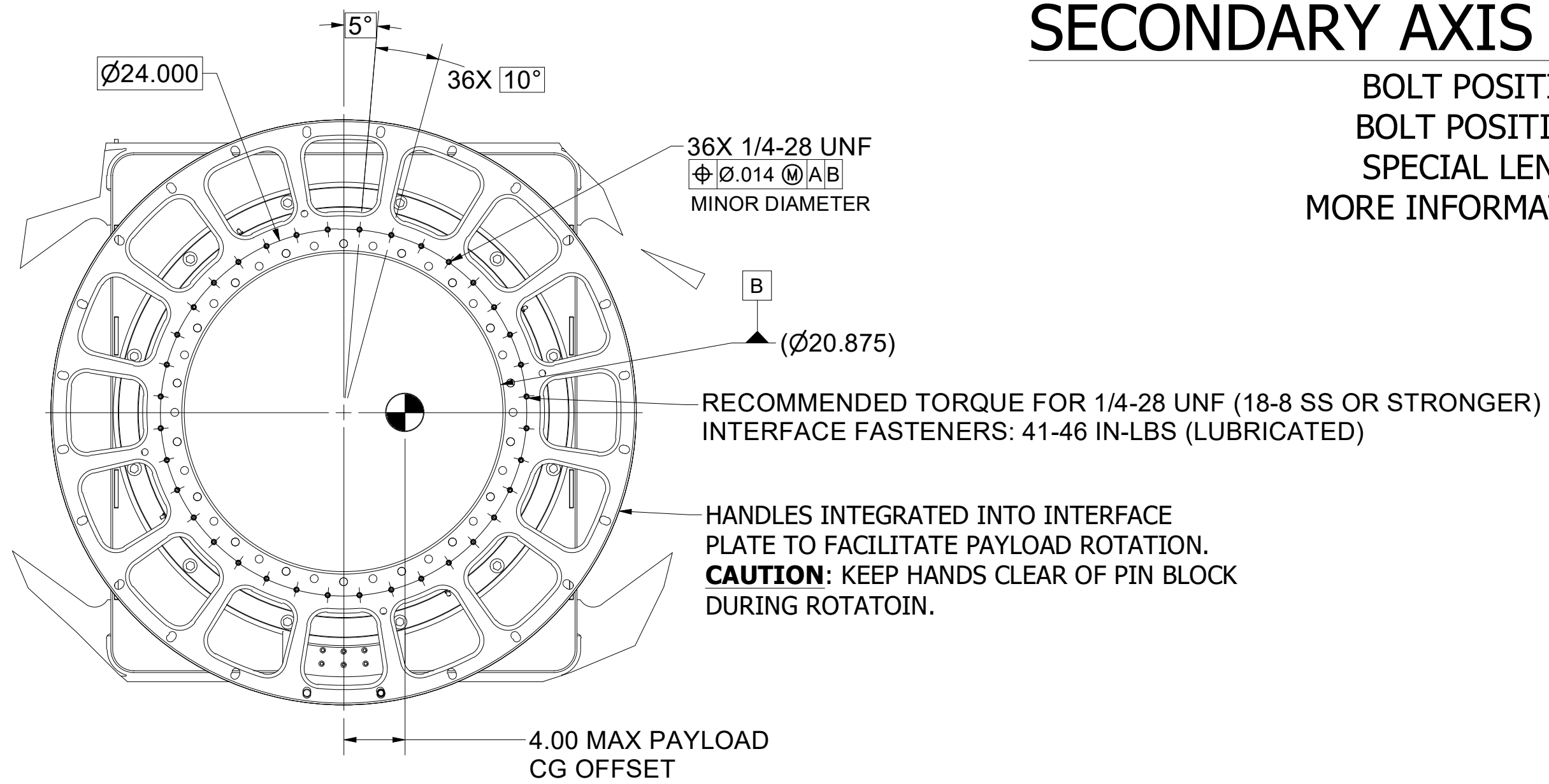
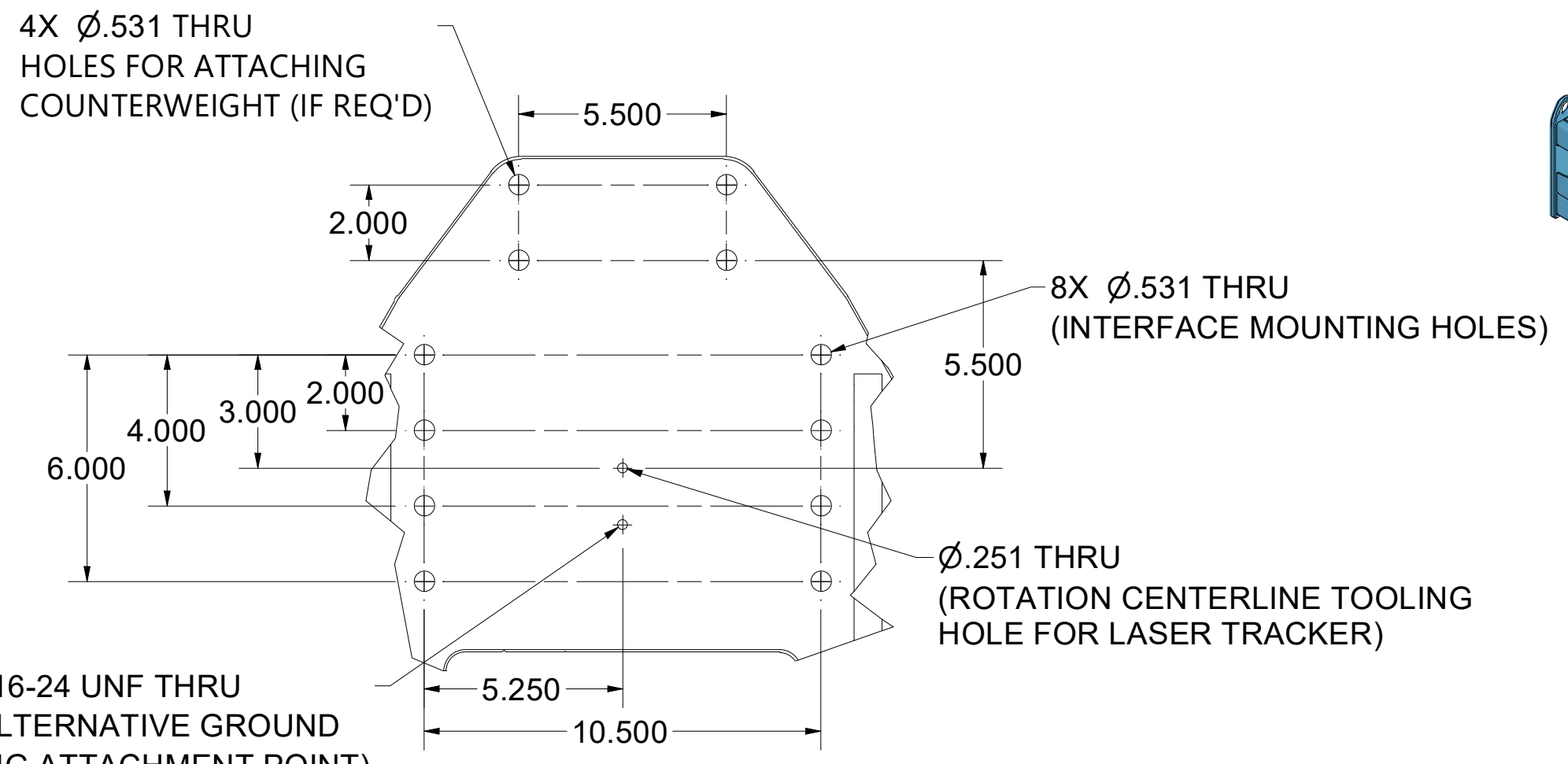


SECONDARY AXIS OF ROTATION CRADLE - PINNED INTERFACE (SA1-SA8)

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.

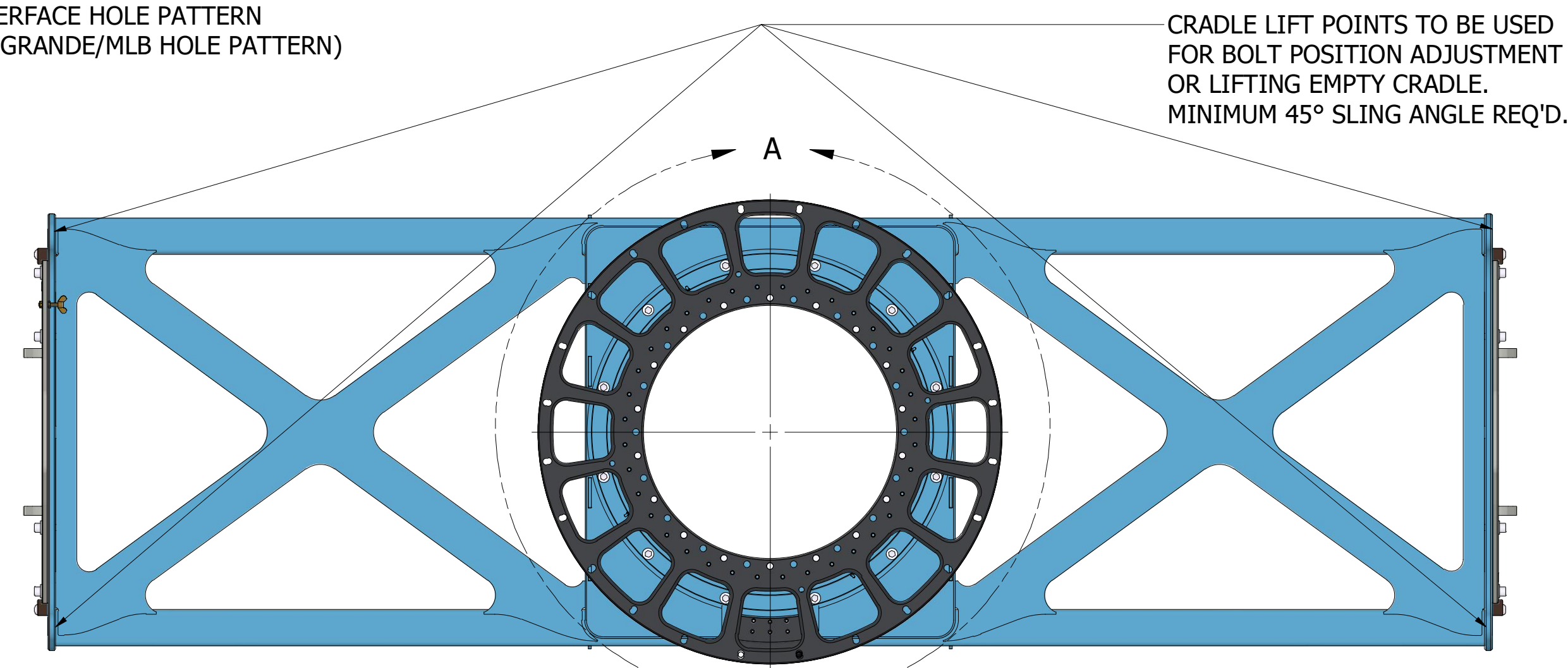
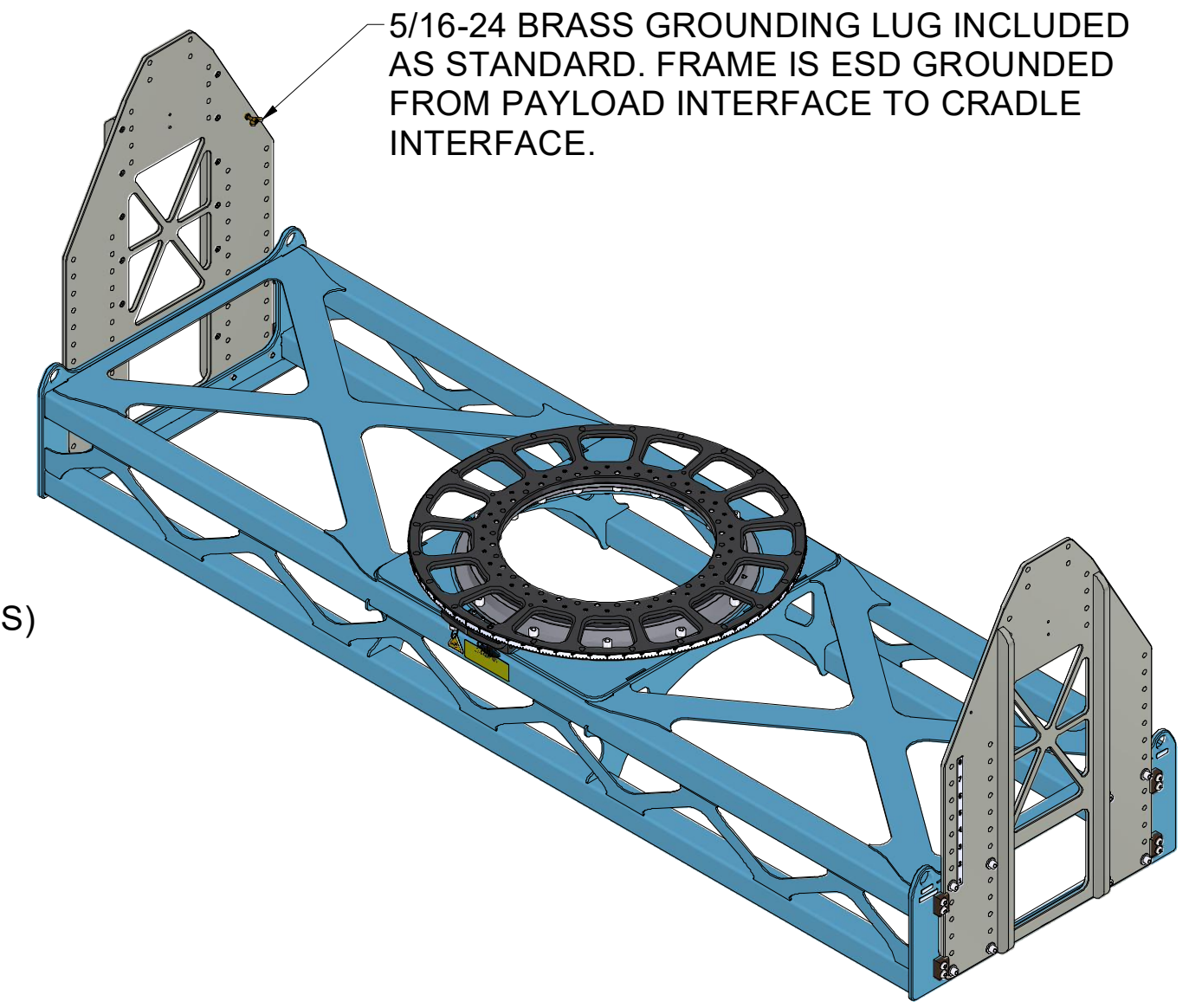


