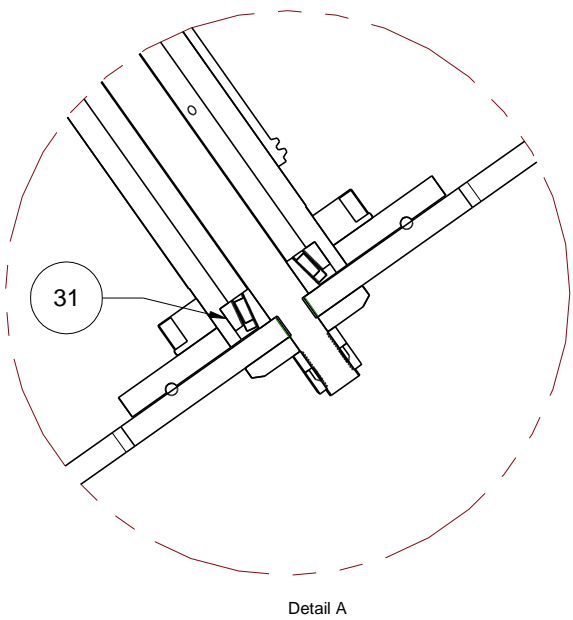
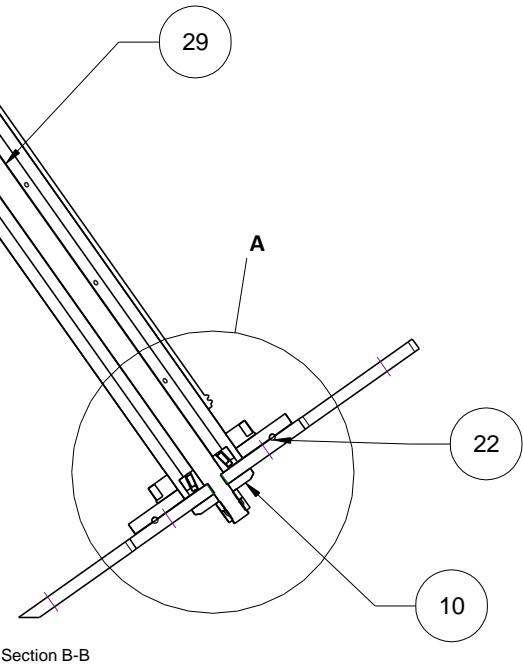
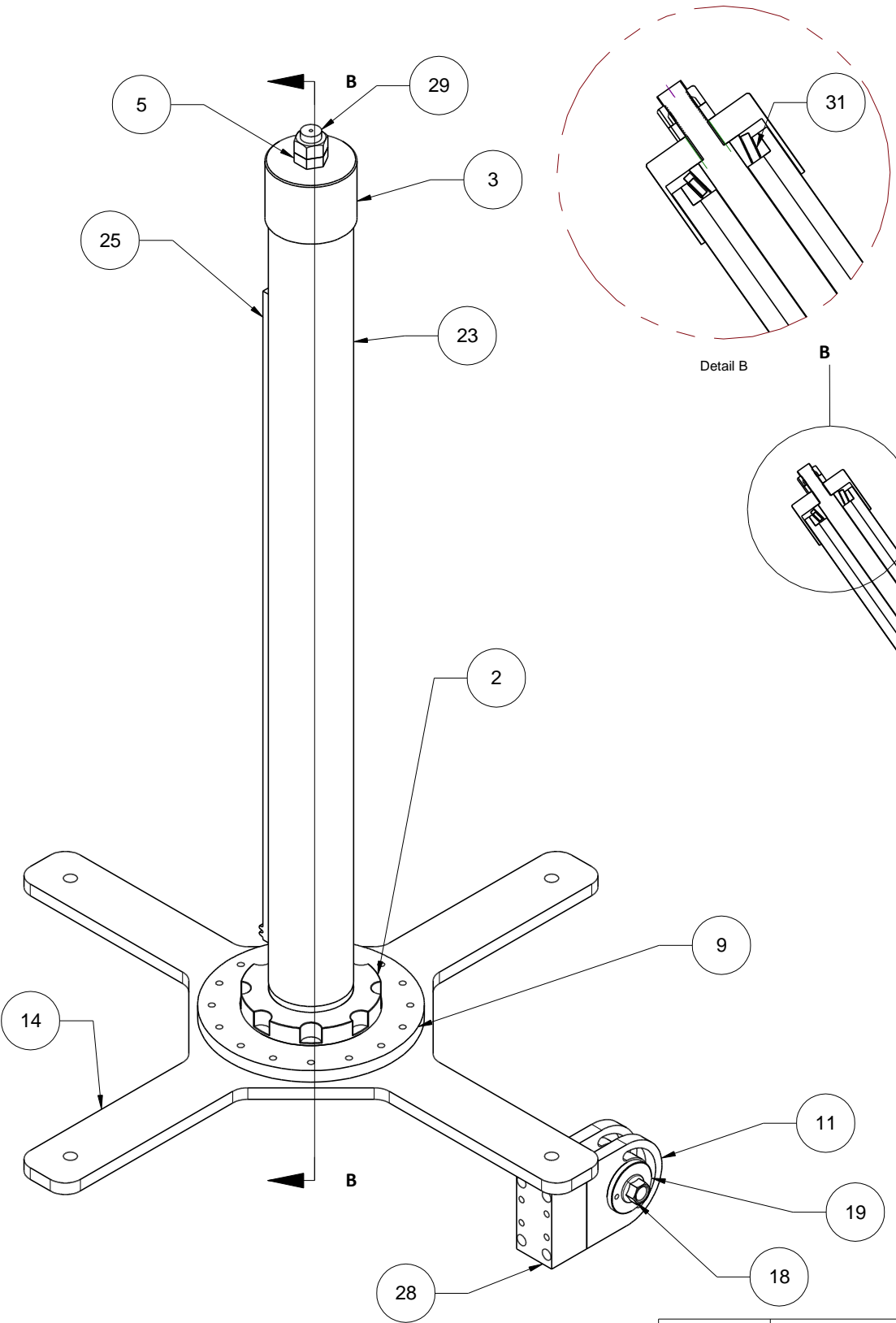


ITEM	PART NUMBER	DESCRIPTION	QTY	REV	Vendor
2	DBT-POP 1207-300-02	Z AXIS JAM NUT	1	0	VEETECH
3	DBT-POP 1207-300-03	Z AXIS CAP	1	0	VEETECH
5	LOCK NUT	90623A210	4		MCMASTER-CARR
9	DBT-POP 1207-300-09	Z AXIS INDEX PLATE	1	0	VEETECH
10	DBT-POP 1207-300-10	Z BASE WASHER	1	0	VEETECH
11	DBT-POP 1207-300-11	PIVOT	2	0	VEETECH
14	DBT-POP 1207-300-14	Z BASE (3)	1	0	VEETECH
18	92316A758	0500-20 NF FLANGED HHCS	1		MCMASTER-CARR
19	DBT-POP 1207-300-19	TH PIVOT WASHER	1	0	VEETECH
22	9558K424	O RING MMC9558K424	1		MCMASTER-CARR
23	DBT-POP 1207-300-23	Z AXIS COLUMN (3)	1	0	VEETECH
25	GEAR RACK 6295K142	RACK L515-4	1		MCMASTER-CARR
27	DBT-POP 1207-300-27	TH LOCK NUT	1	0	VEETECH
28	DBT-POP 1207-300-28	PIVOT BLOCK	1	0	VEETECH
29	DBT-POP 1207-300-29	Z AXIS SHAFT	1	0	VEETECH
31	TAPERED ROLLER BEARING	5709K19	2		MCMASTER-CARR

