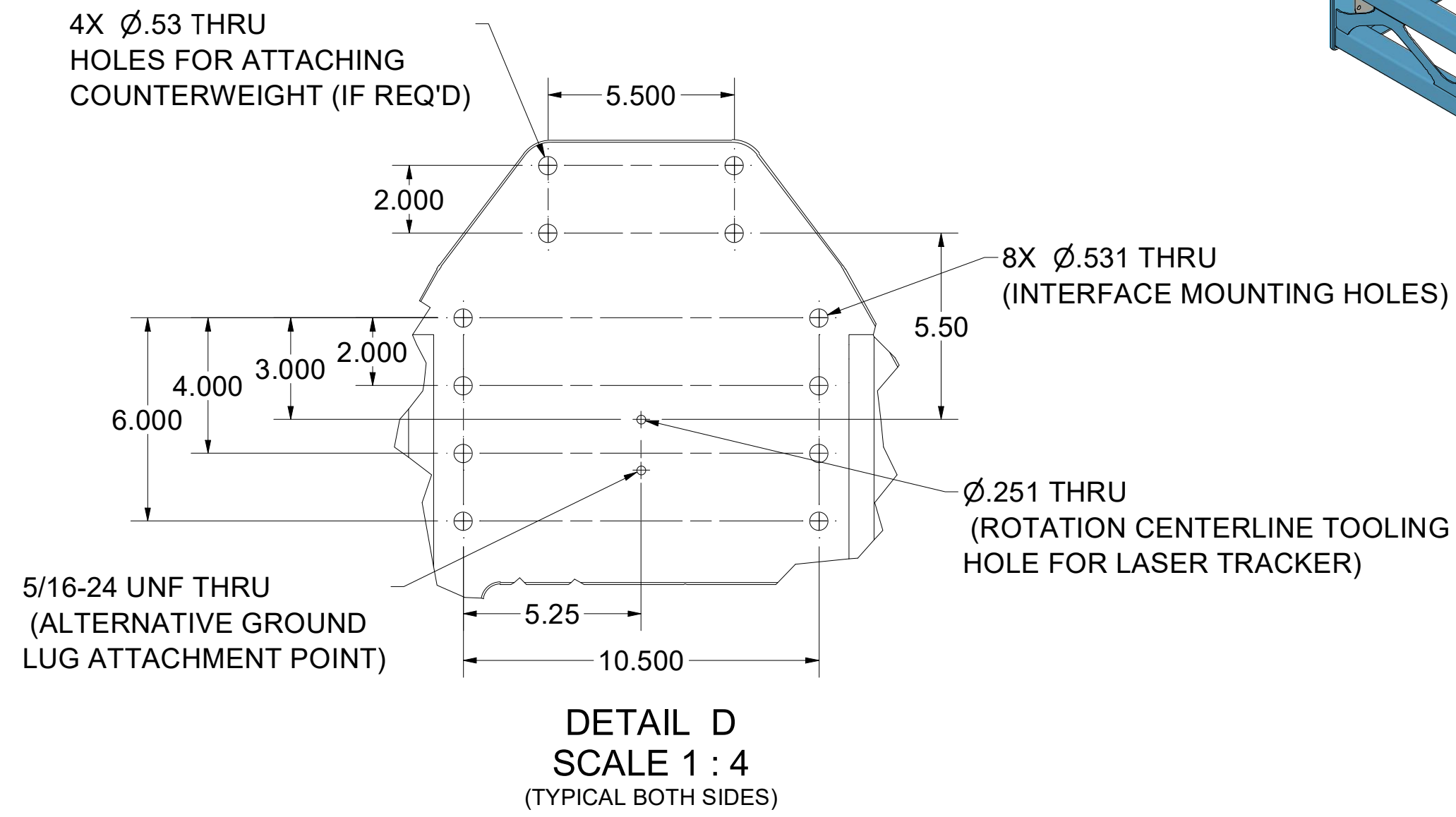
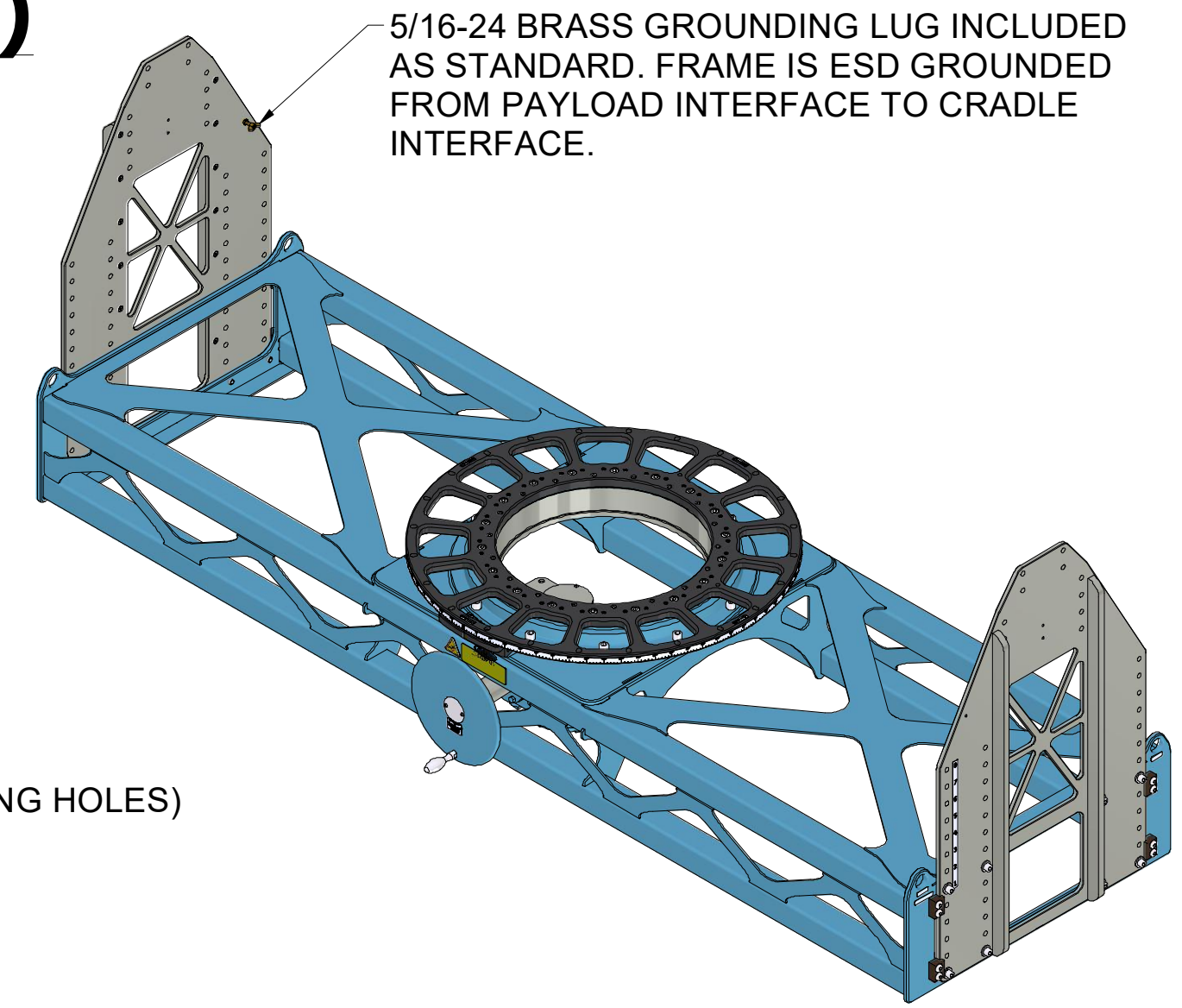
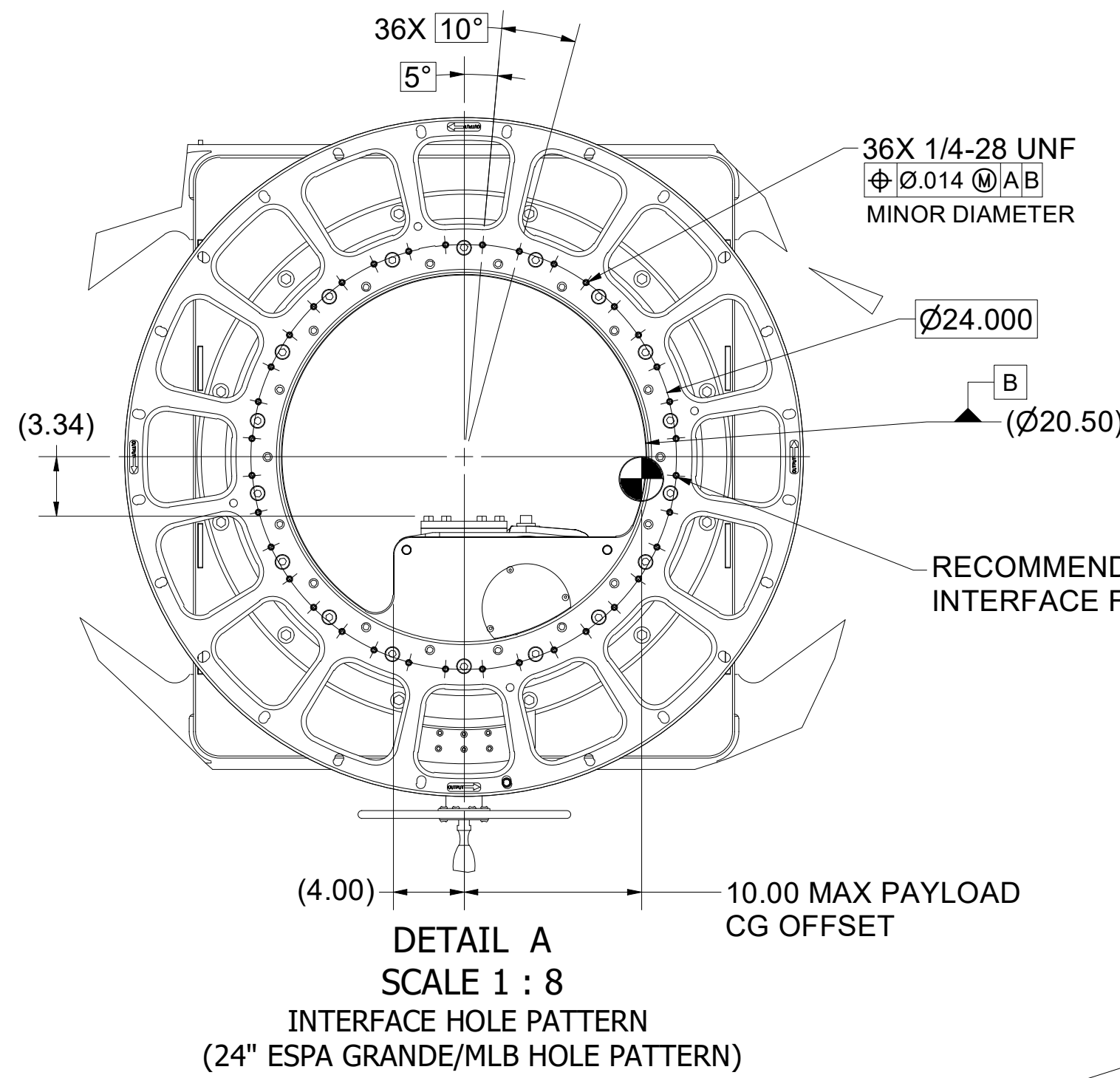
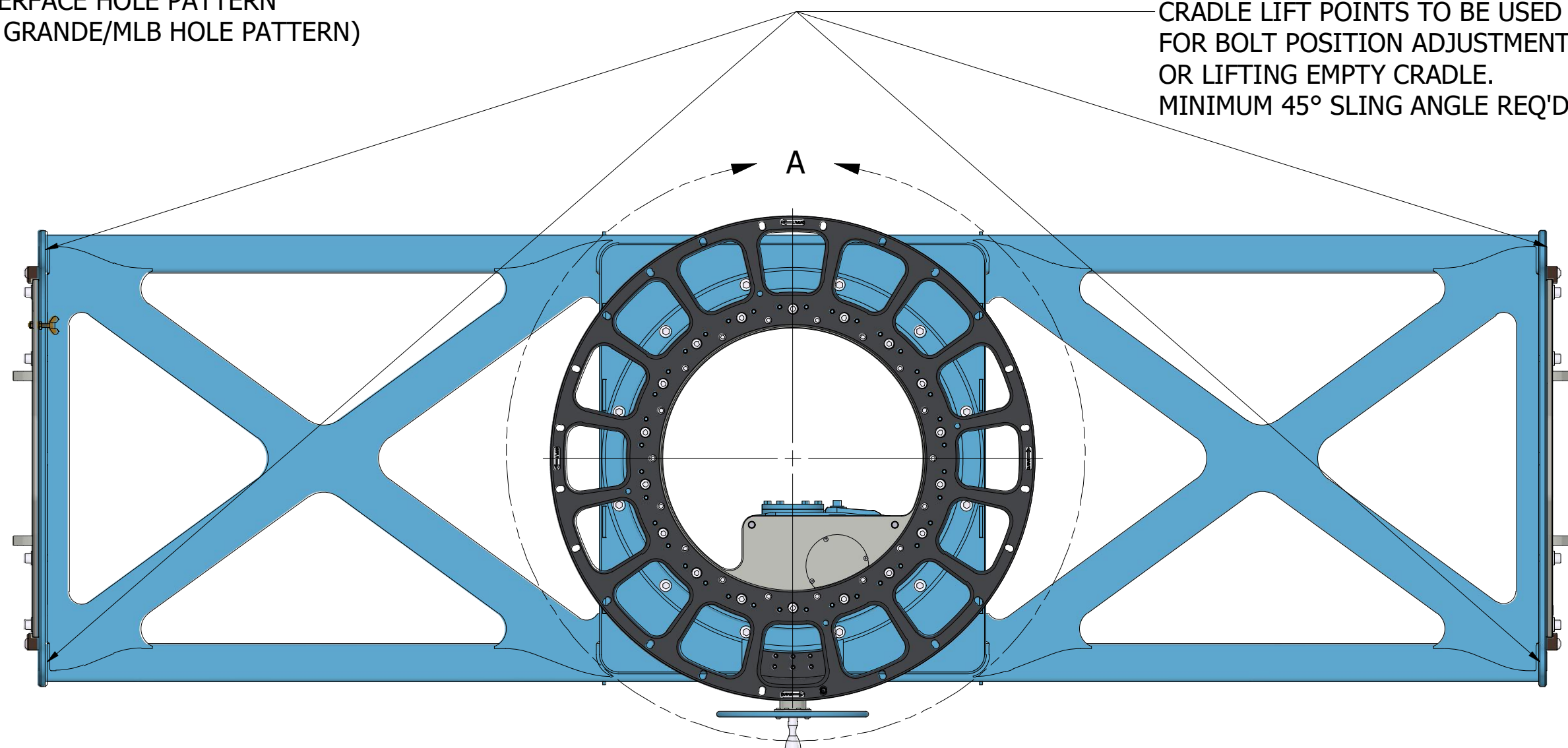


SECONDARY AXIS OF ROTATION CRADLE - GEARBOX DRIVEN (SA1-SA8)

