



Afinitas Forming Systems Division

SmartRoll™ Form Controller Device

Setup and Usage Procedures



Intelligent
Infrastructure
Solutions

www.afinitas.com



Table of Contents

1. INTRODUCTION.....	2
2. PRODUCT OVERVIEW – GENERAL INFORMATION	3
2.1 Product Sizes	3
2.2 SMARTROLL™ Overview	4
2.3 What to Know	4
2.4 General Safety Rules	4
3. ADJUSTING THE TORQUE SETTINGS.....	6
3.1 General Torque Setting Information	6
3.2 Suggested Torque Setting Chart	7
4. POSITIONING SMARTROLL™	8
4.1 Common Product and Equipment Method	8
4.2 Positioning Chart	8
4.3 Uncommon or First-Time Product and Equipment Method	9
5. THE ROLL-OVER PROCESS	10
6. REPLACEMENT PARTS.....	14



1. Introduction

Afinitas Forming Systems equipment is carefully designed and manufactured to give years of dependable service. It is important that the equipment be operated properly, and that regular service be performed to avoid costly down-time and unnecessary repairs. This manual is intended to provide you with information on the setup and usage procedures required to keep this equipment operating safely and efficiently.

The manual is divided into four sections in order to assist you in finding the information you need to perform specific maintenance.

- Product Overview and General Information
- Adjusting the Torque Settings
- Positioning SmartRoll™
- The Roll-Over Process

Use the *Table of Contents* provided to help guide you to the section of the manual containing the information you require.

Although intended to be a comprehensive resource, this manual may not cover all possible issues you may encounter. Contact the Afinitas Forming Systems Division (641-394-4111) if the information you require cannot be found herein.



2. Product Overview – General Information

2.1 Product Sizes

Small SmartRoll™

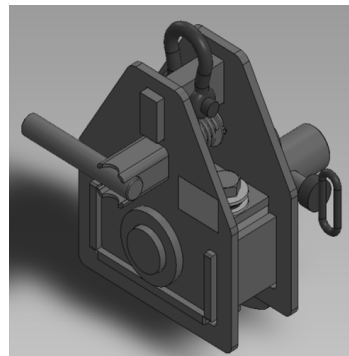
Part# 1000-699

Specified Capacity – 13,000 lbs

Each Specified Capacity – 26,000 lbs. Per Set

Target:

- Manhole bases 48 – 72" diameter.
- Product and equipment weighing less than the 13 TON capacity of the "Small SmartRoll™"



Large SmartRoll™

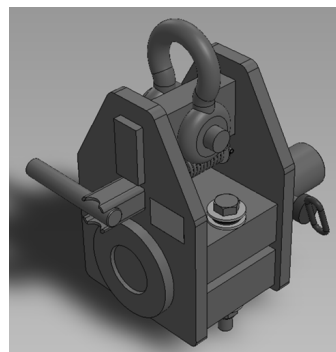
Part# 1000-700

Specified Capacity – 34,000 lbs.

Each Specified Capacity – 68,000 lbs. Per Set

Target:

- Manhole bases 84" – 96" diameter.
- Product and equipment weighing less than the 34 TON capacity of the "Large SmartRoll™"



X-Large SmartRoll™

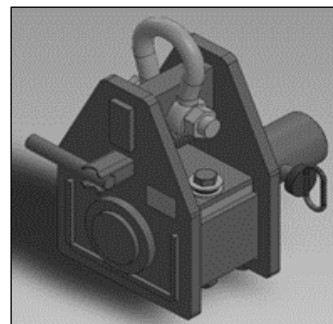
Part# PD-HD-0693

Specified Capacity – 50,000 lbs.

Each Specified Capacity – 100,000 lbs. Per Set

Target:

- Manhole bases 102" – 144" diameter.
- Product and equipment weighing less than the 50 TON capacity of the "X-Large SmartRoll™"





2.2 SMARTROLL™ Overview

SmartRoll™ is an adjustable friction brake. It has been designed to SAFELY slow down the speed at which the product and equipment roll-over, reducing the momentum generated by a potentially violent roll-over process. This will reduce the wear and tear on your crane equipment and reduces the time needed for the product and equipment to come to a rest. By reducing the potential violence associated with this process you will also be taking steps to protect the form equipment from damage and yourself from potential injury.

This book is our suggested start up procedure and it should give you the best, user-friendly, roll-over device. If your setup falls outside these parameters, you should call and talk to one of our service agents, before putting SmartRoll™ into full production use. We are here to help!

2.3 What to Know

There are always variables to consider when rolling over product and/or equipment. Product height, blockout size, and blockout position can greatly affect the momentum generated during the roll-over process. It is important to know what you are rolling over and have a great understanding of its specific “center of gravity”, or C/G point. Failure to do so, along with improper lifting and handling processes may result in serious injury or even death. With any roll-over it is important to get as close as you can, to the correct trunnion hole position. Even when the correct trunnion hole is used, variables may change the C/G during the roll and still make the process violent. SmartRoll™ will reduce the speed and momentum generated during the process.

2.4 General Safety Rules

It is important to consider the dangers when lifting and rolling over product and equipment. Follow all rules and regulations of your overhead lifting equipment. Being SAFE and CLEAR of the product and or equipment during this process is a must! Never operate SmartRoll™ until inspected and tested before each shift. Report any unusual operation or safety concerns to a qualified person and discontinue use of SmartRoll™ until safety has been assured. Make sure that all supporting structures and load attaching devices (i.e. crane, chain, sling, and hook) are rated to support the weight of



SmartRoll™ and load. Never lift loads greater than the rated lifting capacity. Always stay clear of the load. Do not place feet or hands under the load. Keep face and body away from load in case of accidental issues. Make sure that every person operating SmartRoll™ has read and understands the operating instructions. Do not attempt to ride or climb a suspended load or allow others to do the same. Do not keep loads suspended for unnecessarily long periods. Do not keep suspended loads unattended. Do not lift loads over people. Do not stand under suspended loads.



3. Adjusting the Torque Settings

3.1 General Torque Setting Information

Check/adjust the torque value on SmartRoll™ bolts to the appropriate FT-LBS given in the “Suggested Torque Setting Chart” below. (Customer to supply their own torque wrench.)

Things to keep in mind when adjusting SmartRoll™:

- Try to adjust the bolts evenly
- When fine tuning adjustment is being made, 1 to 2 FT-LBS can make quite a difference.
- When rolling the product and equipment over and you see or hear chattering, or if the equipment does not come back to vertical to allow the anti-roll safety pin to lock in place, the torque setting may be set too high.
- Keeping notes and marking of proper trunnion holes is a good, and recommended practice.



