

60408 (2)  
62363 (2) ③

60353 (2)  
62009 (2) ③  
62362 (2)

NOTE! ⑥  
IDLER PIN TO BLOCK  
CHANGED FROM .625 DIA  
5/8-18 THREAD. SET SCRE  
PARTS INVOLVED: 27138, 145

27152

27142 (2) ③  
27138

1.615

②  
66060 (2)  
② 1.231 REF.  
(31.26 MM)

15467 ROLL  
14556 PIN

0012  
ID  
OOT  
AA  
00

27157  
③ 60354 (2)  
62362 (2)  
66594 (2)

60901

27156

27154

27133

⑤  
CAUTION  
ASS'Y. LOCKUP  
SHOULD ALLOW PART  
27156 TO BE  
FREE SLIDING.

BRGS REQD.

(3)	B-1212 BRG.	≠60
(1)	B-128 BRG.	≠60
(4)	TRA-1220	≠60
(2)	NTA-1220	≠60

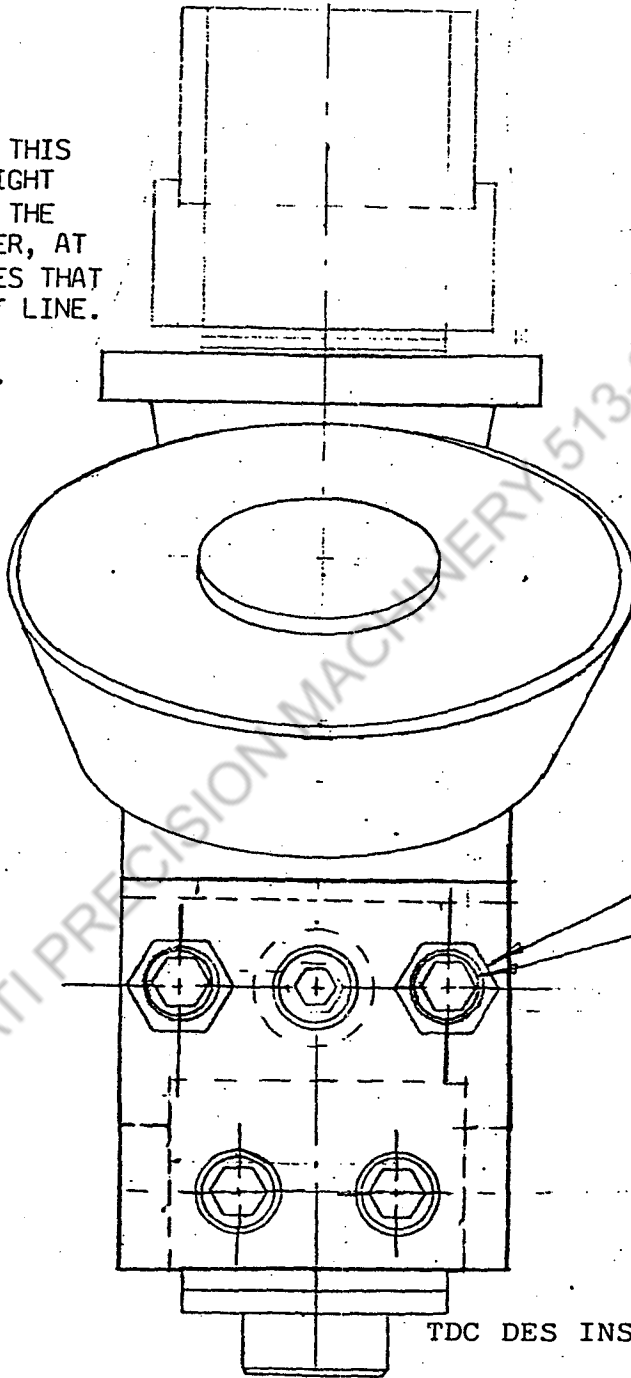
③  
60408 (2)  
62363 (2)

QUANTING STYLE  
STRAIGHT TO  
RETAINED  
27156, 14555

R TDC DUPLEX - THIS CORNER OF THIS  
LIER MUST BE UP AGAINST A STRAIGHT  
GE HELD AGAINST THE CORNER OF THE  
RM ROLLS BEFORE AND AFTER IDLER, AT  
IS VERTICAL LEVEL: THIS ENSURES THAT  
OCK WILL PASS ALONG A STRAIGHT LINE.

TEXT FOR ADDITIONAL DETAILS.