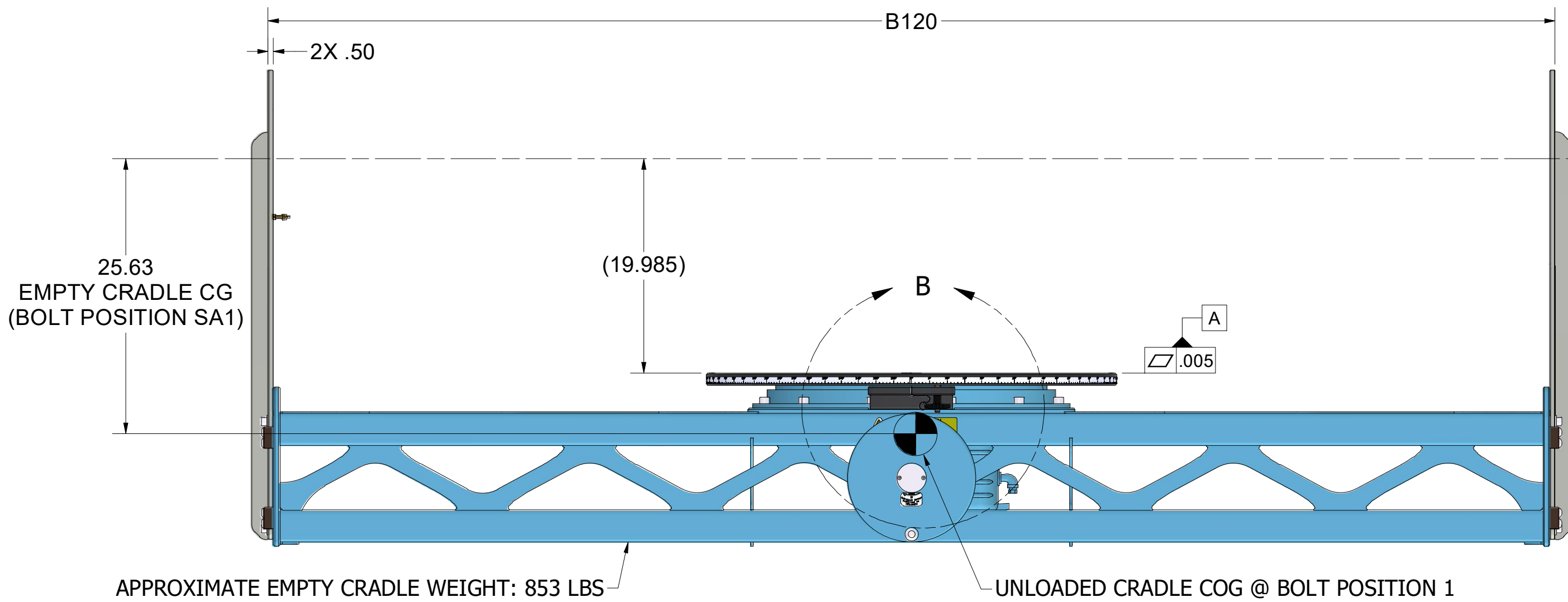
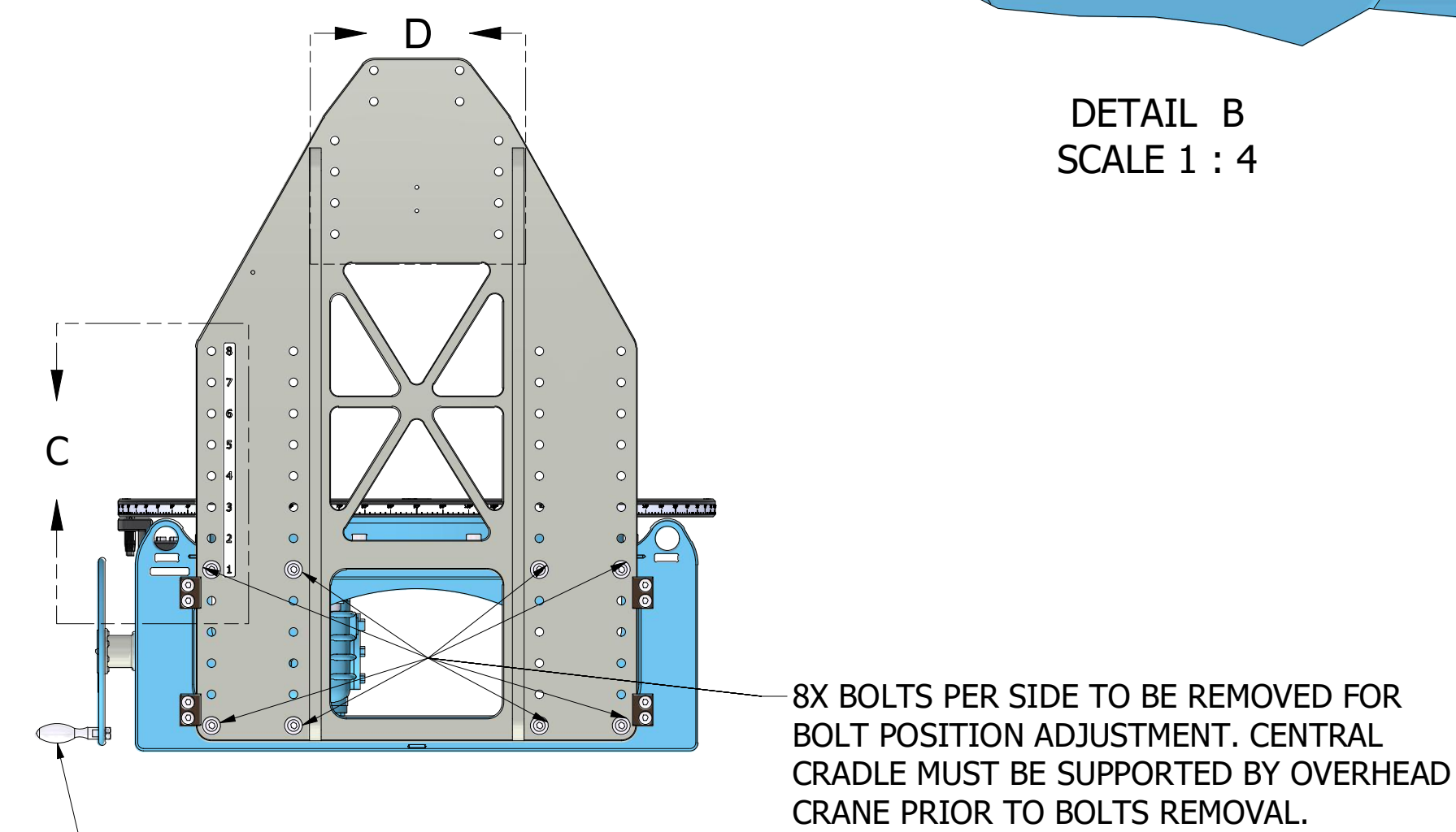
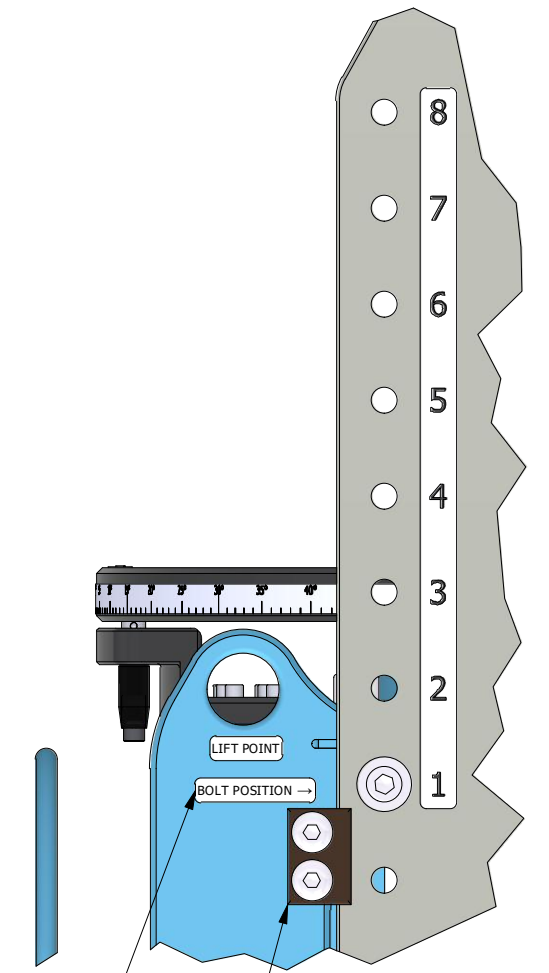
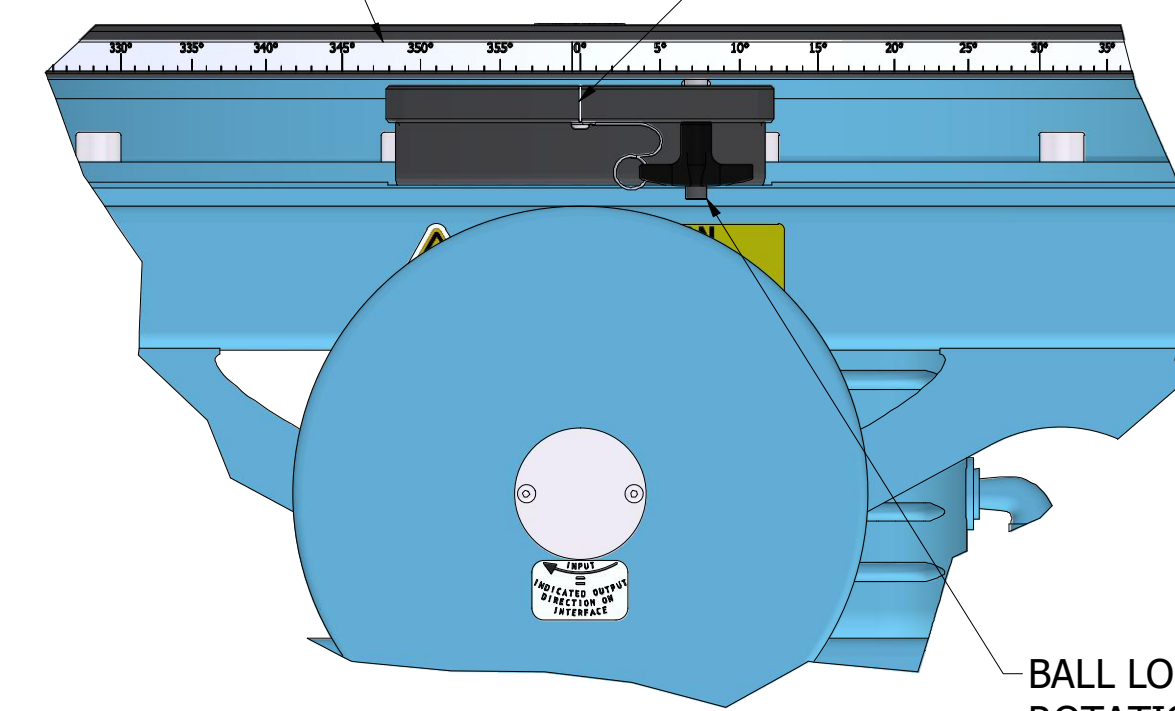
BOLT POSITIONS CAN BE CHANGED IN THE FIELD, BUT BOLT POSITION SELECTED WILL BE THE BOLT POSITION THE FIXTURE IS SHIPPED WITH. B120 INTERFACE DISTANCE IS STANDARD BUT SPECIAL LENGTH CRADLES AVAILABLE UPON REQUEST IN INCREMENTS OF 20". SEE SALES FOR MORE INFORMATION. SPECIAL INTERFACE DISTANCES WILL CHANGE LOAD RATING AND LOAD CURVES.



CRADLE LIFT POINTS TO BE USED FOR BOLT POSITION ADJUSTMENT OR LIFTING EMPTY CRADLE. MINIMUM 45° SLING ANGLE REQ'D.



360° POSITION INDICATOR SCALE
POSITION INDICATOR MARK



2. LOAD RATING: 2,300 LBS CANTILEVERED 30" FROM INTERFACE. MAX ECCENTRICITY 10" FROM SECONDARY AXIS OF ROTATION. SEE LOAD CURVES FOR LOAD RATINGS AT VARIOUS BOLT POSITIONS. MAX TORQUE ON SECONDARY AXIS OF ROTATION INTERFACE: 23,000 IN-LBS; MAX EASY CRANK TORQUE: 11,000 IN-LB

1. FINISHES/LUBRICANTS:
a) "STANDARD" FINISH: CLASS 10K (ISO 7 CLEANROOM COMPATIBLE FINISHES) - CRADLE POWDER COATED TEXTURED FLOTRON BLUE COLOR; STAINLESS STEEL HARDWARE; ALUMINUM PARTS CHEM FILM OR HARD ANODIZED; MOBIL TAC 375NC (OR EQUIVALENT) TO ALL SLEWING RING TEETH; SLEWING RING INNER RACEWAY LUBRICATED WITH MOBILUX EP2 (OR EQUIVALENT). FASTENERS LUBRICATED WITH LOCTITE 242 BLUE OR KRYTOX GPL 207. GEARBOX SEALED AND PRESSURE TESTED.
b) "C" FINISH: CLASS 1K (ISO 6 CLEANROOM COMPATIBLE FINISHES) - SAME AS STANDARD FINISH WITH CRADLE POWDER COATED SMOOTH SKY WHITE.

NOTES:

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
LINEAR TOLERANCES: ±.03
ANGULAR TOLERANCES: ±.5°
XX .004
DO NOT SCALE DRAWING INTERPRET DIMENSIONING AND TOLERANCING PER ASME Y14.5-2018 INTERPRET DWG. PER ASME Y14.100

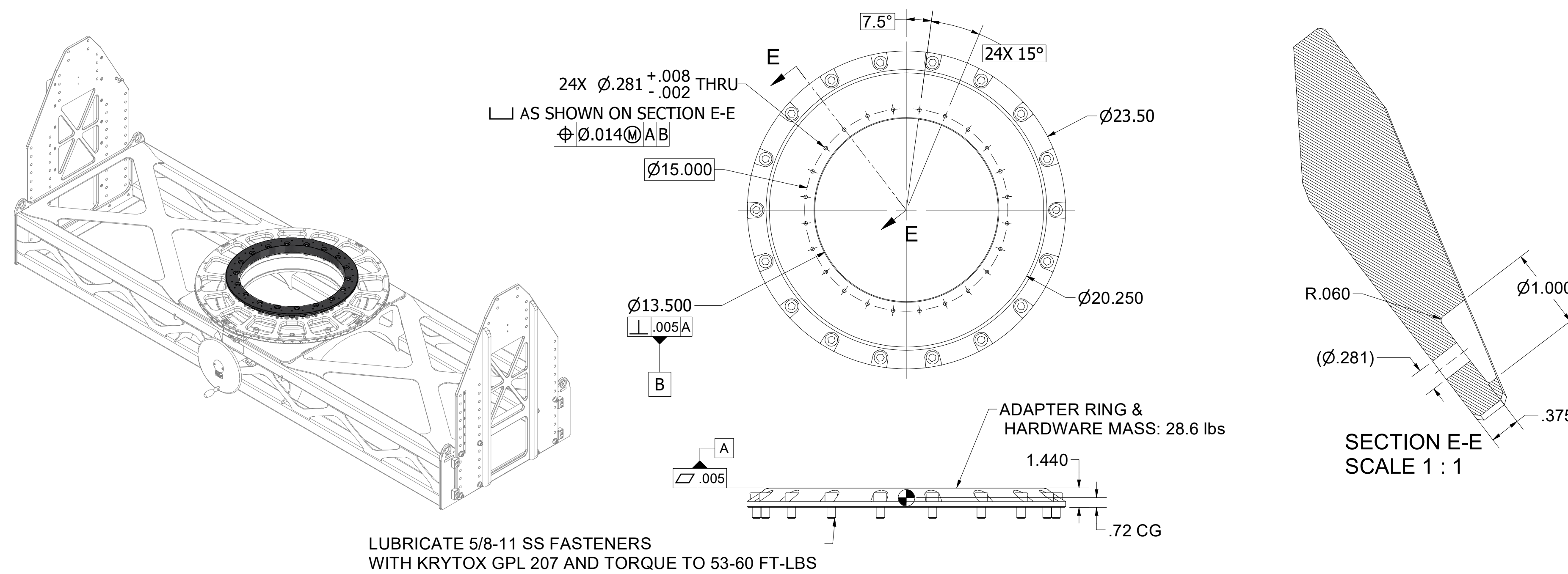
FLOTRON 2630 PROGRESS STREET VISTA, CALIFORNIA 92081 <http://www.flotron.com>

