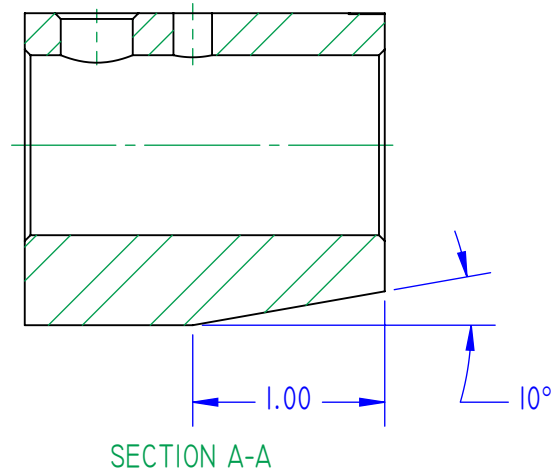
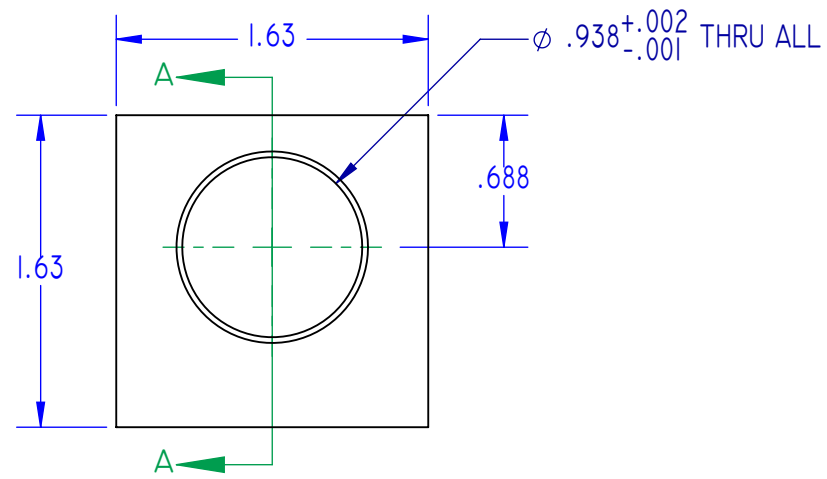
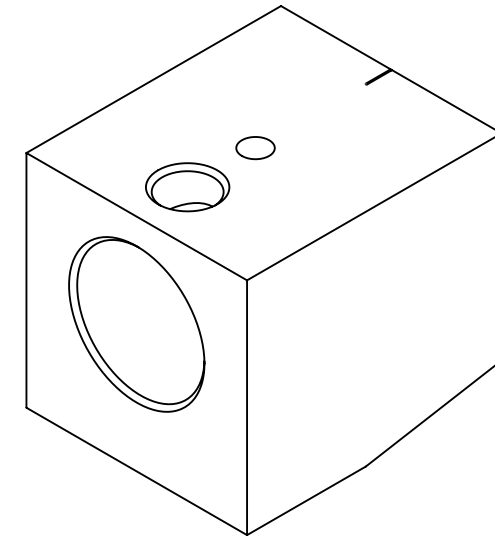
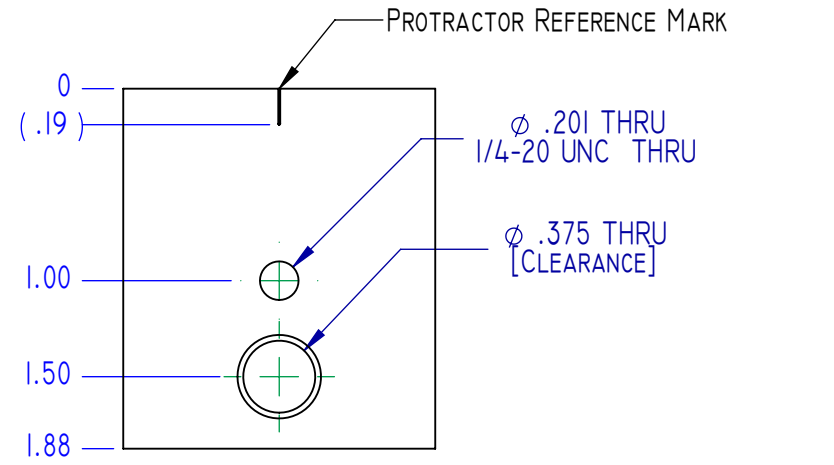