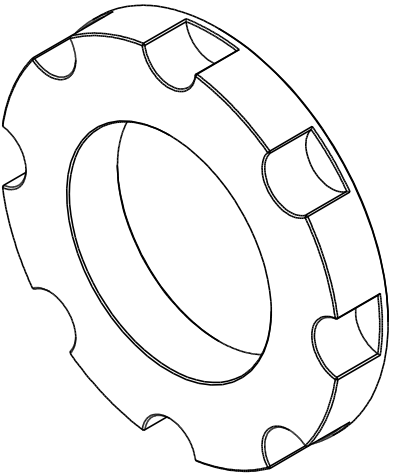
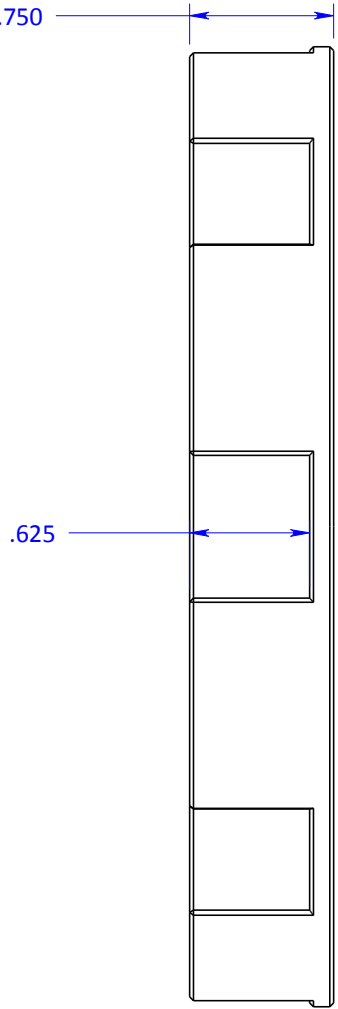
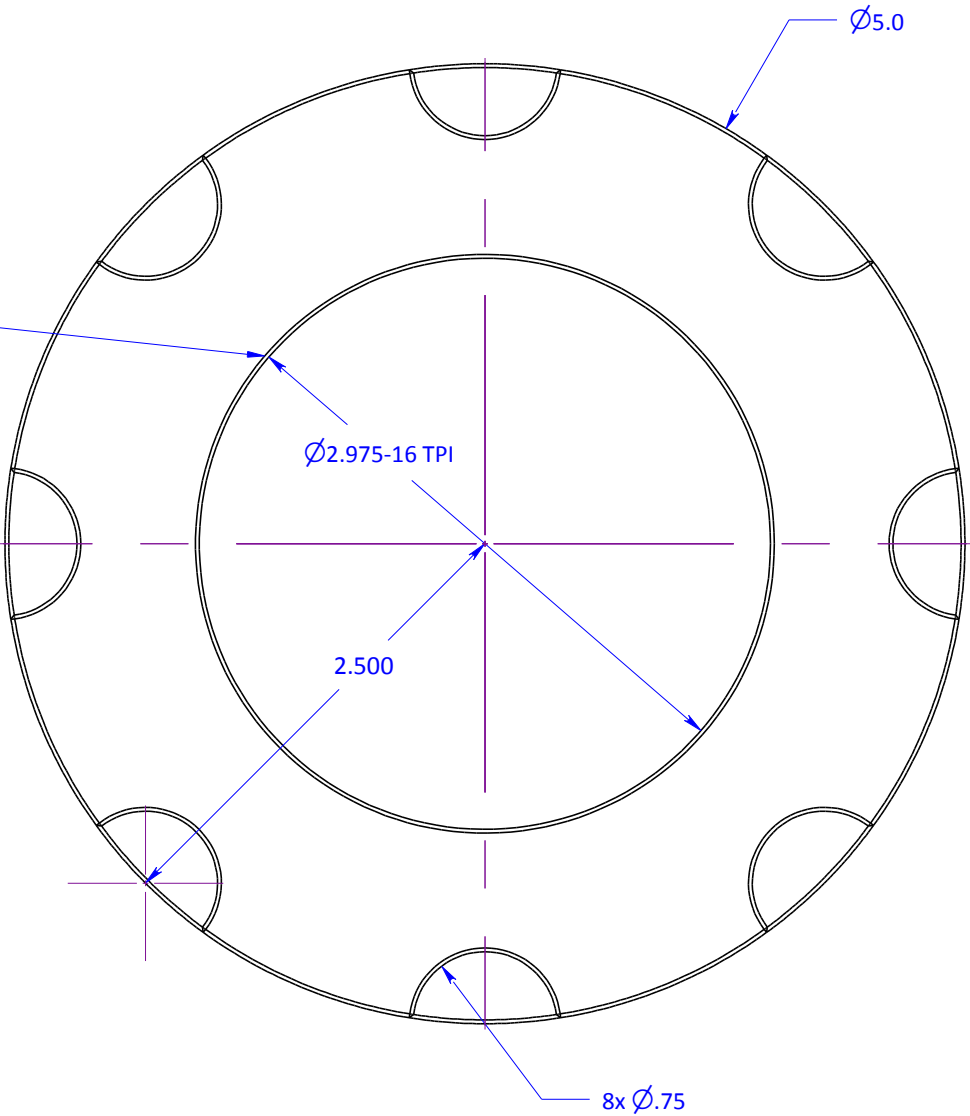


QTY RQ'D	PROJECT	FOR ASSEMBLY		
1	DRAG FINISHER	Z AXIS		
	HEAT TREAT	COATING	MATERIAL	WEIGHT
	NONE	NONE		

FINISH ALL OVER Ra125
BREAK EDGES 0.02/ 0.04
0.0 `` 0.010"
0.00 `` 0.005"
0.000 `` 0.001"
0.0000 `` 0.0005"
FRACTIONAL `` 1/16

DWG No.	DBT-POP 1207-300-00		REV
PART No.			REV DATE (DMY)
PART NAME	Z AXIS ASSY		
DRAWN	SCALE	CREATED (DMY)	SHEET
CFW	NTS	01/11/2012	1 OF 1
DEBOER TOOL INC. CONTACT C WETERBY 647-393-8030			

