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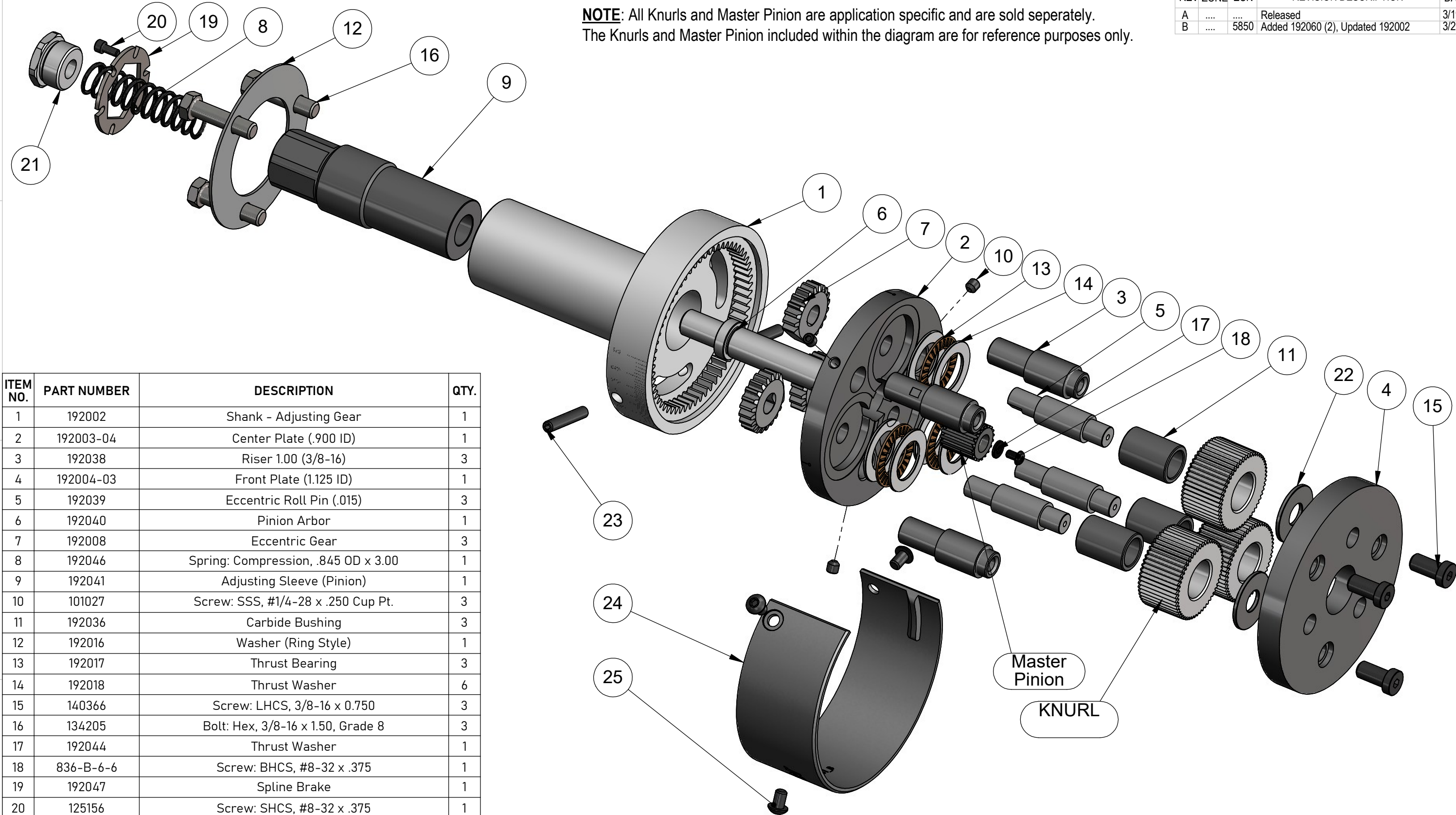
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**NOTE:** All Knurls and Master Pinion are application specific and are sold seperately.  
The Knurls and Master Pinion included within the diagram are for reference purposes only.