SECONDARY AXIS CRADLE - PINNED

SCALE	SIZE	DRAWING NO.
1 : 10	D	8128-200-GEARBOX-PROP
WT: N/A	Cad software: Inventor	SHEET 1 OF 8

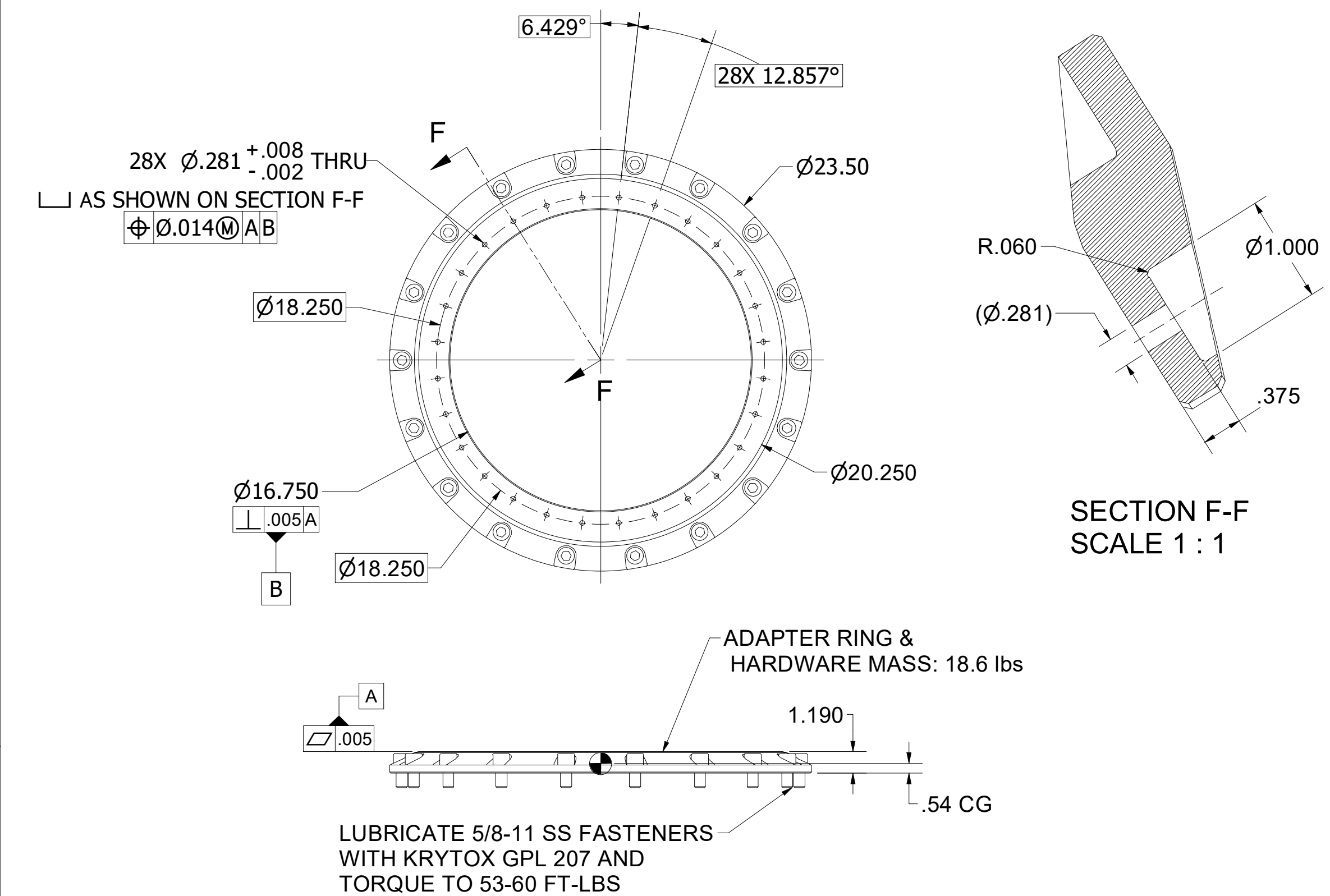
SECONDARY AXIS PAYLOAD ADAPTER RING (R15)

ADAPTER RING TO CONVERT SA INTERFACE
TO 24X Ø.281 THROUGH HOLES ON A Ø15.000" BOLT CIRCLE (STANDARD ESPA/MLB)
WHEN DETERMINING PAYLOAD AND CRADLE CG BALANCE, ADAPTER
RING MASS & CG NEEDS TO BE ADDED TO PAYLOAD CG CALCULATIONS.
HARD ANODIZE FINISH WITH ONE MASKED HOLE FACE FOR ESD.



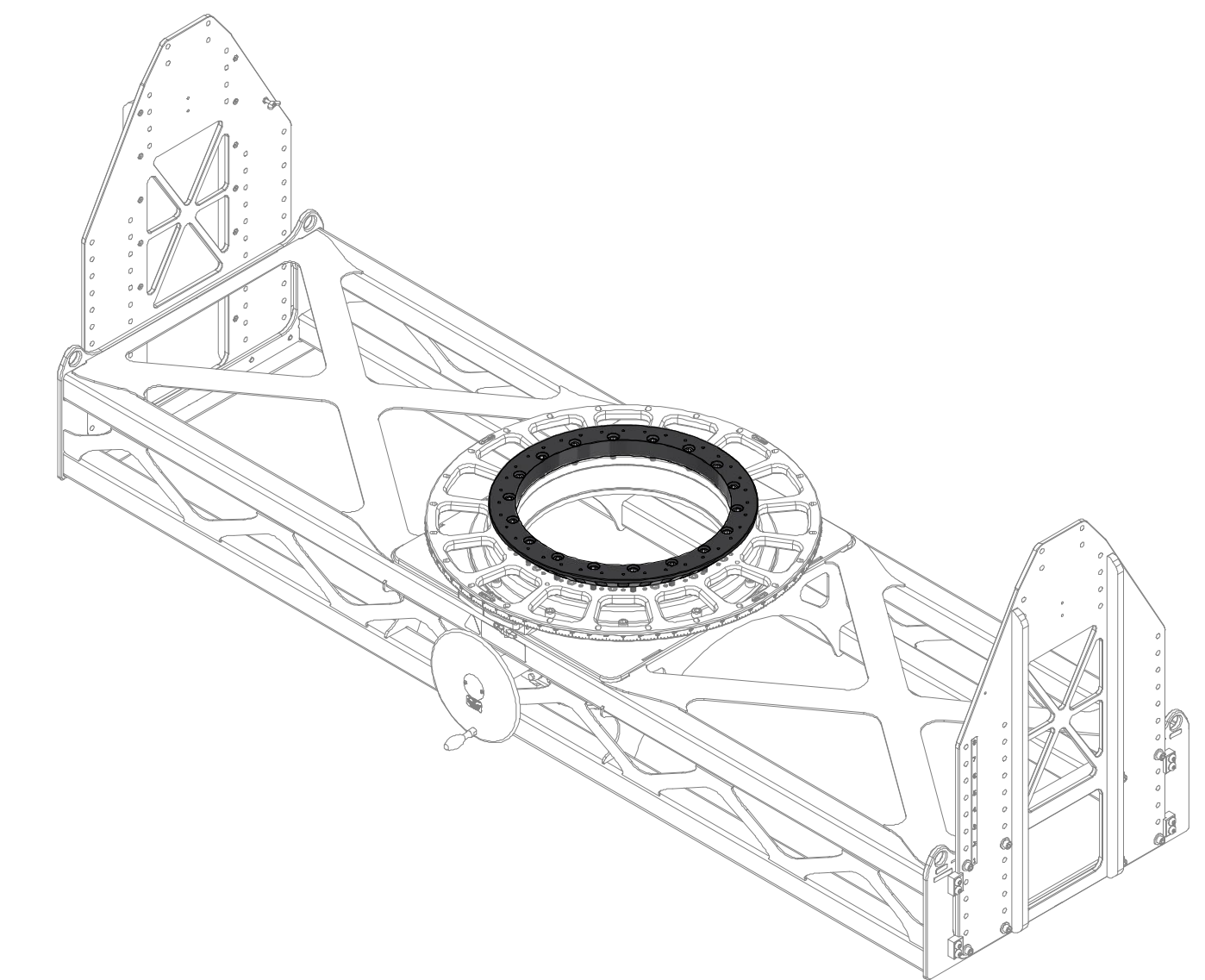
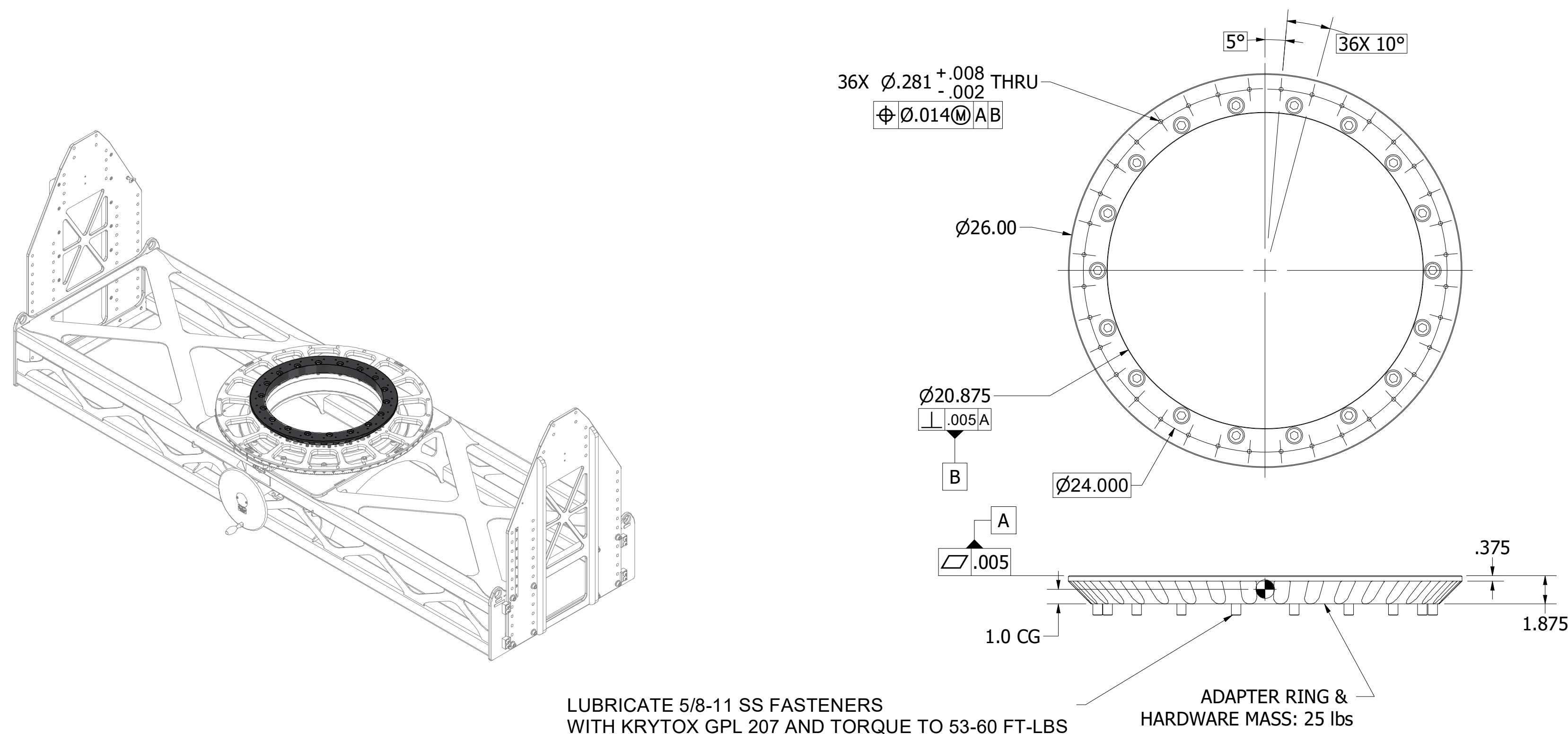
SECONDARY AXIS PAYLOAD ADAPTER RING (R18)

ADAPTER RING TO CONVERT SA INTERFACE
TO 28X Ø.281 THROUGH HOLES ON A Ø18.250" BOLT CIRCLE (MLB)
WHEN DETERMINING PAYLOAD AND CRADLE CG BALANCE, ADAPTER
RING MASS & CG NEEDS TO BE ADDED TO PAYLOAD CG CALCULATIONS.
HARD ANODIZE FINISH WITH ONE MASKED HOLE FACE FOR ESD.



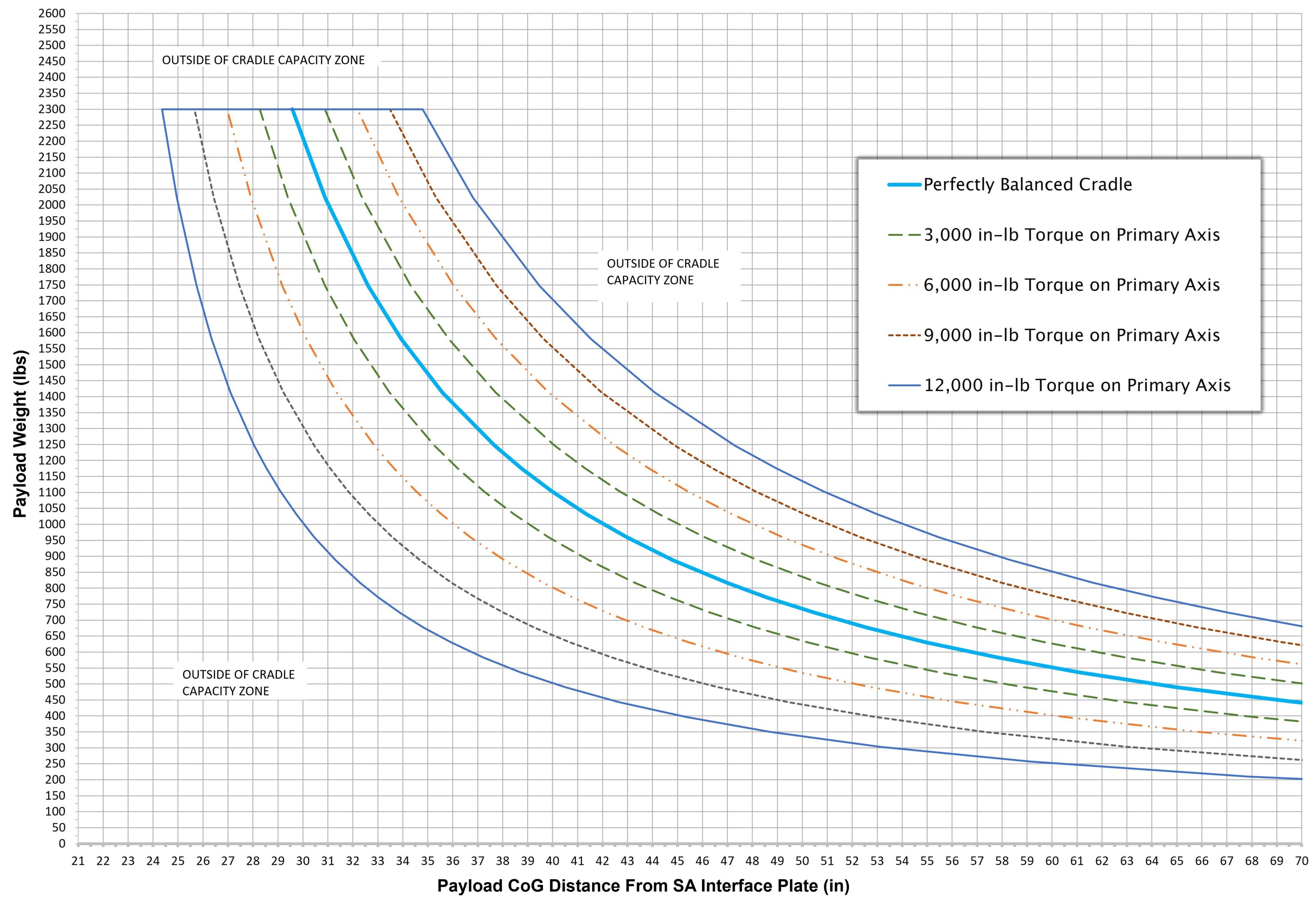
SECONDARY AXIS PAYLOAD ADAPTER RING (R24)

ADAPTER RING TO CONVERT SA INTERFACE THREADED HOLES
TO 36X Ø.281 THROUGH HOLES ON A Ø24.000" BOLT CIRCLE (ESPA GRANDE/MLB)
WHEN DETERMINING PAYLOAD AND CRADLE CG BALANCE, ADAPTER
RING MASS & CG NEEDS TO BE ADDED TO PAYLOAD CG CALCULATIONS.
HARD ANODIZE FINISH WITH ONE MASKED HOLE FACE FOR ESD.