THREAD ID AND PITCH IS NON-STANDARD
MATCH JAM NUT THREAD TO Z AXIS COLUMN
MAKE Z AXIS COLUMN BEFORE JAM NUT

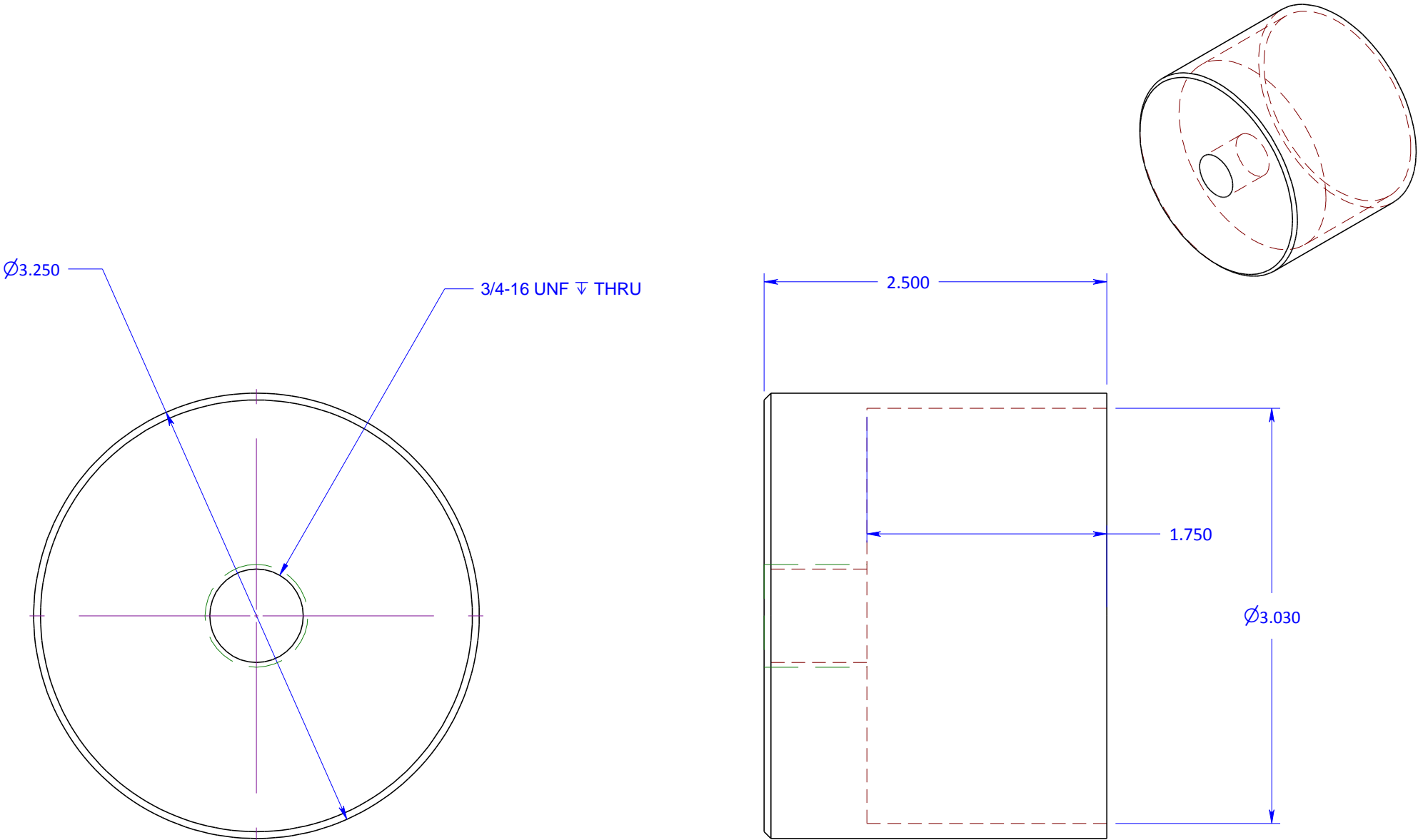


FINISH ALL OVER Ra125
BREAK EDGES 0.02/ 0.04

0.0 `` 0.010"
0.00 `` 0.005"
0.000 `` 0.001"
0.0000 ``0.0005"
FRACTIONAL ``1/16

DWG No. DBT-POP 1207-300--02			REV 0
PART No.			REV DATE (DMY)
PART NAME Z AXIS JAM NUT			
DRAWN CFW	SCALE NTS	CREATED (DMY) 01/11/2012	SHEET 1 OF 1
DEBOER TOOL INC. CONTACT C WETERBY 647-393-8030			

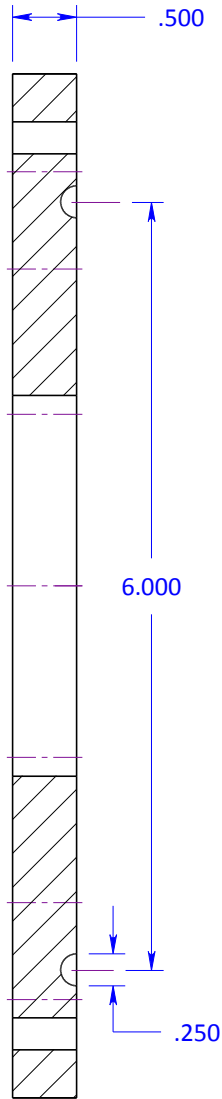
QTY RQ'D 1	PROJECT DRAG FINISHER		FOR ASSEMBLY Z AXIS	
	HEAT TREAT NONE	COATING NONE	MATERIAL 4140 HT	WEIGHT



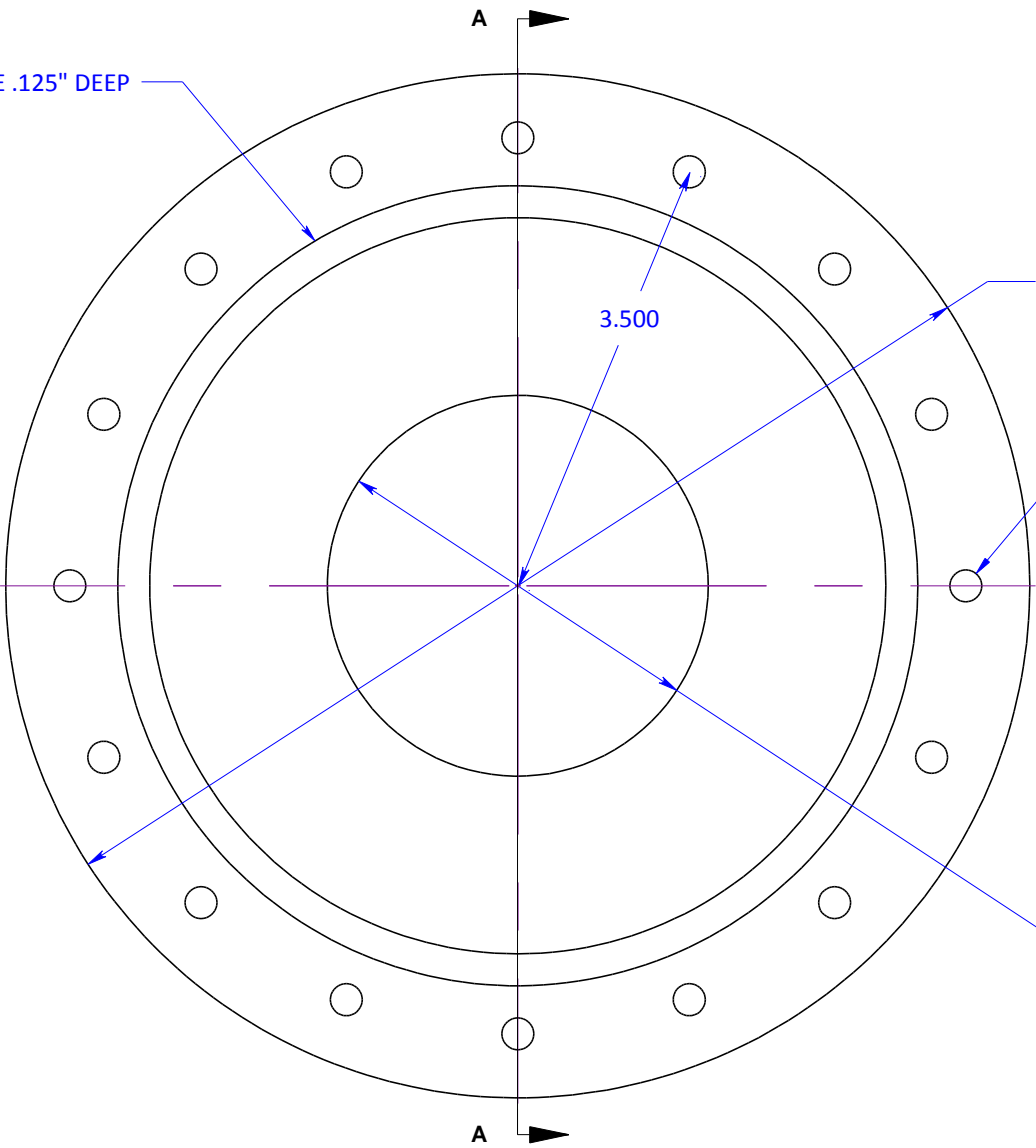
FINISH ALL OVER Ra125
BREAK EDGES 0.02/ 0.04
0.0 `` 0.010"
0.00 `` 0.005"
0.000 `` 0.001"
0.0000 `` 0.0005"
FRACTIONAL `` 1/16

DWG No. DBT-POP 1207-300-03		REV 0
PART No.		REV DATE (DMY)
PART NAME Z AXIS CAP		
DRAWN CFW	SCALE NTS	CREATED (DMY) 01/11/2012
SHEET 1 OF 1		
DEBOER TOOL INC. CONTACT C WETERBY 647-393-8030		

