER OF ADJUSTMENT

- 1) Loosen 3 Hex Bolts Near Shank
- 2) Twist Head Until Fully Closed, Mark Across Both Parts w/ Sharpie
- 3) Twist Head Until Fully Open, Mark Across Both Parts w/ Sharpie
- 4) Adjust Until Mark on Head is Exactly 1/2 way Between Sharpie Marks
- 5) Tighten Hex Bolts



Scale	Chordal position
0.075	1.035
0.070	0.941
0.065	0.850
0.060	0.764
0.055	0.682
0.050	0.604
0.045	0.529
0.040	0.458
0.035	0.390
0.030	0.325
0.025	0.264
0.020	0.205
0.015	0.149
0.010	0.097
0.005	0.047
0.000	0.000
-0.005	-0.047
-0.010	-0.097
-0.015	-0.149
-0.020	-0.205
-0.025	-0.264
-0.030	-0.325
-0.035	-0.390
-0.040	-0.458
-0.045	-0.529
-0.050	-0.604
-0.055	-0.682
-0.060	-0.764
-0.065	-0.850
-0.070	-0.941
-0.075	-1.035

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DRAWN BY: P. Allart
DWG DATE: 02/23/2011
ENG. APPR: P. Allart
APPR DATE: 02/23/2011
MATERIAL: SEE BOM
HEAT TRT: N/A



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DWG SIZE: 1:1
SCALE: 1:1
B
Sheet 3 of 3
DRAWING NO.
192 ES-01

Spline Attachment
(1.000 OAL Roll)