3.2 Suggested Torque Setting Chart

Suggested Torque Setting Chart

SMALL SmartRoll™

(Factory torque setting is 100 FT-LBS)

- 48" Diameter product and equipment or product and equipment weighing less than 13 TON. Adjust between 90 – 110 FT-LBS.
- 60" Diameter product and equipment or product and equipment weighing less than 13 TON. Adjust between 120 – 140 FT-LBS.
- 72" Diameter product and equipment or product and equipment weighing less than 13 TON. Adjust between 150 – 170 FT-LBS.

LARGE SmartRoll™

(Factory torque setting is 175 FT-LBS)

- 84" – 96" Diameter product and equipment or product and equipment weighing less than 34 TON. Adjust between 170 – 180 FT-LBS.

X-LARGE SmartRoll™

(Factory torque setting is 175 FT-LBS)

- 102" – 144" Diameter product and equipment or product and equipment weighing less than 50 TON. Adjust between 170 – 180 FT-LBS.

NOTE: The above torque setting are suggestions based on full pour products with no blockouts. SmartRoll™ can be used with different size equipment without changing the torque settings. Keep in mind that when rolling over "empty" or smaller form equipment, SmartRoll™ will need to move to a lower trunnion hole, allowing for more torque. The opposite is true when rolling over "full" or larger product and equipment, SmartRoll™ will need to move to a higher trunnion hole, reducing the torque. Fine tuning will be required to find the best settings for all product and equipment being rolled over.



4. Positioning SmartRoll™

4.1 Common Product and Equipment Method

- Locate the vertical center line of your form. (Measure the overall height of the form and divide it by 2.)
- Use the “Suggested Trunnion Hole Positioning Chart” below as a guide to locate the trunnion hole for the initial starting point.
- Find the appropriate product height you are producing and move SmartRoll™ above the form centerline according to the chart. (If your measurement falls between 2 holes, to be safe, use the higher of the 2 holes as a starting point.)

4.2 Positioning Chart

Suggested Trunnion Hole Positioning Chart

STRAIGHT BASE (Round Manhole and Equivalent Size Box Equipment)

- 4' Tall product height, move SmartRoll™ 4" – 6" above form centerline.
- 6' Tall product height, move SmartRoll™ 6" – 8" above form centerline.
- 8' Tall product height, move SmartRoll™ 8" – 10" above form centerline.

Extended BASE (Round Manhole Equipment)

(Values may change depending on extension and thickness dimensions.)

- 4' Tall product height, move SmartRoll™ 6" – 8" above form centerline.
- 6' Tall product height, move SmartRoll™ 10" – 12" above form centerline.
- 8' Tall product height, move SmartRoll™ 14" – 16" above form centerline.

NOTE: The above trunnion hole positions are suggestions based on full pour products with no blockouts. For equipment that falls outside of the above parameters, fine tuning will be required to find the best settings for the product and equipment, being rolled over. If your setup falls outside these parameters, you should call and talk to one of our service agents, before putting SmartRoll™ into full production use.



4.3 Uncommon or First-Time Product and Equipment Method

SAFETY FIRST! Using this method may take longer but will help with identifying suitable trunnion hole positions that are unknown.

- Start by placing SmartRoll™ in the top or upper most trunnion hole, for uncommon or first-time product and equipment roll-over. (This is especially true when pouring a short product in a taller form, or a situation that would greatly affect the “center of gravity” or C/G, such as a new and/or relocated blockouts.)
- You will lift and test each trunnion hole and gradually move SmartRoll™ down to the next trunnion hole until you find the one that works best. (See the instructions under the “The Roll-Over Process” on the next page.)
- The target is to use the hole just below your product and equipment’s “center of gravity” or C/G point.
- Use the top or upper most trunnion hole for rolling equipment with product and the bottom holes to roll back the empty form.

NOTE: The above processes are suggestions for uncommon or first-time roll-over products. Fine tuning will be required to find the best settings for the product and equipment, being rolled over. If your setup falls outside these parameters, you should call and talk to one of our service agents, before putting SmartRoll™ into full production use.



5. The Roll-Over Process

Step 1: With SmartRoll™ in the appropriate trunnion hole and the equipment resting safely on the ground, pull and lock out the anti-roll safety pin.



NOTE: The anti-roll safety pin should ALWAYS be locked out when rolling over a product and equipment. NEVER allow the pin to snap back in during the roll-over process. This pin should ONLY be used once the product and equipment have been rolled-over. By locking the anti-roll safety pin in place, after the roll-over, you should be able to strip the product while leaving the lift chains attached to SmartRoll™. This will prevent the form from rolling over once the product has been removed.



STEP 2: Using SmartRoll™, slowly lift the product and equipment approximately 6" to 12" above the floor. If all the settings are correct, the form should NOT attempt to roll-over. Preventing the start of the roll-over should be done reasonably, without much effort. If this is the case move on to step #4.



STEP 3: If the product and equipment start to roll-over, and you find it difficult, beyond a reasonable amount to hold the equipment level, IMMEDIATELY lower it back to the ground. Raise SmartRoll™ up one set of trunnion holes and repeat step #2 and/or make adjustment to the torque setting.





STEP 4: While preventing the roll-over, continue to raise the product to a safe height. Make sure people around you are clear and aware that you are going to start the roll. Push the equipment to start the roll-over process and move out of the way to a safe distance.



NOTE: If the product and equipment DOES NOT attempt to roll-over, without a reasonable effort, move SmartRoll™ down one hole and/or adjust the torque value.



STEP 5: Once the product and equipment have come to a rest. Lower it to the ground and engage the anti-roll safety pin.



STEP 6: Strip the equipment from the product.

STEP 7: Reposition SmartRoll™ and repeat steps in order to roll-over the “empty” equipment.



6. Replacement Parts

See diagrams that follow for detailed information on replacement parts.

REVISIONS				
REV.	ECR	CHANGE	BY	DATE
A		SUB WELDMENTS WHERE PD-HD-0747 , PD-HD-0748 AND PD-HD-0749	DOUG	3/21/2017

THE FOLLOWING IS THE SUGGESTED TORQUE SETTINGS THAT YOU SHOULD USE FOR THE INITIAL TRIAL RUN FOR EACH PRODUCT SIZE. THE ACTUAL TORQUE SETTING THAT WORKS FOR YOUR PARTICULAR SETUP MAY VARY DUE TO FORM STYLE, BLOCKOUTS IN USE, HEIGHT OF FORM VERSUS HEIGHT OF PRODUCT RUN, RANGE OF PRODUCTS BEING ROLLED WITH THE SAME CONTROLLER, ETC....

