Self-Centering Stick

21 EM Stick Shown

25 ½ EM
25 EM
24 ½ EM
24 EM
22 ½ EM
21 EM
18 EM

PLEASE INDICATE LENGTH OF STICK WHEN ORDERING PARTS

FIG. 1

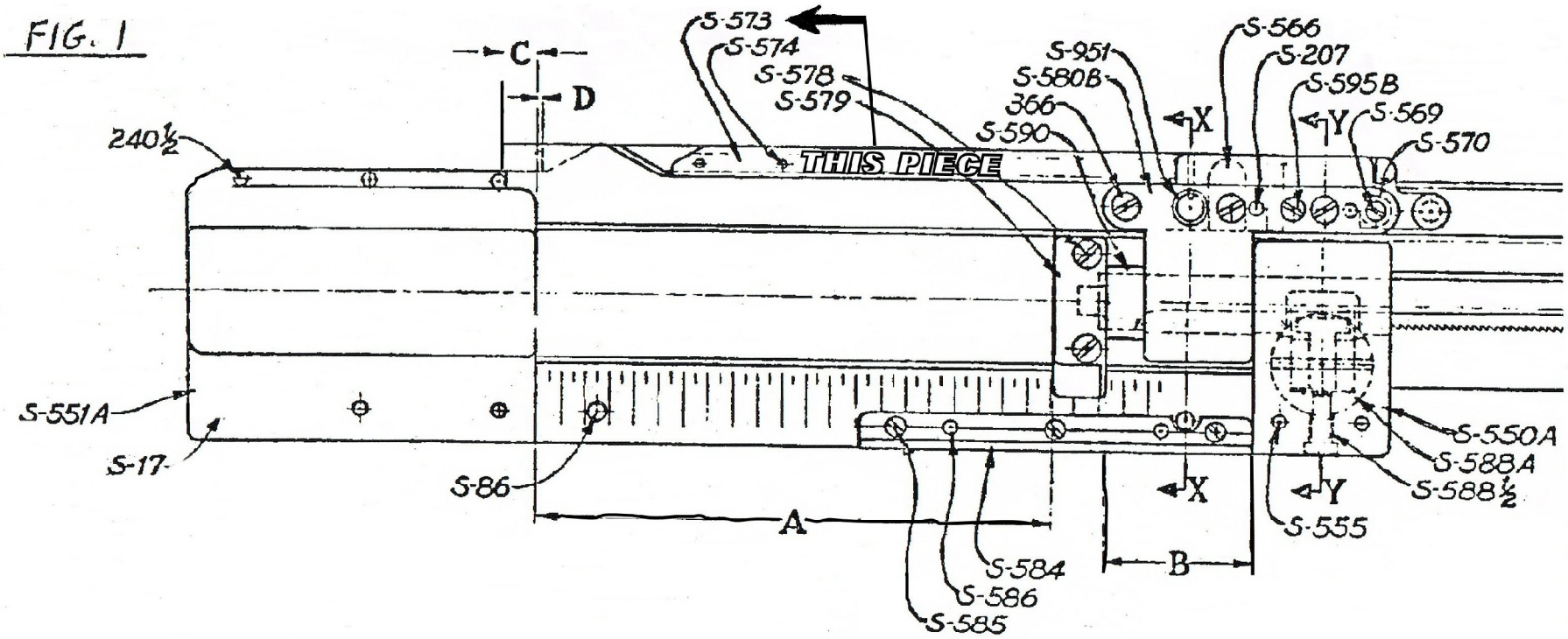
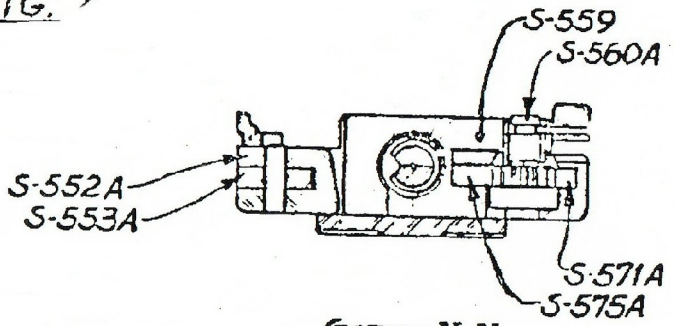
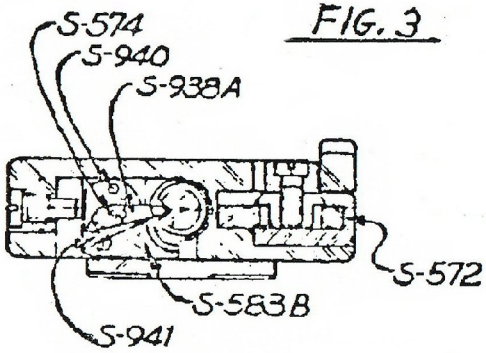


FIG. 2



SECTION X-X

FIG. 3



SECTION Y-Y

FIG. 1

240 ½ Pin for Front Hard Block and Rail.

