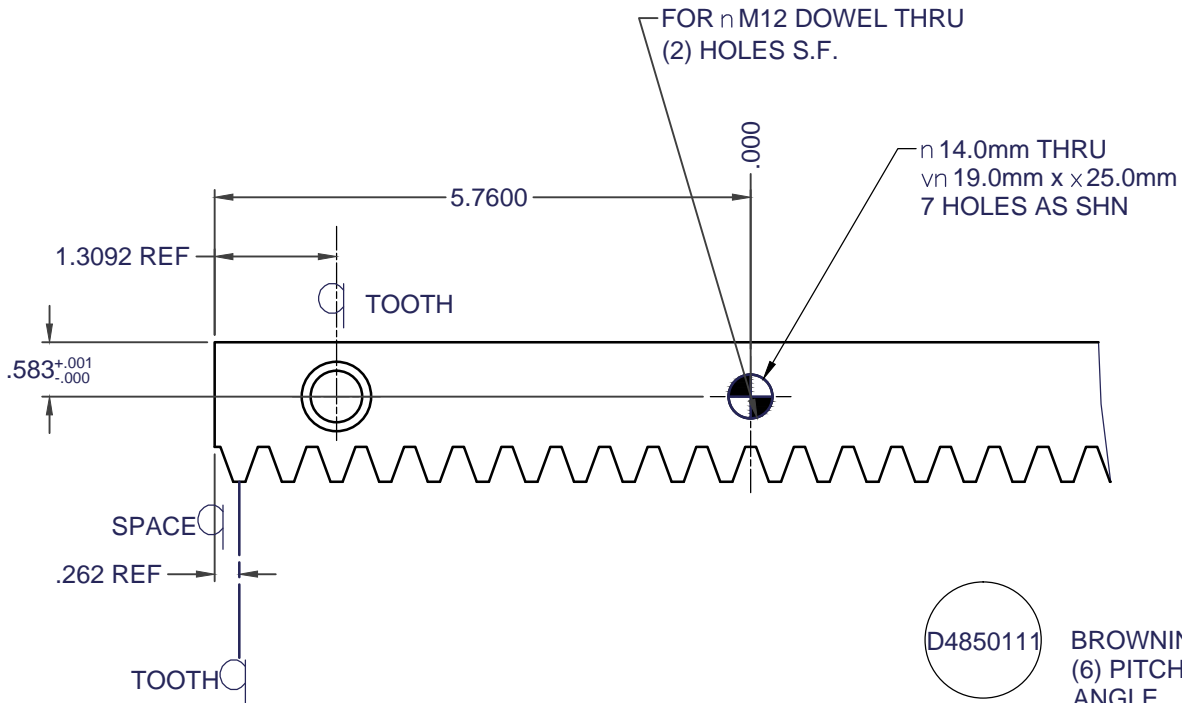
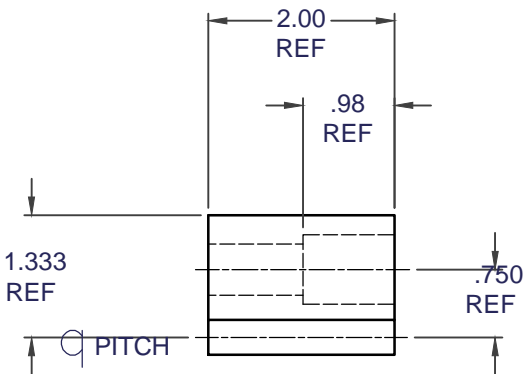
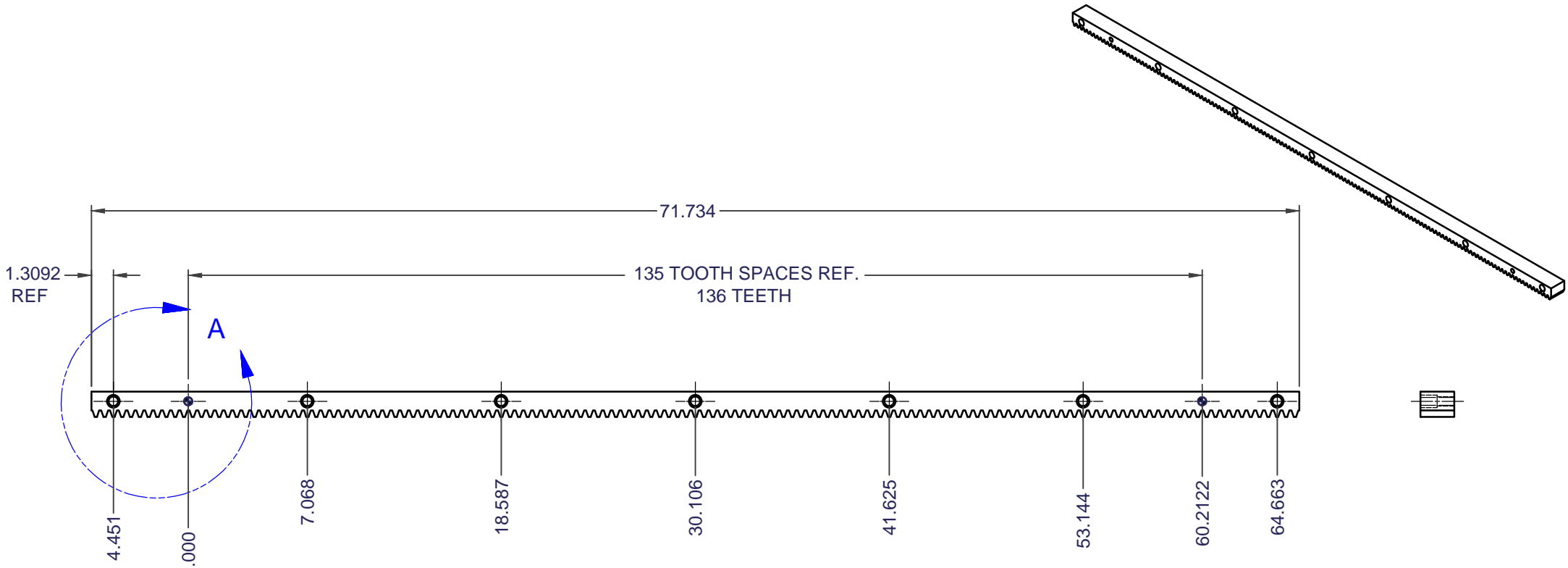