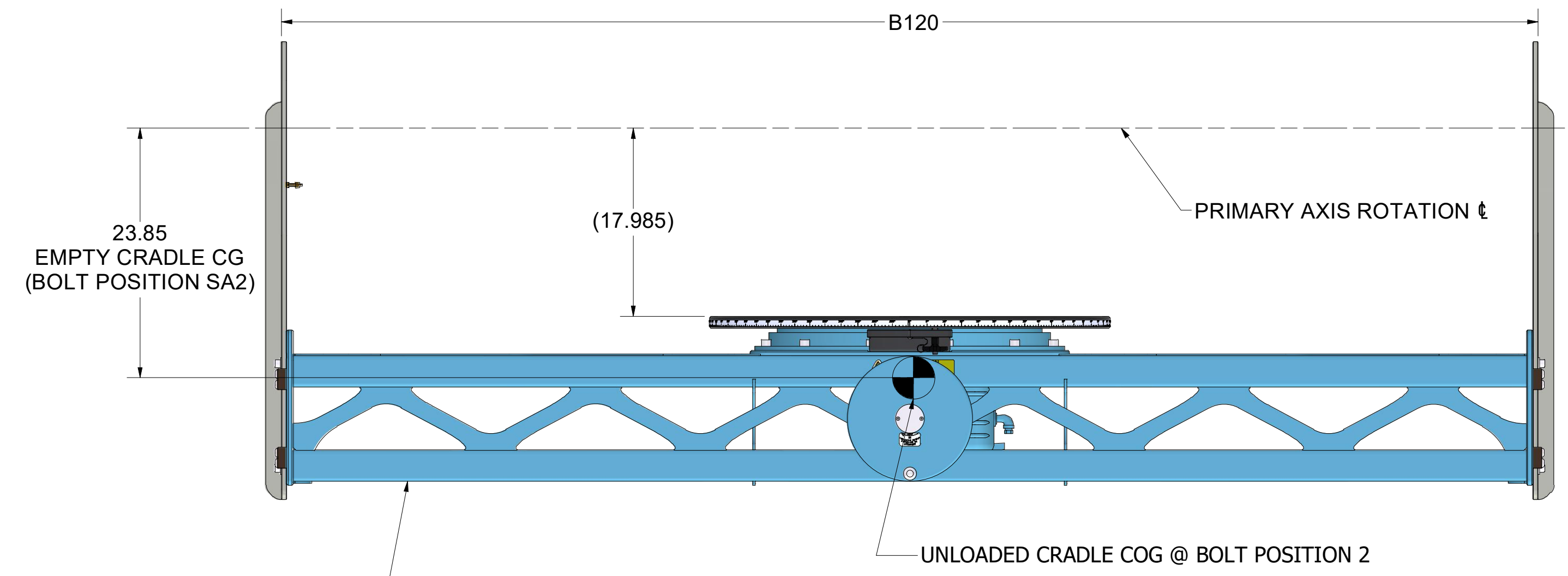
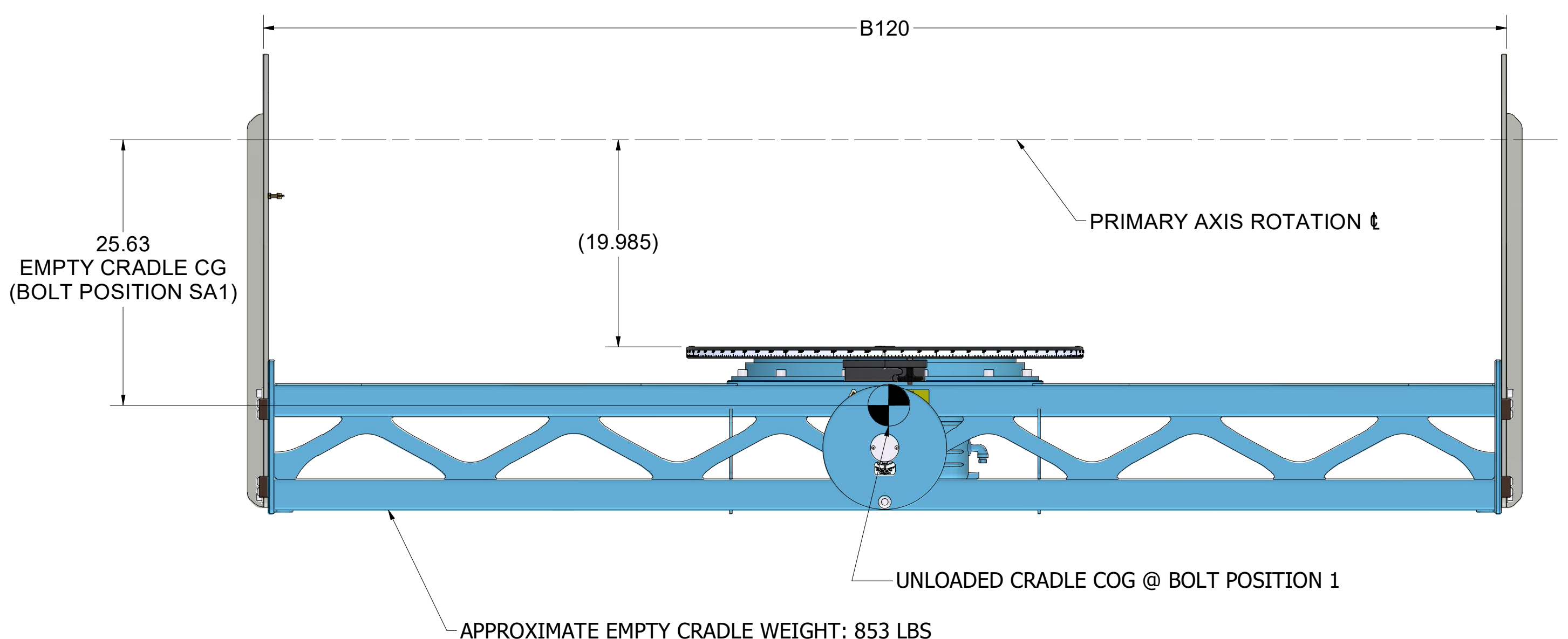
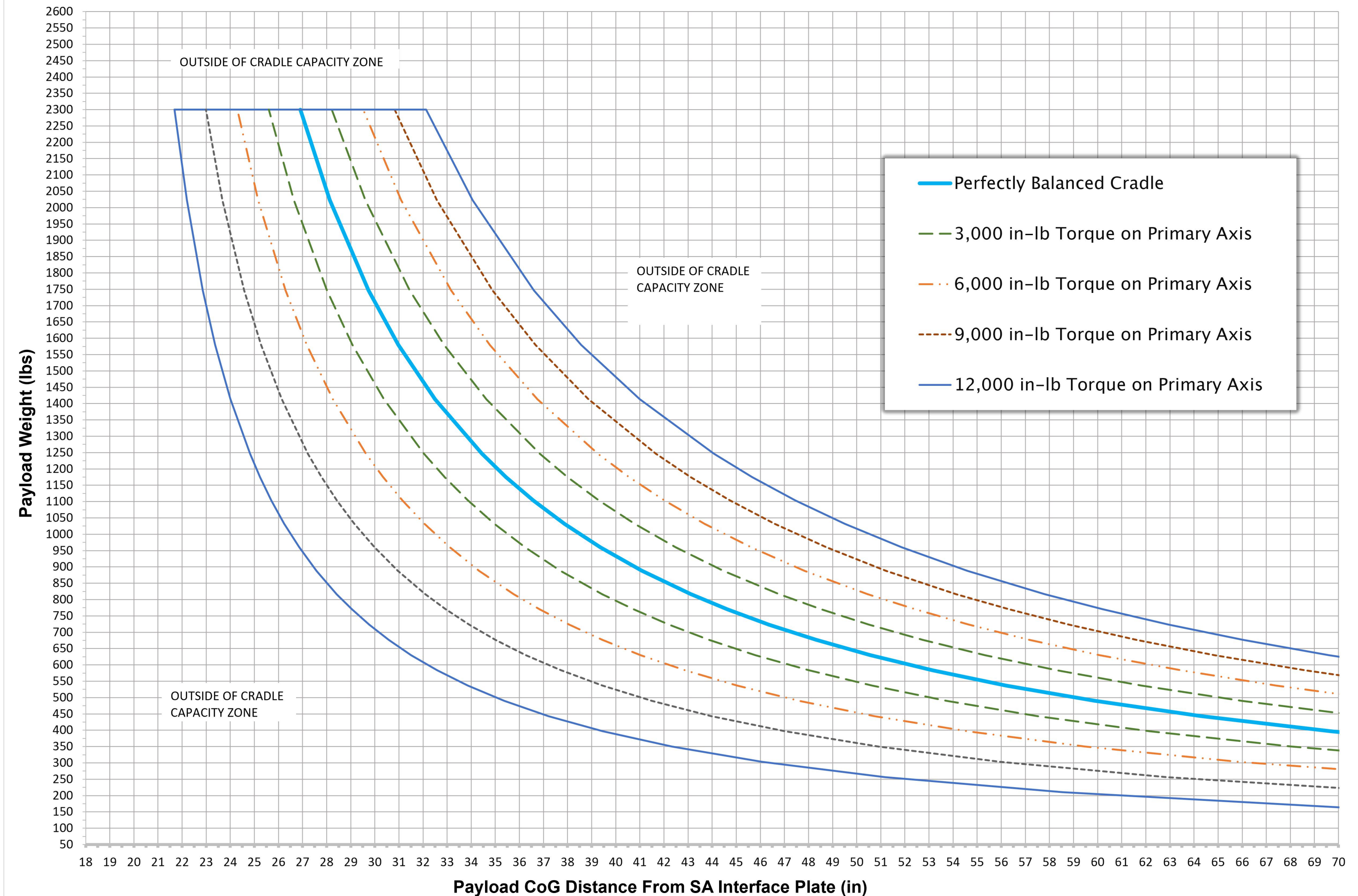


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Secondary Axis of Rotation Loading For Cradle With Gearbox - **Bolt Position 1**



Secondary Axis of Rotation Loading For Cradle With Gearbox - **Bolt Position 2**



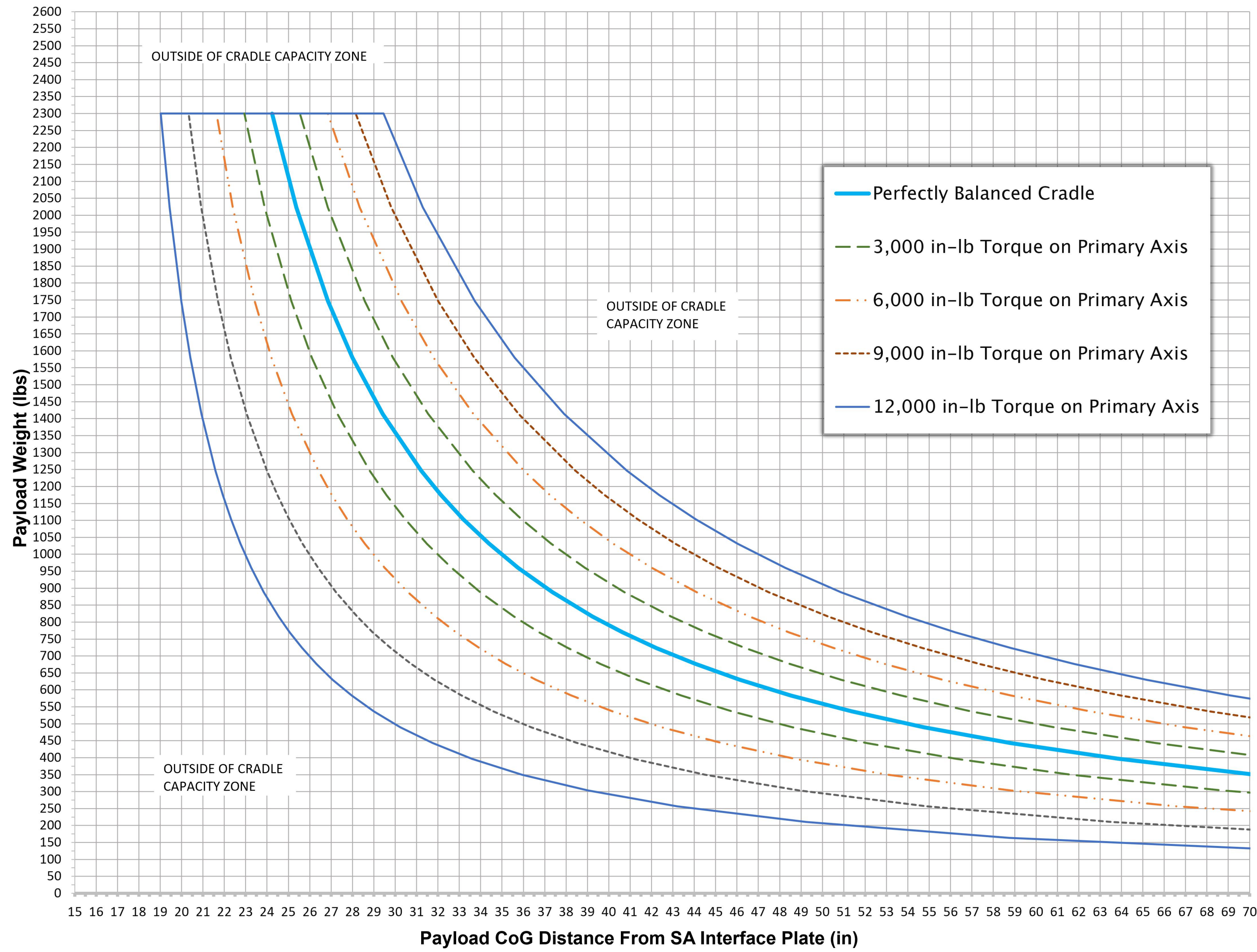
APPROXIMATE EMPTY CRADLE WEIGHT: 853 LBS