REV	ZONE	ECN	REVISION DESCRIPTION	DATE	ENG
A	....	....	Released	3/19	PRD
B	....	5850	Added 192060 (2), Updated 192002	3/25	PA



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	192002	Shank - Adjusting Gear	1
2	192003-04	Center Plate (.900 ID)	1
3	192038	Riser 1.00 (3/8-16)	3
4	192004-03	Front Plate (1.125 ID)	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	101027	Screw: SSS, #1/4-28 x .250 Cup 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
20	125156	Screw: SHCS, #8-32 x .375	1
21	192042	Spring Retainer	1
22	192050-01	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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DIMENSIONS ARE BASIC  
SW

DRAWN BY: P.Diliberto  
DWG DATE: 03/07/2019  
ENG. APPR: P.Allart  
APPR DATE: 03/07/2019  
MATERIAL: SEE BOM  
HEAT TRT: N/A



Spline Attachment (1.13 Plate Dia)  
(1.000 OAL Roll)

DWG SIZE SCALE: 1:2  
B SHEET 1 OF 3  
DRAWING NO.  
192 ES-04

6

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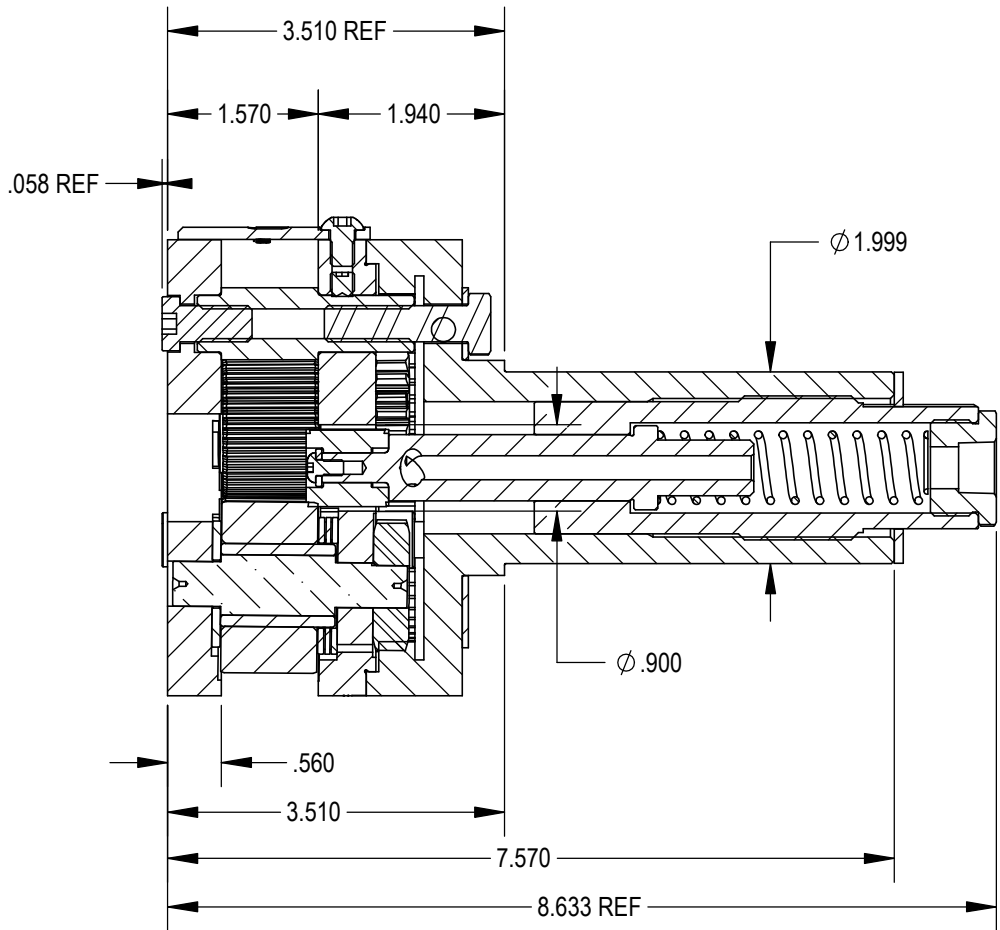
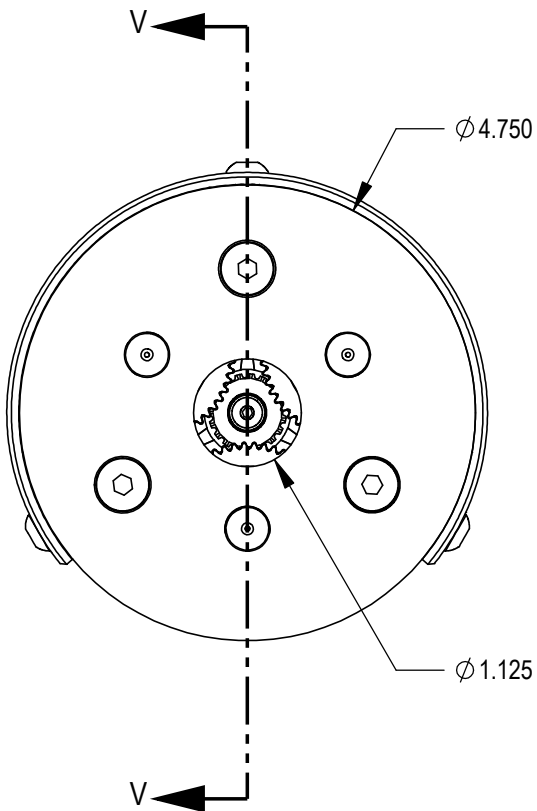
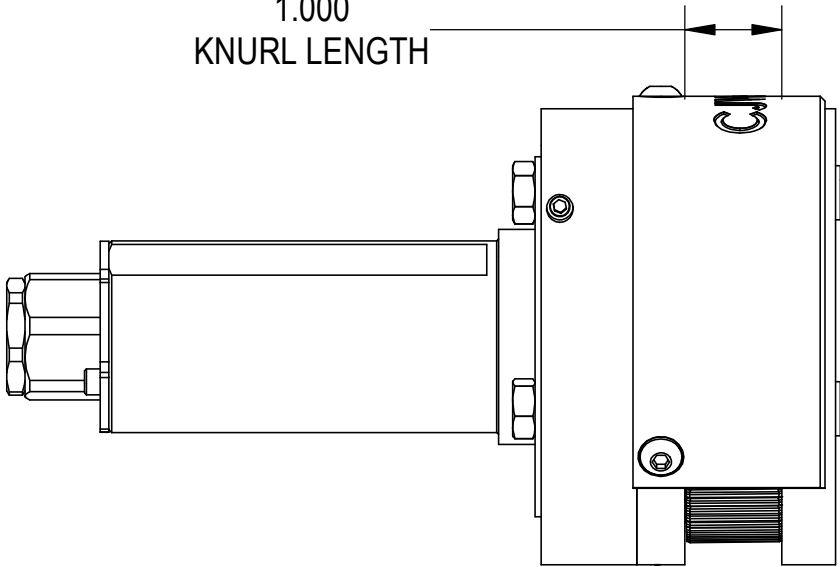
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REV	ZONE	ECN	REVISION DESCRIPTION	DATE	ENG
A	....	....	Released	3/19	PRD



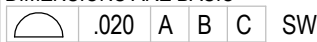
1.000  
KNURL LENGTH



SECTION V-V  
SCALE 1 : 2

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APPR DATE: 03/07/2019  
MATERIAL: SEE BOM  
HEAT TRT: N/A