TORQUE BOLTS BETWEEN 90 AND 110 FT LBS. - 48" FORMS
TORQUE BOLTS BETWEEN 120 AND 140 FT LBS. - 60" FORMS
TORQUE BOLTS BETWEEN 150 AND 170 FT LBS. - 72" FORMS

NOTE: FACTORY TORQUE SETTING IS 100 LBS.

CONTROLLER WEIGHT: 110LBS

					6	1000-698	2	URETHANE CLAMP BLOCK FOR CONTROLLER		
					5	1000-699-1-6	1	3/4 X 2 3/8 X 2 3/8 LG (1000-699-1-6)		
					4	8570002	1	ANCHOR SHACKLE M352 - 6 1/2 TON		
					3	8520001	1	HITCH PIN		
					2	1000-699-2	1	TRUNNION SHAFT 2 1/2 DIA.		
					1	1000-699-1	1	CONTROLLER SUB-ASSEMBLY		
NAME/QTY	NAME/QTY	NAME/QTY	NAME/QTY	NAME/QTY	ITEM	MATERIAL	QTY	DESCRIPTION		
WELDING	MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED.	AFINITAS AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 506591701 MOLER ROAD COLUMBUS, OHIO 43207				
FAB	MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL		ANGULAR DEG							
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0 °		DRAWN BY: DOUG	SMALL CONTROLLER 2 1/2 Ø 6 1/2 TON CAP.				
					DATE: 9/13/16					
					WEIGHT: 114.49 LBS					
					JOB NO:					
						SHEET: 1 OF 1	SCALE: 1:4	SIZE B	DWG NO: 1000-699	REV. A
						QTY:				

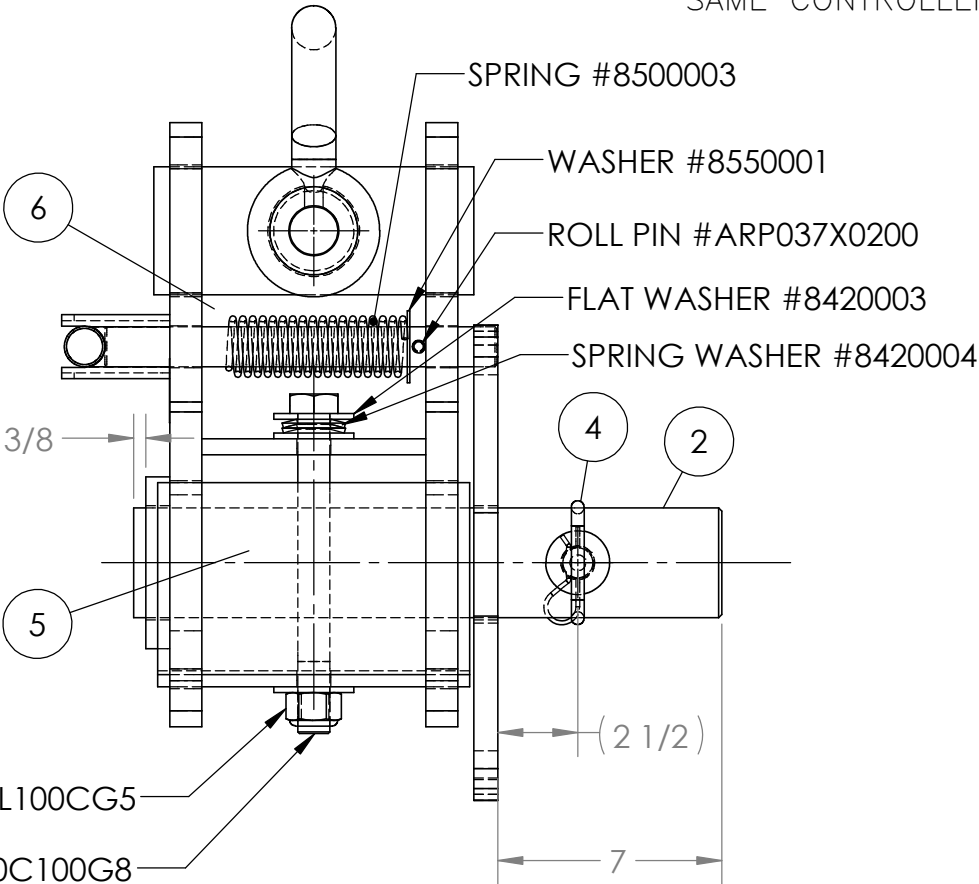
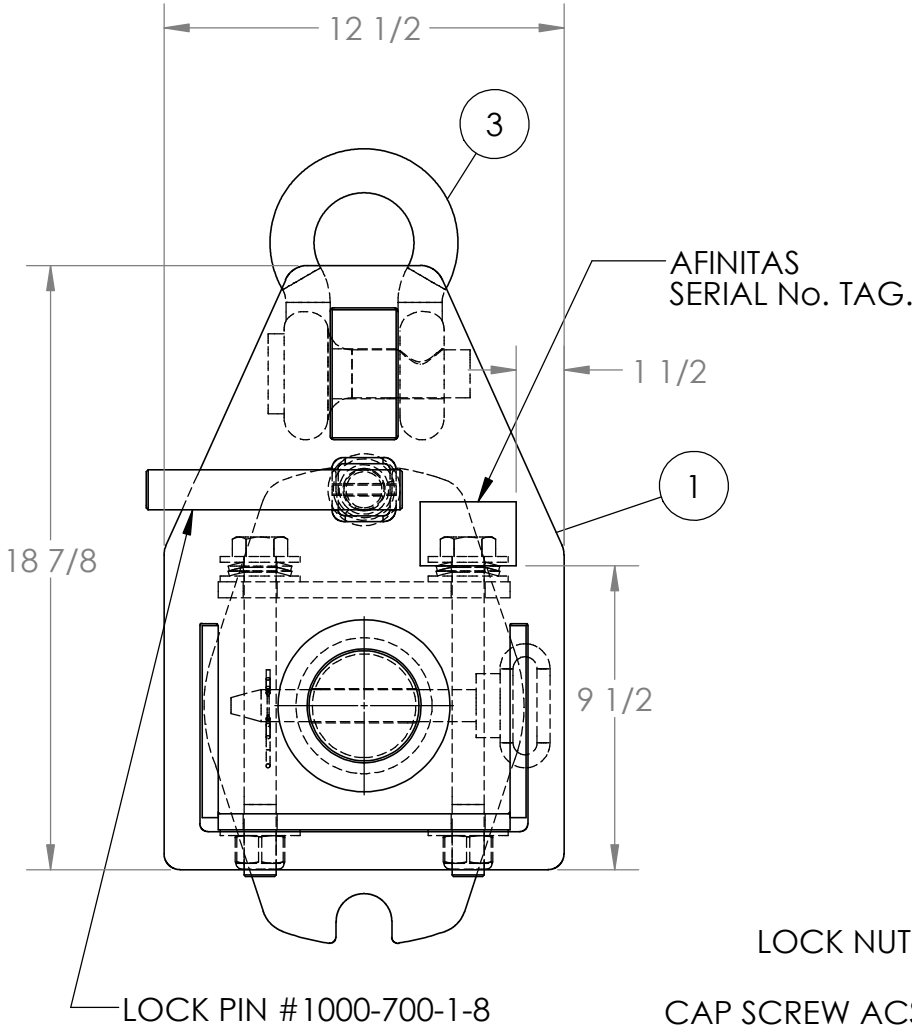
REVISIONS				
REV.	ECR	CHANGE	BY	DATE
A		1000-700-1 WAS PD-HD-0744 1000-700-2 WAS PD-HD-0746	DOUG	3/22/2017

