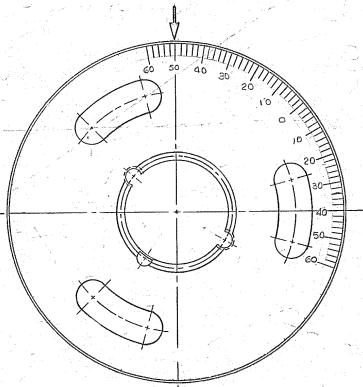


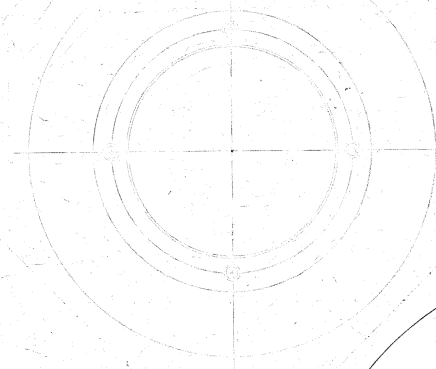
JUN 1967

REVISIONS

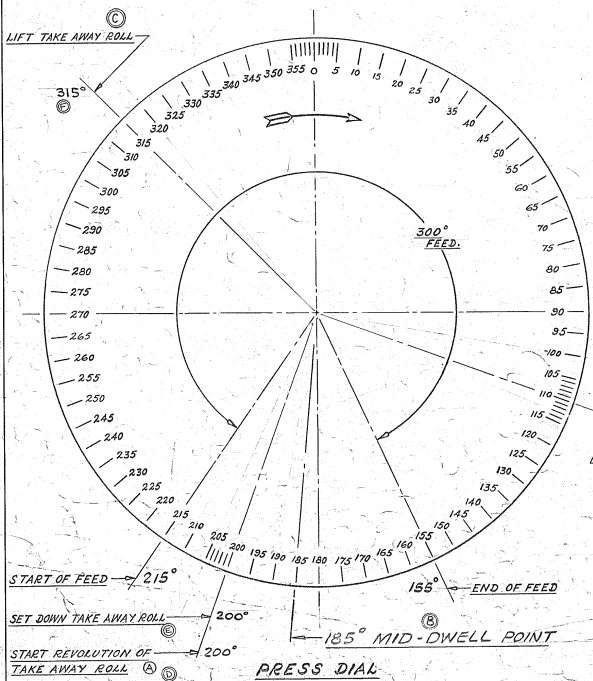
DATE	BY	CHK	BY
1-28-58	A	20° START	40.10
		11.3° STOP	
6-2-70	GGK	UP-DATED - TIMING	MARKS
		LEADS WPT. ETC.	240
10-8-70	B	ADDED	50
10-8-70	C	330°	50
10-8-70	D	150°	50
10-8-70	E	205°	50
10-8-70	F	320°	50
10-8-70	G	100°	50
10-8-70	H	REWORKED TIMING	50



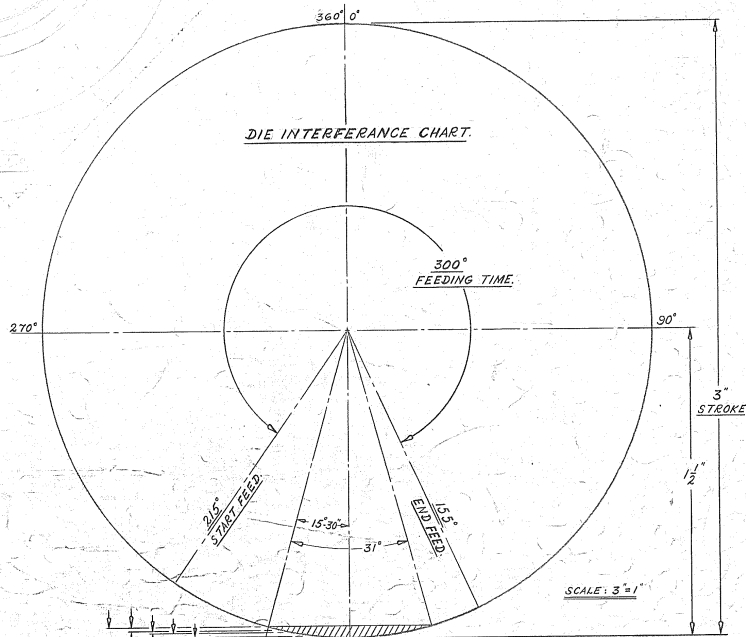
TIMING DISC.
TAKE-AWAY ROLLS



NOTE: FOR TIMING
INDEX PRESS TO 185° (MID-DWELL POINT)
AND SET FEED & TAKE AWAY ROLLS TO "0"



PRESS DIAL



DIE INTERFERENCE CHART.

- CUT PIECE LEAVES DIE HERE
- ...010 APPROX. DIE OVERTRAVEL.
- ...015 MAX. STOCK THICKNESS.
- ...010 APPROX. STRIPPER LEAD.
- ...020 APPROX. SHEAR ON PUNCH.
- ...055 APPROX. TOTAL DIE INTERFERENCE.

SCALE: 3" = 1"
 ORIGINAL ORDER NUMBER: 71800-63
 DATE: JUN 1967
 BY: M.C.T.
 TITLE: DIAGRAM - TIMING
 MACHINE: #538 CAM OPERATED ROLL FEED
 Dwg. No: 51783