DETAIL A
 SCALE 1 : 8
 INTERFACE HOLE PATTERN
 (24" ESPA GRANDE/MLB HOLE PATTERN)



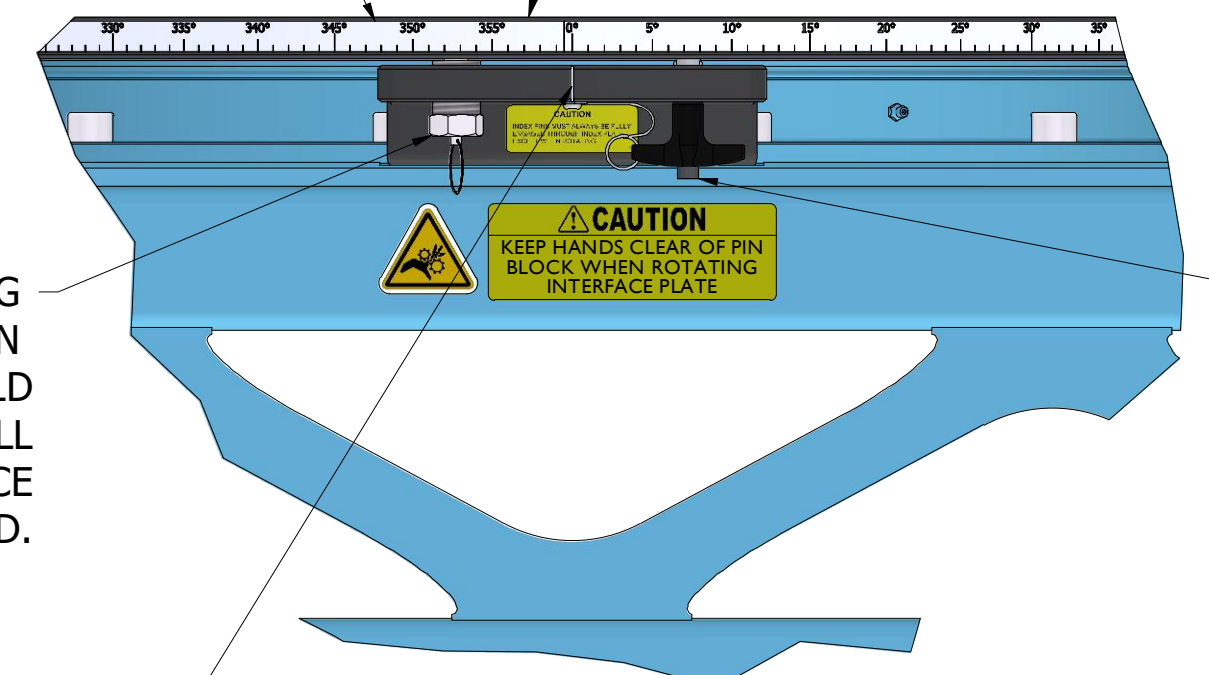
5/16-24 UNF THRU (ALTERNATIVE GROUND LUG ATTACHMENT POINT)

DETAIL D
 SCALE 1 : 4
 (TYPICAL BOTH SIDES)



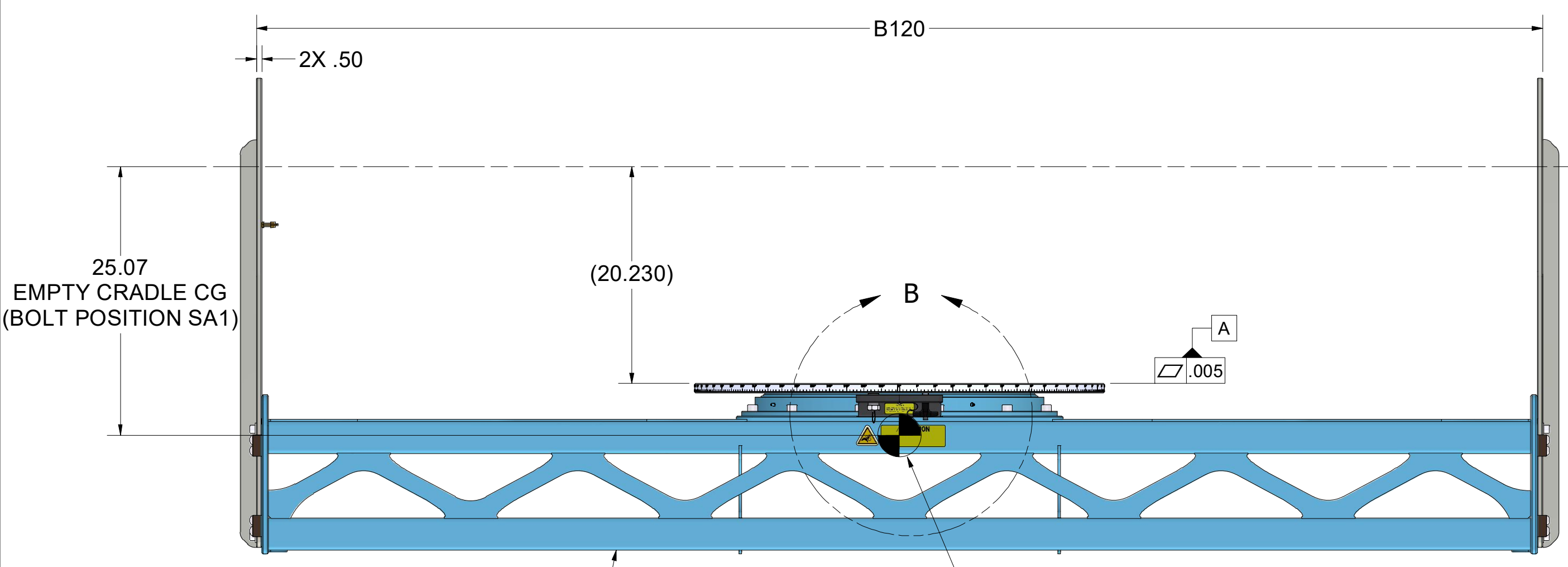
INTERFACE MUST BE IN PAYLOAD VERTICAL ORIENTATION (INTERFACE SURFACE PARALLEL TO FLOOR AS SHOWN) BEFORE REMOVING ROTATION LOCK PINS. DO NOT REMOVE IN ANY OTHER ORIENTATION.

SECONDARY REDUNDANT SPRING LOADED PIN TO LOCK ROTATION IN 15° INCREMENTS. MUST BE HELD OPEN DURING ROTATION AND WILL AUTOMATICALLY SPRING INTO PLACE WHEN RING IS RELEASED.

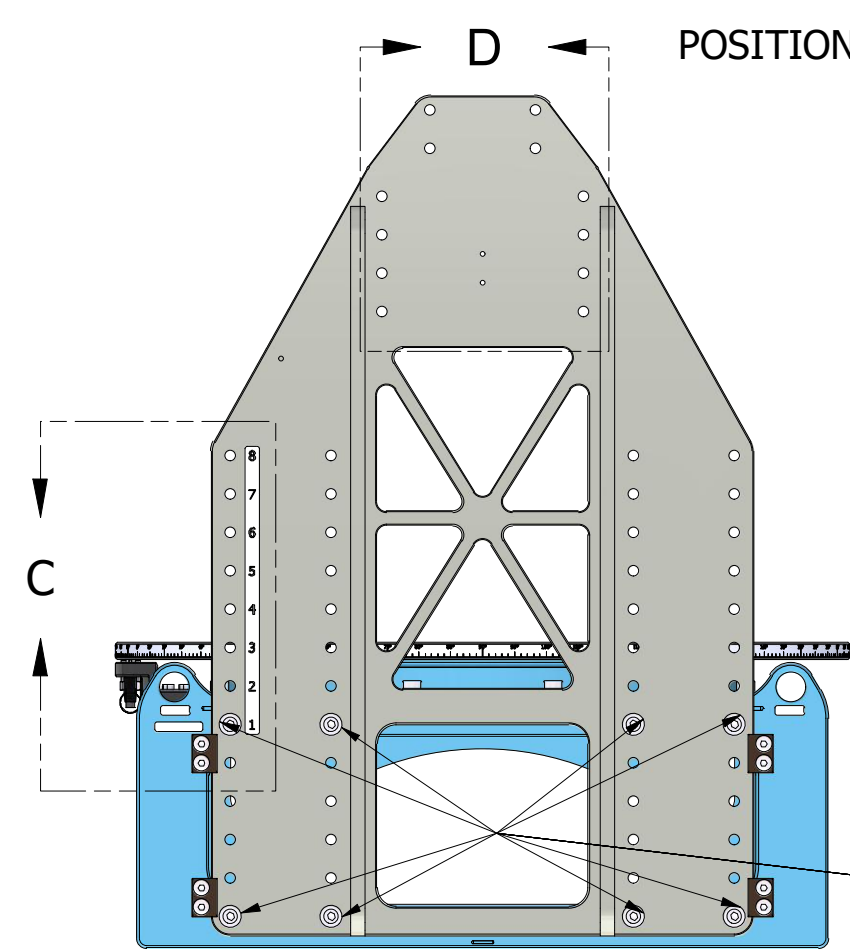


BALL LOCK PIN TO LOCK ROTATION IN 15° INCREMENTS. **MUST BE ENGAGED IN A HOLE EXCEPT WHEN ROTATING.**

DETAIL B
 SCALE 1 : 4



APPROXIMATE EMPTY CRADLE WEIGHT: 665 LBS



BOLT POSITION INDICATOR LABEL. BOLT POSITION SA1 SHOWN.

4X GUIDE BLOCKS TO FACILITATE BOLT POSITION ADJUSTMENT

DETAIL C
 SCALE 1 : 4

2. LOAD RATING: 2,500 LBS CANTILEVERED 30" FROM INTERFACE. MAX ECCENTRICITY 4" FROM SECONDARY AXIS OF ROTATION. SEE LOAD CURVES FOR LOAD RATINGS AT VARIOUS BOLT POSITIONS.

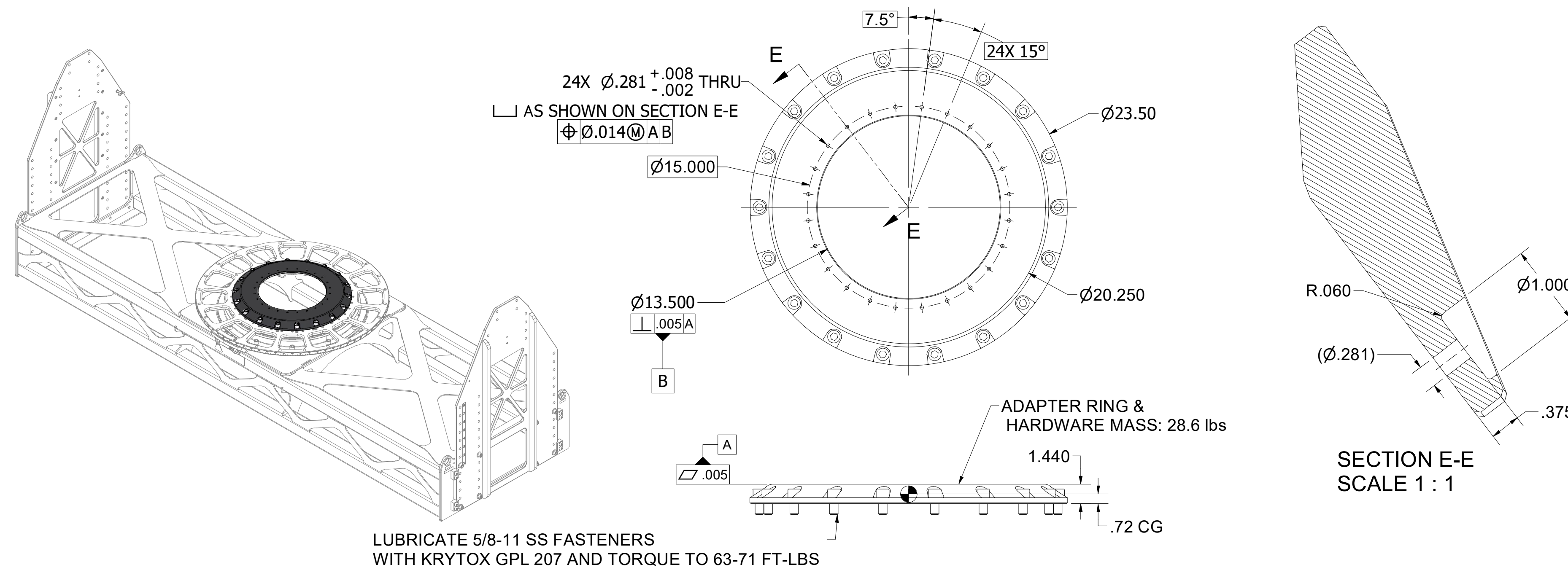
1. FINISHES:
 a) "STANDARD" FINISH: CLASS 10K (ISO 7 CLEANROOM COMPATIBLE FINISHES) - CRADLE POWDER COATED TEXTURED FLOTRON BLUE COLOR; STAINLESS STEEL HARDWARE; ALUMINUM PARTS CHEM FILM OR HARD ANODIZED; MOBILTAC 375NC (OR EQUIVALENT) TO ALL SLEWING RING TEETH; SLEWING RING INNER RACEWAY LUBRICATED WITH MOBILUX EP2 (OR EQUIVALENT). FASTENERS LUBRICATED WITH LOCTITE 242 BLUE OR KRYTOX GPL 207.
 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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	DO NOT SCALE DRAWING INTERPRET DIMENSIONING AND TOLERANCING PER ASME Y14.5-2018 INTERPRET DWG. PER ASME Y14.100		
SCALE: 1 : 10 SIZE: D DRAWING NO.: 8128-200-PINNED-PROP WT: 661.0 lbmass Cad software: Inventor	SHEET 1 OF 8		