THE FOLLOWING IS THE SUGGESTED TORQUE SETTINGS THAT YOU SHOULD USE FOR THE INITIAL TRIAL RUN FOR EACH PRODUCT SIZE. THE ACTUAL TORQUE SETTING THAT WORKS FOR YOUR PARTICULAR SETUP MAY VARY DUE TO FORM STYLE, BLOCKOUTS IN USE, HEIGHT OF FORM VERSUS HEIGHT OF PRODUCT RUN, RANGE OF PRODUCTS BEING ROLLED WITH THE SAME CONTROLLER, ETC....

TORQUE BOLTS BETWEEN 170 AND 180 FT LBS.

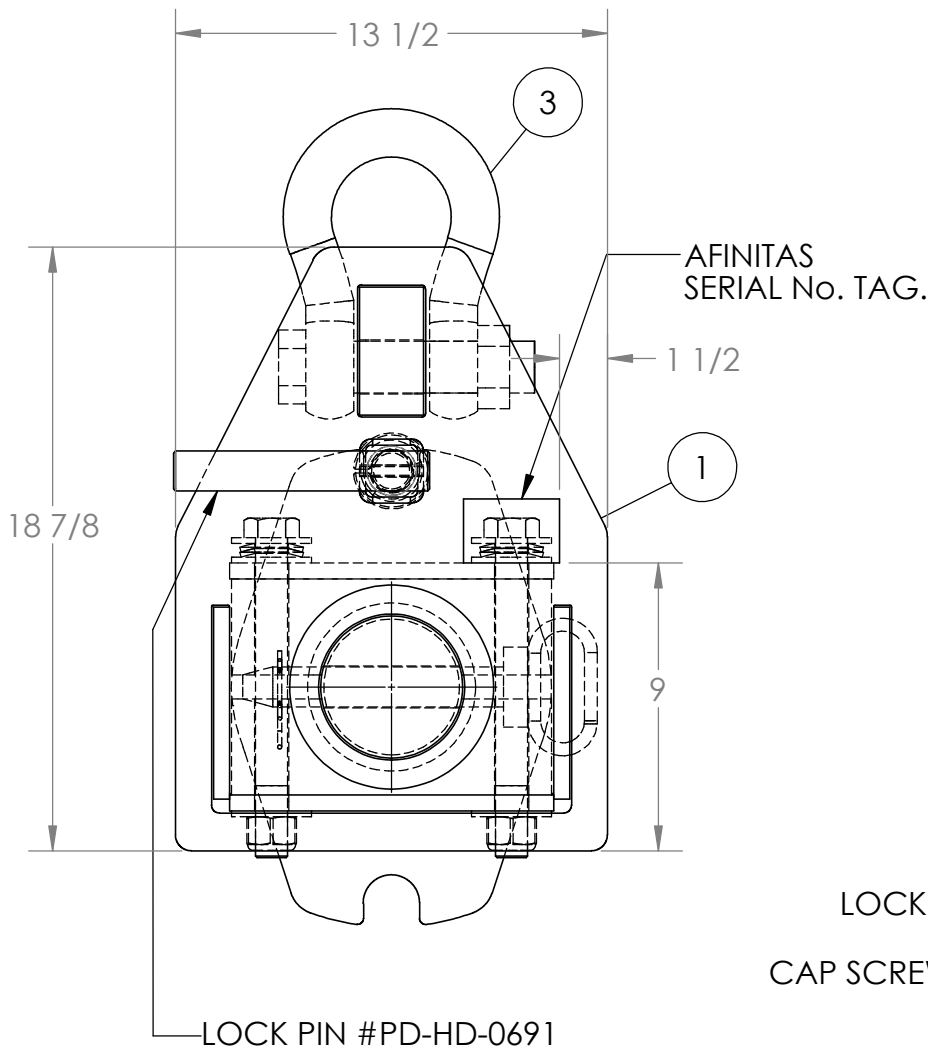
NOTE: FACTORY TORQUE SETTING IS 175 LBS.