QTY RQ'D 1	PROJECT DRAG FINISHER		FOR ASSEMBLY Z AXIS	
	HEAT TREAT NONE	COATING NONE	MATERIAL 6061 T6 ALUMINUM	WEIGHT



O-RING GROOVE .125" DEEP

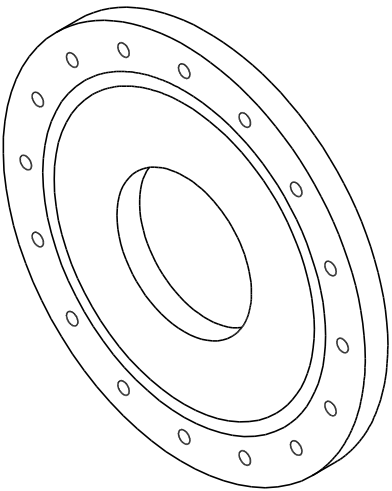


Ø8.0

16x Ø.250+ THRU EQU SPACED
CLOSE SLIP FIT FOR DOWEL

Ø2.975-16 TPI

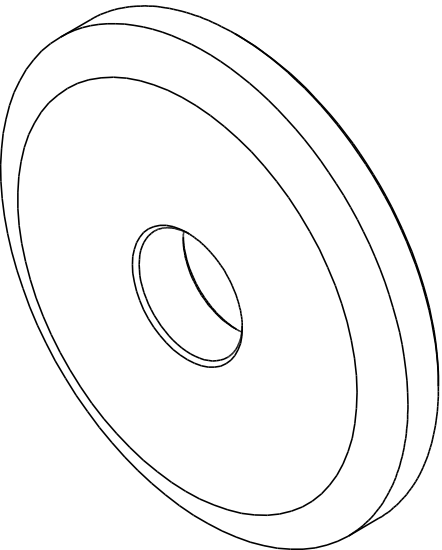
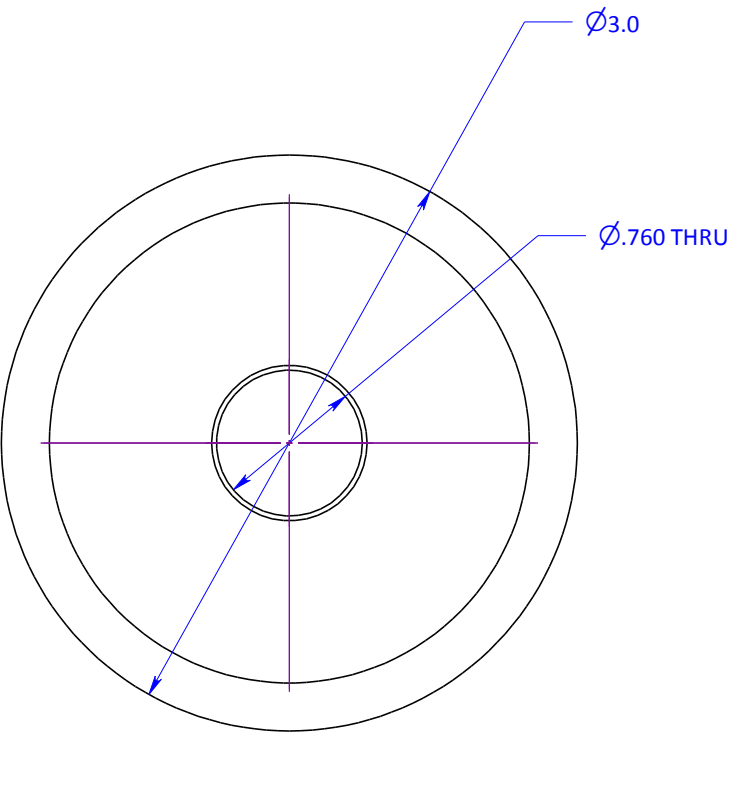
NOTE:
MAKE AFTER Z AXIS COLUMN
THIS INDEX PLATE ASSEMBLES WITH Z AXIS COLUMN.
CUT 2.975-16 TPI NON-STANDARD THREAD TO FIT COLUMN



FINISH ALL OVER Ra125
BREAK EDGES 0.02/ 0.04
0.0 `` 0.010"
0.00 `` 0.005"
0.000 `` 0.001"
0.0000 `` 0.0005"
FRACTIONAL `` 1/16

DWG No.	DBT-POP 1207-300-09			REV	0
PART No.				REV DATE (DMY)	
PART NAME					
Z AXIS INDEX PLATE					
DRAWN	SCALE	CREATED (DMY)		SHEET	
CFW	NTS	01/11/2012		1 OF 1	
DEBOER TOOL INC.					
CONTACT C WETERBY 647-393-8030					

QTY RQ'D	PROJECT		FOR ASSEMBLY	
	DRAG FINISHER		Z AXIS	
	HEAT TREAT	COATING	MATERIAL	WEIGHT
1	NONE	NONE	6061 T6 ALUMINUM	

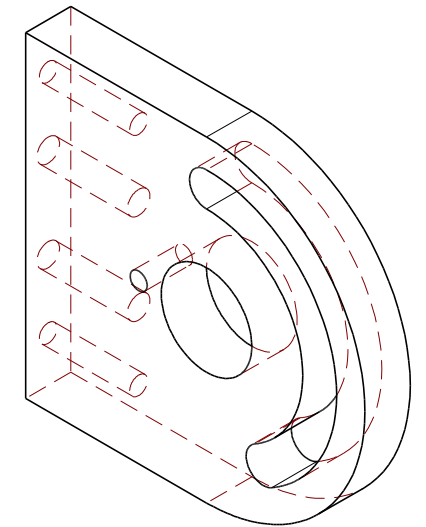
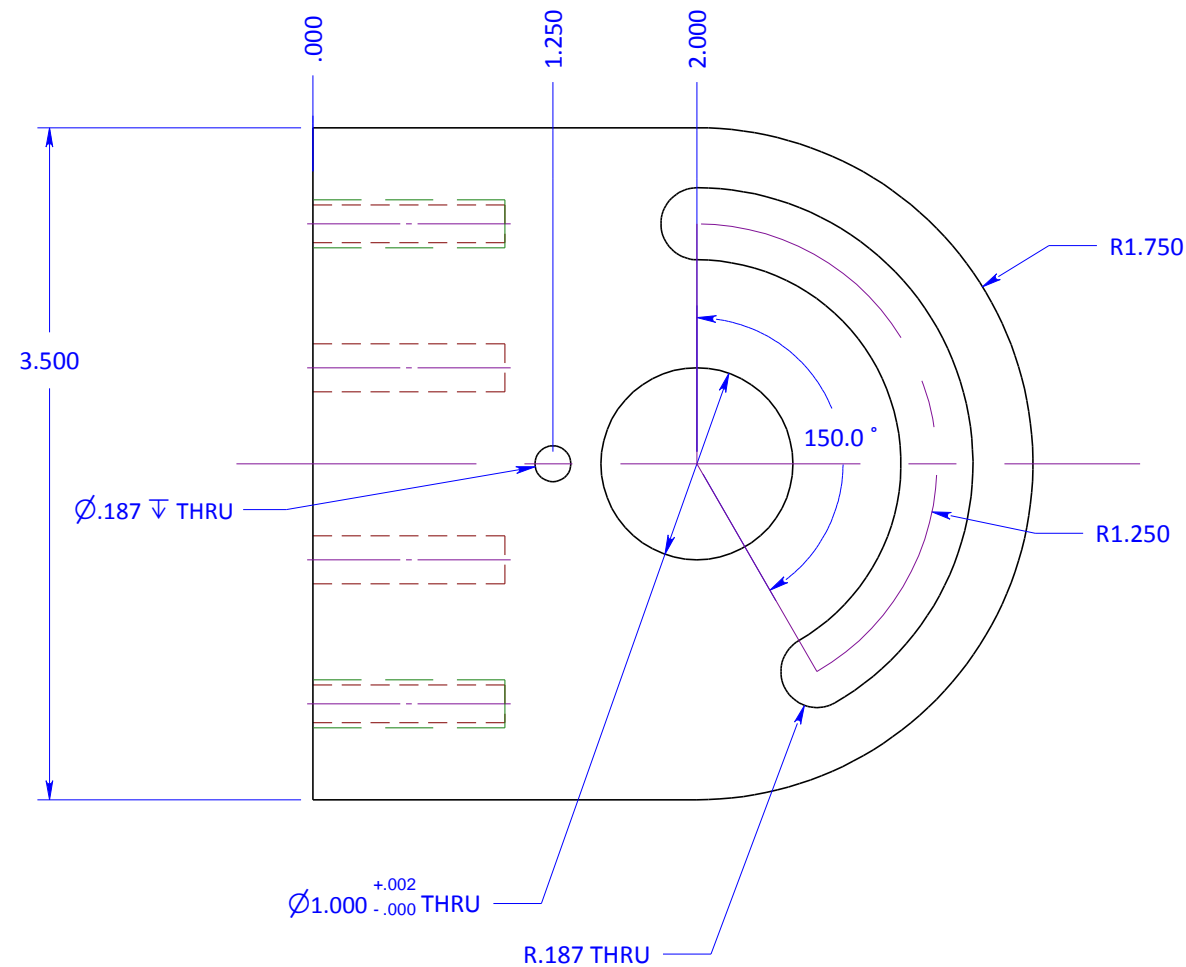
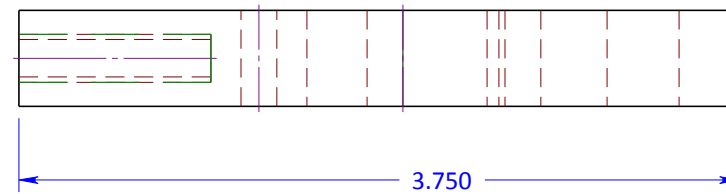
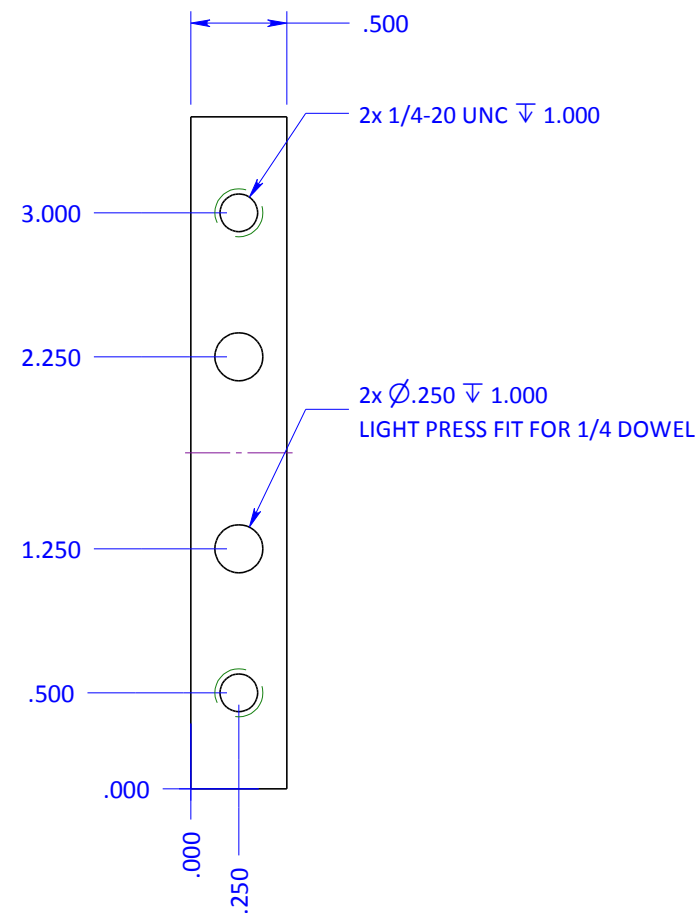