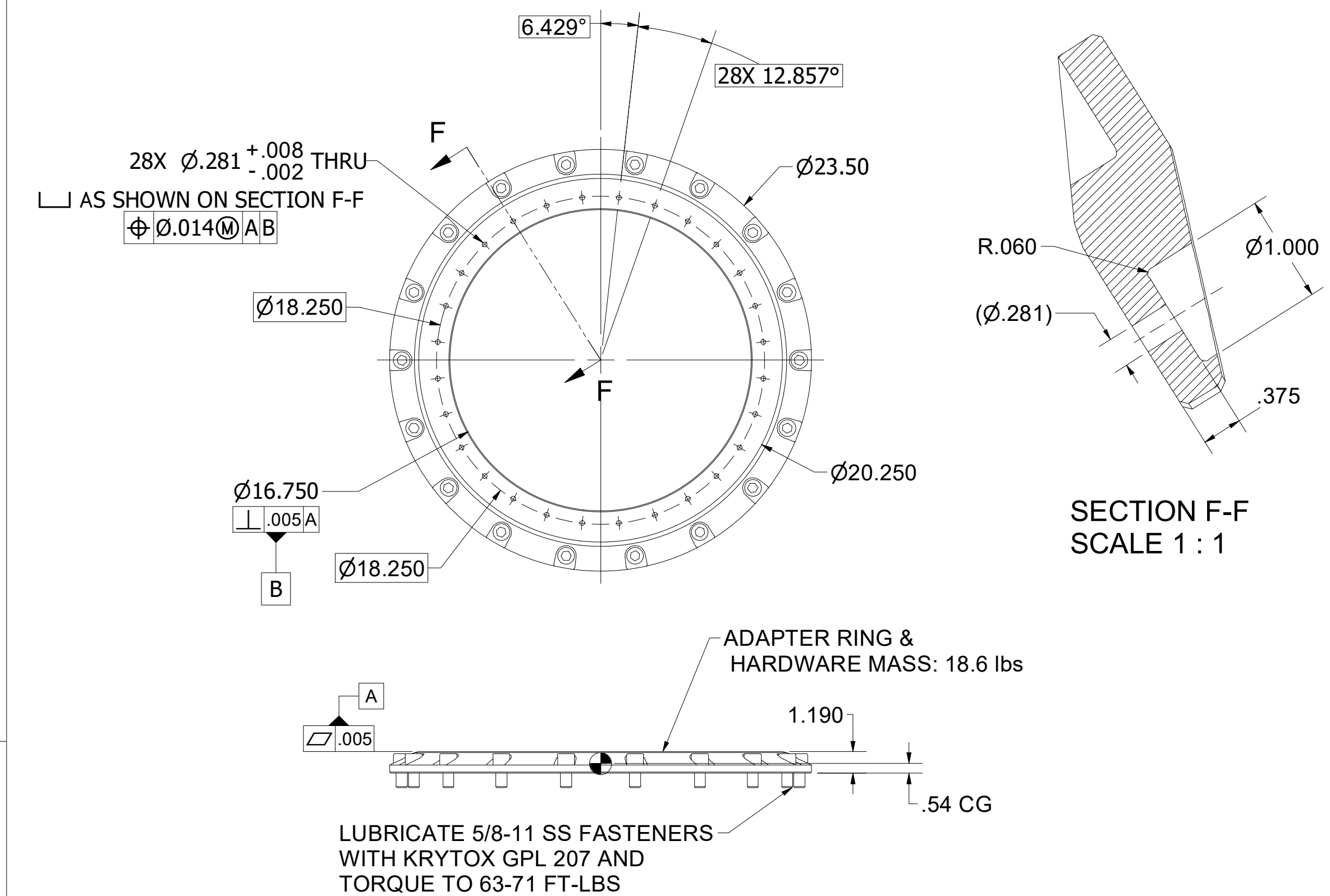
SECONDARY AXIS PAYLOAD ADAPTER RING (R15)

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.



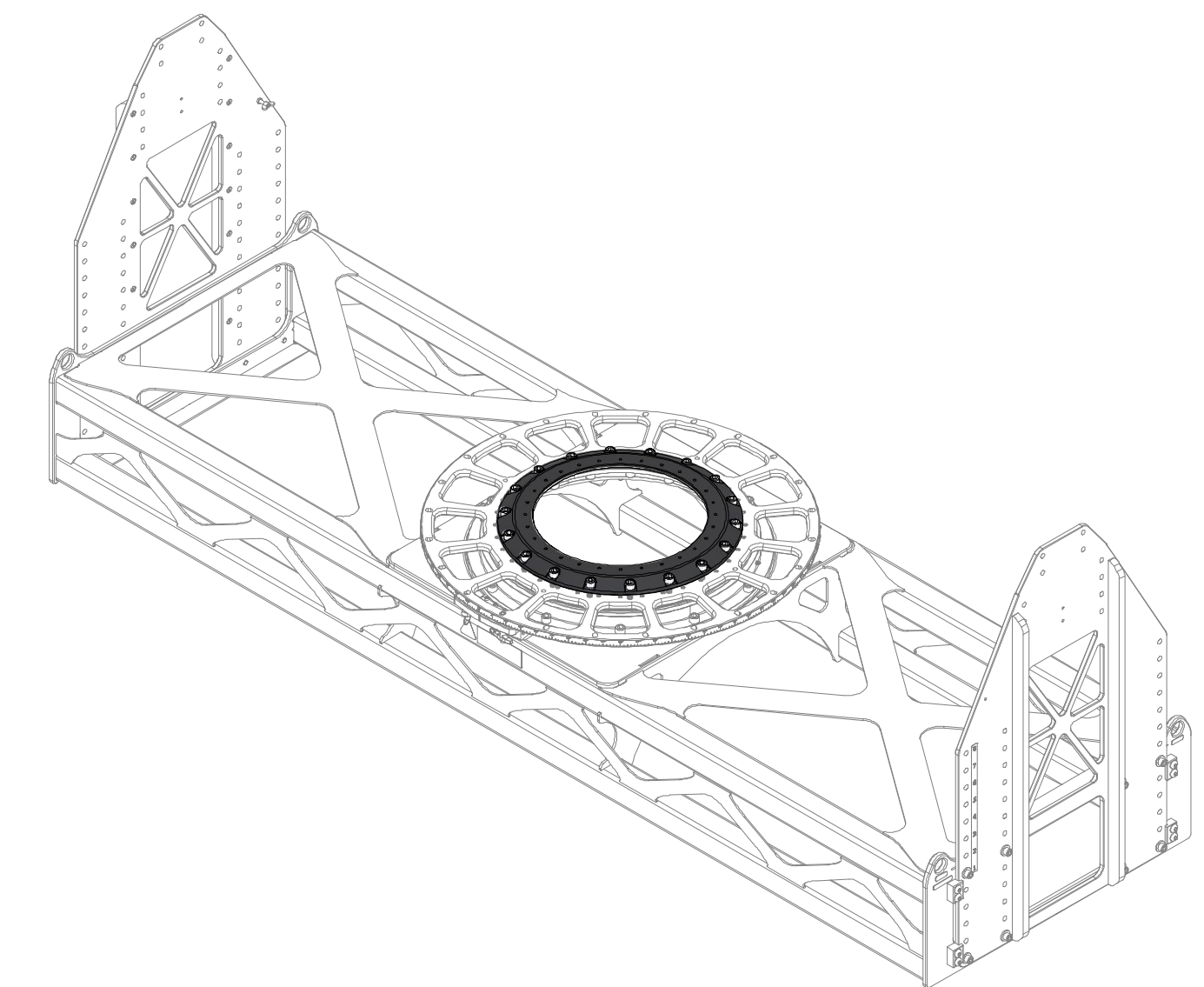
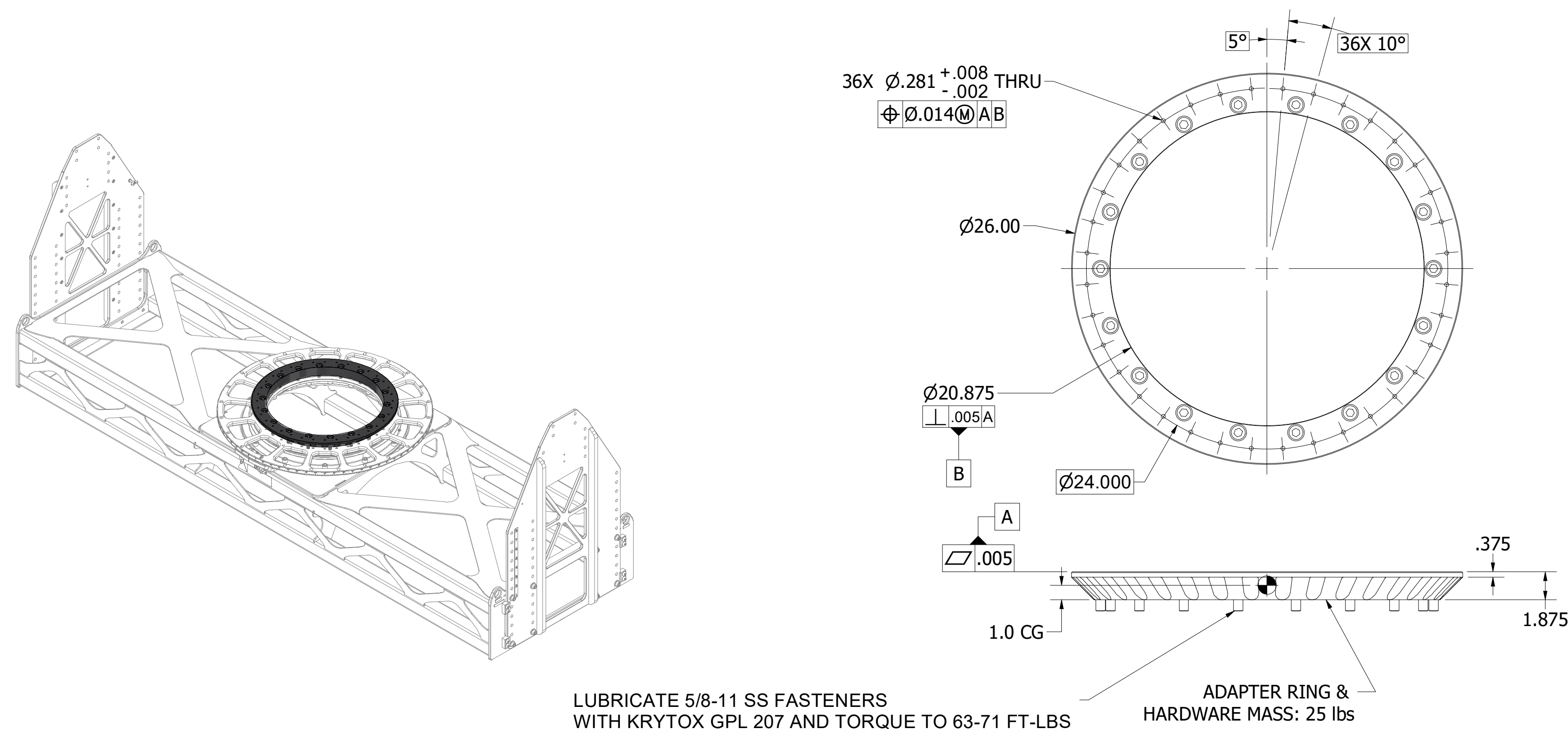
SECONDARY AXIS PAYLOAD ADAPTER RING (R18)

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)

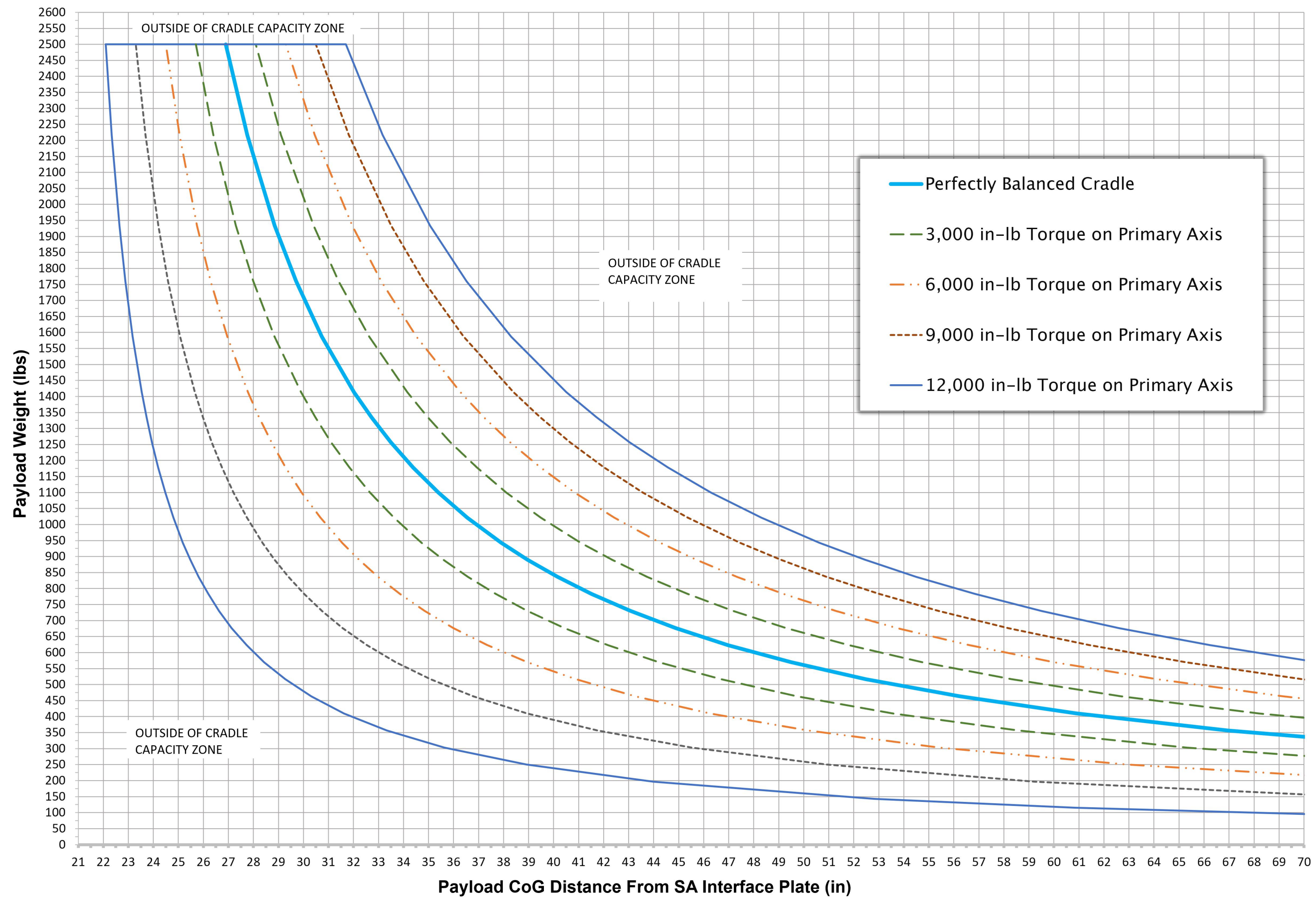
ADAPTER RING TO CONVERT SA INTERFACE THREADED HOLES
TO 36X Ø.281 THROUGH HOLES ON A Ø24.000" BOLT CIRCLE (ESPA GRANDE/MLB)
WHEN DETERMINING PAYLOAD AND CRADLE CG BALANCE, ADAPTER
RING MASS & CG NEEDS TO BE ADDED TO PAYLOAD CG CALCULATIONS.
HARD ANODIZE FINISH WITH ONE MASKED HOLE FACE FOR ESD.