DESIGN BASED ON SOUTH BEND CE2168 GRINDING BLOCK

DWG NO. AS4635-1 REV A

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	Released	4/7/2022	Mr. P



NOTES: UNLESS OTHERWISE SPECIFIED:

1. MATERIAL: ALLOY STEEL
2. FINISH: NONE
3. REMOVE ALL BURRS AND SHARP EDGES; RADIUS OR CHAMFER.
4. PART IS TO BE FREE OF ALL FOREIGN MATERIAL; I.E. WELD SPATTER, DIRT, GREASE.

PROJECT: MP222
N/A
CONTRACT NO.: N/A

DRAWING INTENDED FOR REFERENCE PURPOSES ONLY. REFER TO MODEL FOR DETAILS.

CHECKED BY: *Lyle Peterson* DATE: 4/7/2022

TOLERANCING XX ±0.01 FRACTIONAL: N/A
XXX ±0.003 ANGULAR: ± 1/2°
XXXX ±0.0005

DRAWN BY: DAEN C. HENDRICKSON DATE: 4/4/2022

SIZE DESCRIPTION: B BLOCK, CUTTER BIT GRINDING FIXTURE

DWG TYPE M DWG NO. AS4635-1 REVISION A

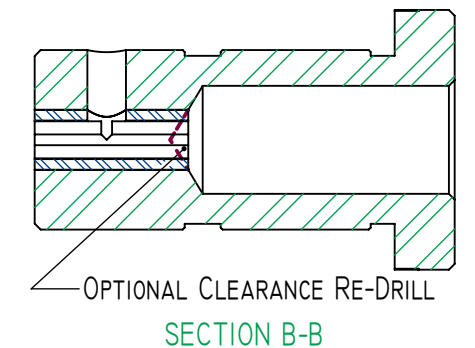
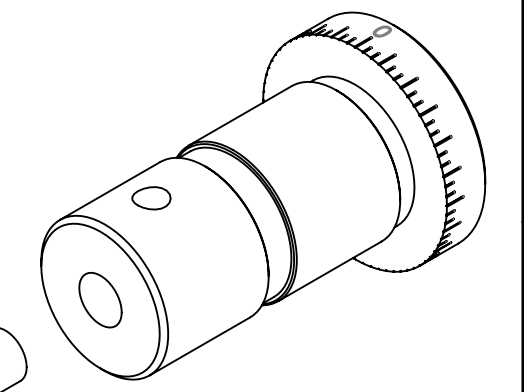
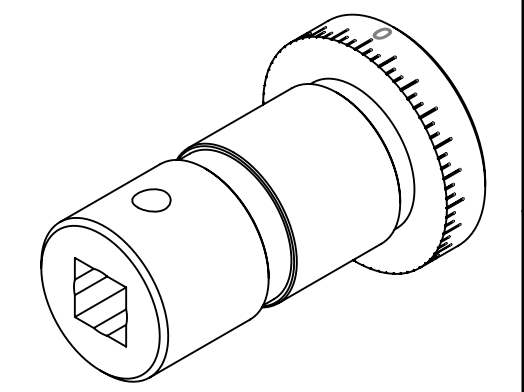
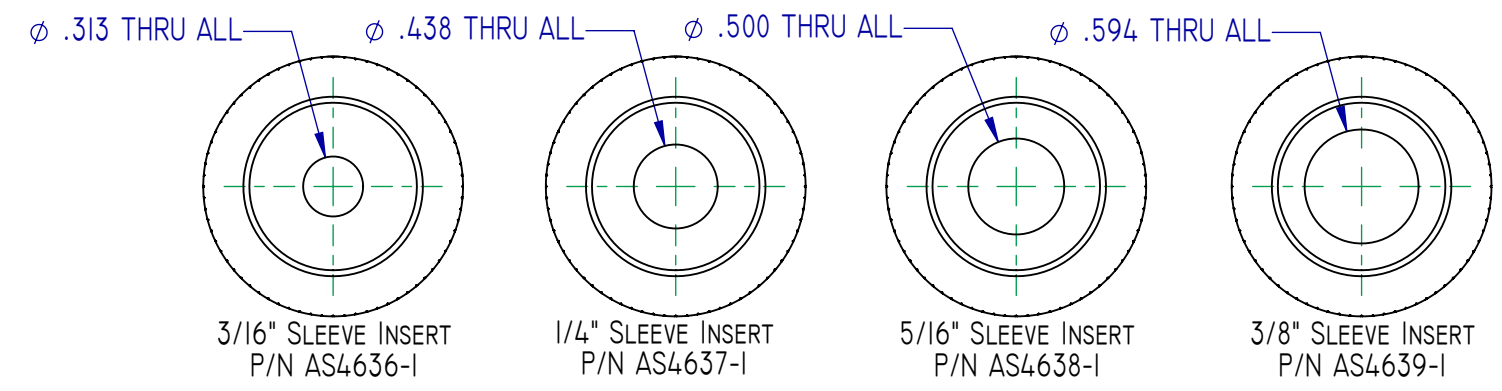
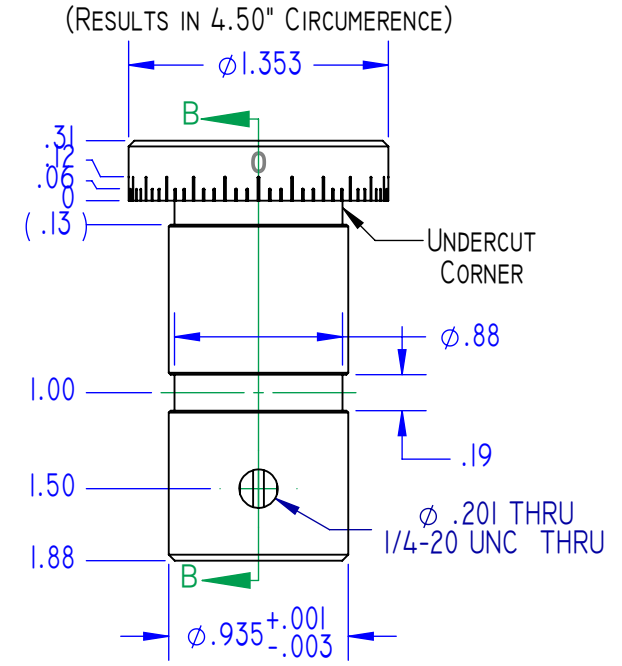
U.O.M.: INCHES [MM] SCALE 1:1 SHEET 1 OF 1