FINISH ALL OVER Ra125
BREAK EDGES 0.02/ 0.04

0.0 `` 0.010"
0.00 `` 0.005"
0.000 `` 0.001"
0.0000 `` 0.0005"
FRACTIONAL `` 1/16

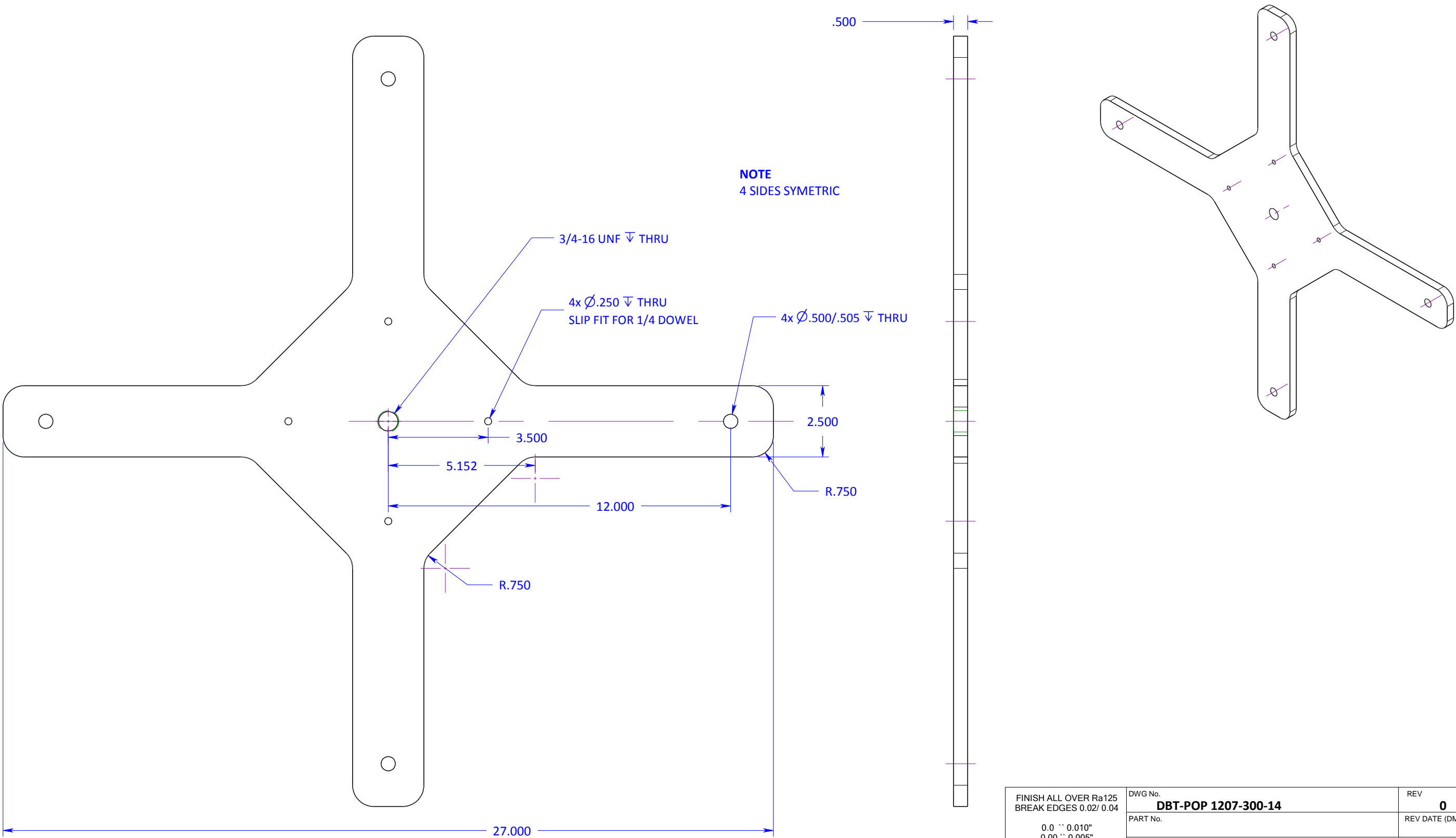
DWG No. DBT-POP 1207-300-10			REV 0
PART No.			REV DATE (DMY)
PART NAME Z BASE WASHER			
DRAWN CFW	SCALE NTS	CREATED (DMY) 01/11/2012	SHEET 1 OF 1
DEBOER TOOL INC. CONTACT C WETERBY 647-393-8030			

QTY RQ'D 1	PROJECT DRAG FINISHER		FOR ASSEMBLY Z AXIS	
	HEAT TREAT NONE	COATING NONE	MATERIAL CRS	WEIGHT



FINISH ALL OVER Ra125 BREAK EDGES 0.02/ 0.04				DWG No. DBT-POP 1207-300-11	REV 0
0.0 `` 0.010" 0.00 `` 0.005" 0.000 `` 0.001" 0.0000 `` 0.0005" FRACTIONAL `` 1/16				PART No.	REV DATE (DMY)
PART NAME PIVOT					
DRAWN CFW	SCALE NTS	CREATED (DMY) 01/11/2012	SHEET 1 OF 1	DEBOER TOOL INC. CONTACT C WETERBY 647-393-8030	

QTY RQ'D 2	PROJECT DRAG FINISHER				
	FOR ASSEMBLY Z AXIS				
	HEAT TREAT NONE	COATING NONE	MATERIAL 6061 T6 ALUMINUM	WEIGHT	