LET.	CHANGE	NAME	CHKD	DATE



DETAIL A
SCALE 1 / 2

D4850111

BROWNING STL RACK
(6) PITCH (20~) PRESSURE
ANGLE
STK: 6YSR 6 x 1 1/2

TOTAL WEIGHT: 41.1 lbs.

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CONFIDENTIAL INFORMATION PURPOSE ONLY
AND IS NOT TO BE DISCLOSED TO ANYONE ELSE
OR REPRODUCED OR USED FOR MANUFAC-
TURING PURPOSES WITHOUT PERMISSION.

NOTE:
THIS DRAWING MAY USE BOTH INCH AND METRIC UNITS OF MEASUREMENT
INCH DIM'S UNLESS SPECIFIED

UNLESS OTHERWISE SPECIFIED:
MAXIMUM ALLOWABLE ROUGHNESS OF ALL
INCH

- 2 PLACE INCH FINISH DIMENSIONS TO BE 250 MICROINCHES
- 3 PLACE INCH FINISH DIMENSIONS TO BE 125 MICROINCHES
- 4 PLACE INCH FINISH DIMENSIONS TO BE 63 MICROINCHES
- ALL GROUND SURFACES TO BE 16 MICROINCHES

EXCEPT AS NOTED TOLERANCES SHALL BE:

- 2 PLACE MACHINING ±0.01
- 2 PLACE FABRICATION ±0.08
- 3 PLACE ±0.003 BETWEEN MACHINE SURFACES
 - ±0.001 BETWEEN SINGLE DOWEL AND A HEEL SURFACE
 - ±0.001 BETWEEN DOWELS IN THE SAME PLANE
 - ±0.004 BETWEEN DOWELS IN DIFFERENT PLANES
 - ±0.005 TO SCREW HOLES, NON ACCUMULATIVE
 - ±0 DEG'S 30 MINUTES ON ANGLES

ALL MACHINED SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN
OR COLD ROLLED SURFACES.