AS4635-1

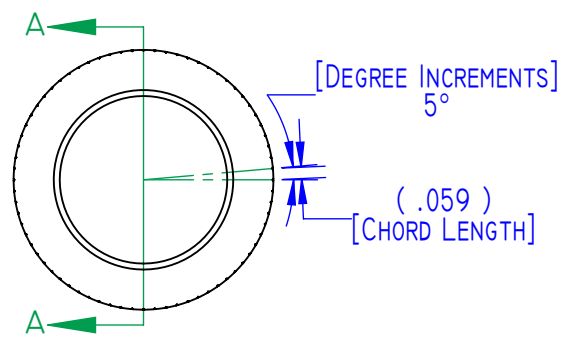
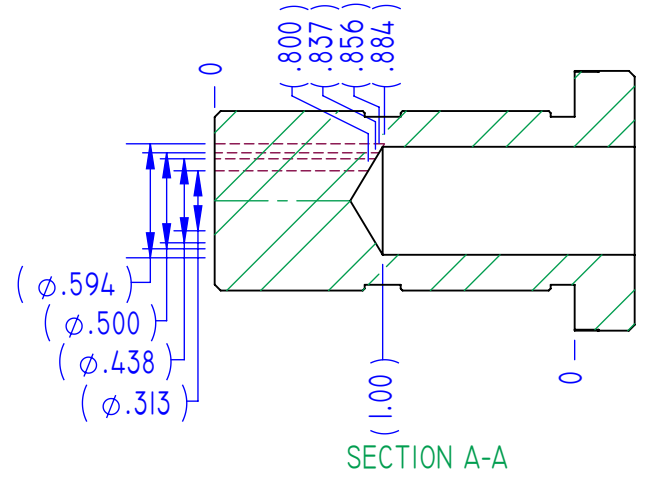
DESIGN BASED ON SOUTH BEND CE2168 GRINDING BLOCK

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	Released	4/7/2022	Mr. P

- SQUARE HOLE NOTES:**
1. USE APPROPRIATE SIZED SQUARE BROACHES IF AVAILABLE. OTHERWISE...
 2. INSTALL SQUARE-HOLED SLEEVES MANUFACTURED BY OTHERS
 3. TRIM SLEEVE INSERT TO APPROPRIATE LENGTH
 4. DRILL PER MANUFACTURER AND SECURE WITH THREAD LOCKING COMPOUND
 5. CROSS-DRILL AND TAP FOR SET SCREW AFTER INSTALLATION
 6. OPTIONAL: RE-DRILL 9/16" CLEARANCE HOLE TO CREATE TAPERED SHOULDER ON INSERT TO AID IN TOOL BIT INSTALLATION



INSERT LENGTHS @ CLEARANCE DRILL TIP



- NOTES: UNLESS OTHERWISE SPECIFIED:**
1. MATERIAL: ALLOY STEEL
 2. FINISH: NONE
 3. REMOVE ALL BURRS AND SHARP EDGES; RADIUS OR CHAMFER.
 4. PART IS TO BE FREE OF ALL FOREIGN MATERIAL; I.E. WELD SPATTER, DIRT, GREASE.