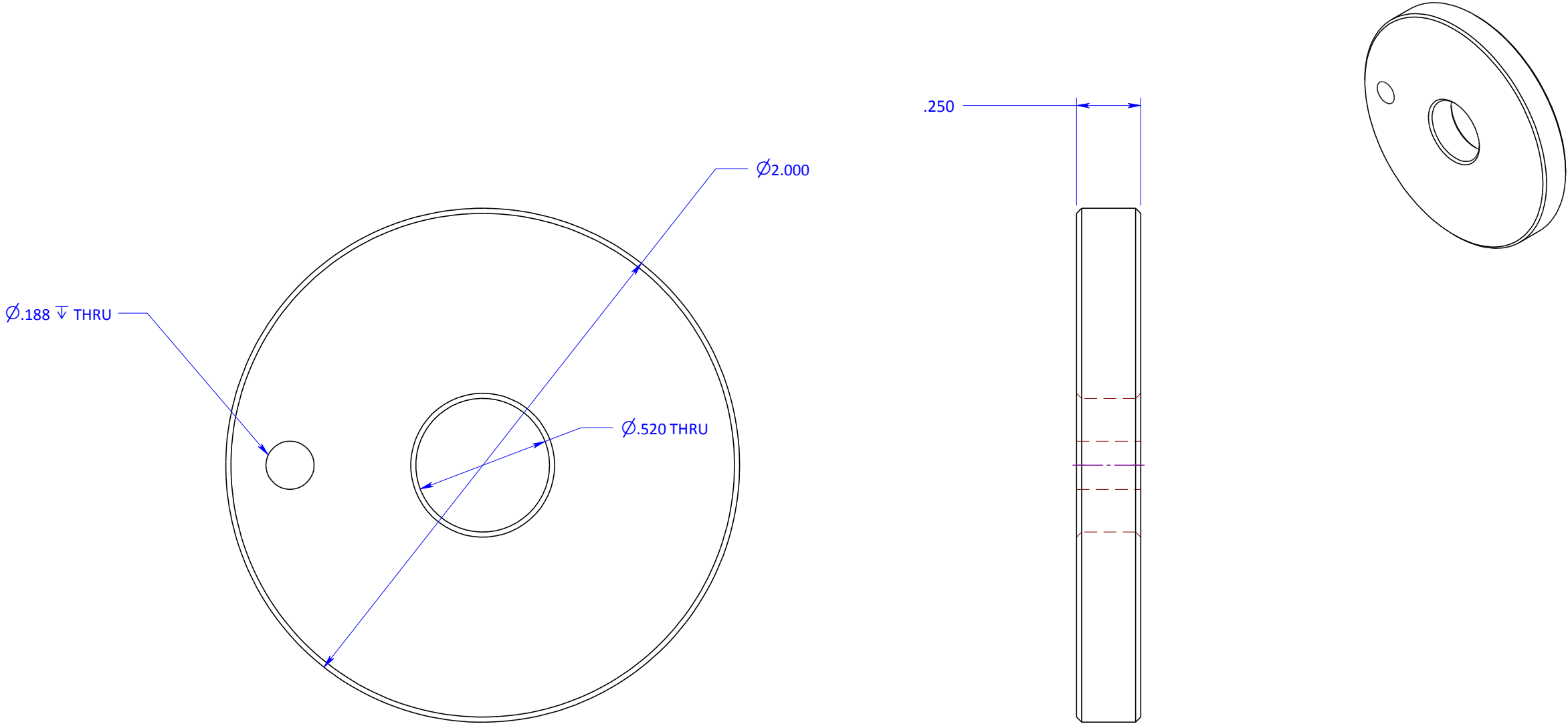
FINISH ALL OVER Ra125
BREAK EDGES 0.02/ 0.04

0.0 `` 0.010"
0.00 `` 0.005"
0.000 `` 0.001"
0.0000 `` 0.0005"
FRACTIONAL `` 1/16

DWG No.	DBT-POP 1207-300-14		REV	0
PART No.			REV DATE (DMY)	
PART NAME	Z BASE (3)			
DRAWN	CFW	SCALE	NTS	CREATED (DMY)
				01/11/2012
SHEET	1 OF 1			

QTY RQ'D	PROJECT		FOR ASSEMBLY	
	DRAG FINISHER		Z AXIS	
	HEAT TREAT	COATING	MATERIAL	WEIGHT
1	NONE	NONE	6061 T6 ALUMINUM	

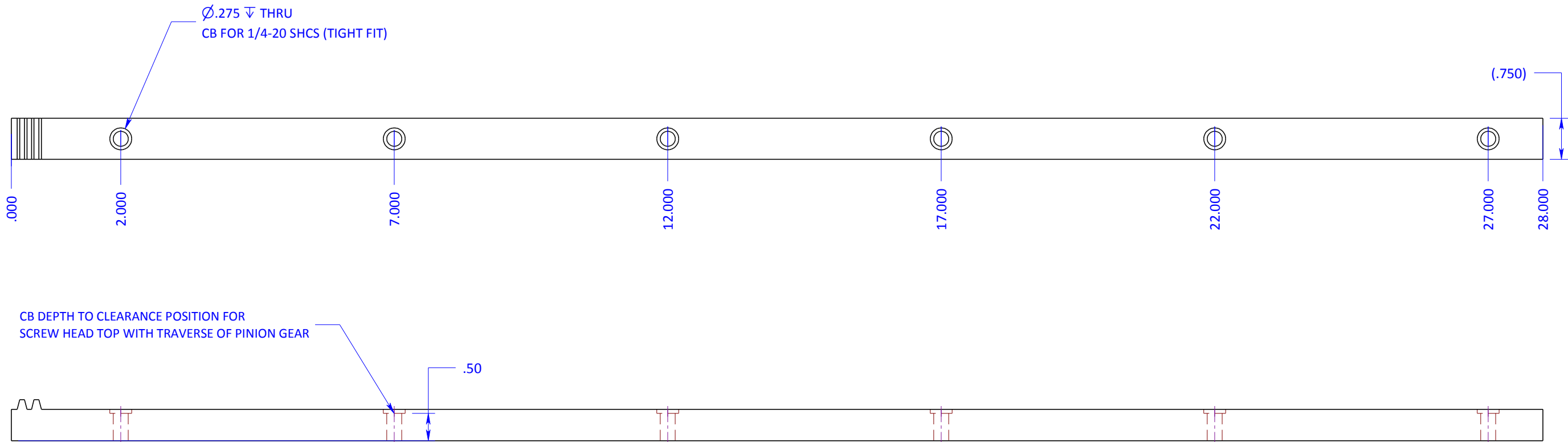
DEBOER TOOL INC.
CONTACT C WETERBY 647-393-8030



			FINISH ALL OVER Ra125 BREAK EDGES 0.02/ 0.04		DWG No. DBT-POP 1207-300-19	REV 0
			0.0 `` 0.010" 0.00 `` 0.005" 0.000 `` 0.001" 0.0000 `` 0.0005" FRACTIONAL `` 1/16		PART No.	REV DATE (DMY)
					PART NAME TH PIVOT WASHER	
QTY RQ'D			PROJECT		DRAWN	SHEET
			FOR ASSEMBLY		CFW	NTS
					CREATED (DMY) 01/11/2012	
					1 OF 1	



					FINISH ALL OVER Ra125 BREAK EDGES 0.02/ 0.04		DWG No. DBT-POP 1207-300-23		REV 0					
					0.0 `` 0.010" 0.00 `` 0.005" 0.000 `` 0.001" 0.0000 ``0.0005" FRACTIONAL ``1/16		PART No.		REV DATE (DMY)					
							PART NAME Z AXIS COLUMN (3)							
QTY RQ'D					PROJECT		SCALE		CREATED (DMY)		SHEET			
1					DRAG FINISHER		CFW		NTS		01/11/2012		1 OF 1	
					FOR ASSEMBLY									
					Z AXIS									
					HEAT TREAT		COATING		MATERIAL		WEIGHT			
					NONE		NONE		STEEL TUBE- DOM					
					DEBOER TOOL INC. CONTACT C WETERBY 647-393-8030									



FINISH ALL OVER Ra125
BREAK EDGES 0.02/ 0.04

0.0 `` 0.010"
0.00 `` 0.005"
0.000 `` 0.001"
0.0000 `` 0.0005"
FRACTIONAL `` 1/16

DWG No. DBT-POP 1207-300-25			REV
PART No.			REV DATE (DMY)
PART NAME RACK L515-4			
DRAWN CFW	SCALE NTS	CREATED (DMY) 01/11/2012	SHEET 1 OF 1
DEBOER TOOL INC. CONTACT C WETERBY 647-393-8030			