WELDMENTS

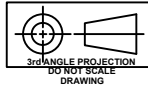
ALL WELD FILLETS TO BE 1/4 INCH
ALL "V" GROOVES TO BE 90 EXCEPT AS SHOWN
ADD VENT HOLES IN ALL WELDMENTS WHERE TRAPPED AIR IS A POSSIBILITY
I.E. TUBING CAPPED AT BOTH ENDS, BOXED FORMS ETC.
SPOTFACE SCREW AND/OR BOLT HEADS AND/OR WASHERS IF INFRINGED
UPON WELD BEADS

ALL EDGES OF PART CONTACT SURFACES ON LOCATING BLOCKS AND
FINGERS TO HAVE .12R INCH / 3.00 MM AFTER SPOTTING
BUILD VENDOR TO BE RESPONSIBLE FOR ACCURACY OF STANDARD
PRODUCTS AFTER ALTERATION

ALL SCREW HOLES, TAPPED HOLES, DOWEL HOLES, REAMED HOLES. TO BE
CALLED OUT IN INCHES

DOWEL TOLERANCES IN INCHES
P.F. = PRESS FIT = -.0000 / -.0005
S.F. = SLIP FIT = +.0010 / +.0005

MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS
PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK



STRESS RELIEVE ALL MAIN BODY WELDMENTS BEFORE MACHINING.
STRESS RELIEVE AFTER ROUGH BUT BEFORE FINISH MACHINING.
BREAK ALL SHARP EDGES TO 1/32 MINIMUM RADIUS OR CHAMFER.

ALL HEAT TREATED STEEL SECTIONS MUST BE STAMPED ON
NON-FUNCTIONING SURFACE WITH GRADE OF MATERIAL USED.

LOCKWASHERS MUST BE APPLIED UNDER ALL SCREW HEADS AND NUTS.

DECARBURIZATION ON ALL WORKING SURFACES OF HARDENED STEEL MUST BE
PREVENTED OR REMOVED COMPLETELY AFTER HARDENING.

HARDNESS AS SPECIFIED MUST BE PROVIDED ON THE WORKING SURFACES OF
HARDENED PARTS WITHOUT FURTHER METAL REMOVAL OR POLISHING.

ALL STEELS WHICH HAVE BEEN SUBJECTED TO A GRINDING OPERATION MUST
BE DEMAGNETIZED BEFORE INSTALLATION IN TOOL.

TAPPED HOLES TO BE UNIFIED COARSE UNC WITH FULL THREAD (2) X DIA.
DOWEL HOLE DEPTH TO BE (2) X DIA.

DO NOT SUBSTITUTE MATERIAL UNLESS APPROVED BY ENGINEERING DEPT.
USE APPROVED FORMED PART TO CHECK CLEARANCE AND
REMOVE INTERFERENCE BEFORE TRYOUT.
TOOLMAKER TO PROVIDE FOR REMOVAL OF DOWELED INSERTS.

UNIT#		LH SHN / RH OPP	OP# 485
SCALE 1/8	TITLE LIFT & CARRY TRANSFER	DWG. NO. D4850111	
		SHT 1 OF 1 SHTS.	CUST. CHRYSLER
DR. JPL	DATE 2/3/2004	MODEL DD-DP	
CHK.	DATE	VENDOR BAY TASK# 4774 JOB#DDP-485	
SAFETY CHK.	DATE	DES. REF.	