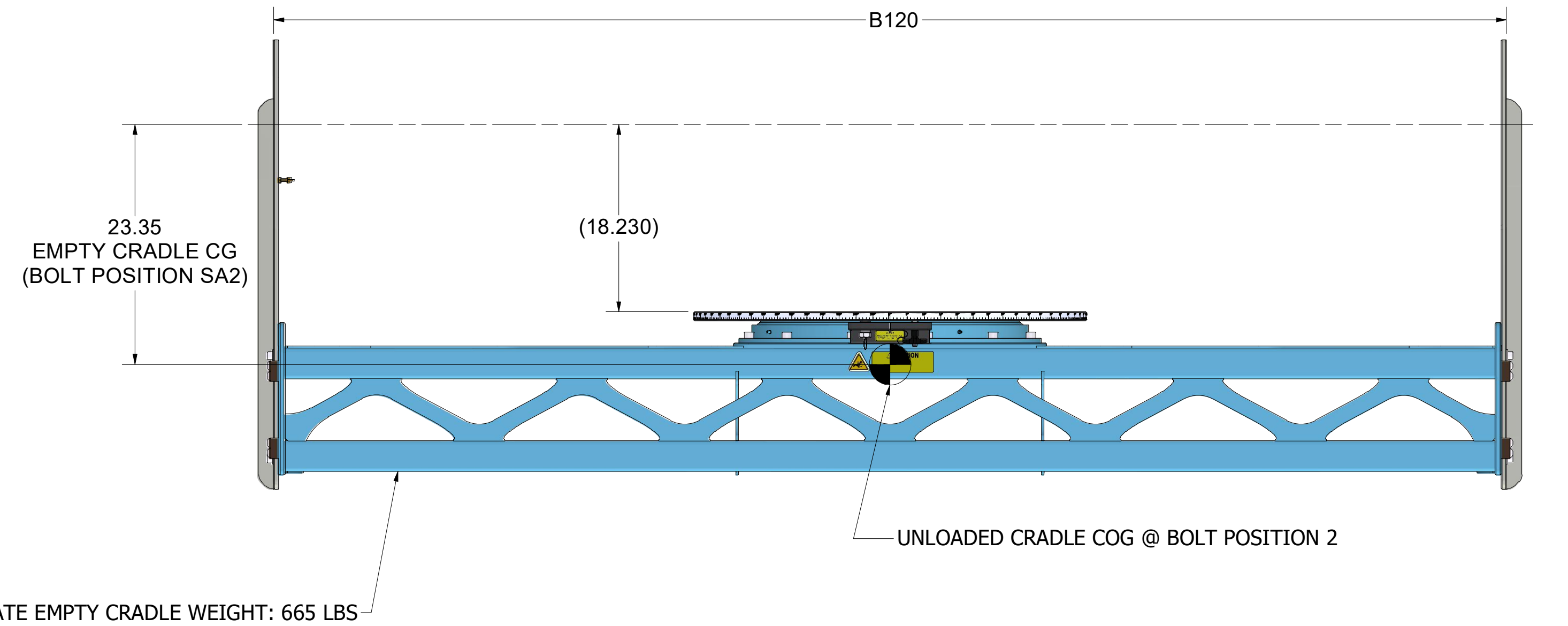
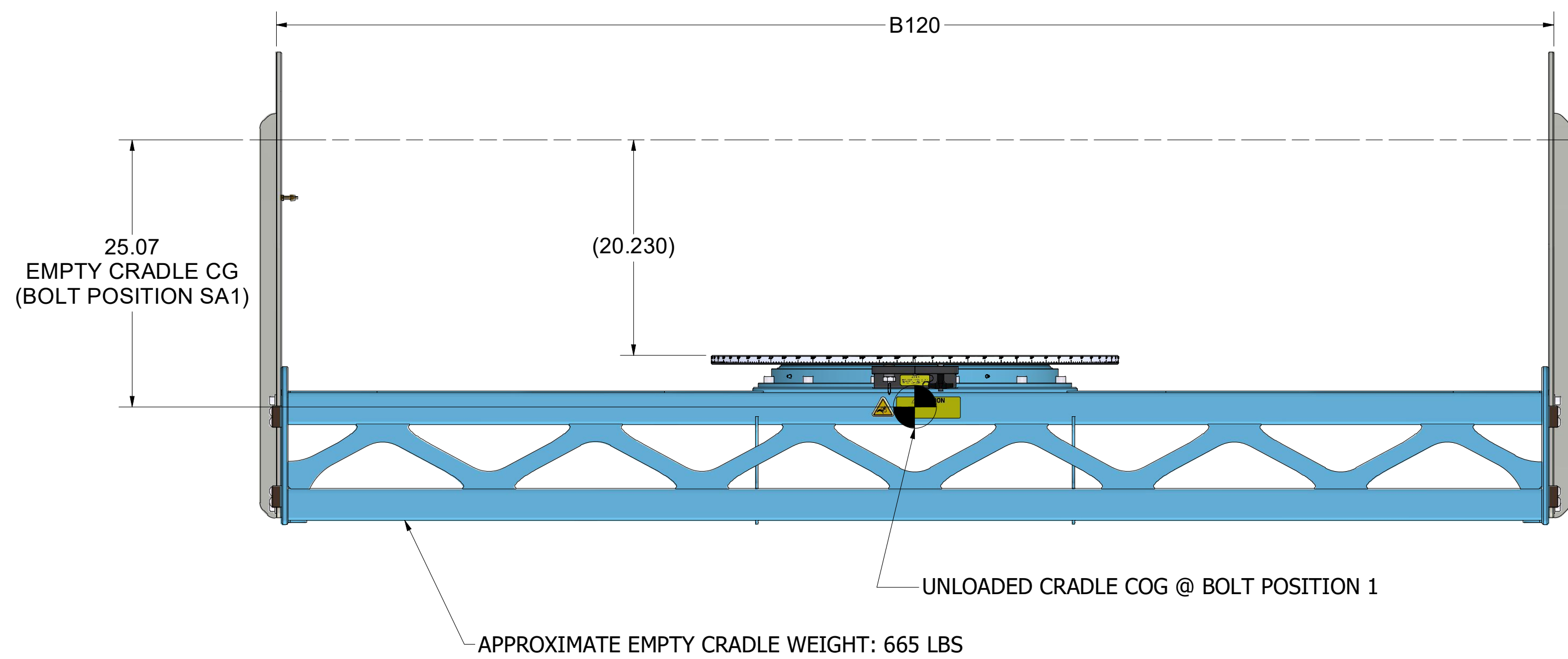
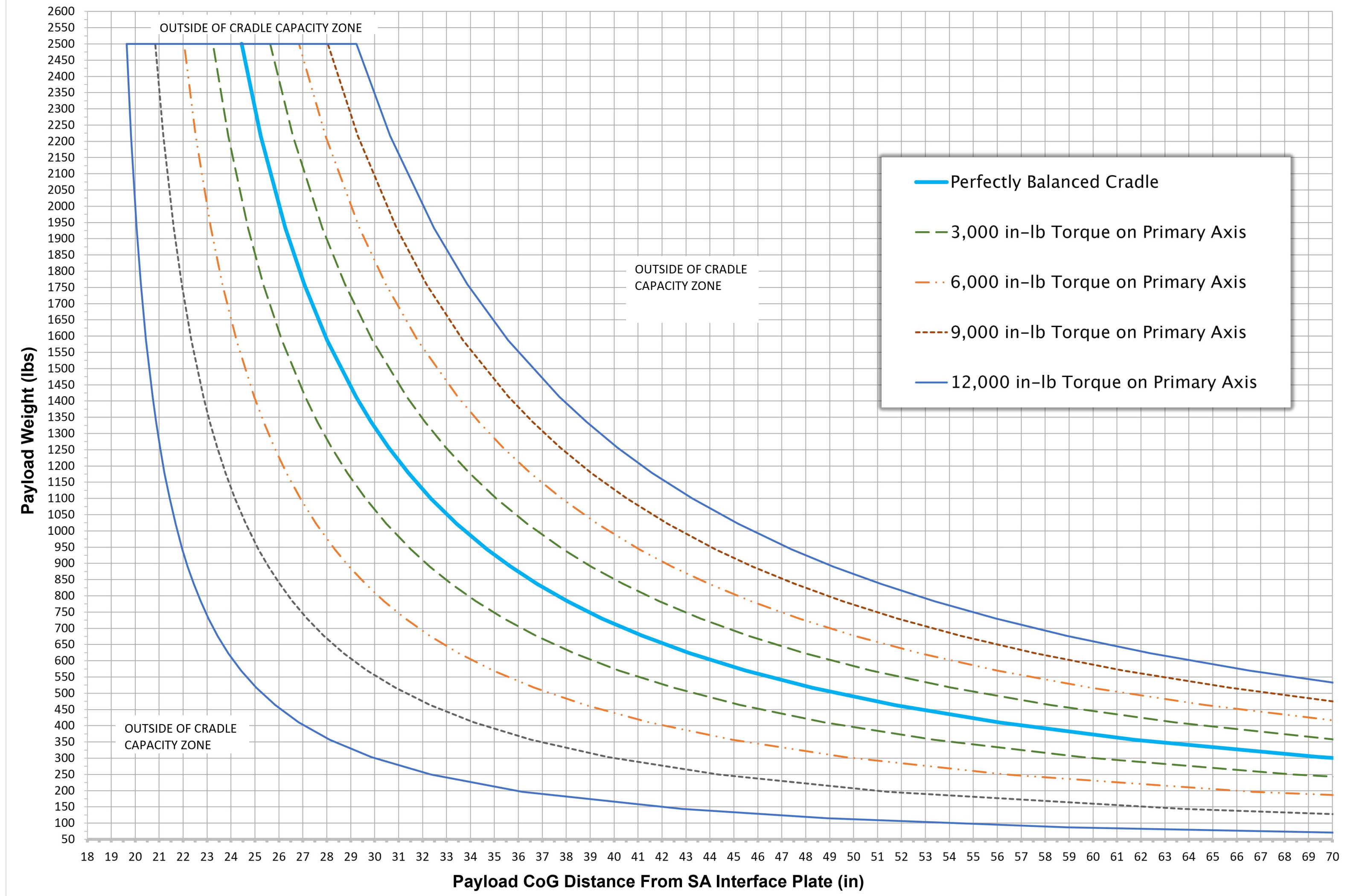
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FLOTRON [®]		2630 PROGRESS STREET VISTA, CALIFORNIA 92081 http://www.flotron.com	
SCALE	SIZE	DRAWING NO.	
1 : 2	D	8128-200-PINNED-PROP	
			SHEET 2 OF 8

Secondary Axis of Rotation Loading For Pinned Cradle Interface (No Gearbox) **Bolt Position 1**

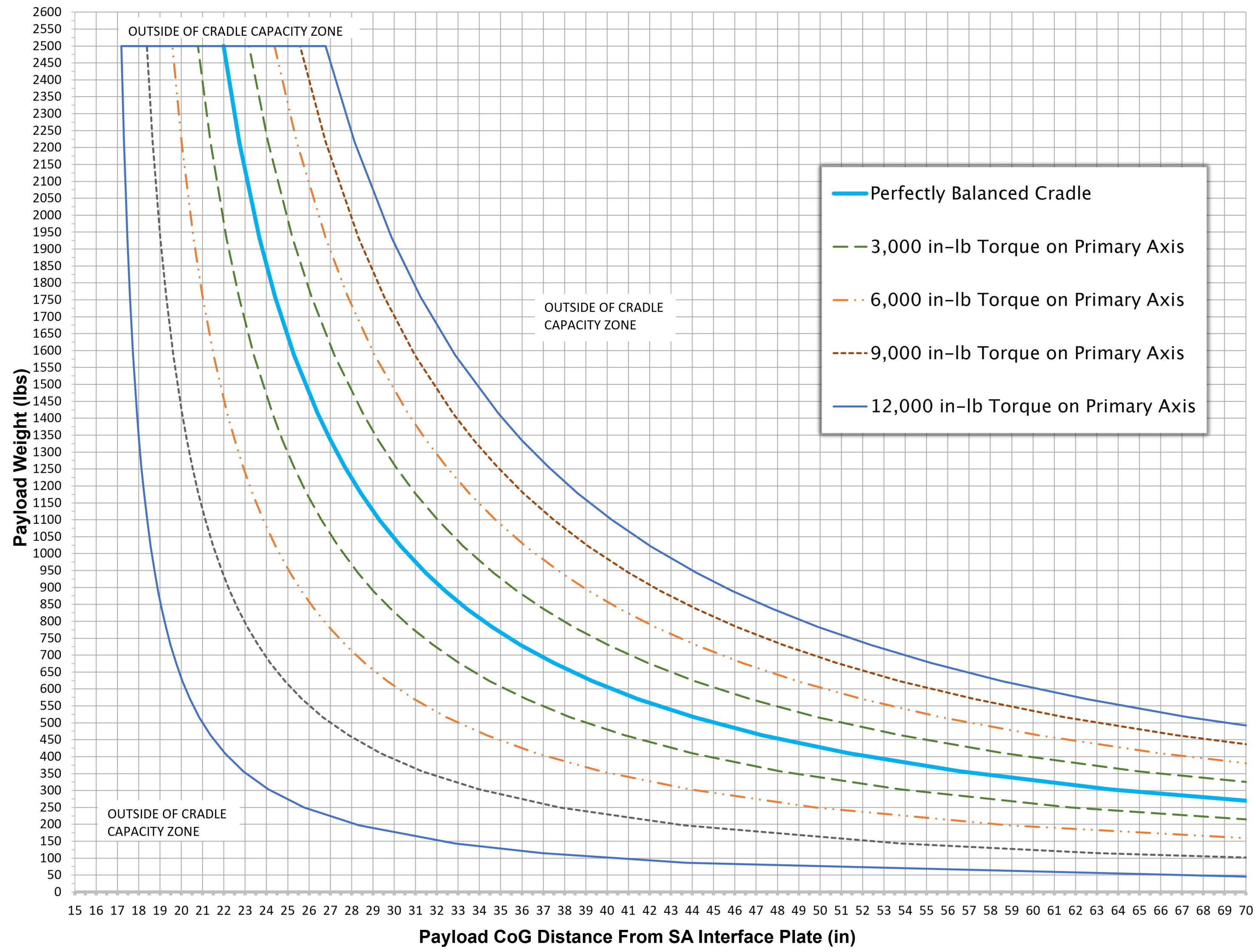


Secondary Axis of Rotation Loading For Pinned Cradle Interface (No Gearbox) **Bolt Position 2**