CONTROLLER WEIGHT: 297 LBS

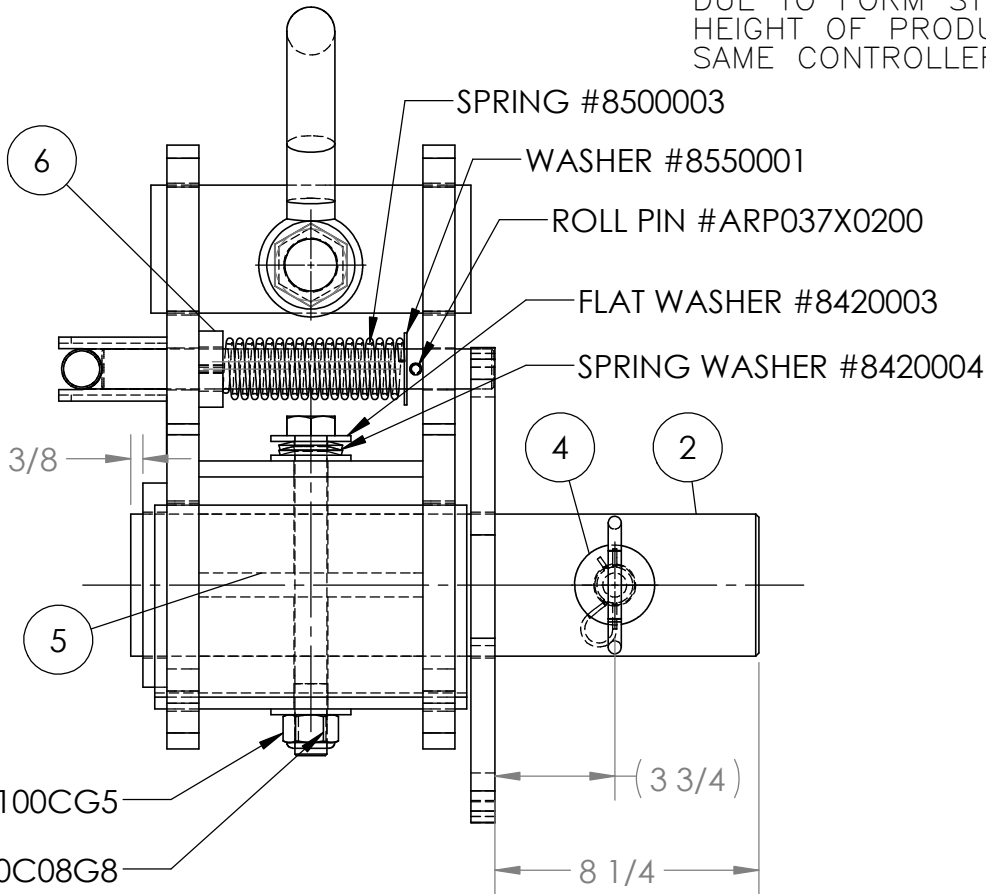


					6	1000-700-1-6	1	3/4 X 2 3/8 X 2 3/8 LG (1000-700-1-6)		
					5	1000-697	2	URETHANE CLAMP BLOCK FOR LARGE CONTROLLER		
					4	8520002	1	HITCH PIN 1" X 6 1/2 GRIP		
					3	8570003	1	ANCHOR SHACKLE M366AP 17 TON CAP.		
					2	1000-700-2	1	TRUNNION SHAFT 3 7/16 DIA.		
					1	1000-700-1	1	CONTROLLER SUB-ASSEMBLY		
NAME/QTY	NAME/QTY	NAME/QTY	NAME/QTY	NAME/QTY	ITEM	MATERIAL	QTY	DESCRIPTION		
WELDING	MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DOUG DATE: 9/13/16 WEIGHT: 281.01 LBS JOB NO:	AFINITAS AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 506591701 MOLER ROAD COLUMBUS, OHIO 43207 LARGE CONTROLLER 3-7/16 ∅ 17 TON CAP.				
FAB	MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL		ANGULAR DEG							
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0 °							

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



THE FOLLOWING IS THE SUGGESTED TORQUE SETTINGS THAT YOU SHOULD USE FOR THE INITIAL TRIAL RUN FOR EACH PRODUCT SIZE. THE ACTUAL TORQUE SETTING THAT WORKS FOR YOUR PARTICULAR SETUP MAY VARY DUE TO FORM STYLE, BLOCKOUTS IN USE, HEIGHT OF FORM VERSUS HEIGHT OF PRODUCT RUN, RANGE OF PRODUCTS BEING ROLLED WITH THE SAME CONTROLLER, ETC....

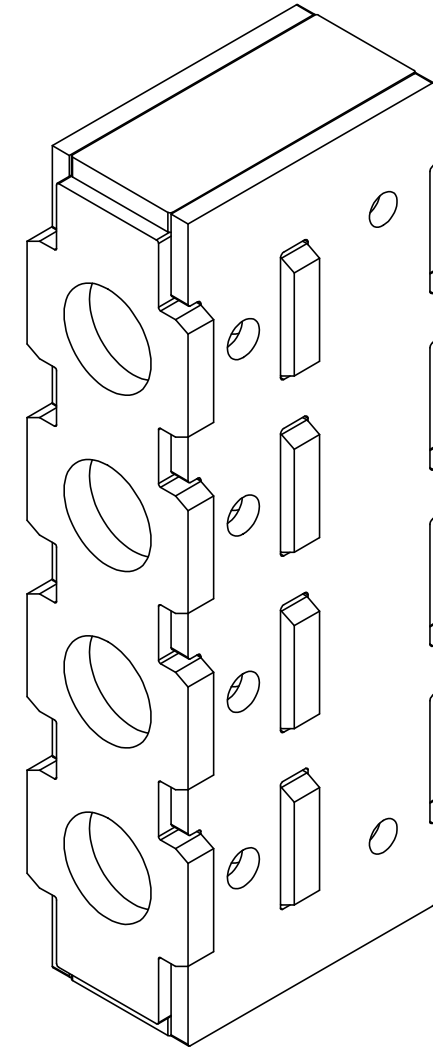
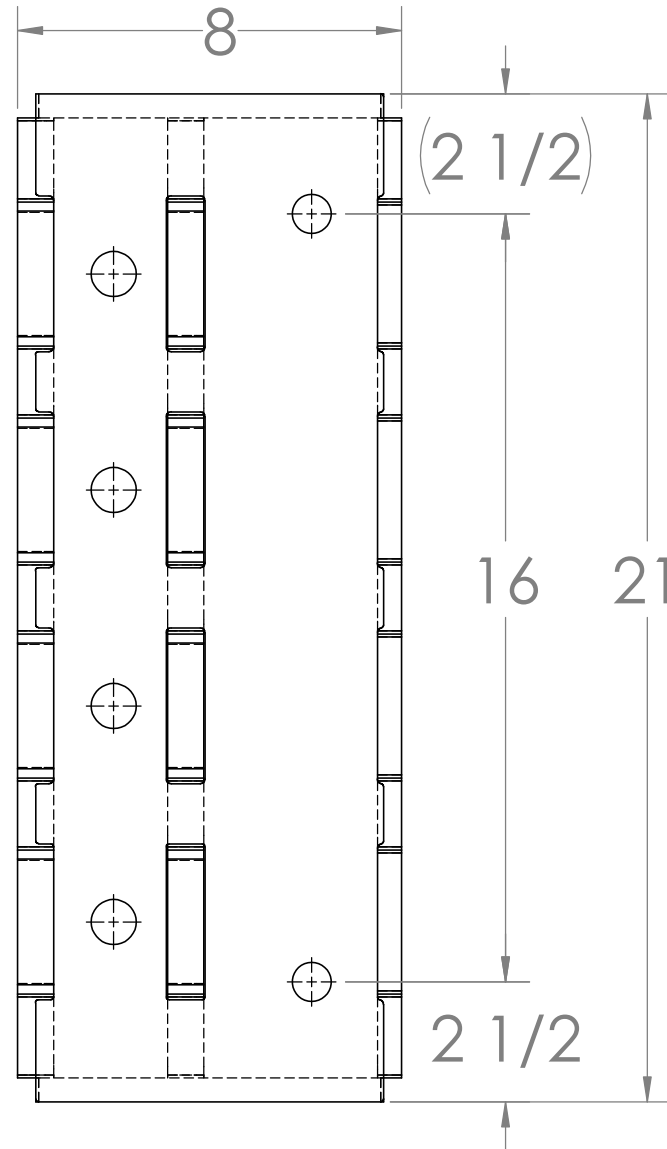
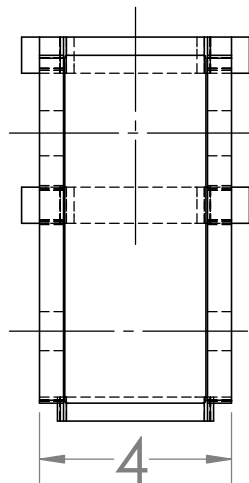
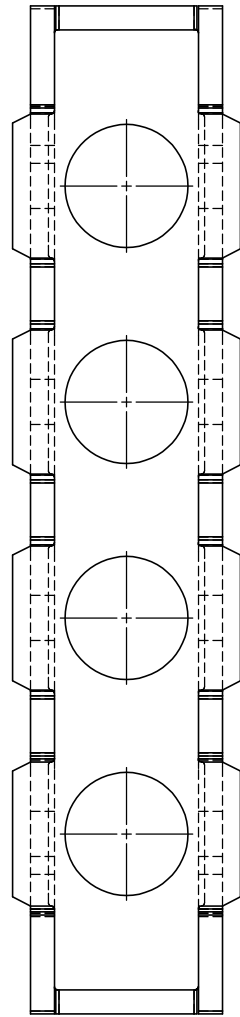