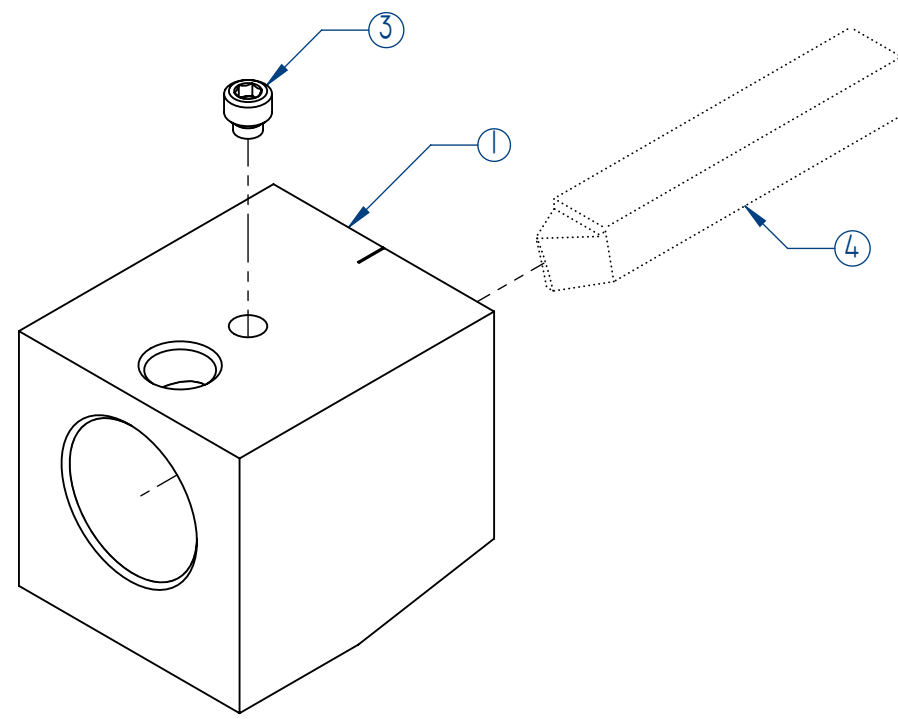
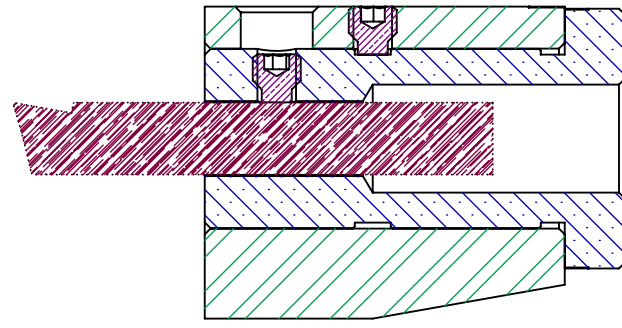
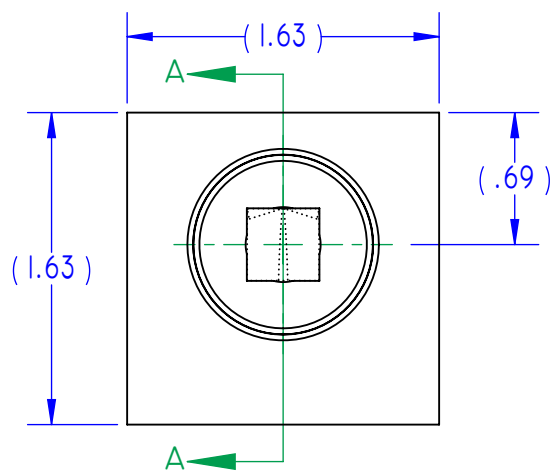
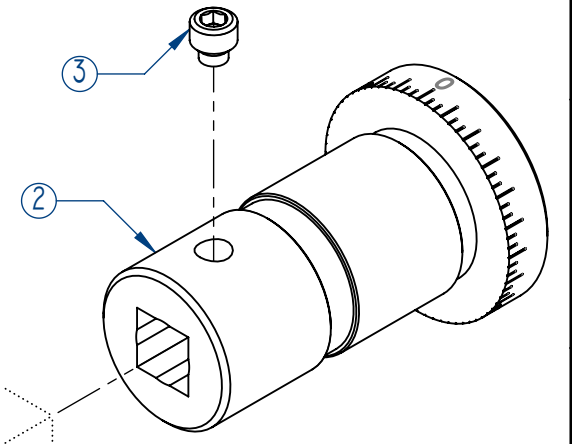
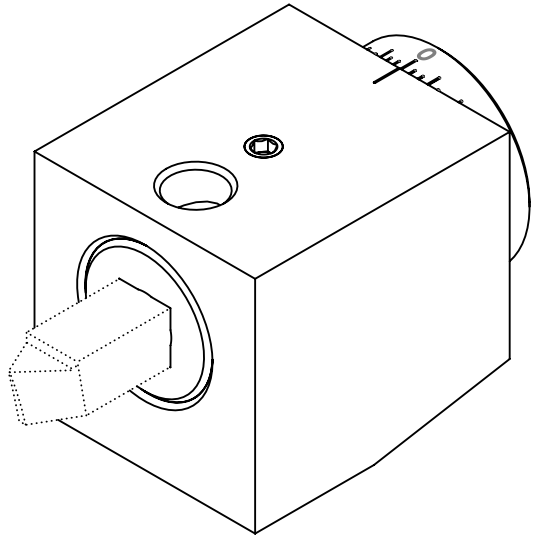
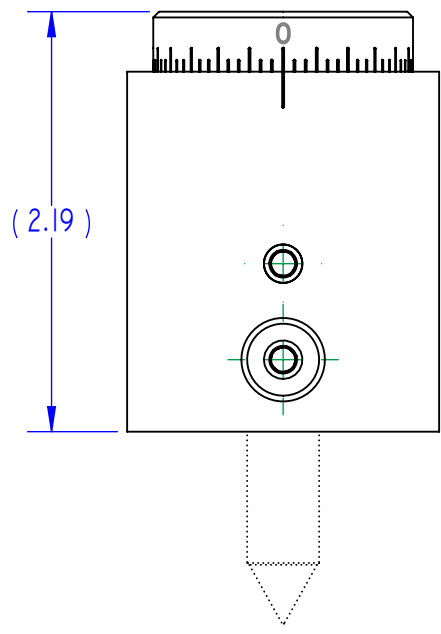
PART NO.	DESCRIPTION
2200-14	SLEEVE, 3/8" SQUARE
2200-13	SLEEVE, 5/16" SQUARE
2200-12	SLEEVE, 1/4" SQUARE
2200-11	SLEEVE, 3/16" SQUARE
GREENBAY MFG SQUARE-HOLED SLEEVES	