APPROXIMATE EMPTY CRADLE WEIGHT: 853 LBS

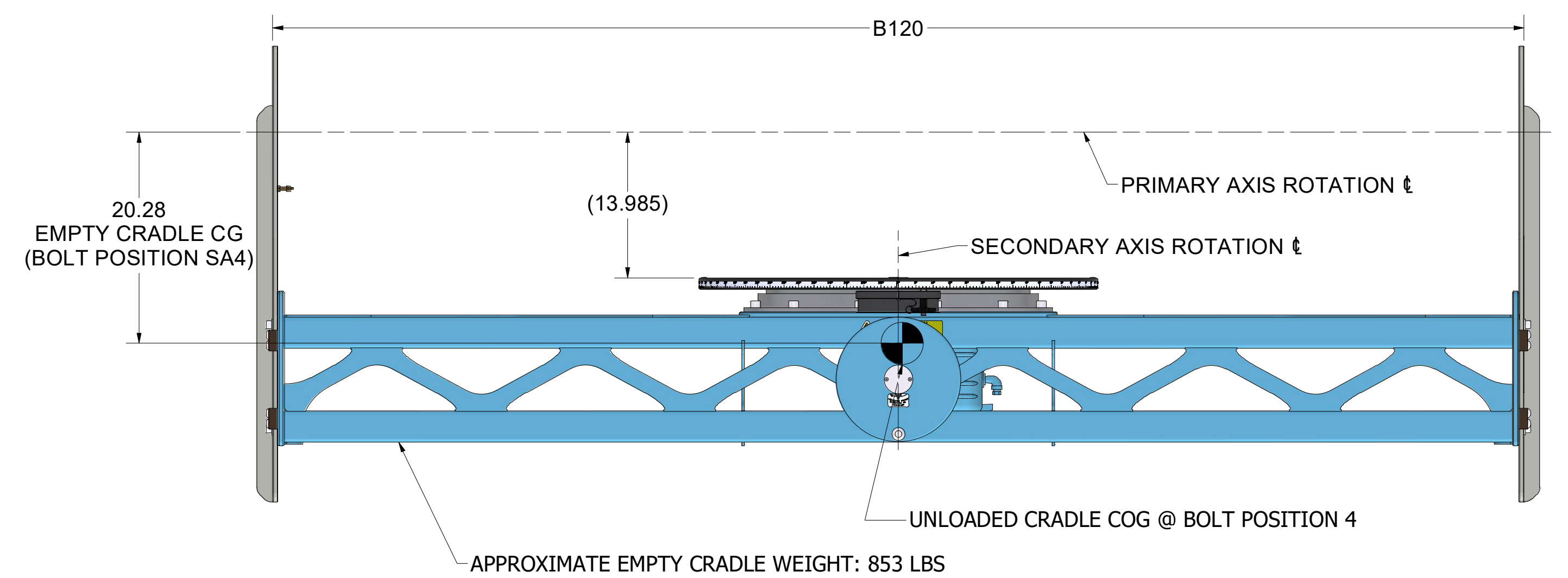
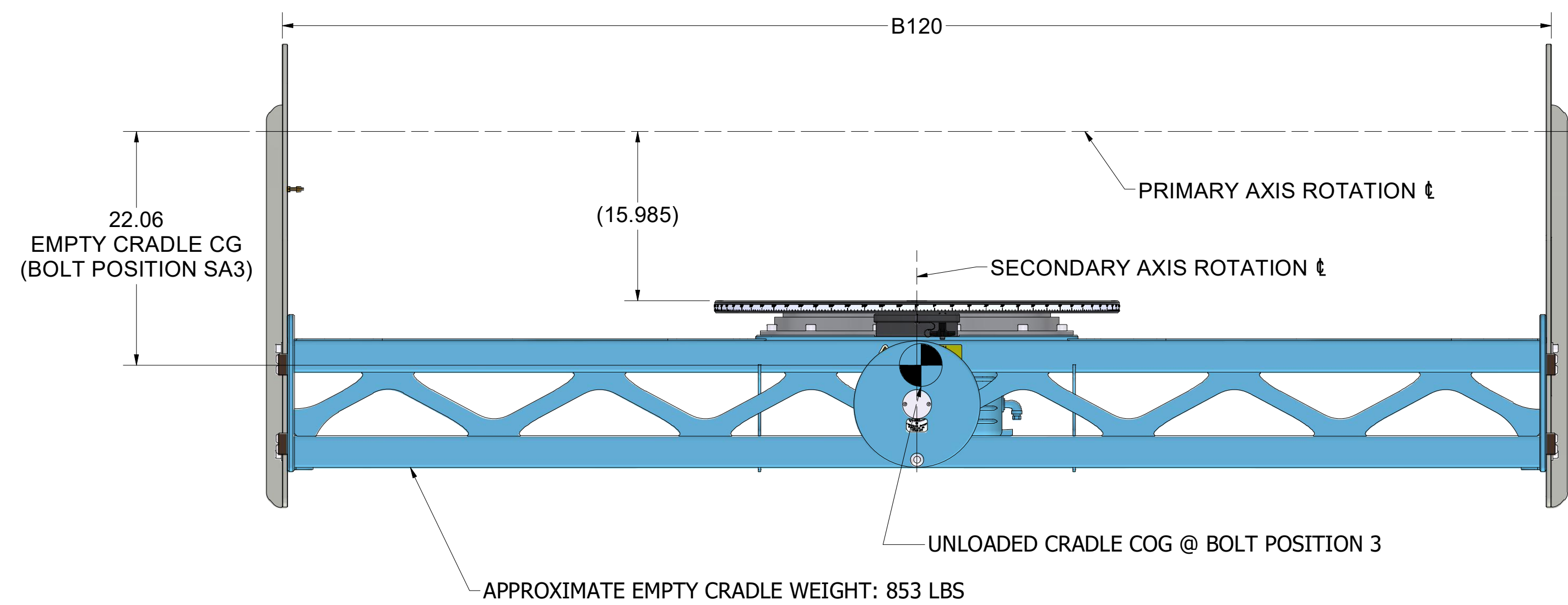
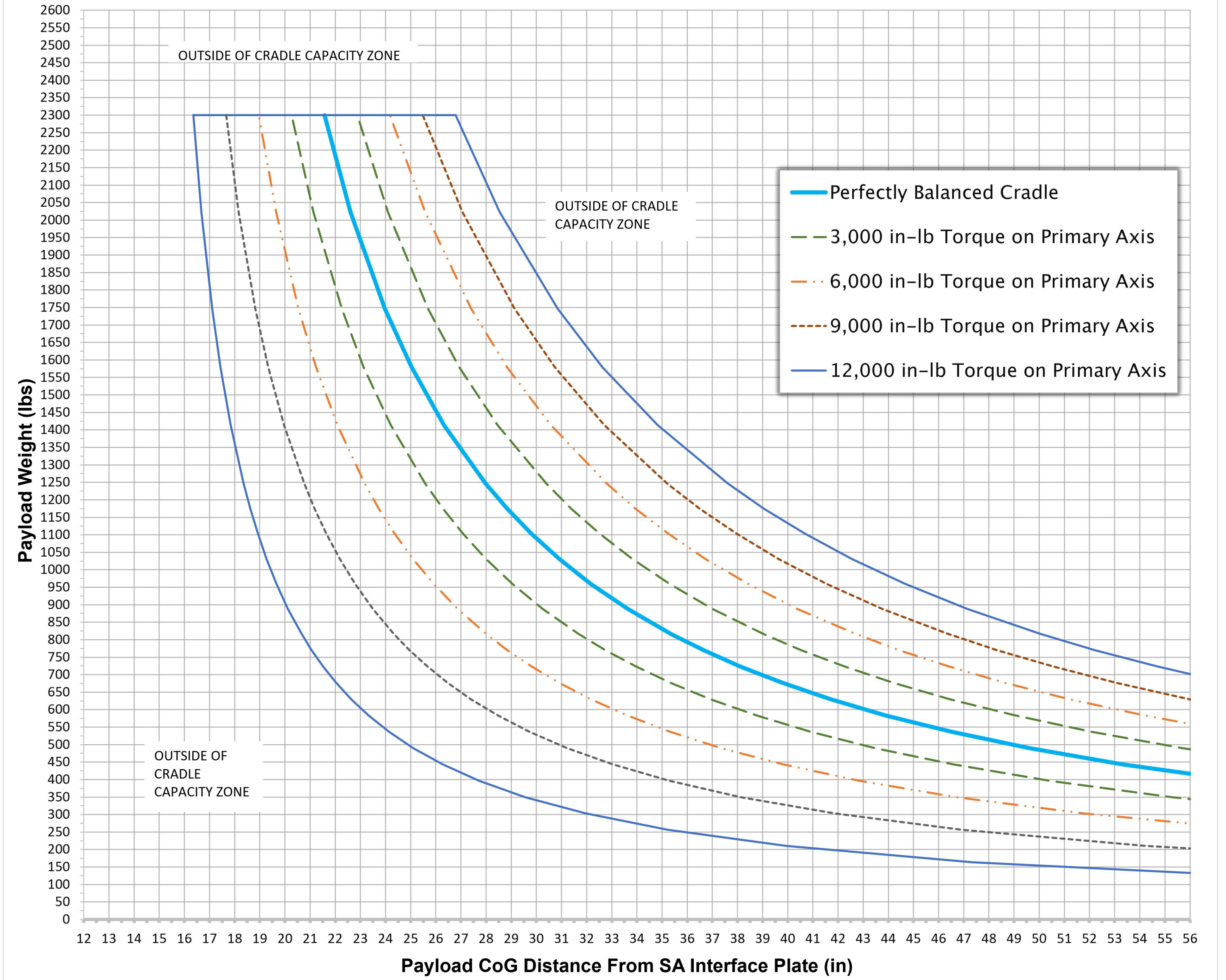
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SCALE 1 : 2	SIZE D	DRAWING NO. 8128-200-GEARBOX-PROP
		SHEET 3 OF 8