TORQUE BOLTS BETWEEN 170 AND 180 FT LBS.

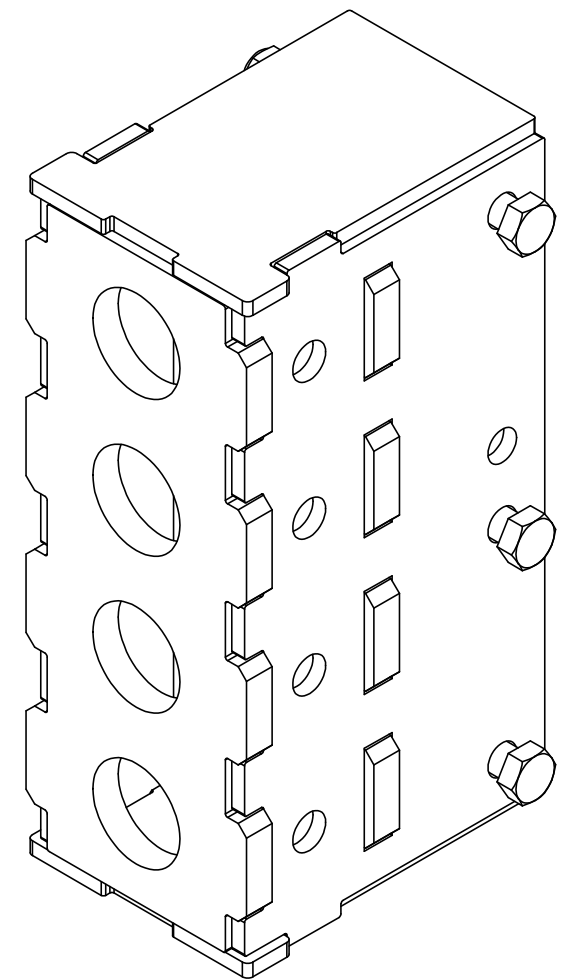
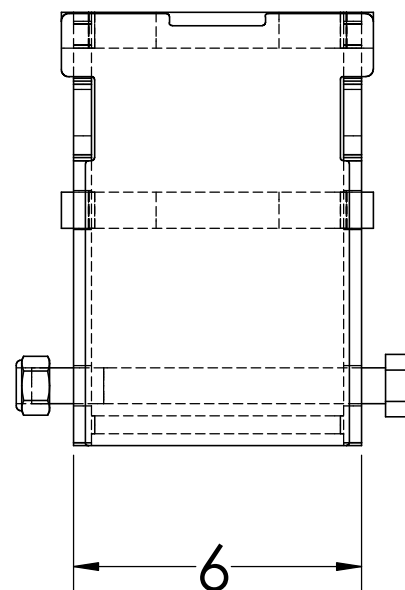
NOTE: FACTORY TORQUE SETTING IS 175 LBS.

CONTROLLER WEIGHT: 315 LBS

					6	PD-HD-0690-6	1	3/4 X 2 3/8 X 2 3/8 LG		
					5	1000-688	2	URETHANE CLAMP BLOCK FOR X-LARGE CONTROLLER		
					4	8520012	1	HITCH PIN 1 1/4 DIA.		
					3	8570032	1	ALLOY ANCHOR SHACKLE 30 TON W/BOLT AND NUT		
					2	PD-HD-0692	1	TRUNNION SHAFT 4 7/16 DIA.		
					1	PD-HD-0690	1	CONTROLLER SUB-ASSEMBLY		
NAME/QTY	NAME/QTY	NAME/QTY	NAME/QTY	NAME/QTY	ITEM	MATERIAL	QTY	DESCRIPTION		
WELDING	MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DOUG DATE: 5/24/16 WEIGHT: 325.99 LBS JOB NO:			AFINITAS AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 506591701 MOLER ROAD COLUMBUS, OHIO 43207 X-LARGE CONTROLLER 4-7/16 Ø 25 TON CAP.		
FAB	MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL		DECIMAL		ANGULAR DEG						
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0 °						
						SHEET: 1 OF 1	SCALE: 1:4	SIZE B	DWG NO: PD-HD-0693	REV.
						QTY:				