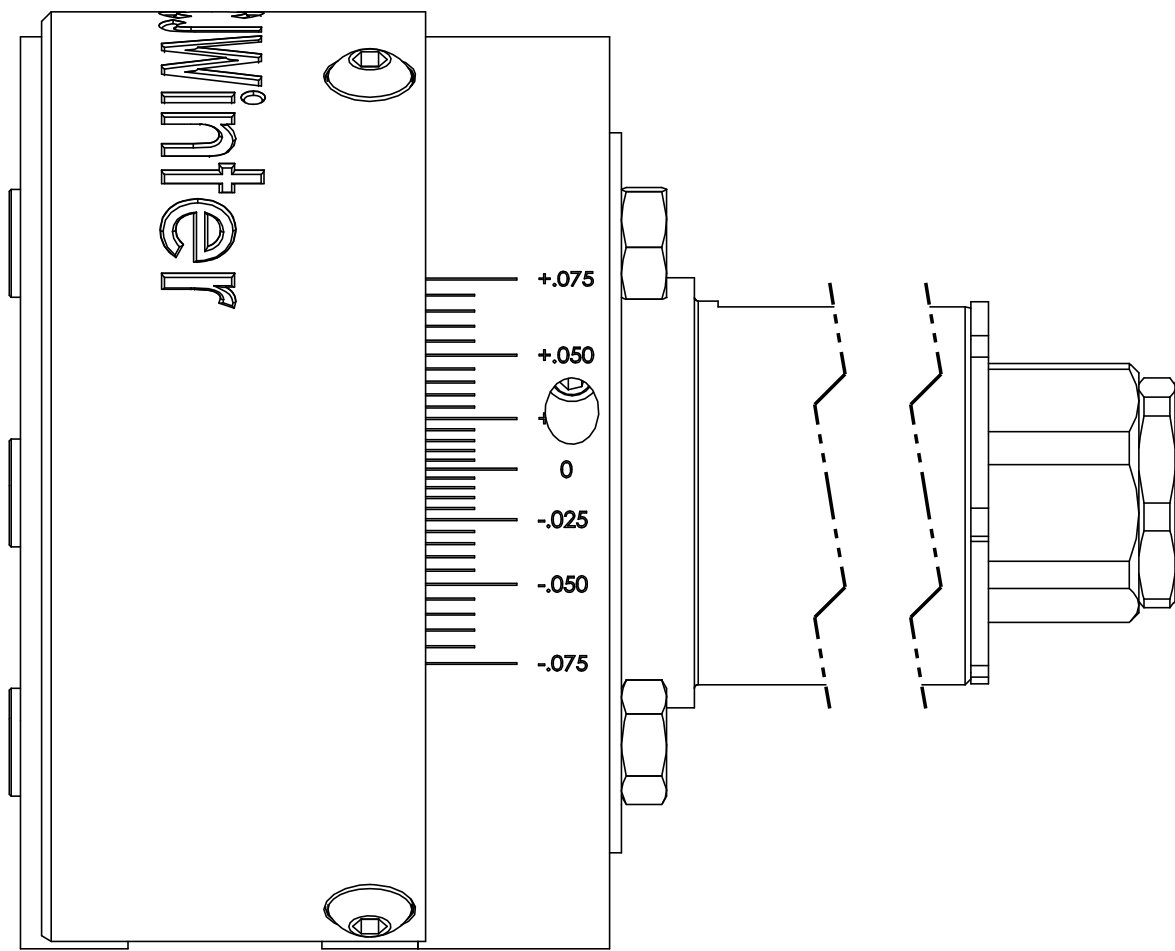
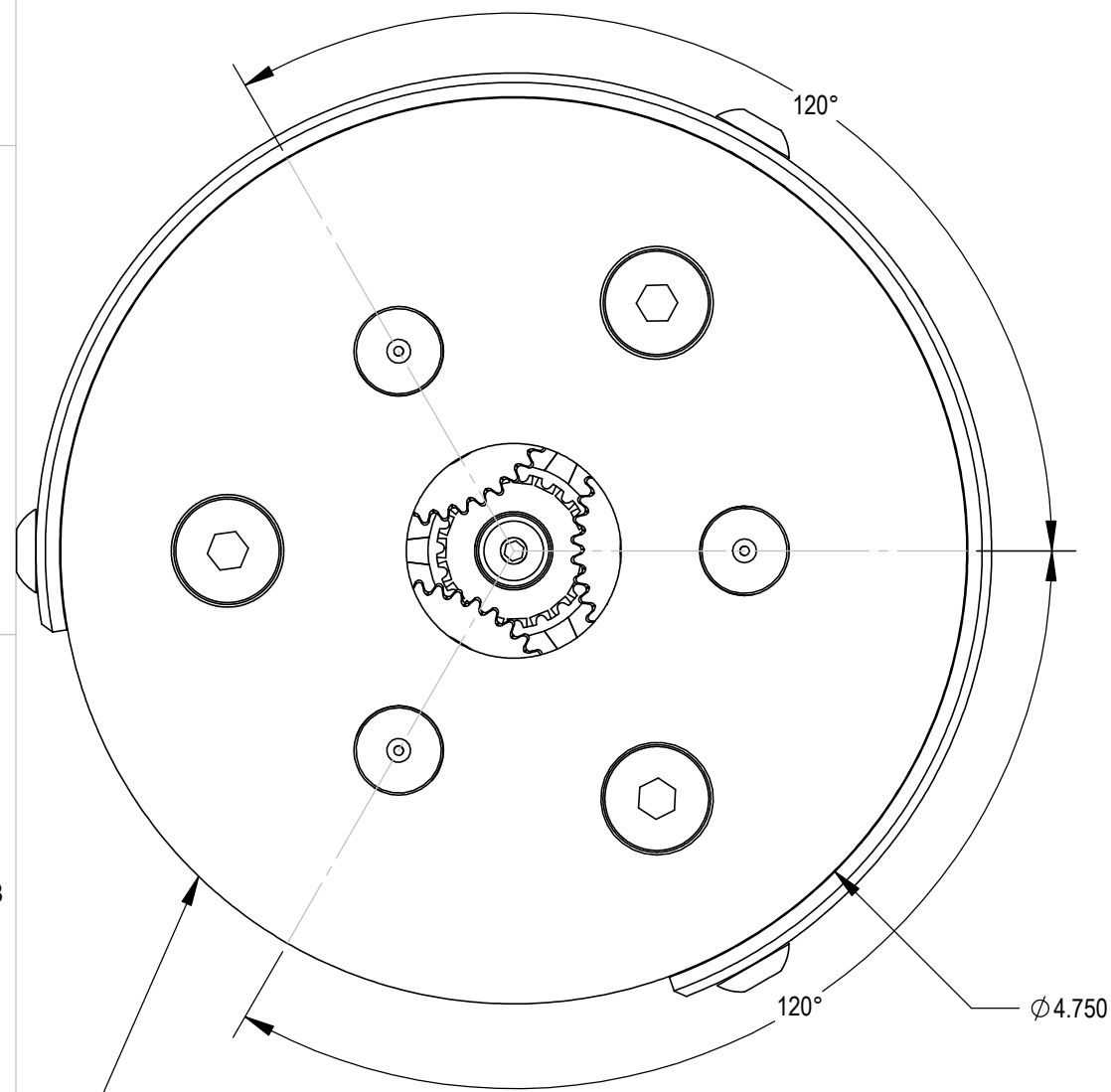
Spline Attachment (1.13 Plate Dia)  
(1.000 OAL Roll)

DWG SIZE  
B  
SCALE: 1:2  
SHEET 2 OF 3

DRAWING NO.  
192 ES-04

# LaserMarking Detail

REV	ZONE	ECN	REVISION DESCRIPTION	DATE	ENG
A	....	....	Released	3/19	PRD



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

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

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 .020 A B C SW

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ENG. APPR: P.Allart  
APPR DATE: 03/07/2019  
MATERIAL: SEE BOM  
HEAT TRT: N/A



Spline Attachment (1.13 Plate Dia)  
(1.000 OAL Roll)

DWG SIZE  
B  
SCALE: 1:1  
Sheet 3 of 3

DRAWING NO.  
192 ES-04