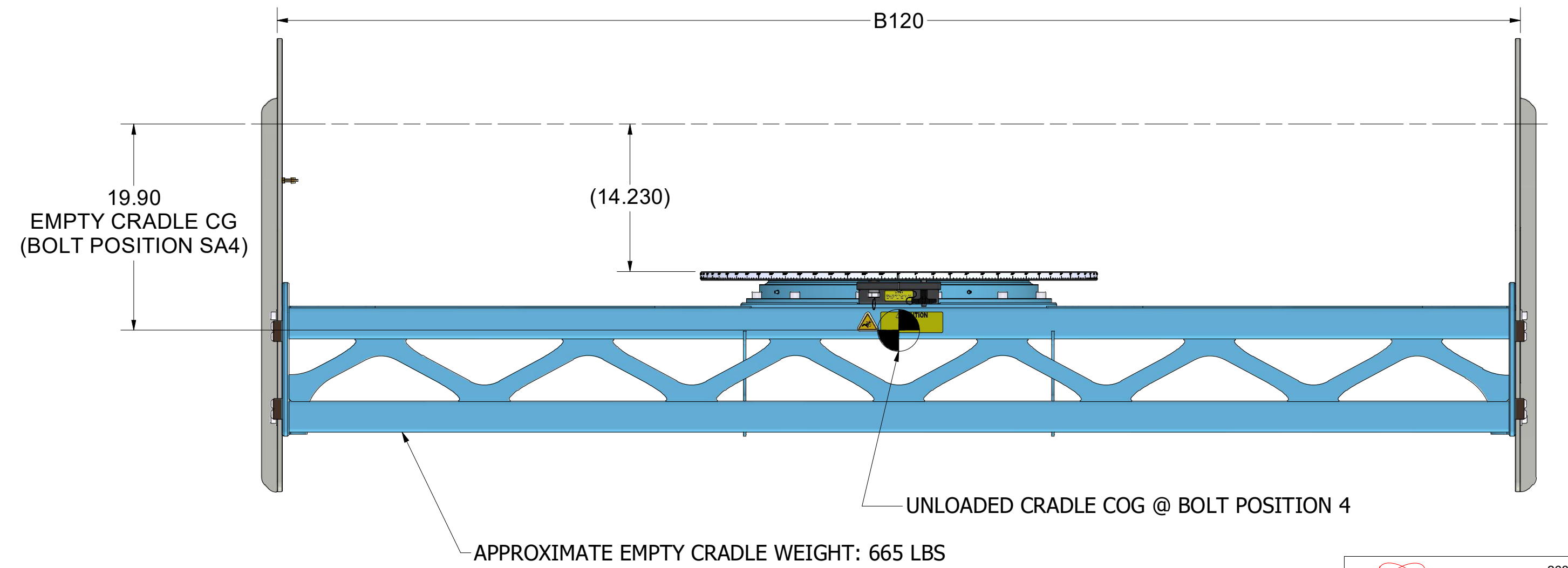
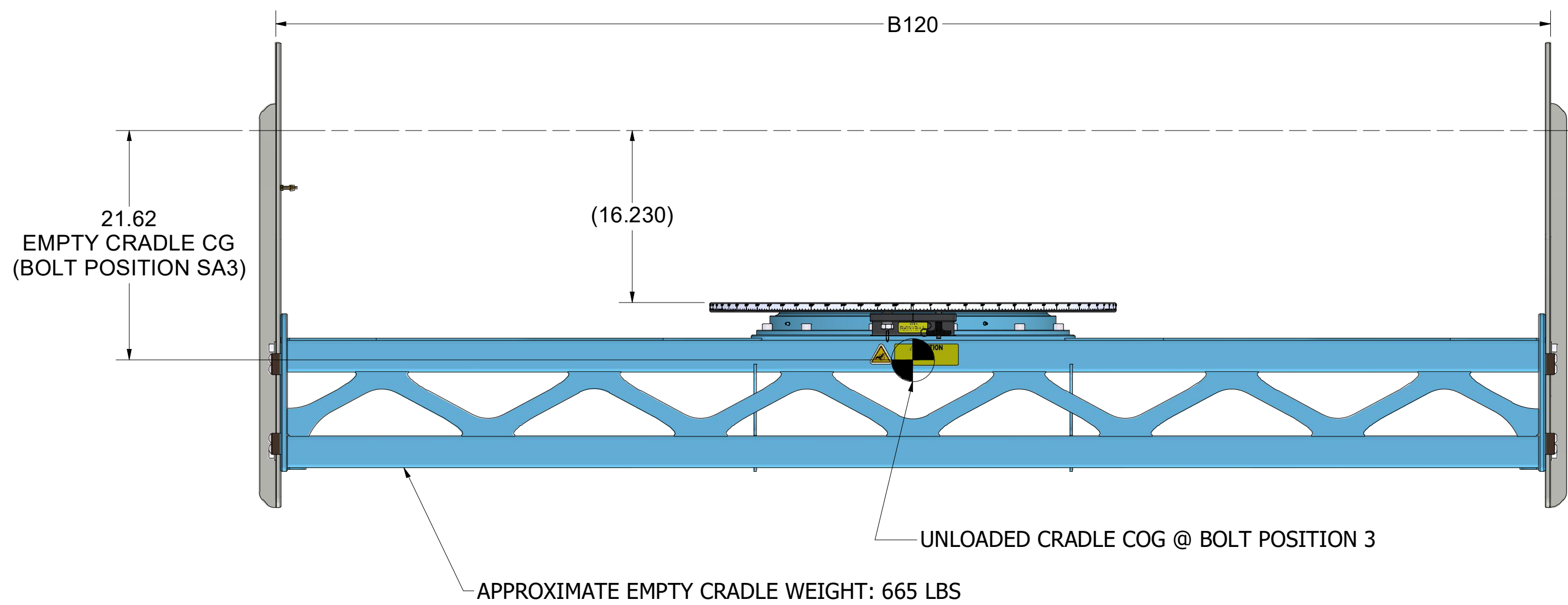
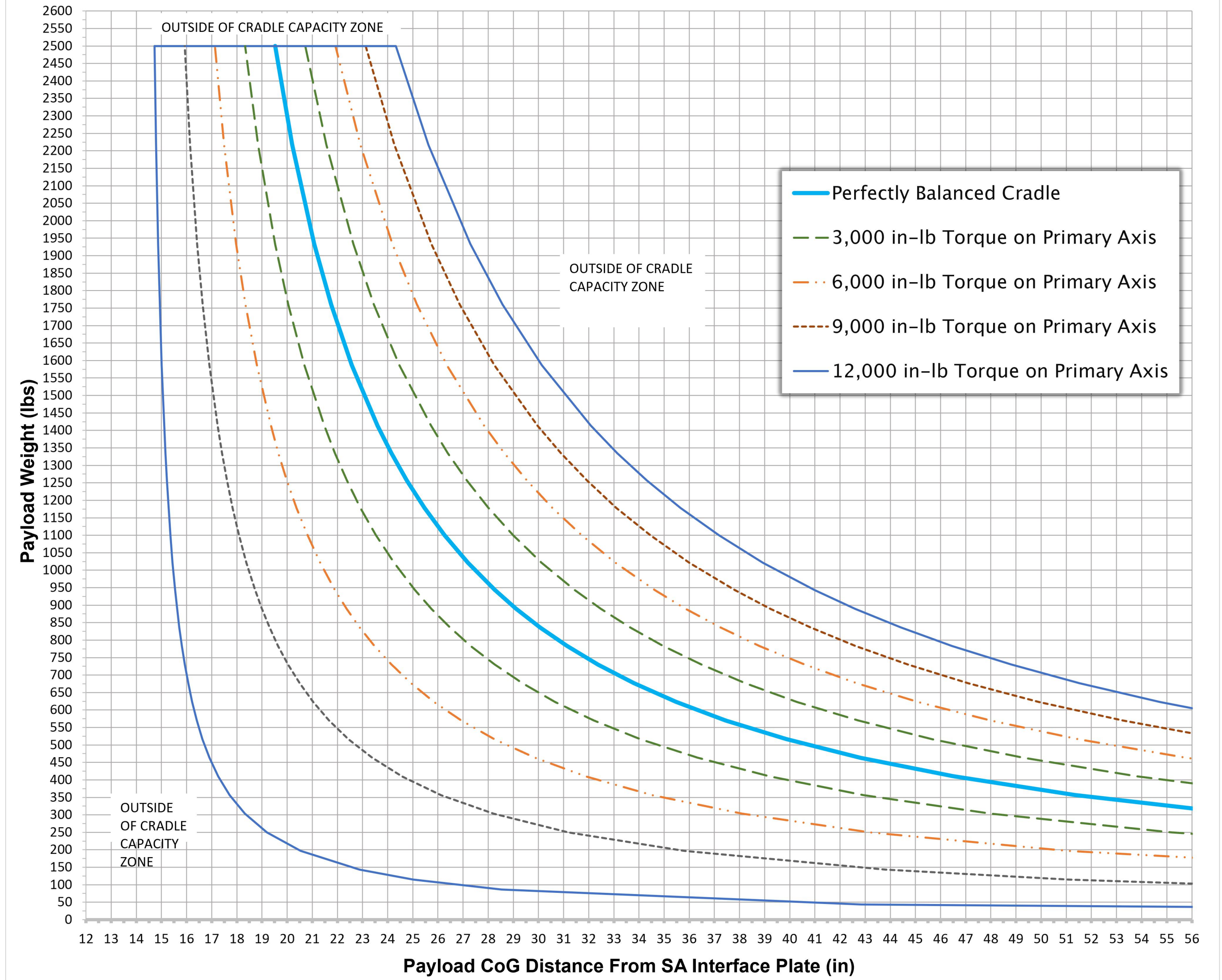


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Secondary Axis of Rotation Loading For Pinned Cradle (No Gearbox) **Bolt Position 3**

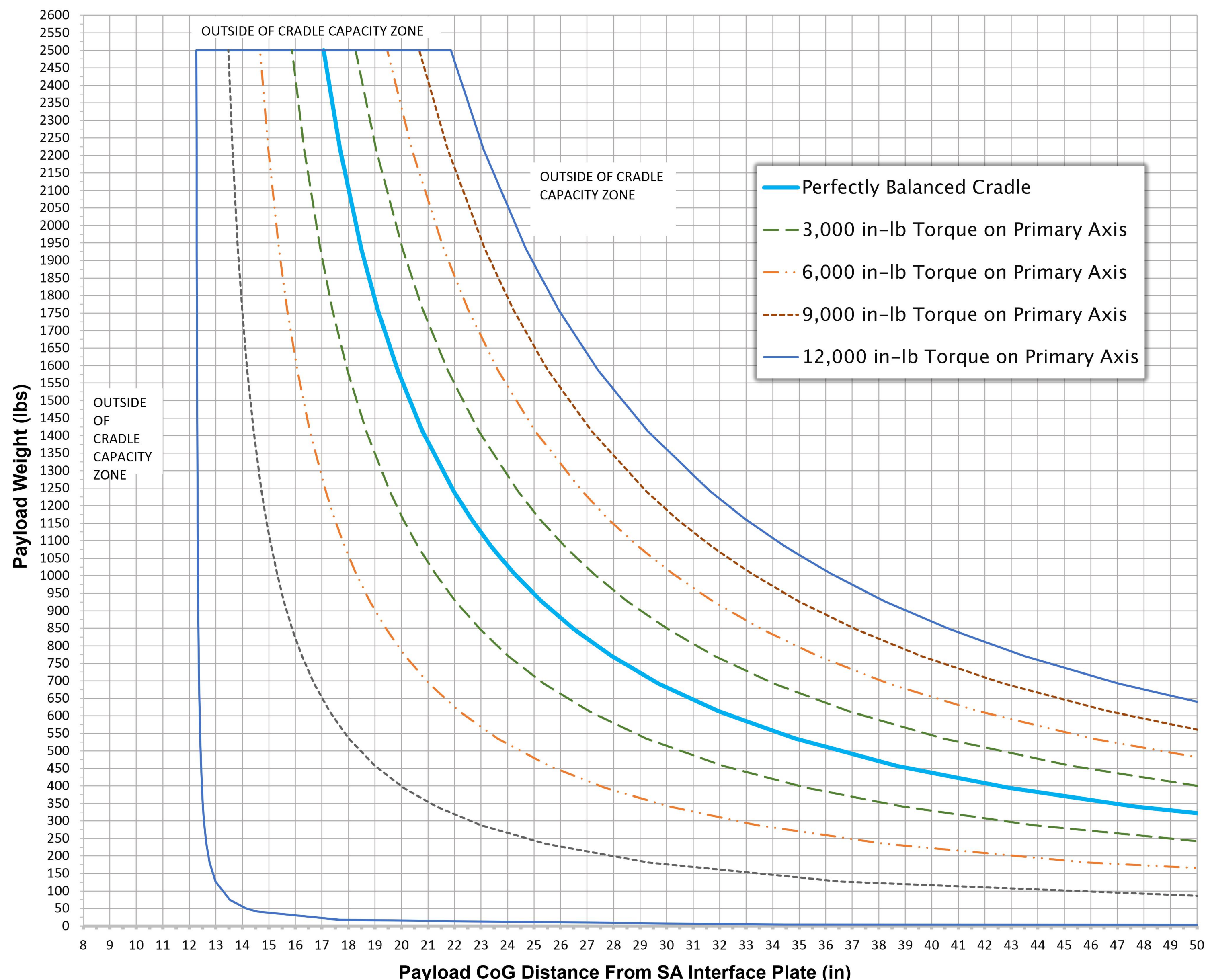


Secondary Axis of Rotation Loading For Pinned Cradle Interface (No Gearbox) **Bolt Position 4**