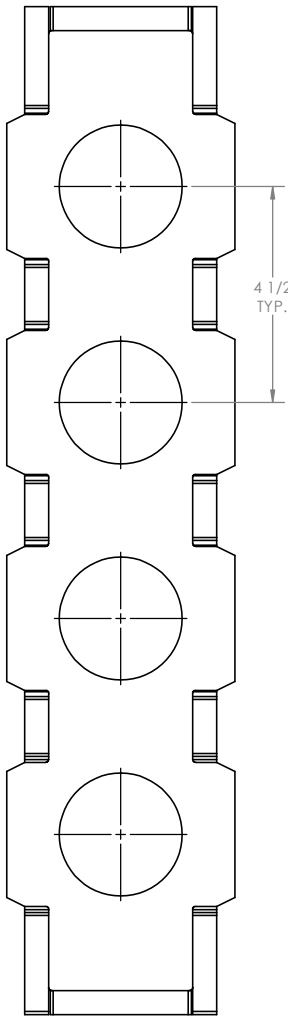
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FAB	MACHINING		CUTTING			QUICK ADJUST TRUNNION TUBE WELDMENT (STANDARD) W/4 HOLES FOR THE "SMALL" SMARTCONNECT										
GENERAL TOLERANCES EXCEPT AS NOTED																
FRACTIONAL	DECIMAL		ANGULAR DEG													
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°													
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					TROY											
					DATE:	4/04/23										
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					JOB NO:		QTY:									



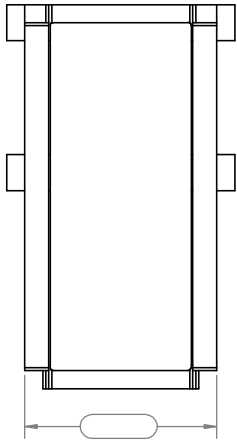
-TRUNNIONS TO BE ATTACHED TO EQUIPMENT USING ALL FASTENERS PROVIDED.
-CAPACITY (13,000 LBS. EACH OR 26,000 LBS. PER SET)

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FAB	MACHINING		CUTTING			QUICK ADJUST TRUNNION TUBE WELDMENT (STANDARD) W/HOLES FOR THE "SMALL" SMARTCONNECT (BESSER FORMING)				
GENERAL TOLERANCES EXCEPT AS NOTED						SHEET: 1 OF 1				
FRACTIONAL		DECIMAL		ANGULAR DEG		SCALE: 1:4				
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°	JOB NO:		QTY:	SIZE B	DWG NO: 1000-424W-MRK	REV. E

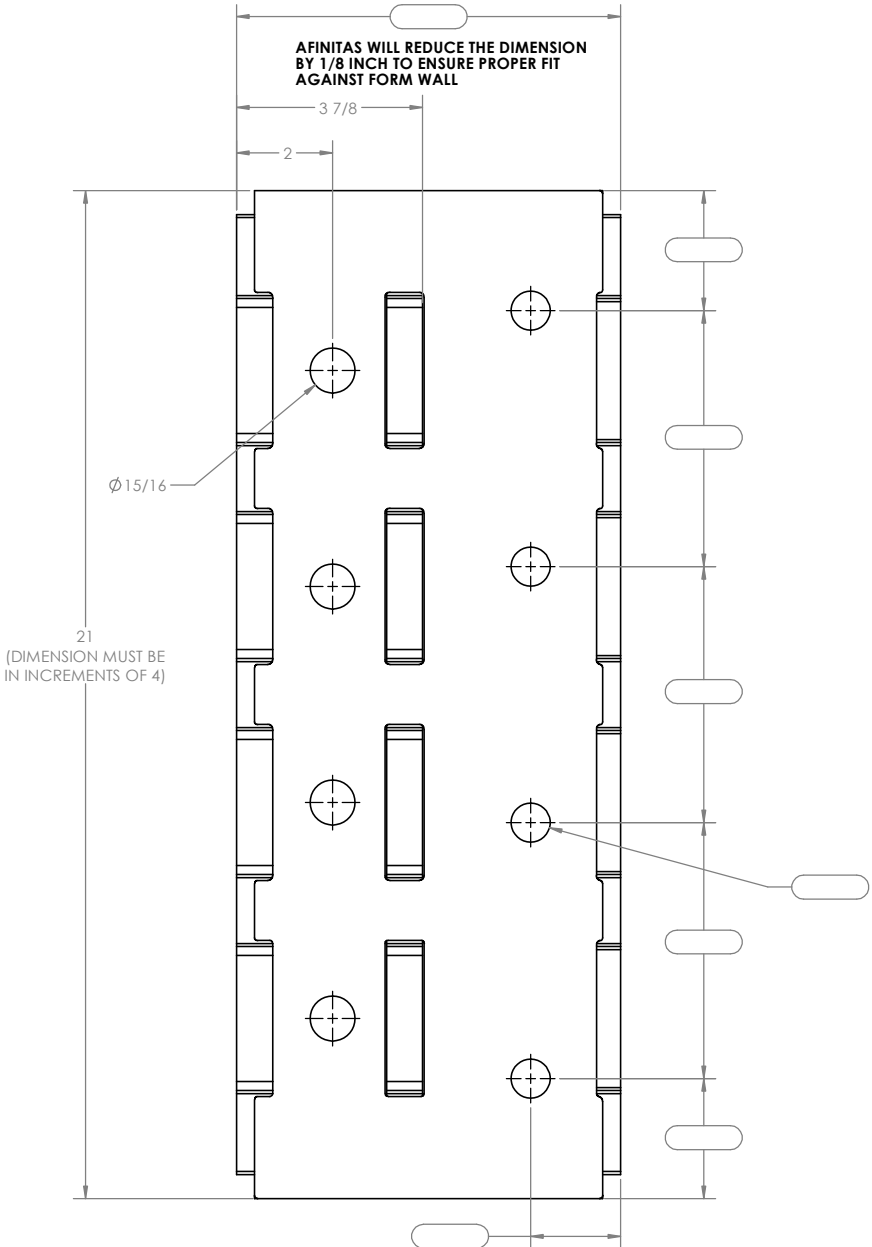
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REV.	ECR	CHANGE	BY	DATE