Secondary Axis of Rotation Loading For Cradle With Gearbox - **Bolt Position 3**

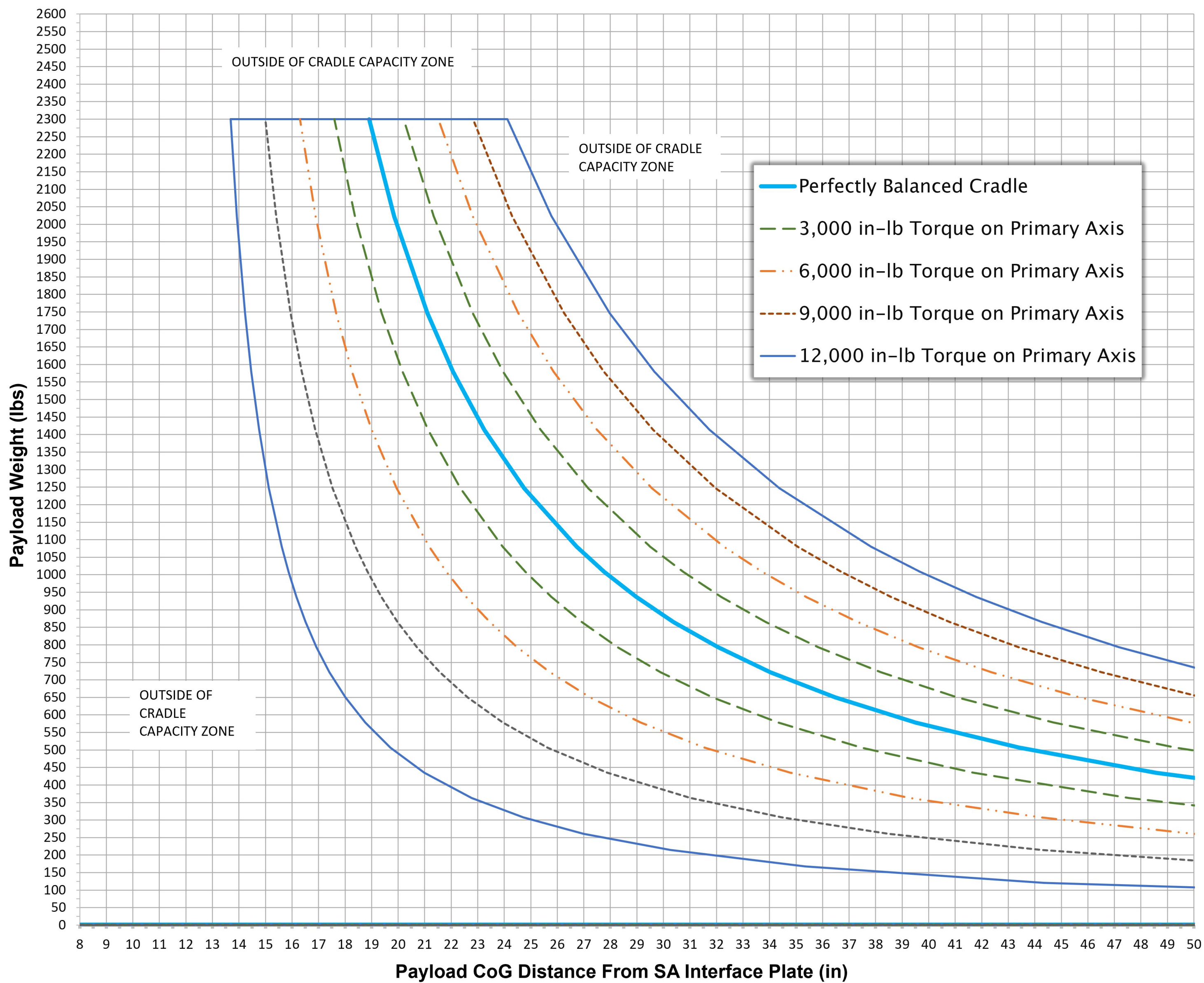


Secondary Axis of Rotation Loading For Cradle With Gearbox - **Bolt Position 4**

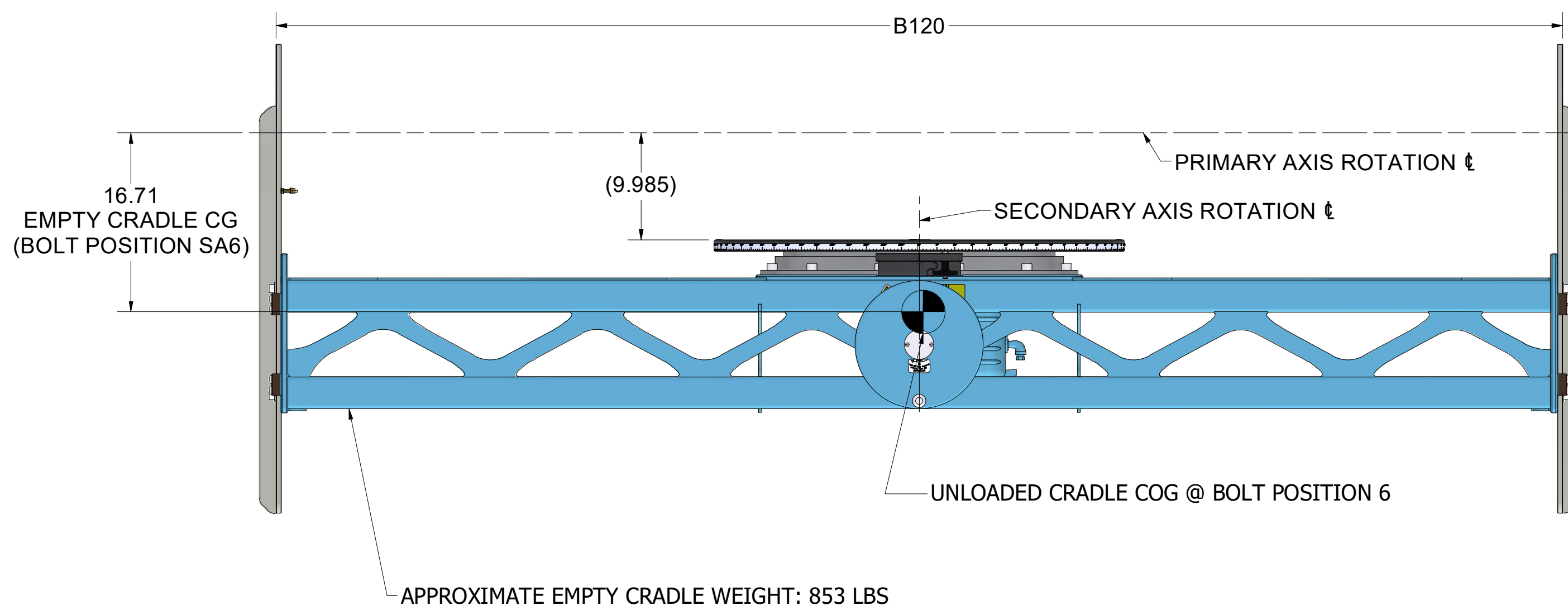
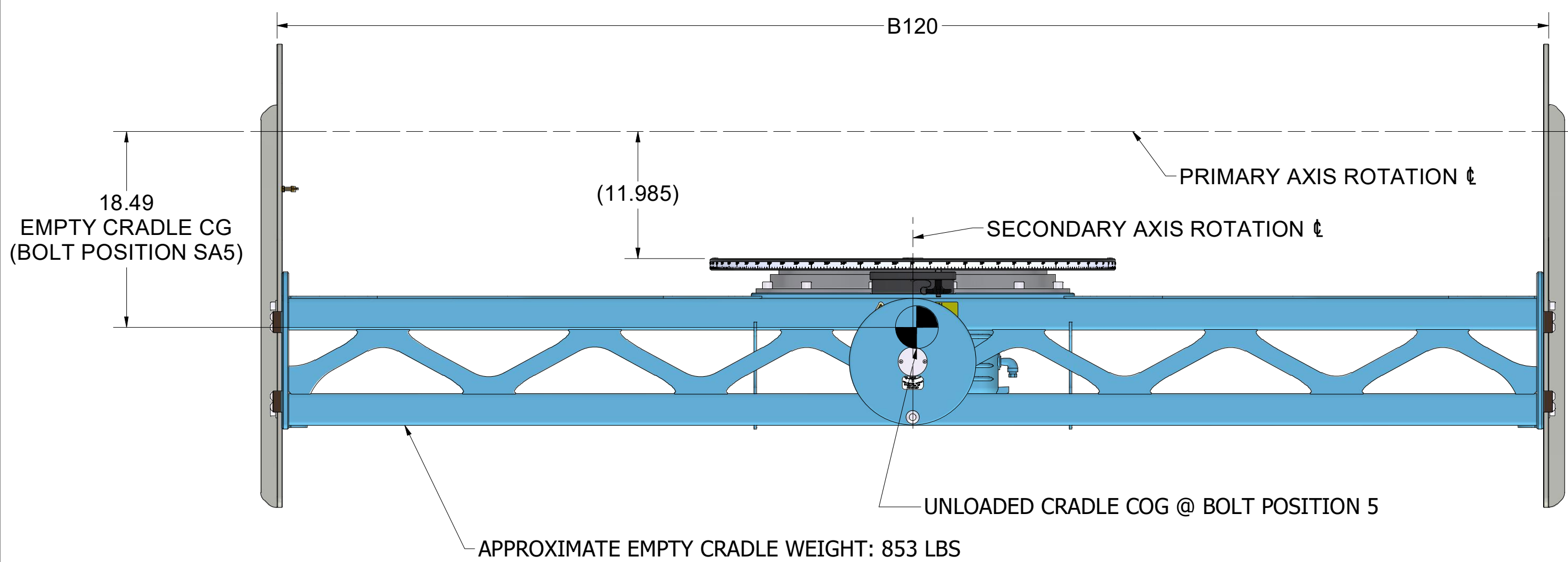
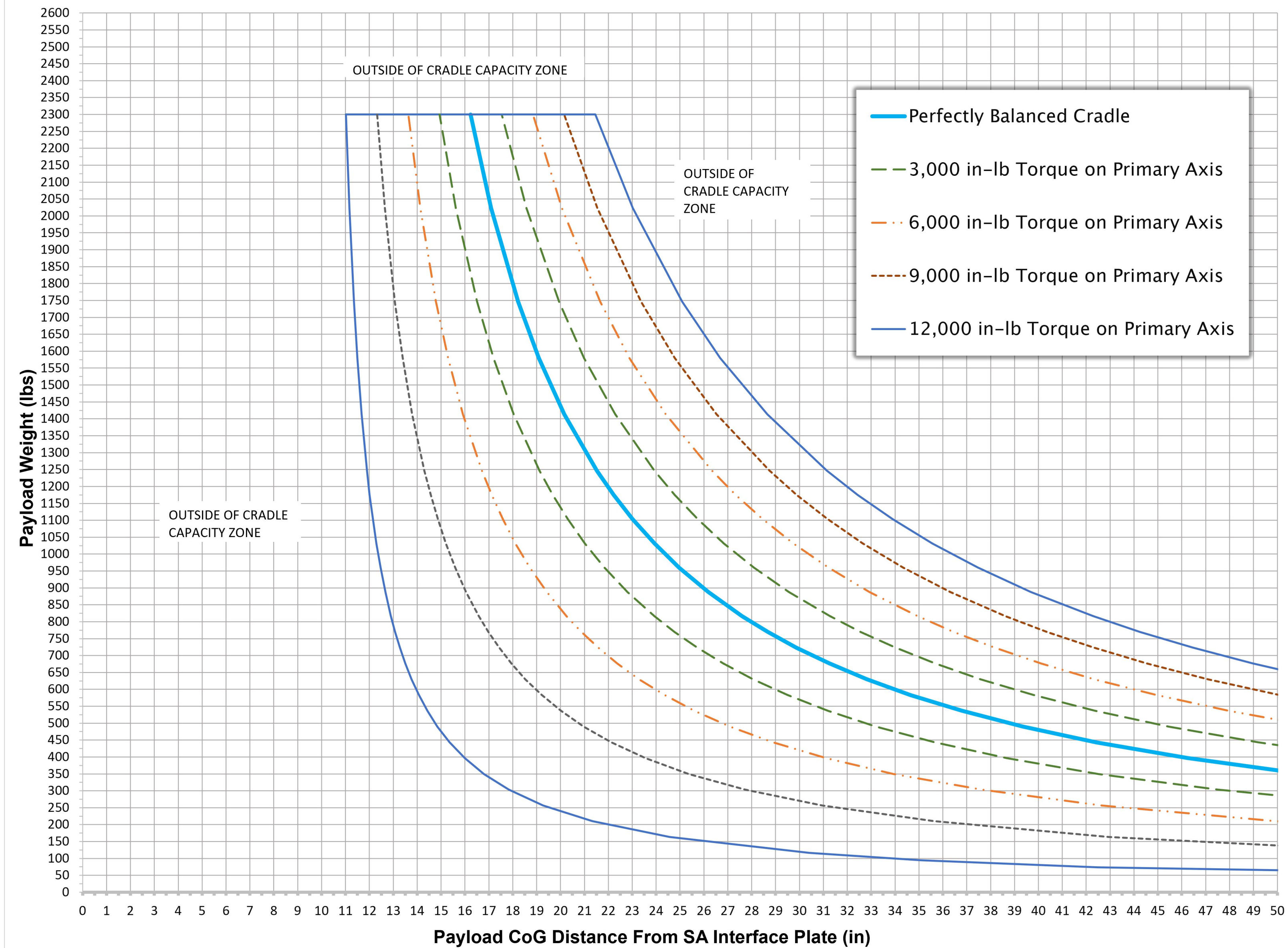


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Secondary Axis of Rotation Loading For Cradle With Gearbox - **Bolt Position 5**