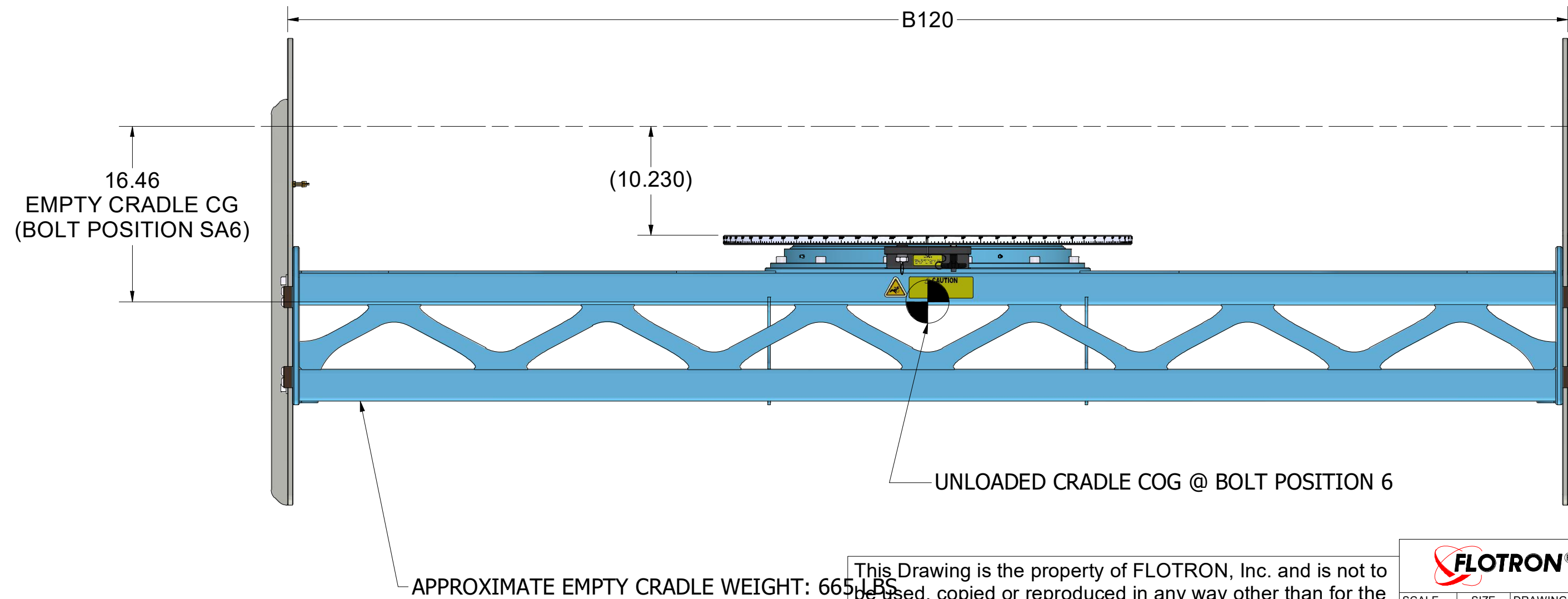
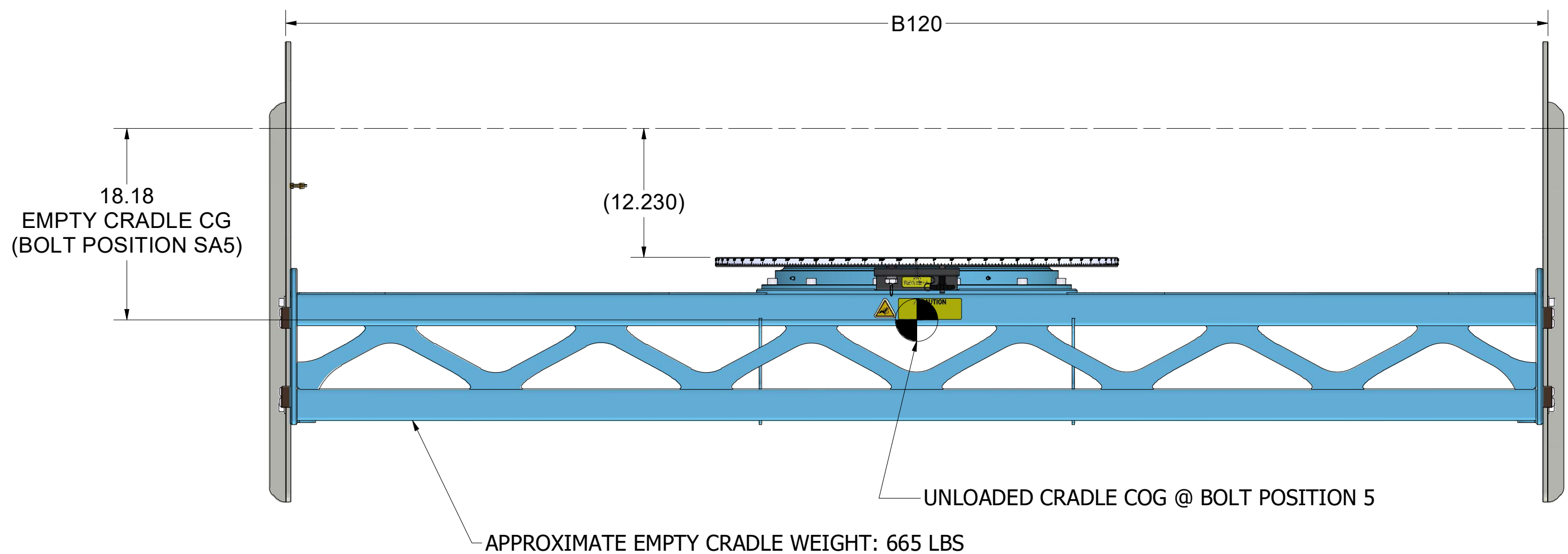
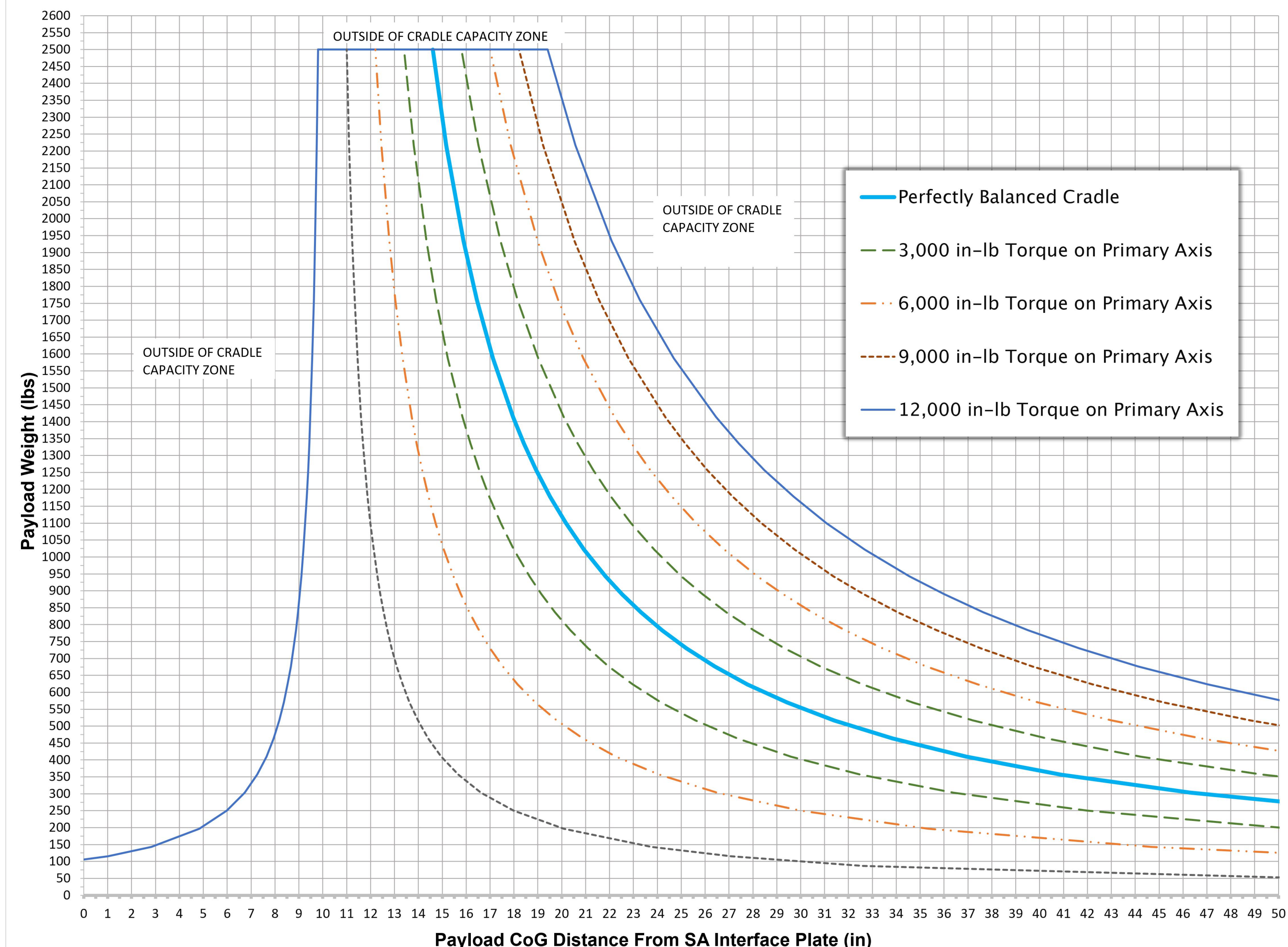


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Secondary Axis of Rotation Loading For Pinned Cradle Interface (No Gearbox) **Bolt Position 5**

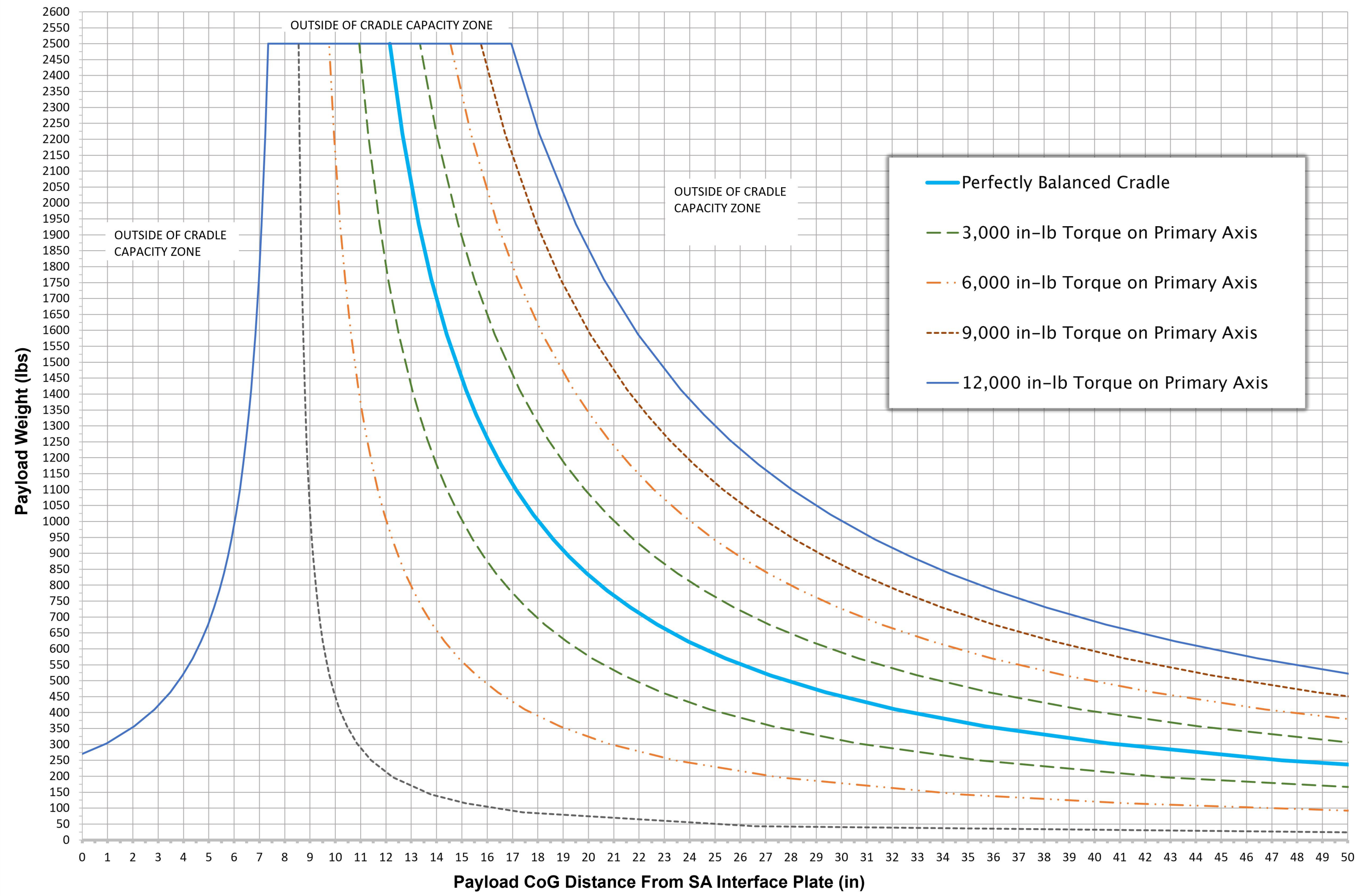


Secondary Axis of Rotation Loading For Pinned Cradle Interface (No Gearbox) **Bolt Position 6**