S-551-A Front Hard Block.

S- 17 Pin for Front Hard Block and Rail.

S-573 Long Filler Piece -- For short length Filler Piece 572.

S-574 Rivet for Filler pieces. (1/16" X 1/2" long)

S-578 Rear Clamp Block Screws -- Hard End Block.

S-579 Hard Block - Front Bearing.

S-951 Pinion Bearing Bushing.

S-580-B Bridge.

S-366 Screw for Bridge.

S-590 Sleeve for length of stick.

S-566 Spring Retainer -- Spring Plate for S-213 Spring.

S-207 Pinion Bridge Pin.

S-595-B Screw for Thumb Lever Shaft -- Replaces old Screw S-564.

S-569 Screw for Locking Lever Pawl -- Also known as Thumb Lever Screw.

S-570 Pinion Lever Operating Friction Spring Washer for S-567.

S- 86 Spring Pin. (1/8" X 3/8" Long)

S-585 1/8" Long Fillister Head Rail Screw.

S-586 Safety Release Bar Dowel Pin. (3/32" Rod X 5/16" Long)

S-584 Safety Release Bar.

S-555 Pin for Rear End Block.

S-550-A Soft Block – Rear Bearing.

S-5881/2 Nut Retainer Lock Screw.

S-588-A Clamp Screw Nut Retainer for S-583-B.

FIG. 2

S-552-A	Loose Side.
S-553-A	Rail.
S-559	Sliding Gib,
S-560-A	Pinion Gear.
S-571-A	Stationary Gear Rack.
S-575-A	Movable Gear Rack.

FIG. 3

S-574	1/16" Dowel -- Clamp Screw Nut Arm Fulcrum.
S-940-A	Nut Suspension Pin.
S-938-A	Clamp Screw Nut Arm.
S-572	Short Length Filler Piece for S-573.
S-583-B	Clamp Screw Nut.
S-941-A	Clamp Screw Nut Spring.

ASSEMBLY

AS-583-B Clamp Screw Nut Assembly.

1 --	S-583-B	Clamp Screw Nut.
1 --	S-938-A	Clamp Screw Nut Arm.
1 --	S-941-A	Clamp Screw Nut Arm Spring.
1 --	S-940	Clamp Screw Nut Arm Suspension Pin.
1 --	S-574	Clamp Screw Nut Arm Fulcrum Pin.
1 --	S-588-A	Clamp Screw Nut Retainer for S-583-B.

FIG. 4

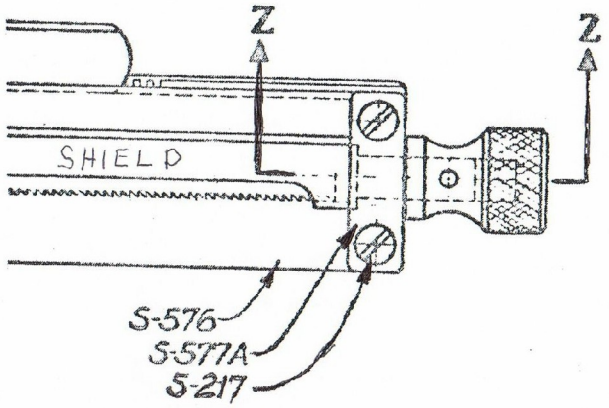
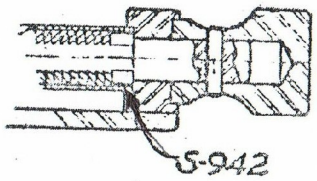