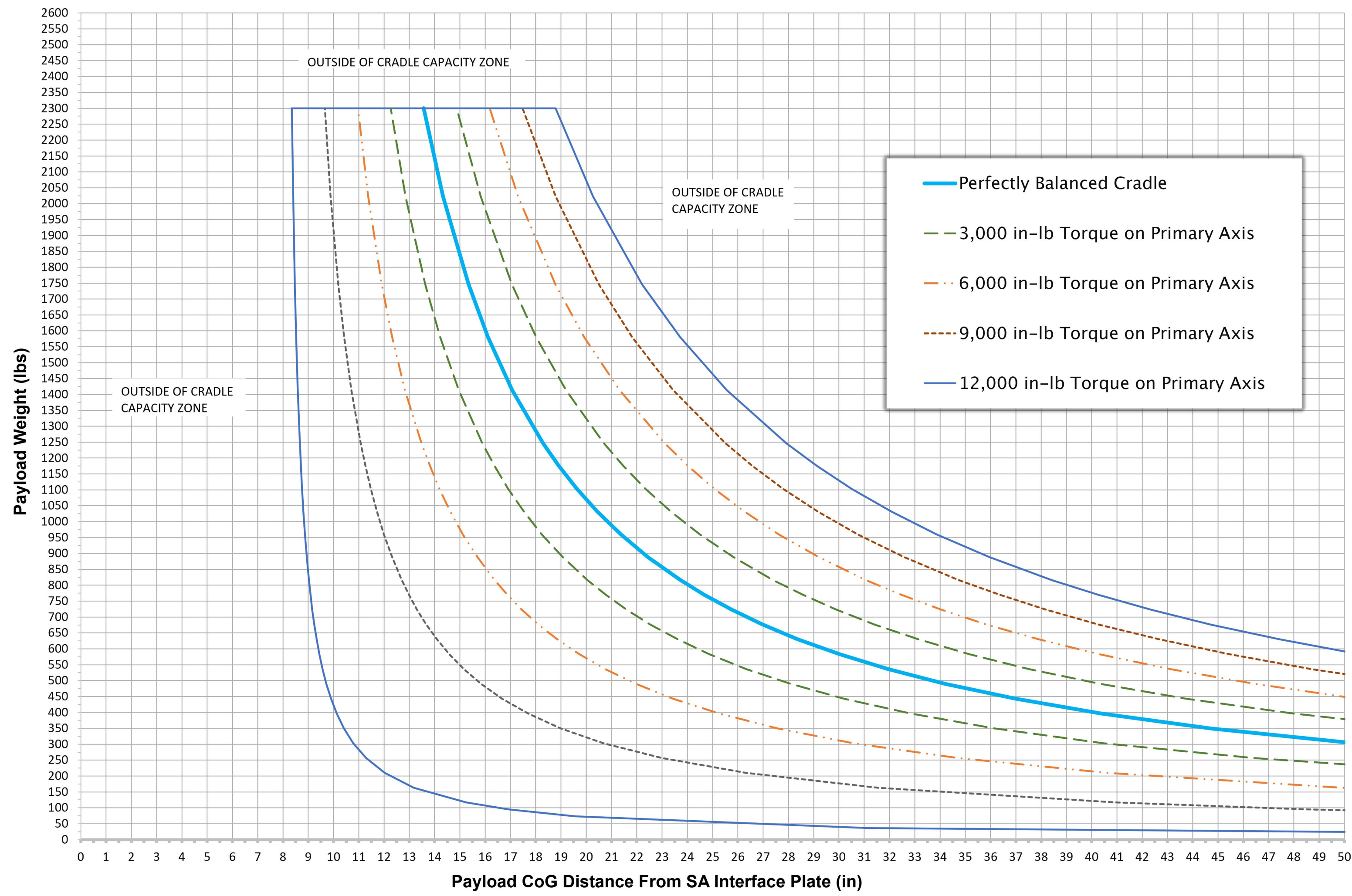


Secondary Axis of Rotation Loading For Cradle With Gearbox - **Bolt Position 6**

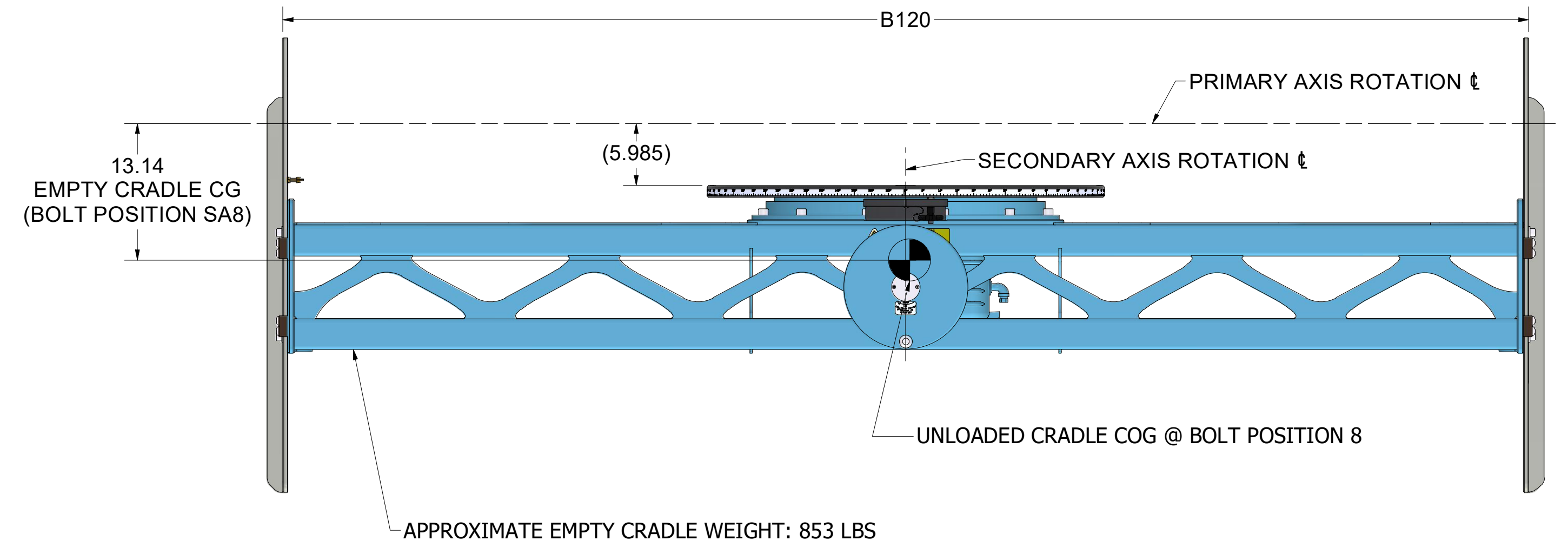
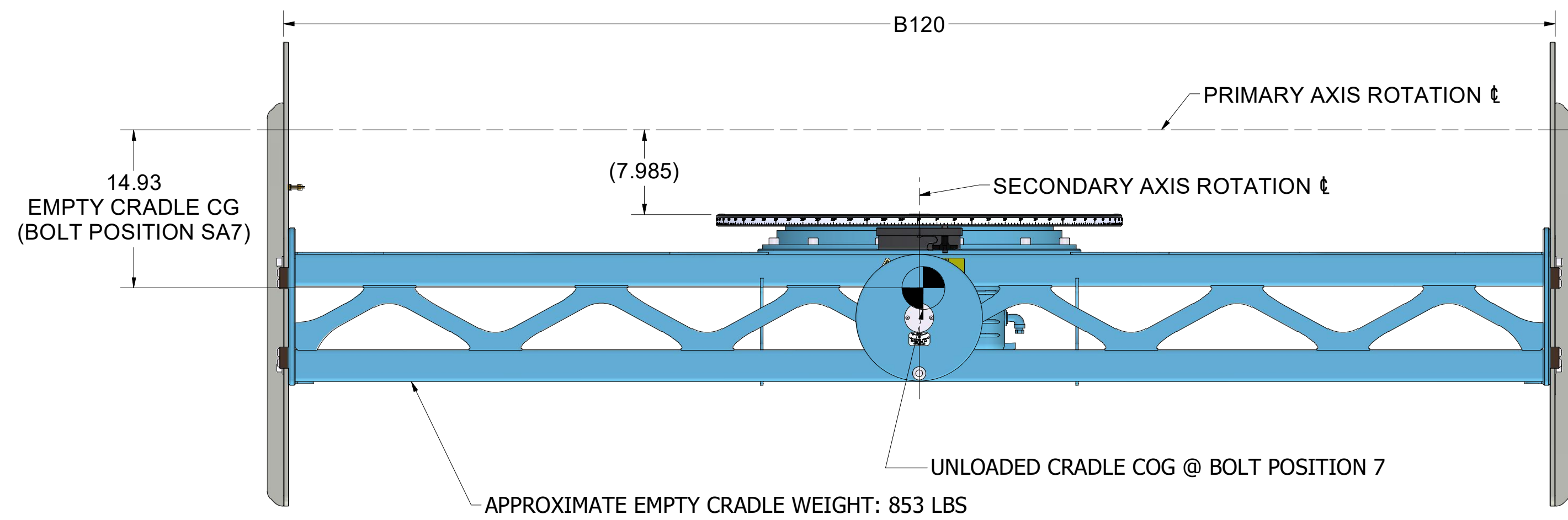
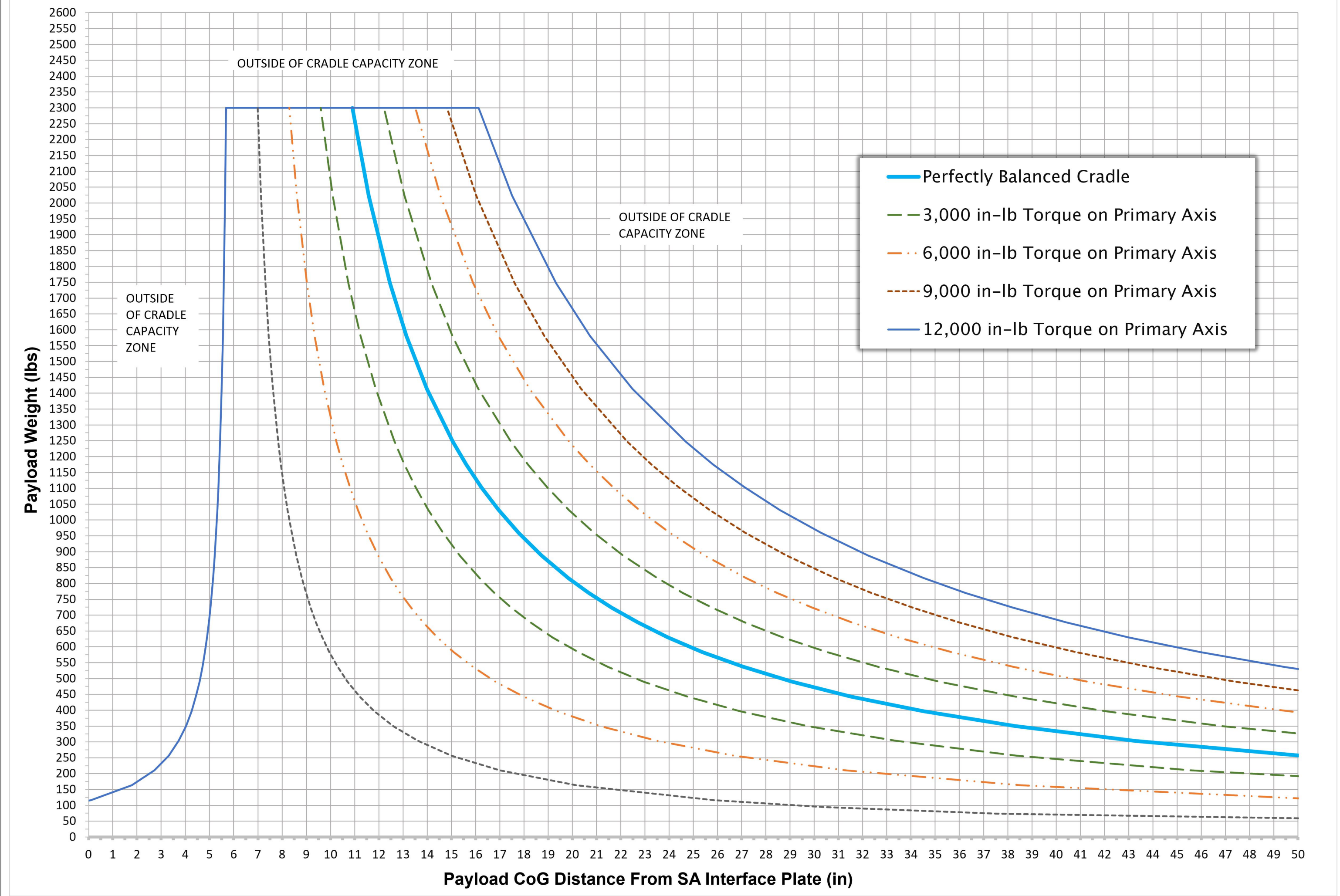


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Secondary Axis of Rotation Loading For Cradle With Gearbox - **Bolt Position 7**

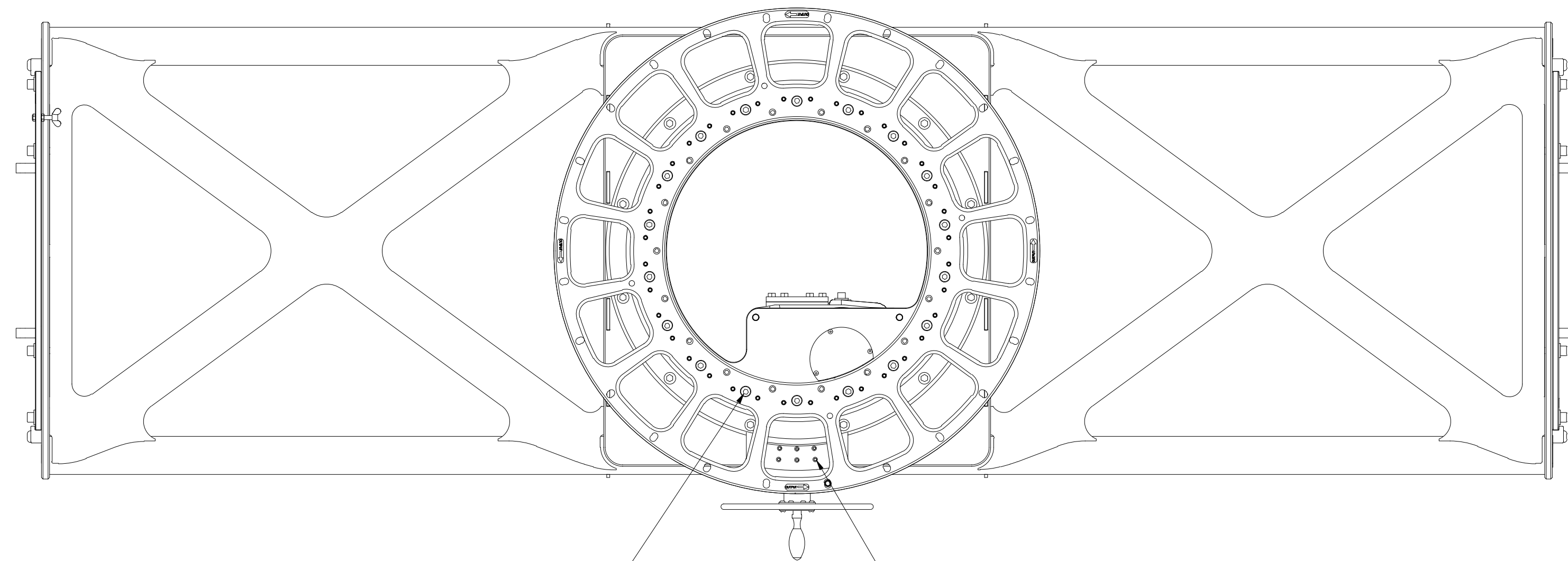


Secondary Axis of Rotation Loading For Cradle With Gearbox - **Bolt Position 8**



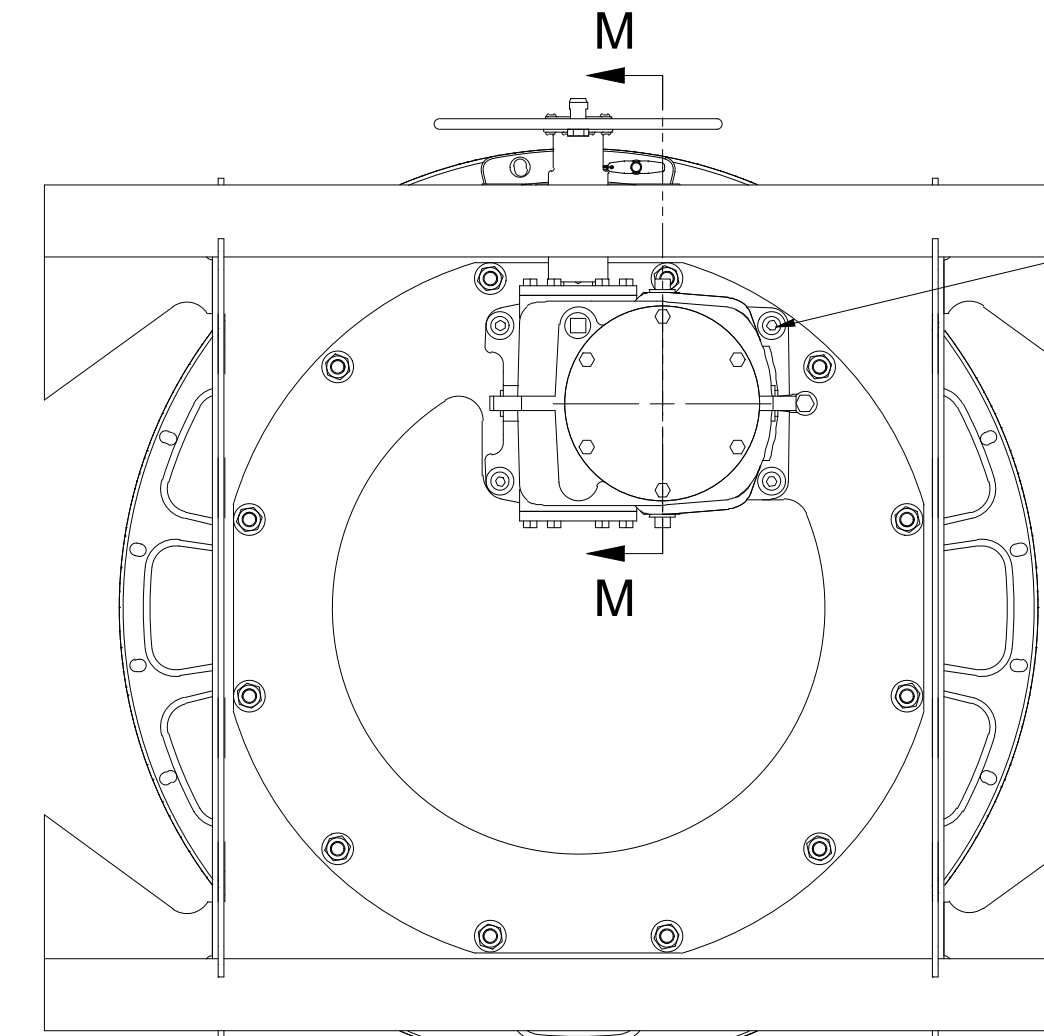
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BOLT TORQUE AND LUBRICATION INFORMATION



F 004-0025-SS
26-30 FT-LBS
Loctite 242 (Blue) 18
SHCS, .500-13 X 1.00, SS

B 004-0408-SS
36-41 IN-LBS
Loctite 242 (Blue) 10
SHCS, .250-20 X 1.00, SS



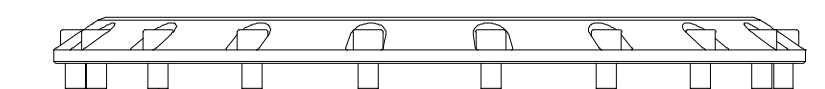
VIEW H-H
SCALE 1 : 8

G 004-0060-SS
26-30 FT-LBS
Loctite 242 (Blue) 4
SHCS, .500-13 X 2.75, SS

M MOBILUX EP2 (OR EQUIVALENT) 1
SLEWING RING INNER RACEWAY

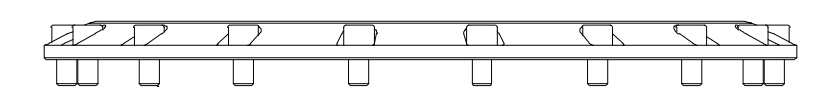
L MOBILTAC 375NC (OR EQUIVALENT) 1
TO ALL SLEWING RING TEETH
SECTION M-M
SCALE 1 : 4

R15 OPTION



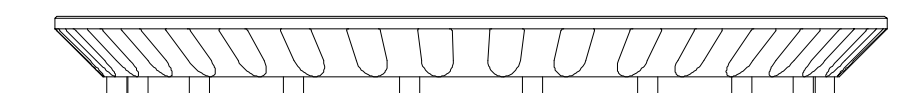
I 004-0284-SS
53-60 FT-LB
Loctite 242 (Blue) 18
SHCS, .625-11 X 1.25, SS

