NOTE:
PRIOR TO MACHINING - WELD SHOP MUST CHECK WITH ENGINEERING TO ASCERTAIN WHETHER ANY ADDITIONAL MATERIAL IS REQD. FOR SETWORKS BRACKET SUPPORTS.

FABRICATING PROCEDURE:-
1. FABRICATE FRAME C/W. RAILS.
2. STRESS RELIEVE.
3. ROUGH MACHINE. (SEE MACHINING NOTE)
4. STRESS RELIEVE.
5. FINISH MACHINE. (SEE MACHINING NOTE.)

MACHINING NOTE:-
MACHINE FLAT RAIL & THEN MACHINE VEE RAIL UNTILL THE GAUGE BLOCKS ARE PARALLEL & FLAT WITHIN .002" OVER LENGTH OF RAIL. A SET OF GAUGE BLOCKS (SEE DWG C-12073) MUST BE USED TO MACHINE SUB BASE.

NOTE:
FOR MK 4. BALLSCREW SETWORKS ONLY.

4" x 3" x 1/4" WALL RECT. MECH. TUBE x 24 LG. TOP & BOTTOM 2 REQ /CORNER (TOTAL REQ: 16)

14WF 38 x 54 13/16 LG. 2 REQD.

1/4" RAD. END OF RAIL.

SECTION A-A
(TYP BOTH ENDS OF SUB BASE)

F.B. 6" x 3/4" x 12" 4 REQD.

SUB BASE

SETWORKS BRKT

BANDMILL WHEELS

DRILL & TAP 3/4" N.C. FOR JACKING BOLTS - 18 PLACES SHOWN THUS ●

DRILL 7/8" DIA. HOLES FOR 3/4" DIA ANCHOR BOLTS - 22 PLACES SHOWN THUS O

F.B. 6" x 3/4" x 6" 8 REQD.

14WF 38. TYP.

F.B. 3" x 3/8" x 17" LG.

F.B. 3" x 3/8" x 15 3/4" LG. TOTAL REQ: 8

F.B. 3" x 3/8" x 17" LG.

VIEW B-B
(SIMILAR 4 PLACES)
SCALE: 1 1/2 = 1'-0

DRILL 11/16" Ø 4 HOLES (TYP. 4 PLACES) FOR MECH. STOP DWG. # D/16283

WITNESS FACE FOR BANDMILL ALIGNMENT. (MUST BE ON INSIDE OF SUB BASE)

#24 x 4" x 18.4 #2 REQ A-36 OR BETTER.

SECTION C-C
SCALE: 3" = 1'-0"

F.B. 3" x 3/8" x 17" LG. (TOTAL REQ: 2+) STIFFENER PATTERN DUPLICATED ON FAR SIDE OF OPPOSITE WF.

1/4" MACH. ALLOW.

VIEW ON 'X'

5/8" ALLOW

7/8Ø DRILL 2-HOLES (PER BRKT)

DRILL & TAP 3/4-10 NC 2-HOLES PER BRKT FOR 3/4" Ø TACKING SCREWS

SECTION D-D
SCALE: 3" = 1'-0"

F.B. 3" x 3/8" x 13" LG. (TOTAL REQ: 2+)

#8 3" x 12" x 43 LG 2 REQD - A36 OR BETTER

#3 1/2" x 22" x 36" - 4 REQ.

#1" x 3" x 30" C.H.T 100 - 4 REQ (WEAR PL - SEE SECN C-C)

2" Ø BALL (2 REQ) OR 1/2" GUAGE PIN

WITNESS FACE

GAUGE BLOCK

DETAIL SHOWING METHOD OF GUAGING ANGLE OF VEE RAIL.
SCALE: FULL

#14WF 0.38" x 30 4/16 (4 REQD)

3/4" PL 8" x 26" LG (4 REQD)

1/8" PL 33" x 26" (4 REQD)

FLAT RAIL

VEE RAIL

SETWORKS BRKT

P1 LOG QUAD SUB BASE - 1 REQ PER QUAD.

REV.	DESCRIPTION
RB 7/8/77	15 7/8 DIMN ADDED
DM 7/8/77	SETWORKS SUPPORT 12 1/2" WAS 12" 7/8 WAS 1"
REV RB 4 JUN 15	4 - 3/4"Ø - 10 NC HOLES WAS 6 1/2"Ø - 13 NC HOLES ADDED.
REV RE	5 1/2" WAS 4 1/2"

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LETSON 5 FT. BANDMILL
MODEL HSA-1
LOG QUAD SUB BASE DETAIL

REV.	REF.
APPROVED	QUOTE NO.
CHECKED	
DRAWN	DATE
SCALE 3/4" = 1'-0"	
B.M.	
W.O.	

LETSON & BURPEE LTD.
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