

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 REQ'D.

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

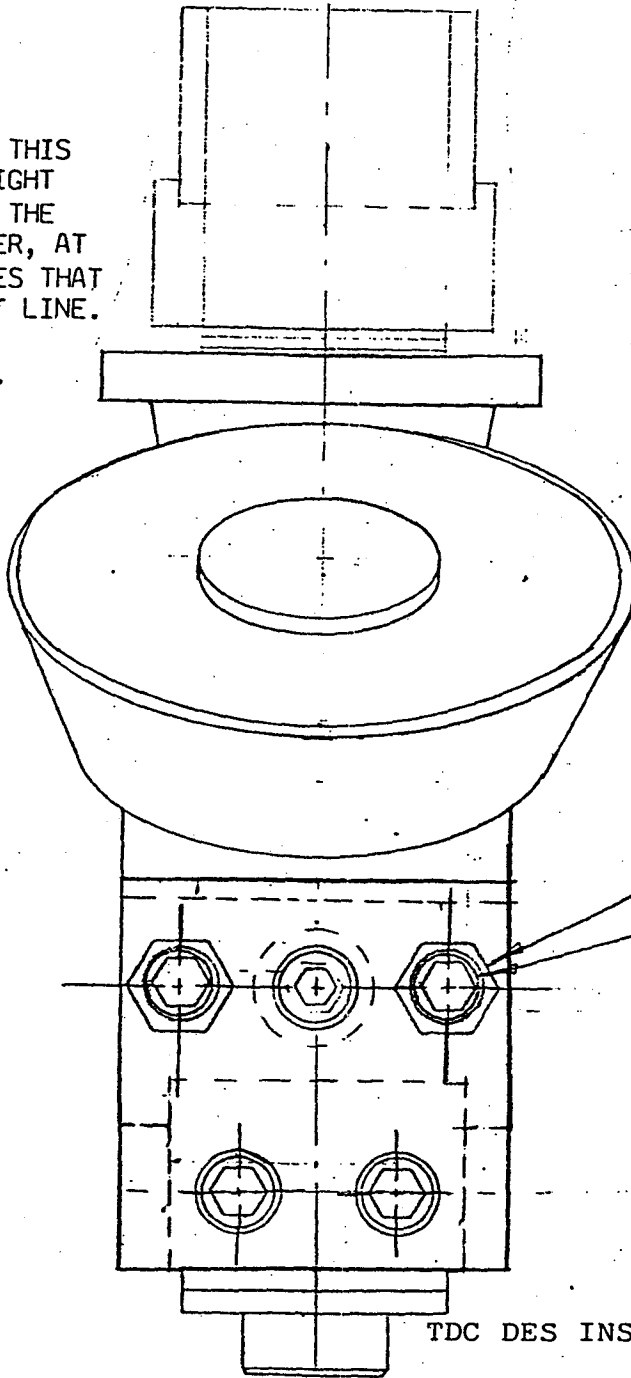
③
60408 (2)
62363 (2)

OUNTING 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

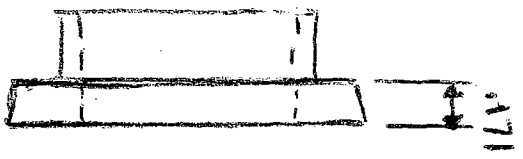
TDC DES INSTRUCTIONS #9 ILLUSTRATION

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

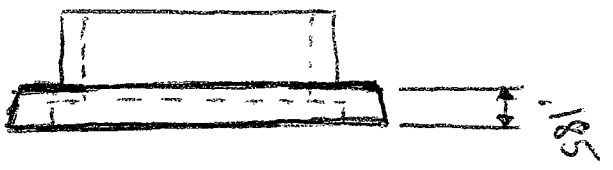
- 7. ADD IDLER NOTE 9-16-91
- 8. ADDED IDLER PIN ILLUSTRATION NOTE. 4/14/89 KCB NY
- 5. ADD CAUTION NOTE 7-14-88 RW
- 4. ADDED 62765 & 62057 5-20-88 BIF
- 3. SEE C.O. 070/7267 8-24-88 DD
- 2. REVISED PER KIM C.O. 070-6657 9-5-88

160
20
39
52

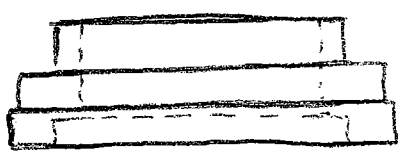
COMPARISON OF THREE DIFFERENT
IDLER ROLLS FOR 5/16 BOTTOM



15466



15431



15405

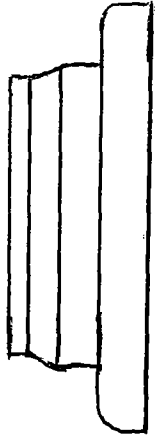
IDENTIFICATION CHART FOR TDC TOOLING

| | <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 |

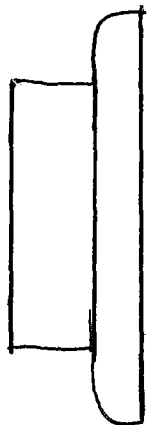
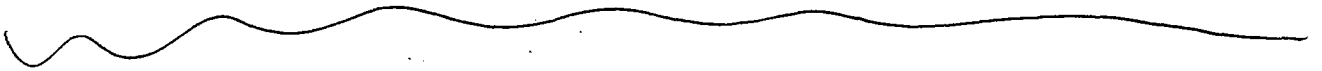
NOTE: On some very old tooling, the Bottom #14 Roll is one piece. When Up-dating, both Segment "A" and Segment "B" must be replaced.

702943
TDC85 KIT

TDC IDLER ROLL TOP AT 5-6



PART 15404



PART 15465