PROJECT: MP222	DRAWING INTENDED FOR REFERENCE PURPOSES ONLY. REFER TO MODEL FOR DETAILS.	CHECKED BY: <i>Lyle Peterson</i>	DATE: 4/7/2022
N/A	TOLERANCING: XX ±0.01 FRACTIONAL: N/A XXX ±0.003 ANGULAR: ± 1/2° XXXX ±0.0005	DRAWN BY: DAEN C. HENDRICKSON	DATE: 4/6/2022
CONTRACT NO.: N/A	DWG TYPE: M	DWG NO.: AS463x-I	REVISION: A

SIZE: B	DESCRIPTION: SLEEVE, TOOL BIT	DWG NO.: AS463x-I	REVISION: A
U.O.M.: INCHES [MM]		SCALE: 1:1	SHEET: 1 OF 1

DESIGN BASED ON SOUTH BEND CE2168 GRINDING BLOCK

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	Released	4/7/2022	Mr. P



SECTION A-A

- NOTES: UNLESS OTHERWISE SPECIFIED:
1. MATERIAL: SEE BOM
 2. FINISH: N/A
 3. REMOVE ALL BURRS AND SHARP EDGES; RADIUS OR CHAMFER.
 4. PART IS TO BE FREE OF ALL FOREIGN MATERIAL; I.E. WELD SPATTER, DIRT, GREASE.

ITEM NO.	NUMBER	DESCRIPTION	MATERIAL	QTY
4	n/n	Tool Bit, HSS	Alloy Steel	1
3	92845A528	SET SCREW, 1/4-20 x 1/4, Hex Socket, 0.156 Dog Point	18-8 Stainless Steel	2
2	AS463x-1	SLEEVE, Tool Bit	Alloy Steel	1
1	AS4635-1	BLOCK, Cutter Bit Grinding Fixture	Alloy Steel	1

PROJECT: MP222	DRAWING INTENDED FOR REFERENCE PURPOSES ONLY. REFER TO MODEL FOR DETAILS.	CHECKED BY: <i>Lyle Peterson</i>	DATE: 4/7/2022
N/A	TOLERANCING: XX ±0.01 FRACTIONAL: N/A XXX ±0.003 ANGULAR: ± 1/2° XXXX ±0.0005	DRAWN BY: DAEN C. HENDRICKSON	DATE: 4/4/2022
CONTRACT NO.: N/A			