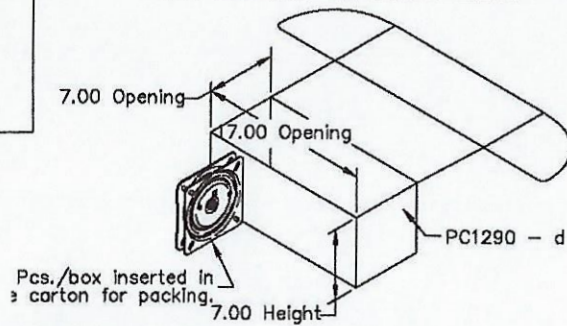


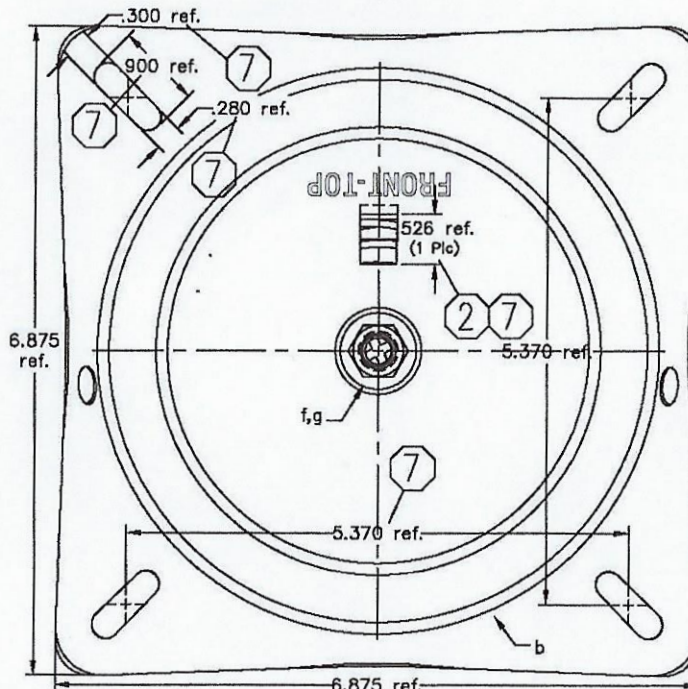
**Legend**

**ROUTING SEQUENCE:**  
101110(SHEAR FORM ASSEMBLE & TEST)

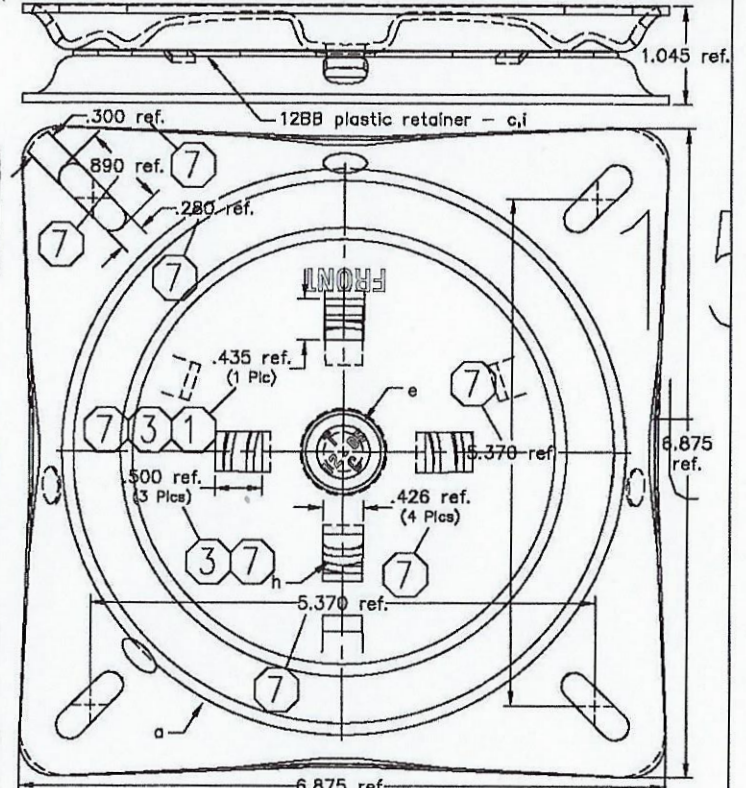
6



REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
1	A	Change width of shear form openings from .513±.010 to .435±.010.	09/27/00	FC
2	B	Add hole as shown on the drawing.	10/05/00	FC
3	C	Keep top shear form as .435±.010 and change three other shear form openings from .435±.010 to .500±.010.	07/26/01	FC
4	D	Change shear form opening from .485±.010 to .526±.010.	08/07/02	FC
5	E	Added "RETURN SWIVEL TEST" to testing standards per ECN "RETURN SWIVEL TESTING".	09/10/02	FC
6	F	Shear forming included in the assembly process per ECN "RETURN SWIVEL'S SHEAR FORMING".	07/27/05	MAS
7	G	Removed tolerances on dimensions as shown and added note on tolerances for components.	12/03/05	MAS



**Top View**



**Bottom View**

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**\*\*NOTE:** For tolerances on components see **Material Specifications**.

SWIVEL TENSION - NOT APPLICABLE  
LOAD CAPACITY - 500 LB.

**TEST STANDARDS (TC):**

- TENSION TEST (TORQUE)
- ANSI/BIFMA X5.1-1993:
- BACK STRENGTH TEST - STATIC - TYPE IIA
- BACK DURABILITY TEST - CYCLIC - TYPE IIA & IIB
- SWIVEL TEST - CYCLIC

**RETURN SWIVEL TEST:**

SWIVEL MUST RETURN FREELY TO ORIGINAL POSITION WHEN TESTED AT 45 DEGREES.

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BOM	QTY (U/M):
a. 200062:PLB 712 RS NF	1.000 ea
b. 200119:PLT 712 LN FL NF	1.000 ea
c. 300008:PLASTIC RETAINER FOR 7"	1.000 ea
d. PC1290:CTN SWL 17.00 x 7.00 x 7.00	0.067 ea
e. PF1120:BOLT CGE 3/8-24 x .875 PH HD1.000	ea
f. PF4070:NUT FLG 3/8-24 SIDE LOCK ZC	1.000 ea
• PG1100:Grease Swivel #725	0.015 lb
g. PP1020:PLASTIC NYLATRON WSHR .75 x	1.000 ea
h. PS1030:SPRING, CLOCKWORK FOR SWIVELS2.000	ea
i. PZ1000:BALL BEARING 5/16 CARBON STL	12.00 ea

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN DECIMAL INCHES & TOLERANCES ARE SHOWN ON THE DRAWING OR REFERENCED ARE:  
FRACTIONS ANGLES DECIMALS  
± ± .XX ±  
± .XXX ±



**712 FL RS90 12BB NF**

CRITICAL DIMENSIONS ARE IN BOLD LETTERING