R18 OPTION

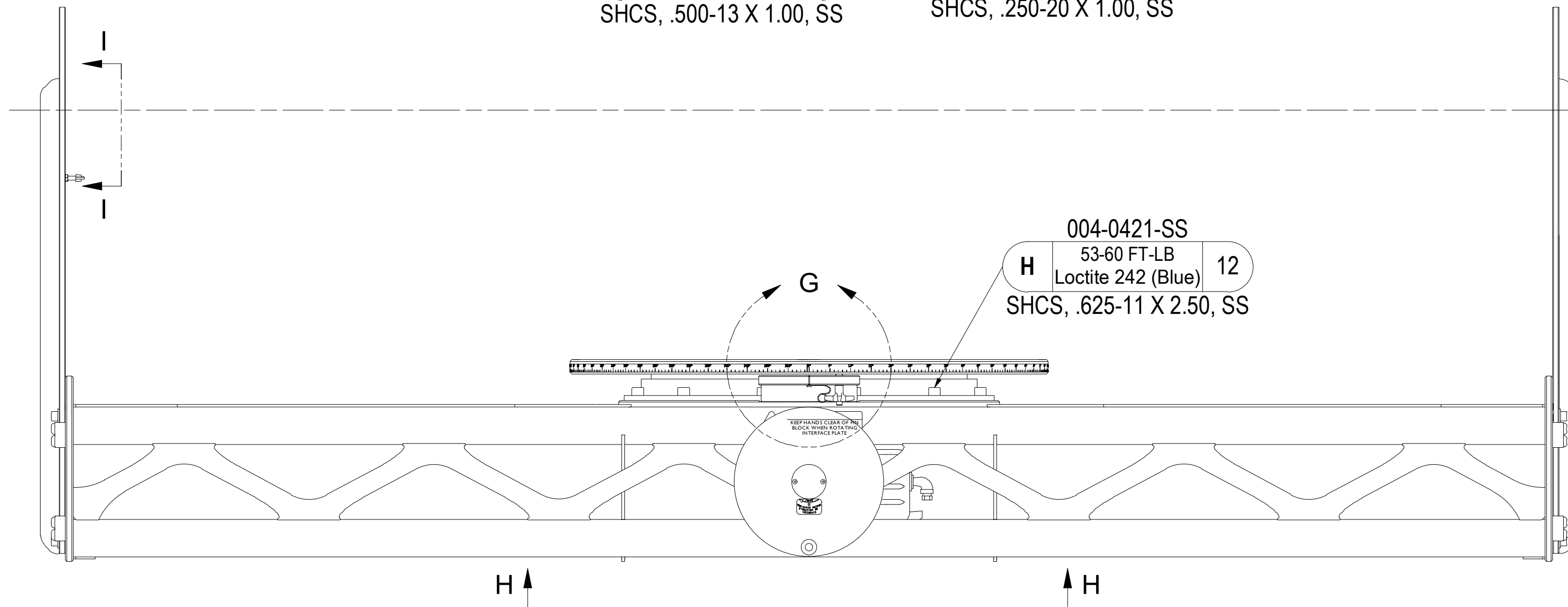


J 004-0284-SS
53-60 FT-LB
Loctite 242 (Blue) 18
SHCS, .625-11 X 1.25, SS

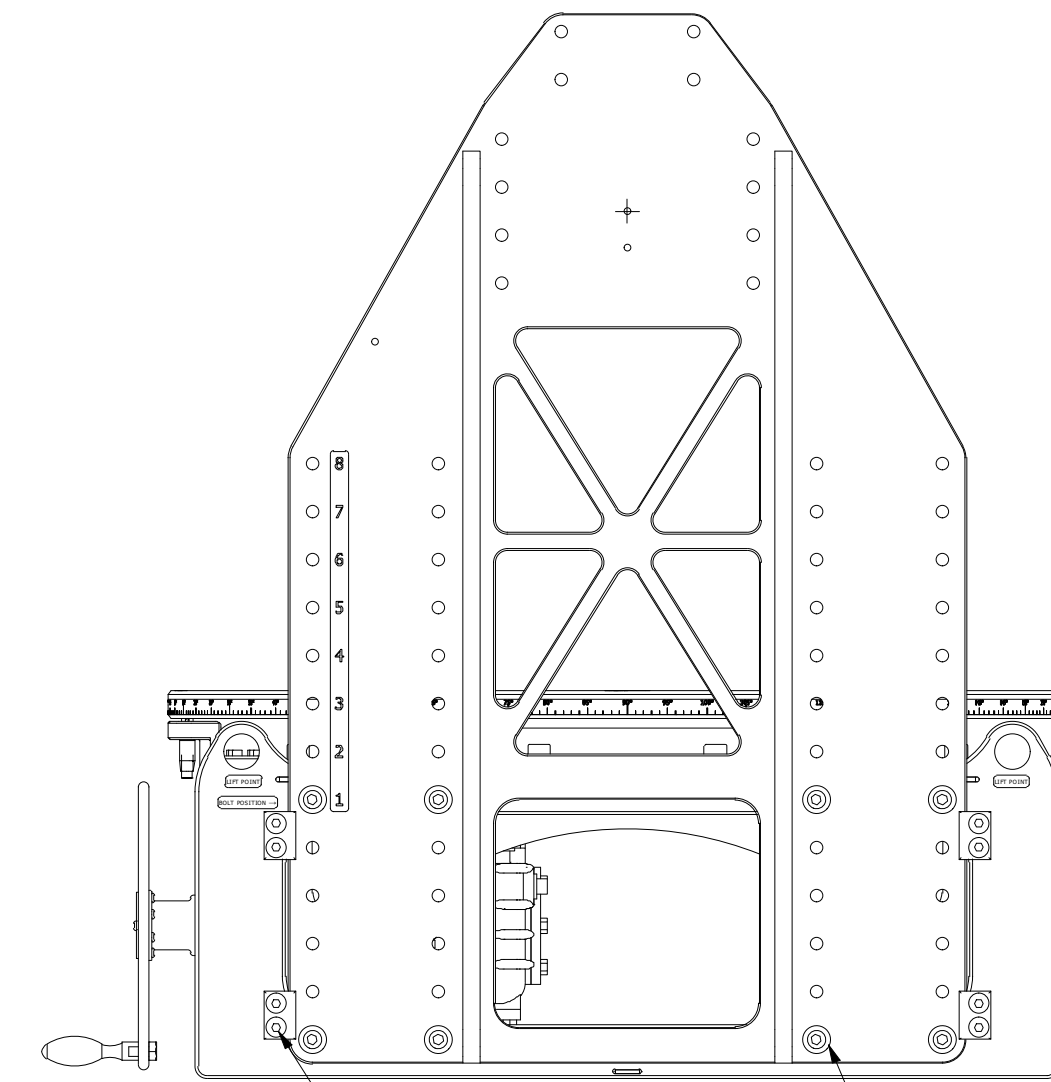
R24 OPTION



K 004-0047-SS
53-60 FT-LB
Loctite 242 (Blue) 18
SHCS, .625-11 X 1.75, SS

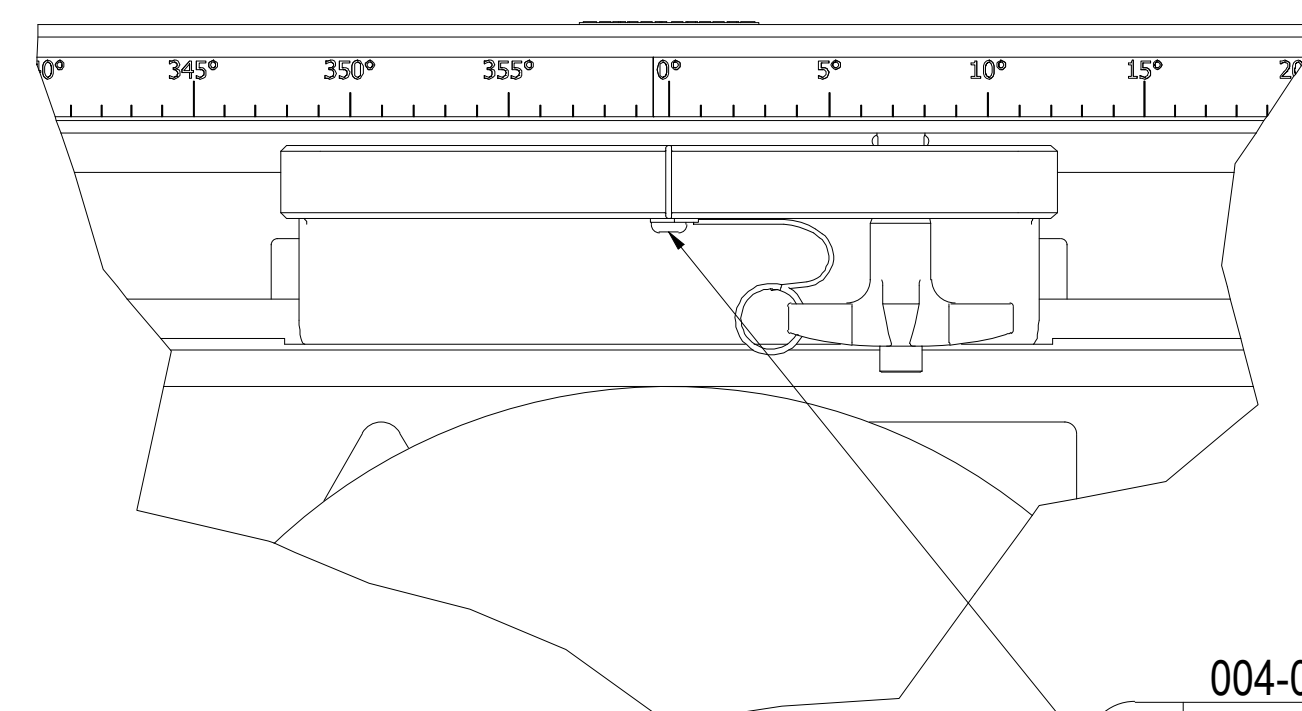


H 004-0421-SS
53-60 FT-LB
Loctite 242 (Blue) 12
SHCS, .625-11 X 2.50, SS



D 002-0064-SS
26-30 FT-LBS
Krytox GPL207 16
WASHER, .500 NOM ID, FLAT, THICK, SS

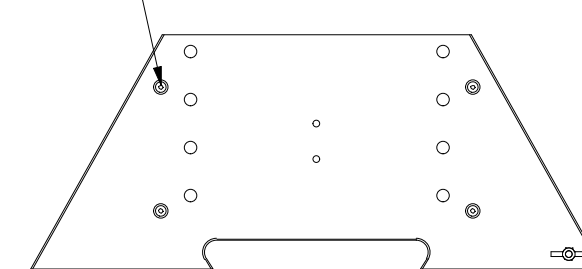
E 004-0419-SS
26-30 FT-LBS
Loctite 242 (Blue) 16
SHCS, .500-13 UNC X 1.25 BUTTON, SS



DETAIL G
SCALE 1 : 2

A 004-0104-SS
18-20 IN-LBS
Loctite 242 (Blue) 1
SHCS, #10-32 X .375 BUTTON, SS

C 004-0197-SS
36-41 IN-LBS
Loctite 242 (Blue) 32
SFHCS, .250-20 X 1.00 FLAT HEAD, SS



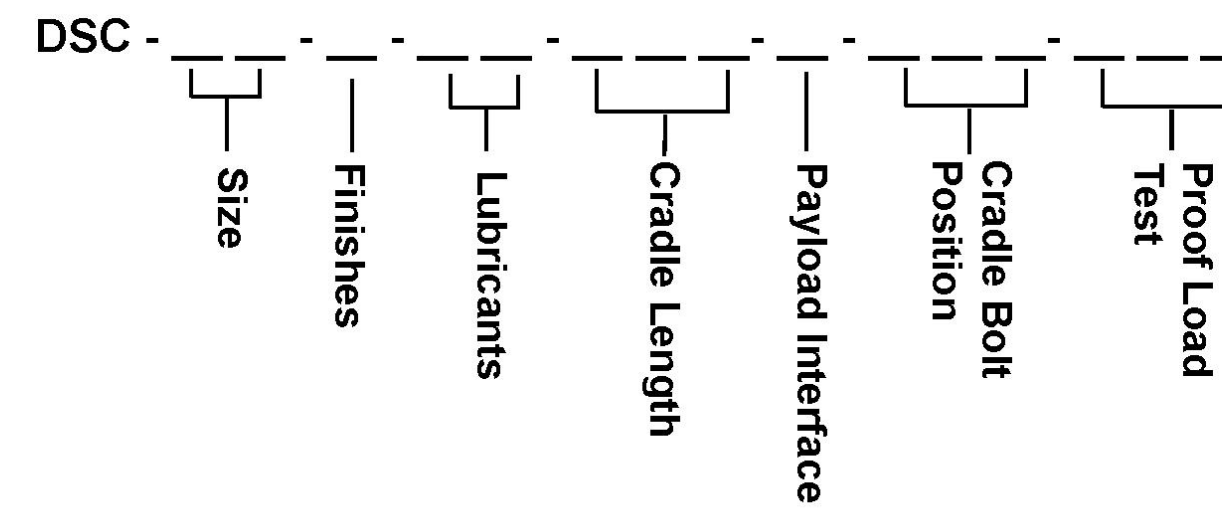
SECTION I-I
SCALE 1 : 8

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Dual Support Cradle

Creating a model number



Size

- P1 – Capacity: 700 lbs @ 24" – Manual rotation, pinned.¹
- P2 – Capacity: 2,500 lbs @ 30" – Manual rotation, pinned.²
- G2 – Capacity: 2,300 lbs @ 30" – Gearbox driven rotation.³

Finishes

- (blank) - Standard finishes.⁴
- C - - - - Clean room finishes – Same as standard with gloss white powder coated frame. Slewing ring lubricated with Krytox.

Lubricants

- (blank) – Standard lubricants.⁵
- L1 - - - - Braycote 601EF on gear teeth (if applicable) & fasteners.

Cradle Length

- B060 - - - 60" Standard length for P1 size.
- B120 - - - 120" Standard length for P2 & G2 size.
- Special length cradles available upon request in increments of 20".⁶*

Proof Load Test

- (blank) - No proof load test.
- PLT - - - Standard proof load test. Static 2X vertical load, 100% torque. (includes deliverable report)

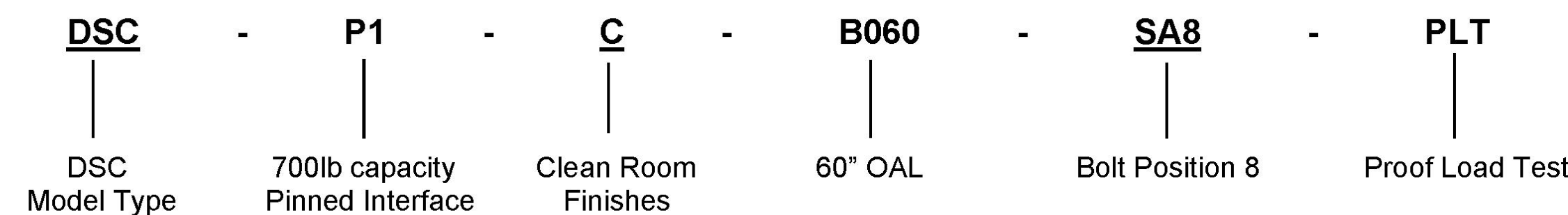
Cradle Bolt Position

- SA1 - - - Bolt Position 1
 - SA2 - - - Bolt Position 2
 - SA3 - - - Bolt Position 3
 - SA4 - - - Bolt Position 4
 - SA5 - - - Bolt Position 5
 - SA6 - - - Bolt Position 6
 - SA7 - - - Bolt Position 7
 - SA8 - - - Bolt Position 8
- See proposal drawing load curves to determine correct bolt position. Bolt positions can be changed in the field, but the bolt position selected will be the bolt position fixture is shipped with.*

Payload Interface

- (blank) – ESPA Grande/MLB interface. 36X ¼-28 UNF threaded holes on a Ø24" bolt circle.
- R15 - - - MLB Adapter ring included for 24X Ø.281 through holes on a Ø15" bolt circle.
- R18 - - - MLB Adapter ring included for 28X Ø.281 through holes on a Ø18.25" bolt circle.
- R24 - - - ESPA Grande/MLB Adapter ring included for 36X Ø.281 through holes on a Ø24" bolt circle.

Example:



¹ P1 Size designed to be used with Flotron models XD739, XD747, and SFP-645.

² P2 Size designed to be used with Flotron models SFP-759, SFP-853, and SFP-862. When used with SFP-759, load rating is reduced to 1,800 lbs cantilevered 33" max. (Cradle capacity limited by base fixture load rating. Subtract weight of cradle from base fixture max load rating to get capacity of cradle.)

³ G2 Size designed to be used with Flotron models SFP-759, SFP-853, and SFP-862. When used with SFP-759, load rating is reduced to 1,800 lbs cantilevered 33" max. (Cradle capacity limited by base fixture load rating. Subtract weight of cradle from base fixture max load rating to get capacity of cradle.)

⁴ Cradle powder coated textured Flotron blue color; Stainless steel hardware; Aluminum parts chem film or hard anodize.

⁵ Mobilnac 375NC (or equivalent) applied to all slewing ring teeth; slewing ring inner raceway lubricated with Mobilux EP2. Fasteners lubricated with Loctite 242 or Krytox.

⁶ Cradle length specified will affect load ratings and load curves. For cradles shorter than standard, load rating will stay the same. For cradles longer than standard length, load ratings will be lower.

For more information, questions, or to request a quote for this product, please contact Flotron sales at:

P: 760-727-2700 E: sales@flotron.com

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		SCALE 1 : 2	SIZE D