

D

8		7		6		5		4		3		2		1	
ITEM NO.	QTY.	AMTPID	DESCRIPTION						MANUFACTURE / SUPPLIER		MANUFACTURE PART NUMBER				
1	1		CRADLE BACK												
2	1		CRADLE BASE												
3	1		SWIVEL CASTER						COLSON		4.06109.459.2 BRK2				
4	1		GUSSET												
5	4		3/8-16 x .75 LG Grade 8 Hex Bolt												
6	4	105723	18-8 SS SAE TYPE A FLAT WASHER, 3/8" SCREW SIZE, .81" OD, .05"-.08" THICK												

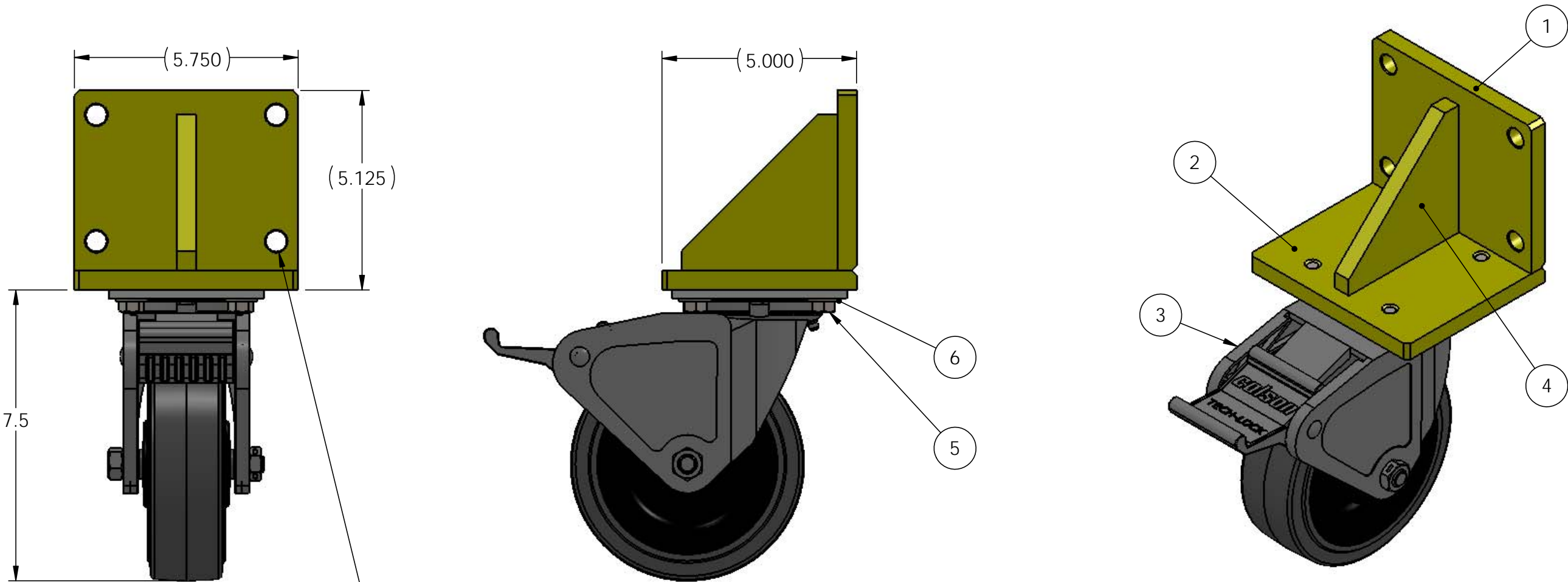
D

NOTE:

WELDED CONSTRUCTION - WELD FILLETS NOT SHOWN

2 ASSEMBLIES REQUIRED PER CAR - QUANTITIES LISTED ARE PER ASSEMBLY

FOR REFERENCE, THE STANDARD HEIGHT OF THE SUBFRAME TO THE FLOOR IS 5.5"



USE SUB FRAME
BOLTS TO FASTEN TO UNIBODY

POWDER COAT FINISH, SAFETY YELLOW

INTERPRET DIMENSIONS AND TOLERANCES PER
ASME Y14.5M-1994, THIRD ANGLE PROJECTION

UNITS: INCHES, DO NOT SCALE DRAWING

PROPRIETARY NOTICE:
THIS DRAWING IS CONFIDENTIAL AND
THE INFORMATION WITHIN SHALL NOT BE COPIED NOR
UTILIZED IN ANY WAY WITHOUT THE WRITTEN PERMISSION
FROM AUTOMATED MACHINE TECHNOLOGIES INC.
DRAWING TO BE RETURNED UPON REQUEST

TOLERANCES:

TWO PLACE DECIMALS:
THREE PLACE DECIMALS:
FOUR PLACE DECIMALS:
ANGLES:

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS AND TOLERANCES ARE
AFTER FINISH.
BREAK SHARP EDGES 0.010 X 45°
MAX FILLET RADIUS 0.010.
SURFACE FINISH TO BE 64 MICROFINISH OR
BETTER.



Automated Machine Technologies, Inc.