FIG. 5



SECTION Z-Z

SYMBOL	SIZE OF STICK	A	B	C	D
SC 7/8	25 1/2 EM	4.253 4.251	.247 .245	0	.0044 .0034
	25 EM	4.170 4.158	.330 .328	.0383 .0373	0
	24 1/2 EM	4.087 4.085	.413 .411	.080 .079	0
	24 EM	4.003 4.001	.497 .495	.1215 .1205	0
	22 1/2 EM	3.753 3.751	.747 .745	.2465 .2455	0
	21 EM	3.504 3.502	.997 .995	.2465 .2455	0

NOTE:- SEE FIG. 1

A & B DIMENSIONS INCLUDE $^{.005}_{.005}$ OVERSIZE MATRIX SPACE IN THE STICK OPENING
(A- OVERSIZE B-UNDERSIZE)

FIG. 4

S-576 Tie Plate.
S-577-A Front End Block for Tie Plate.
S-217 Screw for Rear Soft Block Bearing.

FIG. 5

S-942 Stop Pin for locking Shaft Tube.

FIG. 6

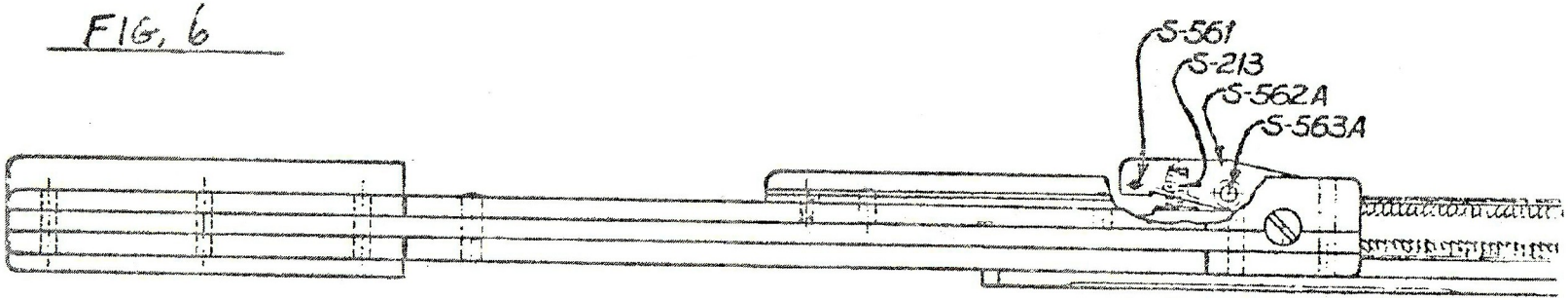
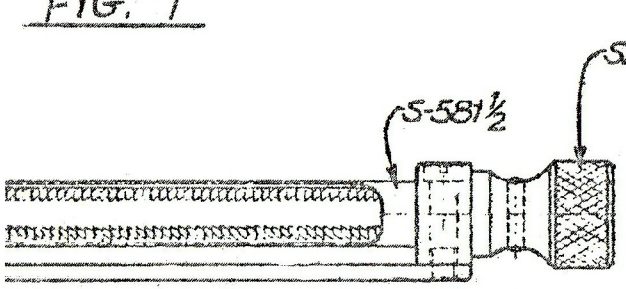


FIG. 7



(1) S-581B - SCREW
(1) S-207 — PIN
(1) S-809 — KNOB

FIG. 8

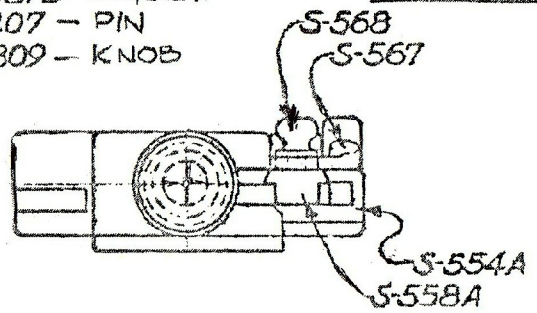


FIG. 6

S-561	**Pin on Lever to lift Pinion Gear.**
S-213	**Pinion Lever Operating Spring.**
S-562-A	**Thumb Lever,**
S-563-A	**Lever Pin for Thumb Lever.**

FIG. 7

S-581 1/2	**Tube.**
SAS-581-B	**Assembly includes the following:**

S-581-B	**Screw**
S-207	**Pin**
S-809	**Knob**

FIG. 8

S-568	**Pawl Knob.**
S-567	**Thumb Lever.**
S-554-A	**Stationary Side. S-554 1/2 is for 6-LP**
S-558-A	**Stop Slide.**