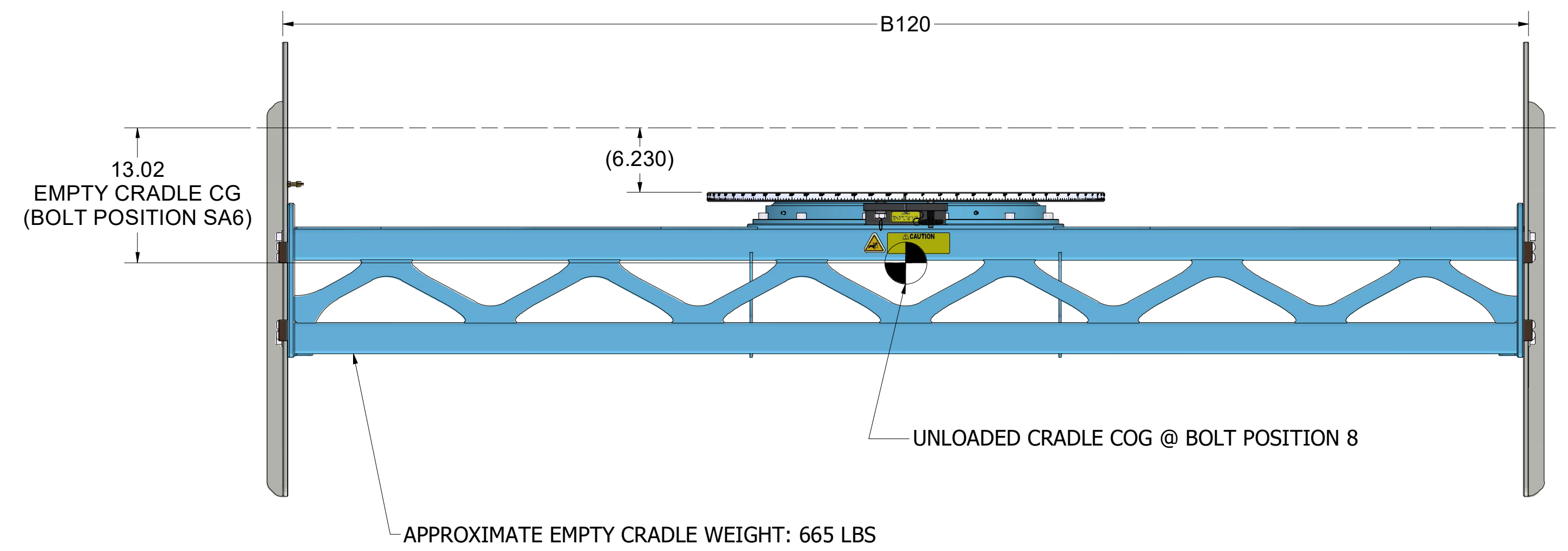
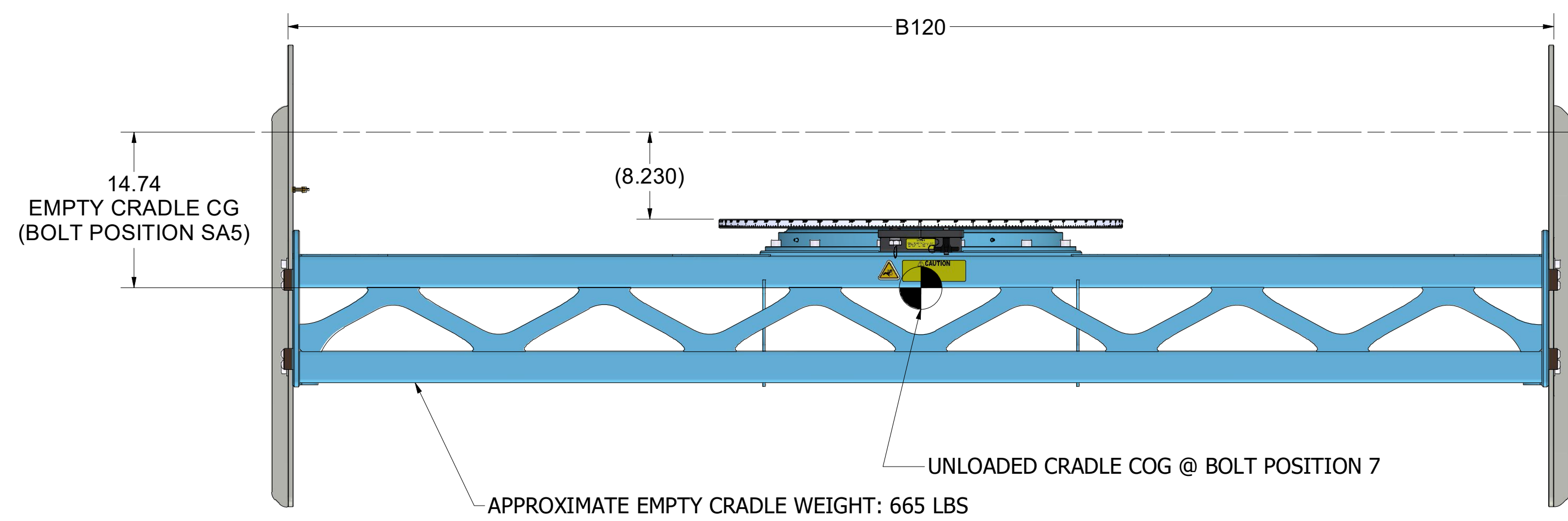
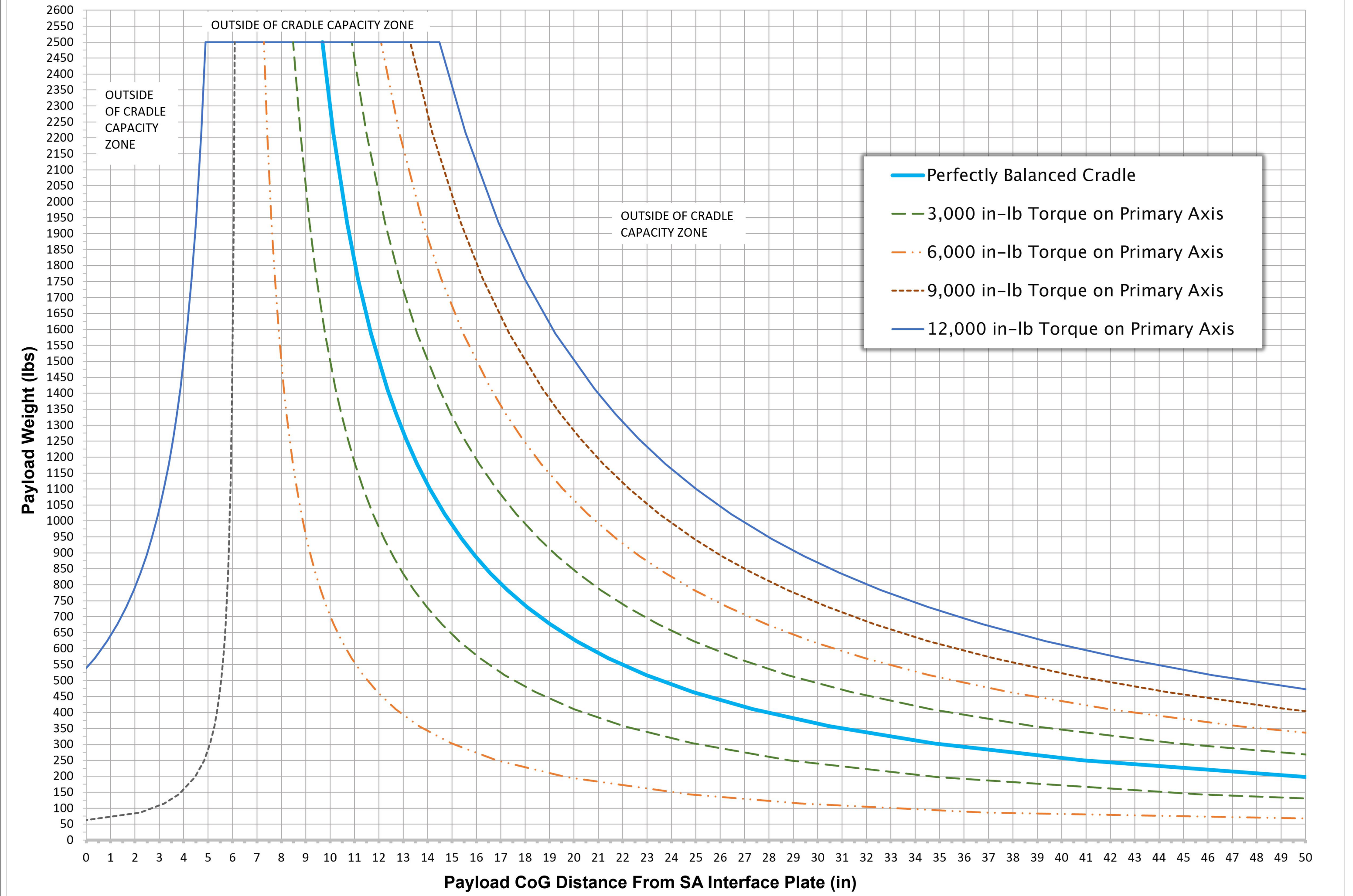


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Secondary Axis of Rotation Loading For Pinned Cradle Interface (No Gearbox) **Bolt Position 7**

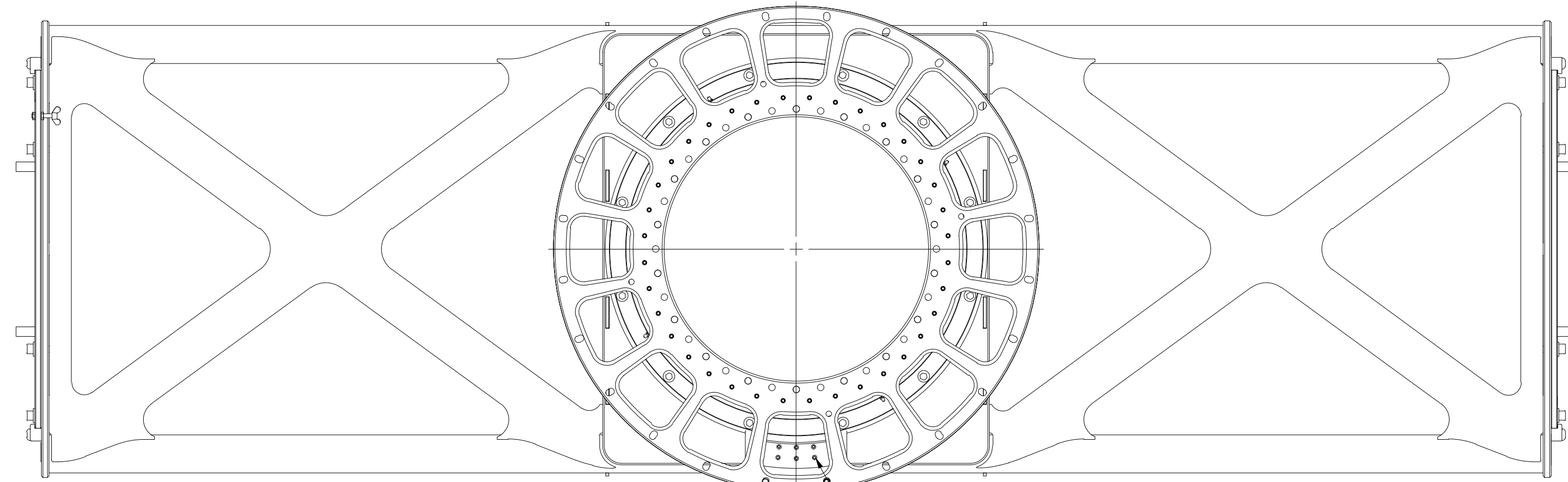


Secondary Axis of Rotation Loading For Pinned Cradle Interface (No Gearbox) **Bolt Position 8**

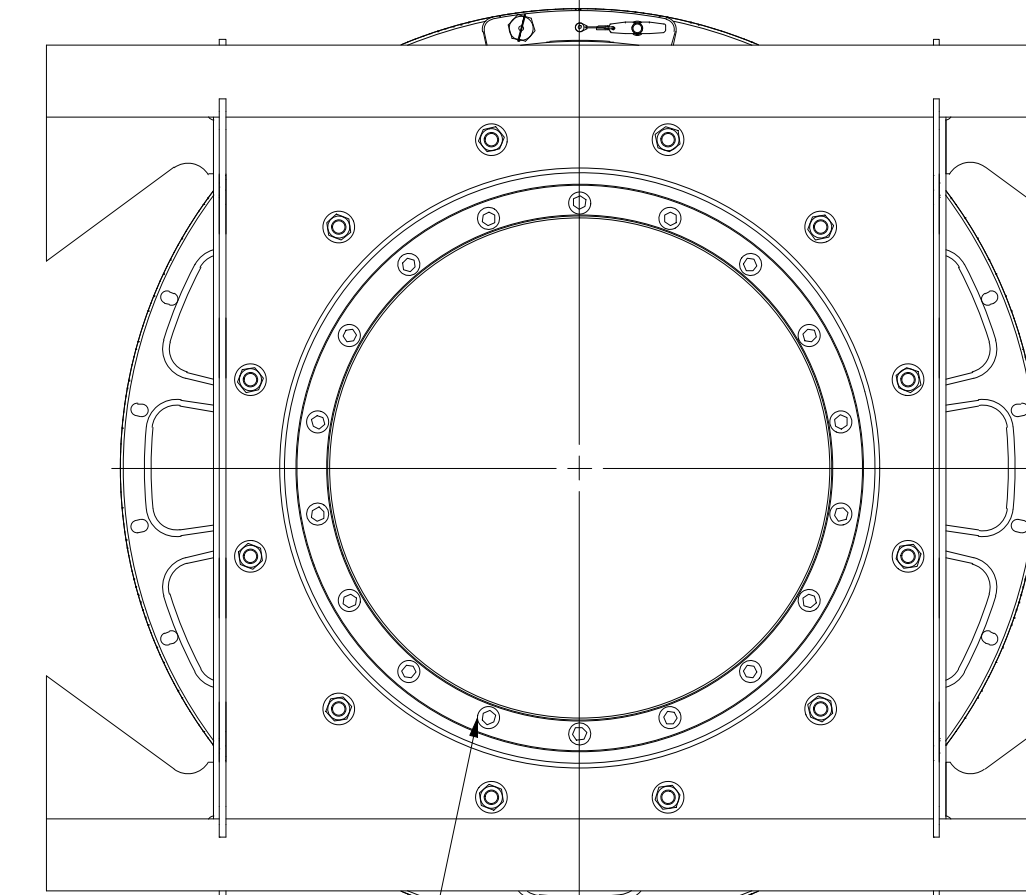


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BOLT TORQUE AND LUBRICATION INFORMATION



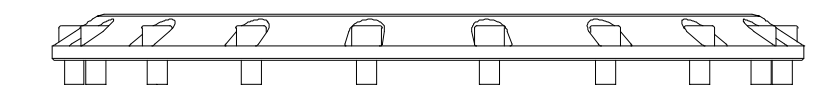
B 004-0408-SS
40-46 IN-LBS
Loctite 242 (Blue) 10
SHCS, .250-20 X 1.00, SS