3626 California Road • Orchard Park, New York 14127 • USA
Phone: 716-667-0778
www.amtry.com

DESCRIPTION:

355 SUB FRAME CASTER CRADLES

DESIGN/DETAIL BY:
D. LELONEK

DRAWING DATE:
3/24/2015

APPROVAL BY:
D. LELONEK

APPROVAL DATE:
3/24/2015

DRAWING SCALE:
1:3

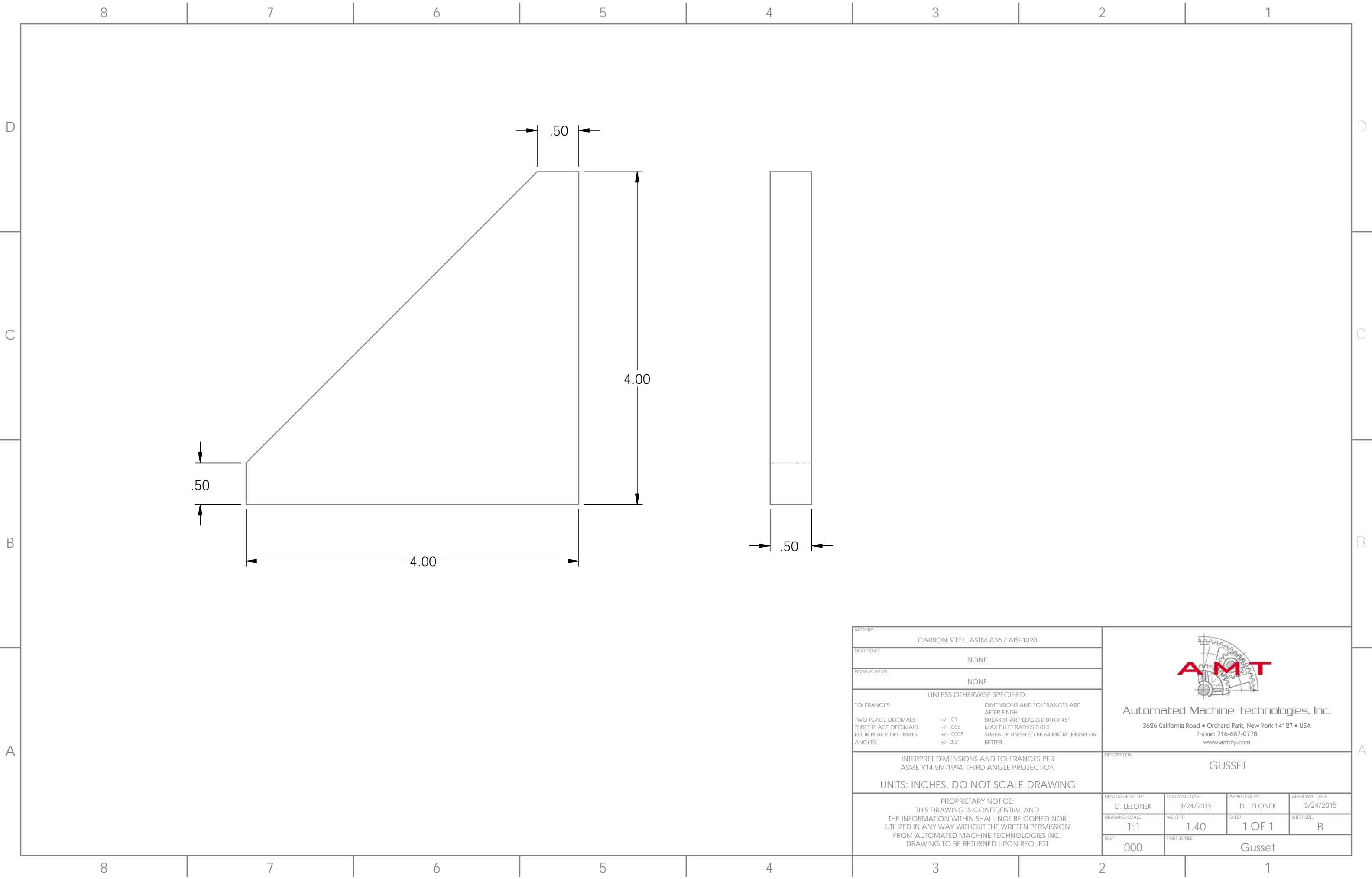
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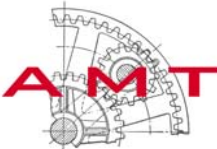
SHEET:
1 OF 1

SHEET SIZE:
B

REV:
000

PART ID/FILE:
355 Sub Frame Caster Cradles



MATERIAL: CARBON STEEL, ASTM A36 / AISI-1020		<div> Automated Machine Technologies, Inc. 3626 California Road • Orchard Park, New York 14127 • USA Phone: 716-667-0778 www.amtry.com</div>			
HEAT TREAT: NONE					
FINISH/PLATING: NONE					
TOLERANCES: TWO PLACE DECIMALS: +/- .01 THREE PLACE DECIMALS: +/- .005 FOUR PLACE DECIMALS: +/- .0005 ANGLES: +/- 0.5°		UNLESS OTHERWISE SPECIFIED: DIMENSIONS AND TOLERANCES ARE AFTER FINISH. BREAK SHARP EDGES 0.010 X 45° MAX FILLET RADIUS 0.010. SURFACE FINISH TO BE 64 MICROFINISH OR BETTER.			
INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994. THIRD ANGLE PROJECTION UNITS: INCHES, DO NOT SCALE DRAWING		DESCRIPTION: GUSSET			
PROPRIETARY NOTICE: THIS DRAWING IS CONFIDENTIAL AND THE INFORMATION WITHIN SHALL NOT BE COPIED NOR UTILIZED IN ANY WAY WITHOUT THE WRITTEN PERMISSION FROM AUTOMATED MACHINE TECHNOLOGIES INC. DRAWING TO BE RETURNED UPON REQUEST		DESIGN/DETAIL BY: D. LELONEK	DRAWING DATE: 3/24/2015	APPROVAL BY: D. LELONEK	APPROVAL DATE: 3/24/2015
		DRAWING SCALE: 1:1	WEIGHT: 1.40	SHEET: 1 OF 1	SHEET SIZE: B
		REV: 000	PART ID/FILE: Gusset		