5 - PIN ⑦  
ROLLS:  
6B - 35mm  
10B - 30mm  
53A - 25mm



② NOTE: THIS IDLER ROLL  
UP SHOULD NOT BE CHA  
- FROM ITS ORIGINAL SE  
IDLER ROLL NEARER MAC  
PLATE IS FIXED AT A P  
POSITION AND IDLER FU  
FROM PLATE IS MOUNTED  
SPRINGED BRACKET WHICH  
KEEPS IT IN CONTACT WI  
THE INNER ROLL UNTIL S  
PASSES BETWEEN THEM. IN  
ROLL SHOULD STAY AS SE  
OUTER ROLL CAN BE RESE  
CORRECT TENSION BY TIGH  
ING ITS OUTER POSITIONI  
BOLT COMPLETELY, UP AGA  
THE ROLLBLOCK, THEN LOO  
ING IT BY 1 FULL TURN.  
LOCATES THE END OF THE  
POSITIONING BOLT SO IT  
THE ROLLBLOCK FROM MOVI  
ANY FARTHER THAN IT SHO

- 66060 (1) ②
- 66020 (1) ②
- 71039
- 27155
- 60901
- 60352 (2)
- 62362 (2) ③
- ④
- 62765 (1)
- 62057 (2)

- 61100 (2) ③
- 60354 (2) ③

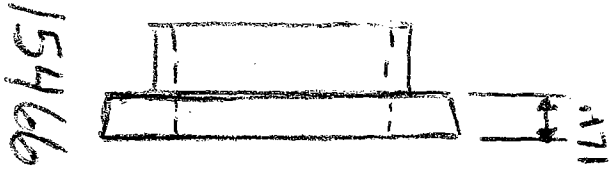
TDC DES INSTRUCTIONS #9 ILLUSTRATION

<b>THE LOCKFORMER CO.</b>		
711 OGDEN AVE.		LISLE, ILLINOIS 60532
MACHINE	TDC	
PART NAME		PART NUMBER
IDLER ASSEMBLY		50321
STATIONS 12-13.		
MATERIAL	HEAT TREAT	SCALE
		FULL
ANG. TOL	DRAWN BY	CHECKED BY

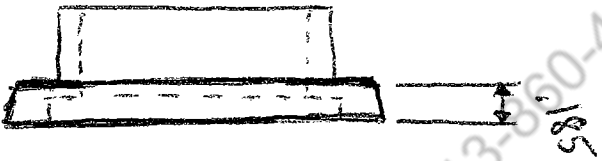
- 7. ADD IDLER NOTE 9-16-91
- 8. ADDED IDLER PIN ILLUSTRATION NOTE. 4/14/89 KCB NY
- 5. ADD CAUTION NOTE 7-14-88 RW
- 4. ADDED 62765 & 62057 5-20-88 BIF
- 3. SEE C.O. 070/7267 8-24-88 DD
- 2. REVISED PER KIM C.O. 070-6657 9-5-88

160  
20  
39  
52

COMPARISON OF THREE DIFFERENT  
IDLER ROLLS FOR 5/16 BOTTOM



15466



15431



15405

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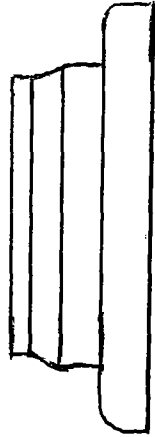
## IDENTIFICATION CHART FOR TDC TOOLING

	<u>Original</u>	<u>TDC90</u>	<u>TDC85</u> (Current)
Top #2 Roll	15483	15421	15421
Bottom #2 Roll	15498	15426	15426
Top #3 Roll	15482	15422	15422
Bottom #3 Roll	15497	15427	15427
Top #4 Roll	15481	15423	15423
Bottom #4 Roll	15496	15428	15428
Top #5 Roll	15480	15424	15424
Bottom #5 Roll	15495	15429	15429
Bottom #6 Roll	15494	15430	15430
5/6 Idler Roll (bottom)	15466	15431	15405
5/6 Idler Roll (top)	15465	15465	15404
Bottom #14A Roll	15565	15565	15565
Bottom #14B Roll	15566	15566	15403

**NOTE:** On some very old tooling, the Bottom #14 Roll is one piece. When Up-dating, both Segment "A" and Segment "B" must be replaced.

702943  
TDC 85 KIT

TDC IDLER ROLL TOP AT 5-6



PART 15404



PART 15465

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