VIEW G-G
SCALE 1 : 8

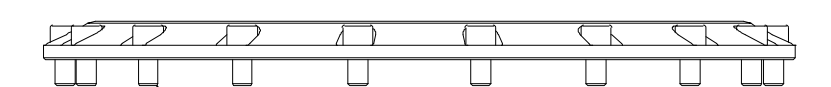
F 004-0284-SS
53-60 FT-LB
Loctite 242 (Blue) 18
SHCS, .625-11 X 1.25, SS

R15 OPTION



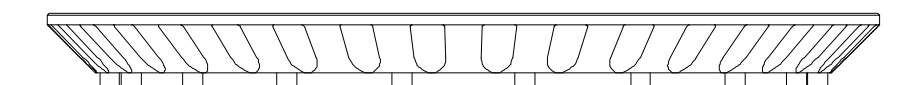
H 004-0284-SS
53-60 FT-LB
Loctite 242 (Blue) 18
SHCS, .625-11 X 1.25, SS

R18 OPTION

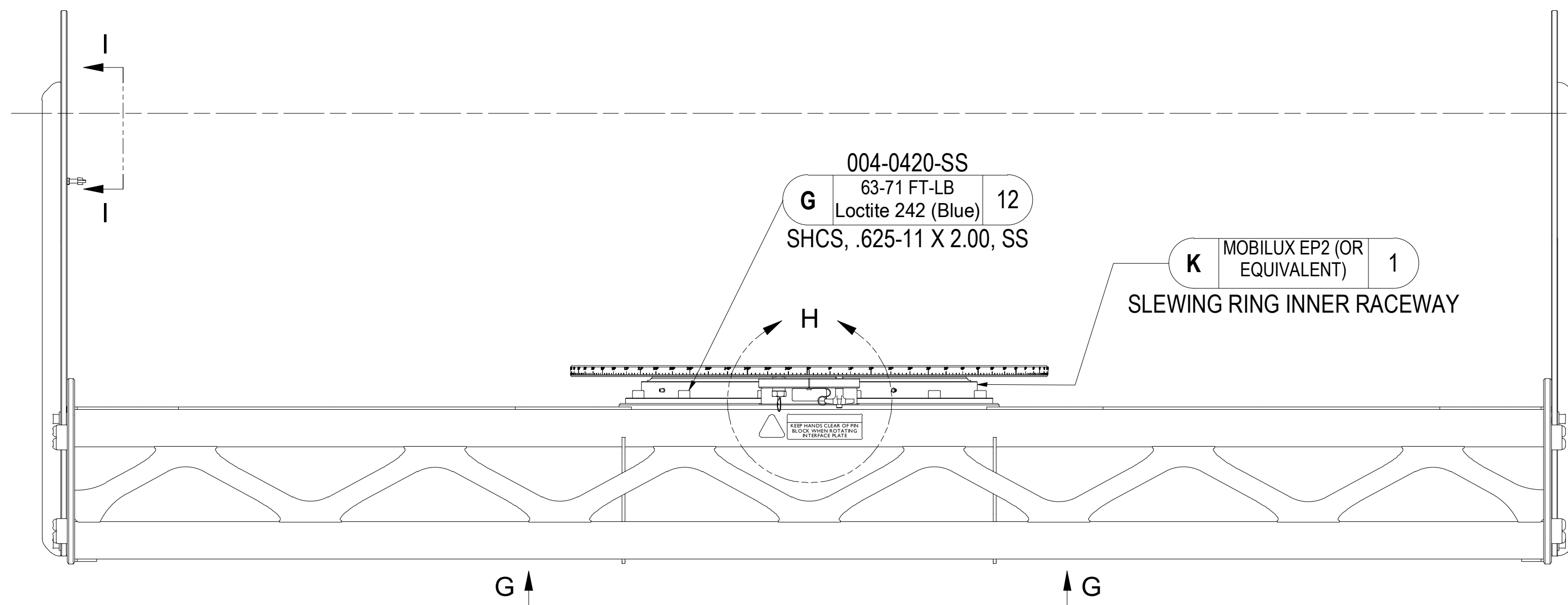


I 004-0284-SS
53-60 FT-LB
Loctite 242 (Blue) 18
SHCS, .625-11 X 1.25, SS

R24 OPTION

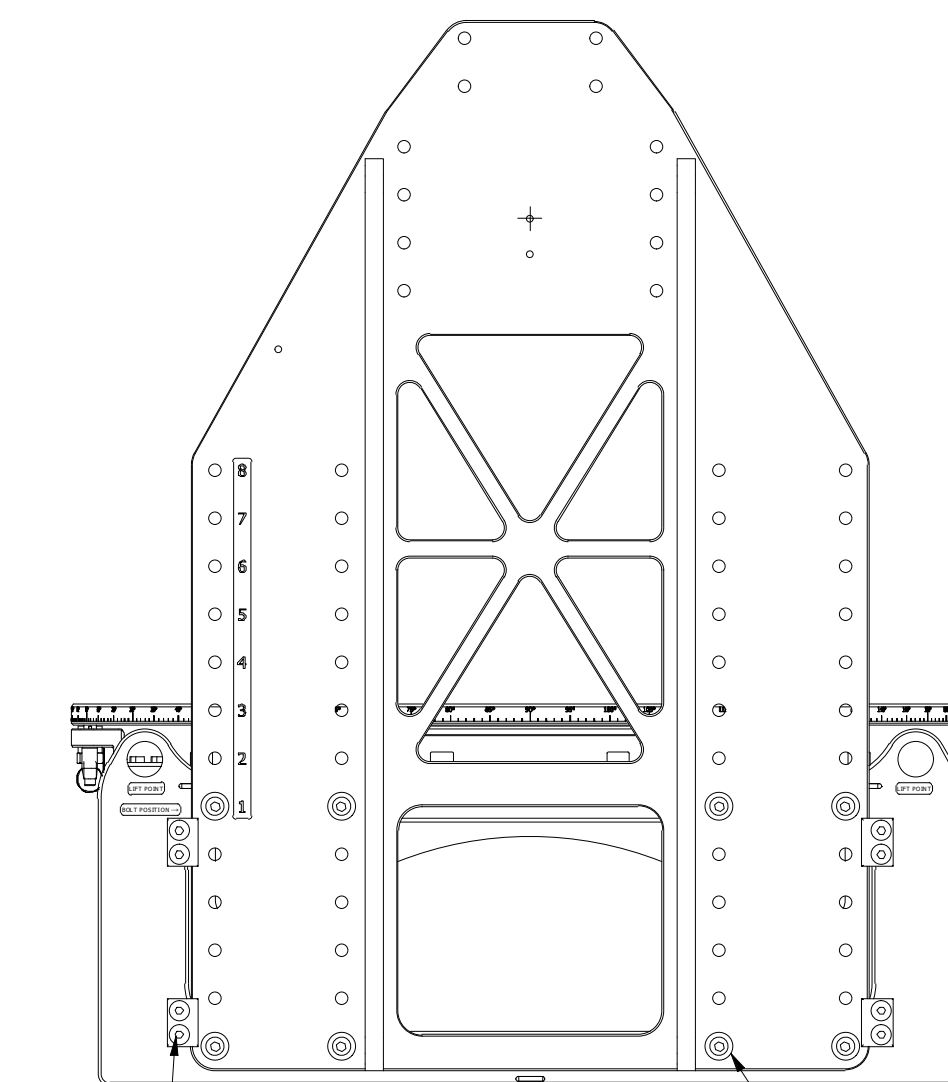


J 004-0047-SS
53-60 FT-LB
Loctite 242 (Blue) 18
SHCS, .625-11 X 1.75, SS



G 004-0420-SS
63-71 FT-LB
Loctite 242 (Blue) 12
SHCS, .625-11 X 2.00, SS

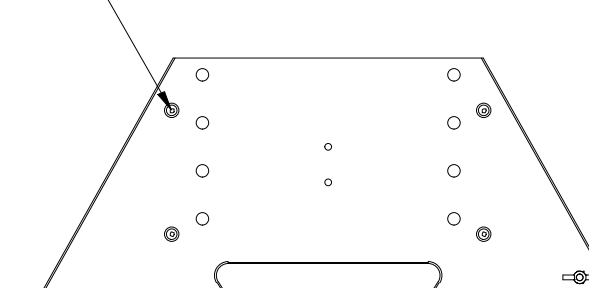
K MOBILUX EP2 (OR EQUIVALENT) 1
SLEWING RING INNER RACEWAY



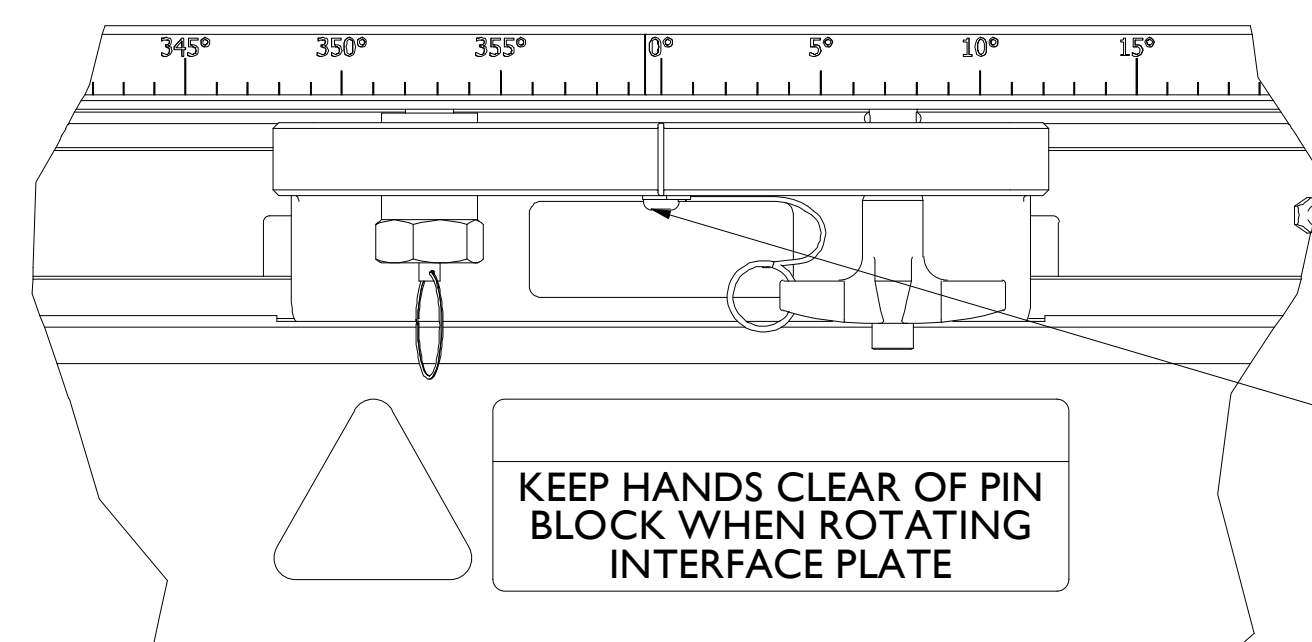
D 002-0064-SS
26-30 FT-LBS
Krytox GPL207 16
WASHER, .500 NOM ID, FLAT, THICK, SS

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

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



DETAIL H
SCALE 1 : 2

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

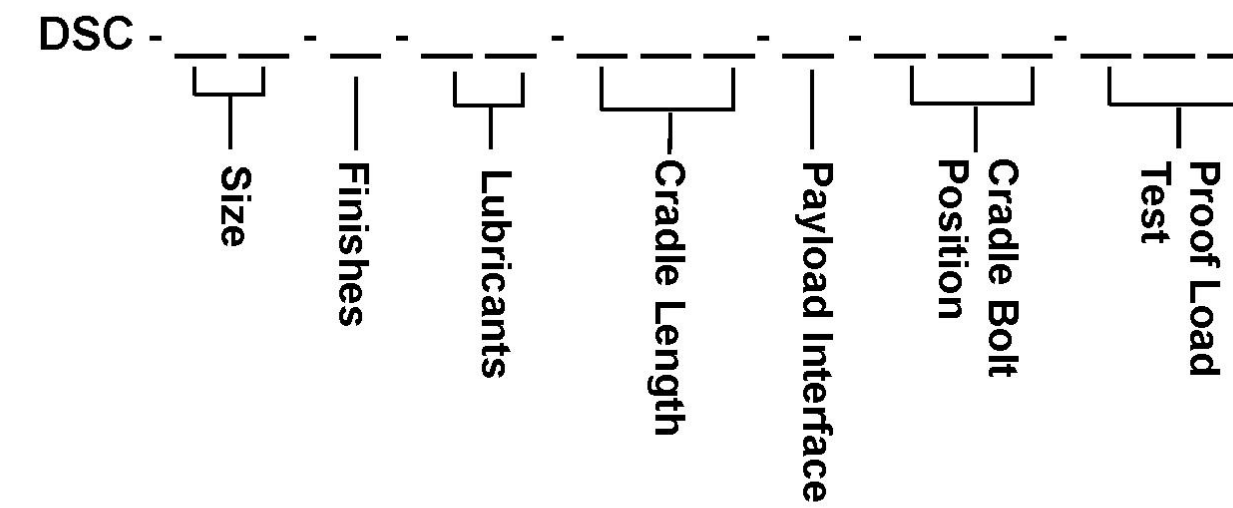
KEEP HANDS CLEAR OF PIN
BLOCK WHEN ROTATING
INTERFACE PLATE

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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)

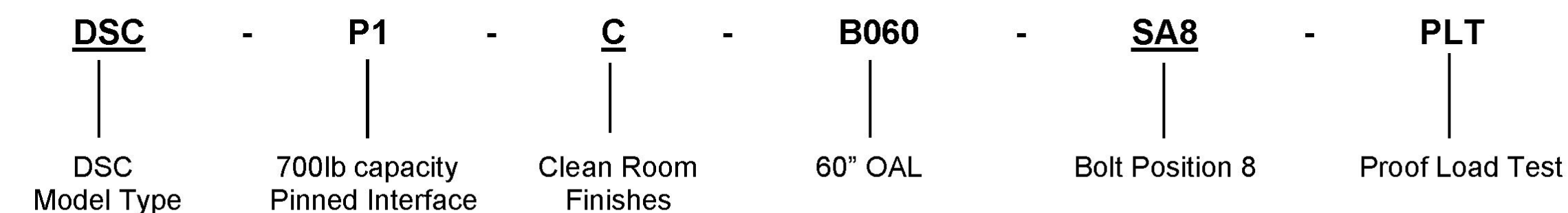
Cradle Bolt Position

- 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	SIZE	DRAWING NO.	
1 : 2	D	8128-200-PINNED-PROP	
SHEET			8 OF 8