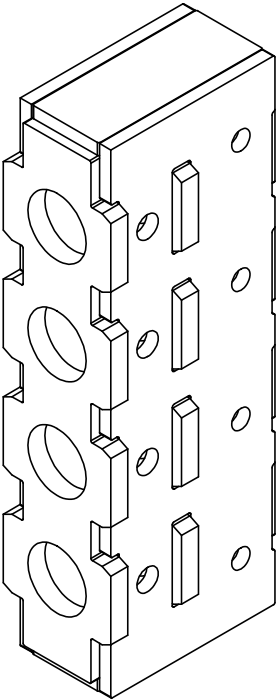
FRONT VIEW



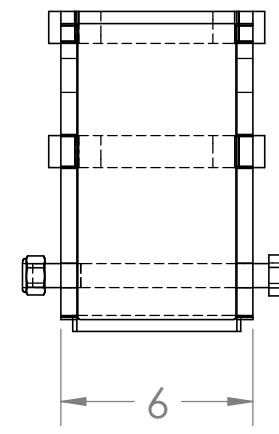
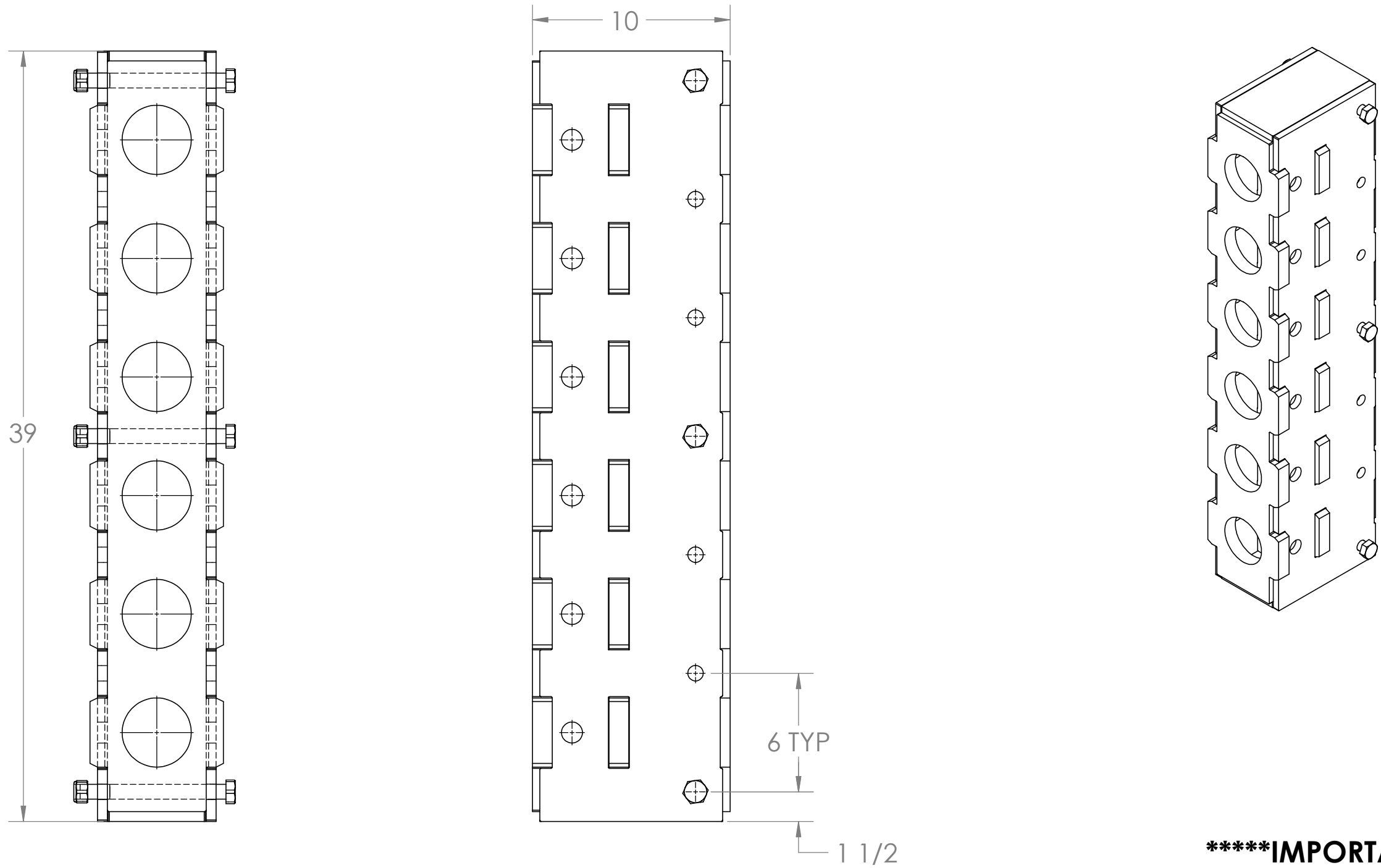
TOP VIEW



SIDE VIEW



WELDING	MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: TROY DATE: 4/04/23 WEIGHT: 76.91 LBS JOB NO:	 AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207					REV.	
FAB	MACHINING			CUTTING		QUICK ADJUST TRUNNION TUBE WELDMENT (STANDARD) W/4 HOLES FOR THE "SMALL-LARGE-EXTRA LARGE" SMARTCONNECT (FILL IN THE BLANK)						
GENERAL TOLERANCES EXCEPT AS NOTED												
FRACTIONAL	DECIMAL		ANGULAR DEG			SHEET: 1 OF 1						
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°			SCALE: 1:4						
					QTY:					SIZE D	DWG NO: RETROKIT-MRK	



*******IMPORTANT NOTE*******
-TRUNNIONS TO BE ATTACHED TO EQUIPMENT USING ALL FASTENERS PROVIDED.
-CAPACITY (34,000 LBS. EACH OR 68,000 LBS. PER SET)

WELDING	MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: TROY DATE: 3/14/23 WEIGHT: 226.76 LBS JOB NO:	AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207				
FAB	MACHINING		CUTTING			QUICK ADJUST TRUNNION TUBE WELDMENT (STANDARD)				
GENERAL TOLERANCES EXCEPT AS NOTED						W/6 HOLES FOR THE "LARGE" SMARTCONNECT				
						(BESSER FORMING)				
FRACTIONAL	DECIMAL		ANGULAR DEG							
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0 °							
					SHEET:	1 OF 1	SCALE:	SIZE	DWG NO:	REV.
							1:6	B	PD-OS-3537-MRK	



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