QTY RQ'D	PROJECT		FOR ASSEMBLY	
	DRAG FINISHER		Z AXIS	
	HEAT TREAT NONE	COATING NONE	MATERIAL	WEIGHT

Ø.1875 ∇ THRU
LPF 3/16 DOWEL

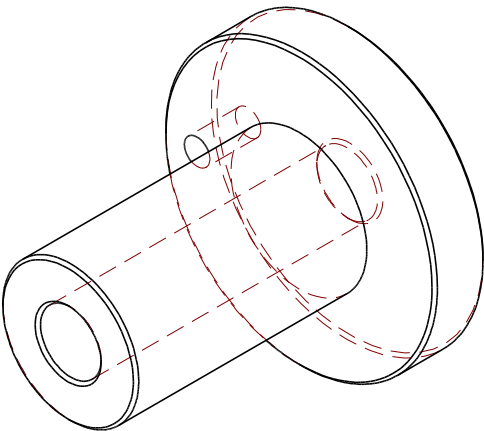
Ø2.0

1/2-20 UNF ∇ THRU

Ø1.000 ^{+0.000}
- .001

2.075

.375

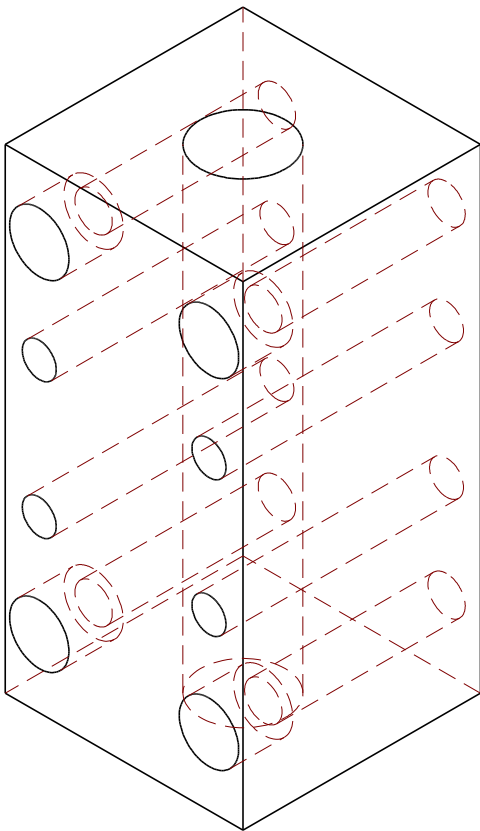
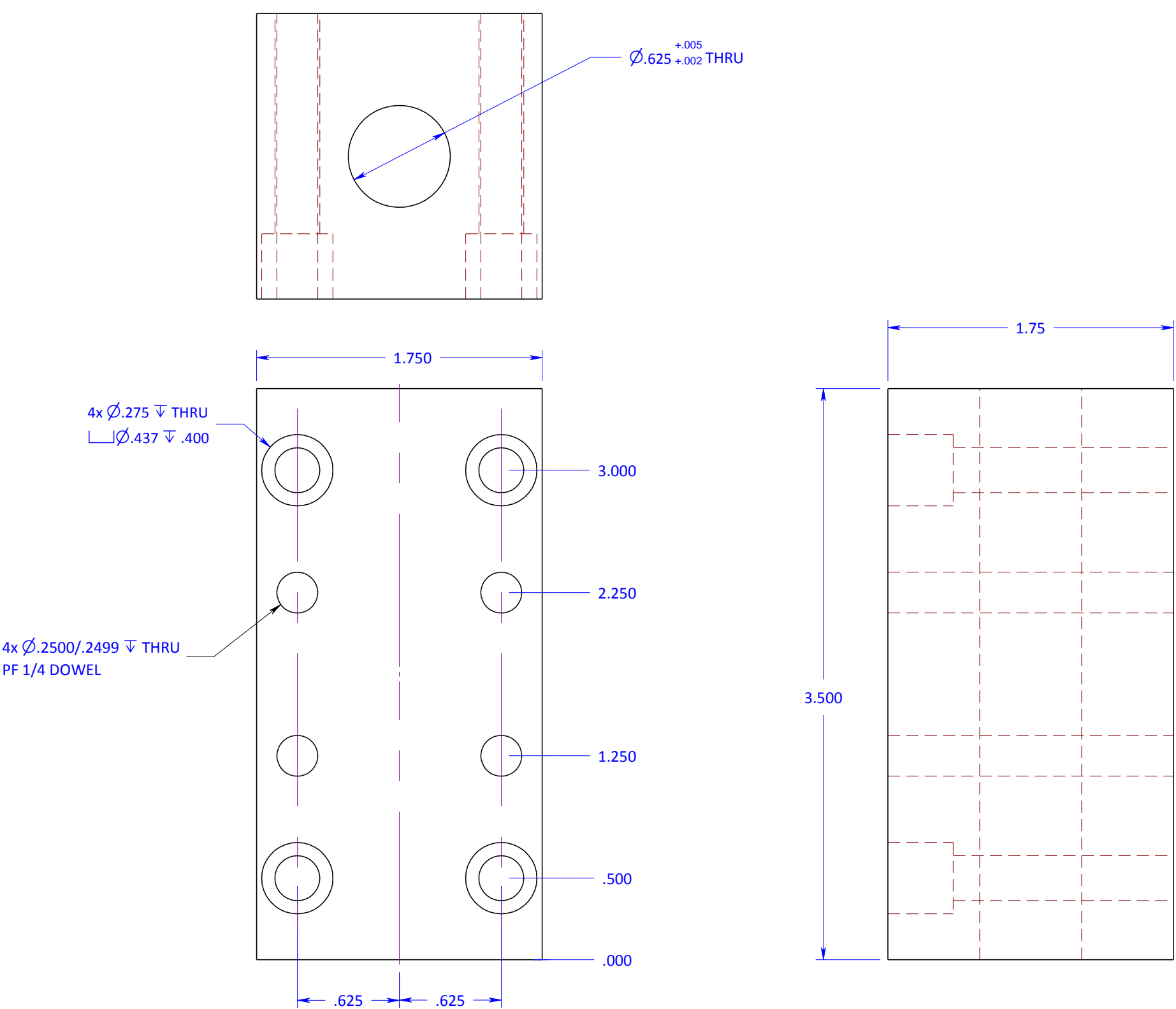


FINISH ALL OVER Ra125
BREAK EDGES 0.02/ 0.04

0.0 `` 0.010"
0.00 `` 0.005"
0.000 `` 0.001"
0.0000 ``0.0005"
FRACTIONAL ``1/16

DWG No. DBT-POP 1207-300-27		REV 0
PART No.		REV DATE (DMY)
PART NAME TH LOCK NUT		
DRAWN CFW	SCALE NTS	CREATED (DMY) 01/11/2012
SHEET 1 OF 1		
DEBOER TOOL INC. CONTACT C WETERBY 647-393-8030		

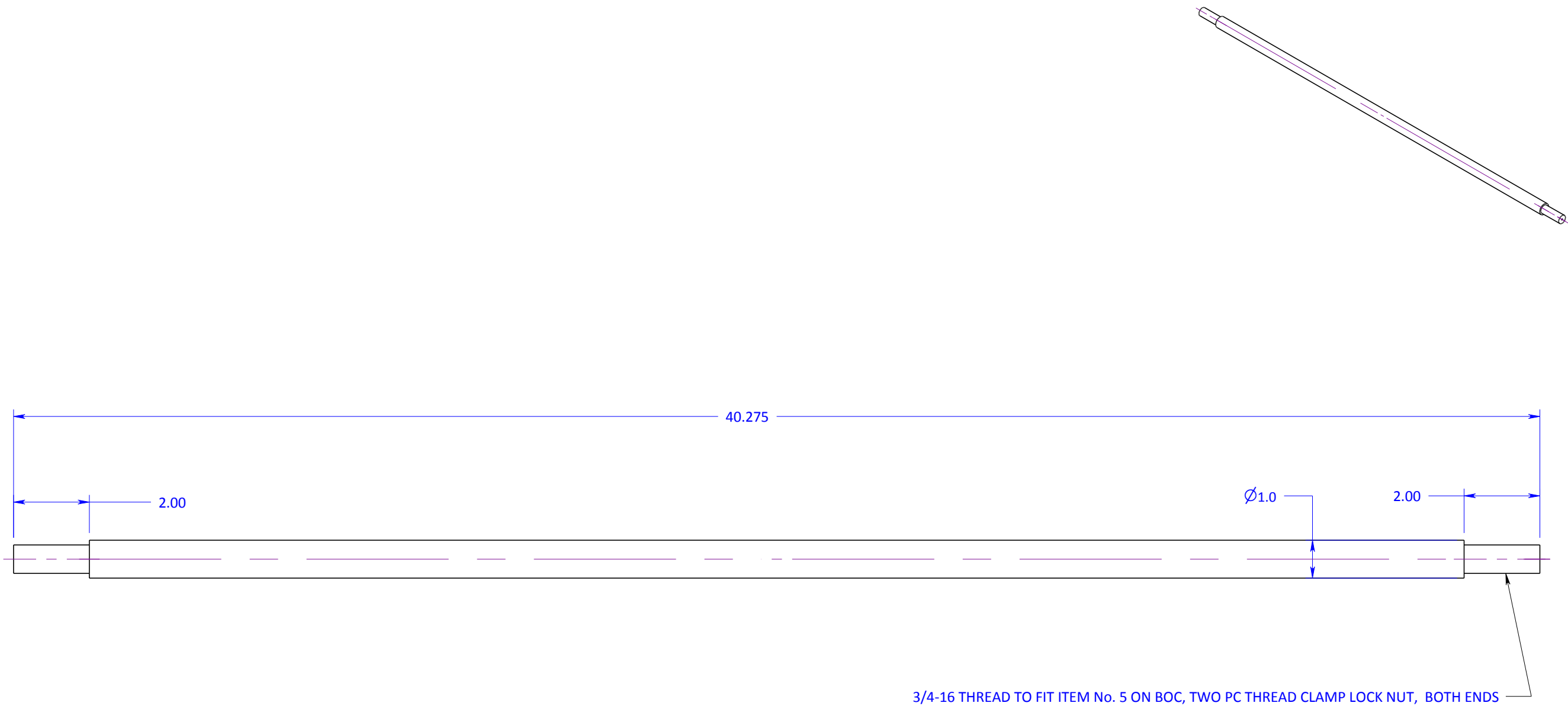
QTY RQ'D 1	PROJECT DRAG FINISHER		FOR ASSEMBLY Z AXIS	
	HEAT TREAT NONE	COATING NONE	MATERIAL 4140 HT	WEIGHT



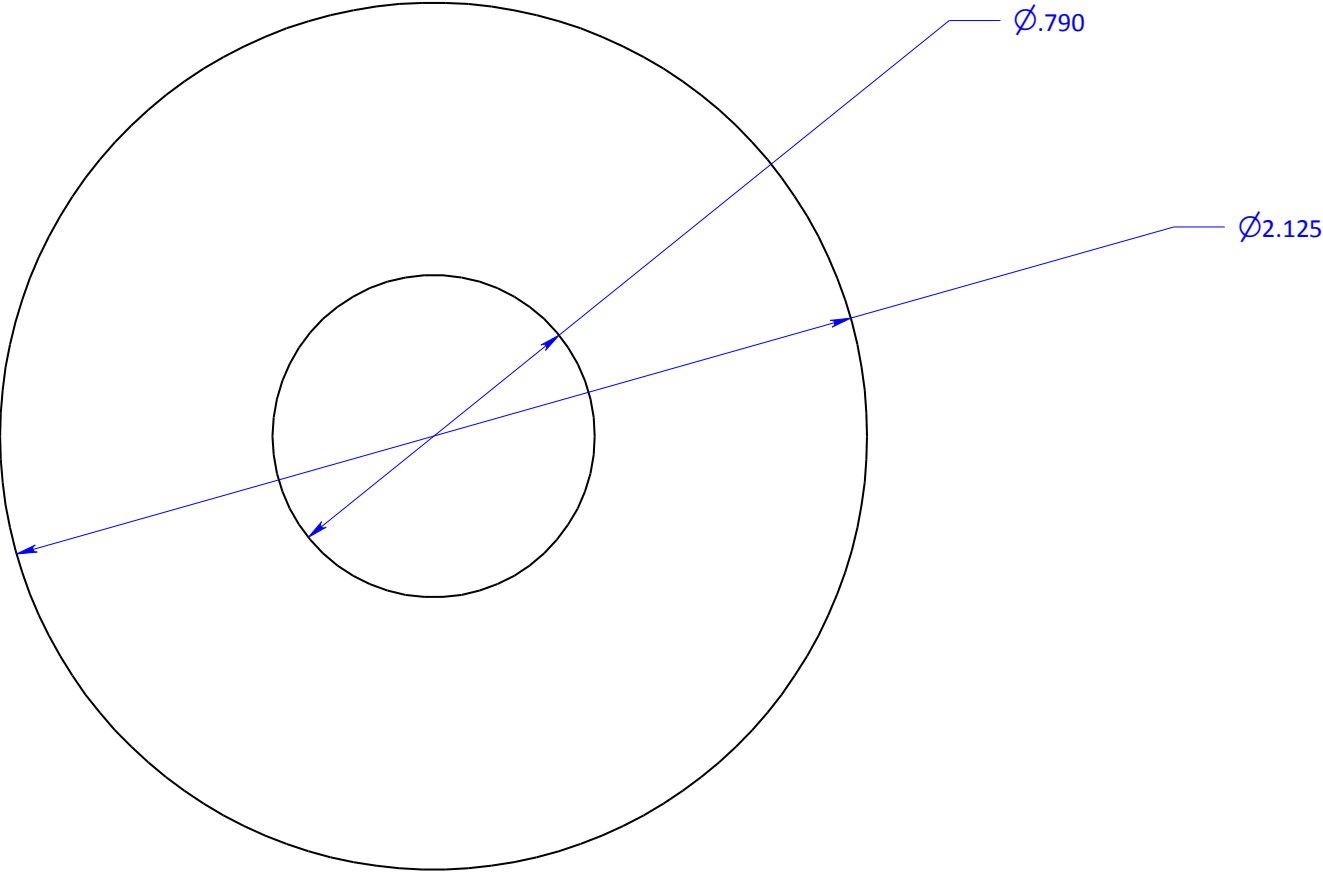
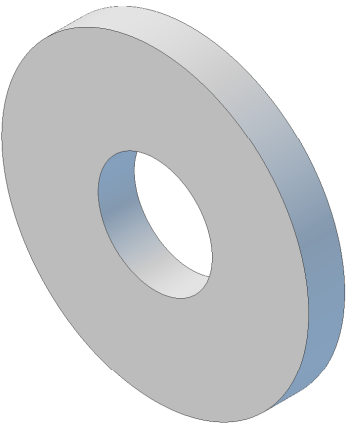
FINISH ALL OVER Ra125
BREAK EDGES 0.02/ 0.04
0.0 `` 0.010"
0.00 `` 0.005"
0.000 `` 0.001"
0.0000 `` 0.0005"
FRACTIONAL `` 1/16

DWG No. DBT-POP 1207-300-28		REV 0	
PART No.		REV DATE (DMY)	
PART NAME PIVOT BLOCK			
DRAWN CFW	SCALE NTS	CREATED (DMY) 01/11/2012	SHEET 1 OF 1
DEBOER TOOL INC. CONTACT C WETERBY 647-393-8030			

QTY RQ'D 1	PROJECT DRAG FINISHER		FOR ASSEMBLY Z AXIS	
	HEAT TREAT NONE	COATING NONE	MATERIAL 6061 T6 ALUMINUM	WEIGHT



<div>QTY RQ'D</div> <div>1</div>					PROJECT					FOR ASSEMBLY					<div>FINISH ALL OVER Ra125 BREAK EDGES 0.02/ 0.04</div> <div>0.0 `` 0.010" 0.00 `` 0.005" 0.000 `` 0.001" 0.0000 ``0.0005" FRACTIONAL ``1/16</div>					<div>DWG No.</div> <div>DBT-POP 1207-300-29</div>					<div>REV</div> <div>0</div>									
					<div>HEAT TREAT</div> <div>NONE</div>					<div>COATING</div> <div>NONE</div>					<div>MATERIAL</div> <div>STEEL - ANY</div>					<div>WEIGHT</div>					PART No.					REV DATE (DMY)				
																									<div>PART NAME</div> <div>Z AXIS SHAFT</div>									
<div>DRAG FINISHER</div> <div>Z AXIS</div>					<div>SCALE</div> <div>NTS</div>					<div>CREATED (DMY)</div> <div>01/11/2012</div>					<div>SHEET</div> <div>1 OF 1</div>					<div>DRAWN</div> <div>CFW</div>														
																				<div>DEBOER TOOL INC.</div> <div>CONTACT C WETERBY 647-393-8030</div>														



				FINISH ALL OVER Ra125 BREAK EDGES 0.02/ 0.04		DWG No. DBT-POP 1207-300-32		REV	
				0.0 `` 0.010" 0.00 `` 0.005" 0.000 `` 0.001" 0.0000 ``0.0005" FRACTIONAL ``1/16		PART No.		REV DATE (DMY)	
						PART NAME Z AXIS SHAFT LOWER BEARING SPACER			
QTY RQ'D		PROJECT		FOR ASSEMBLY		DRAWN	SCALE	CREATED (DMY)	SHEET
2		DRAG FINISHER		Z AXIS		CFW	NTS	06-MAY-13	1 OF 1
		HEAT TREAT	COATING	MATERIAL				DEBOER TOOL INC. CONTACT C WETERBY 647-393-8030	
		NONE	NONE	STEEL, ANY					
				WEIGHT					