

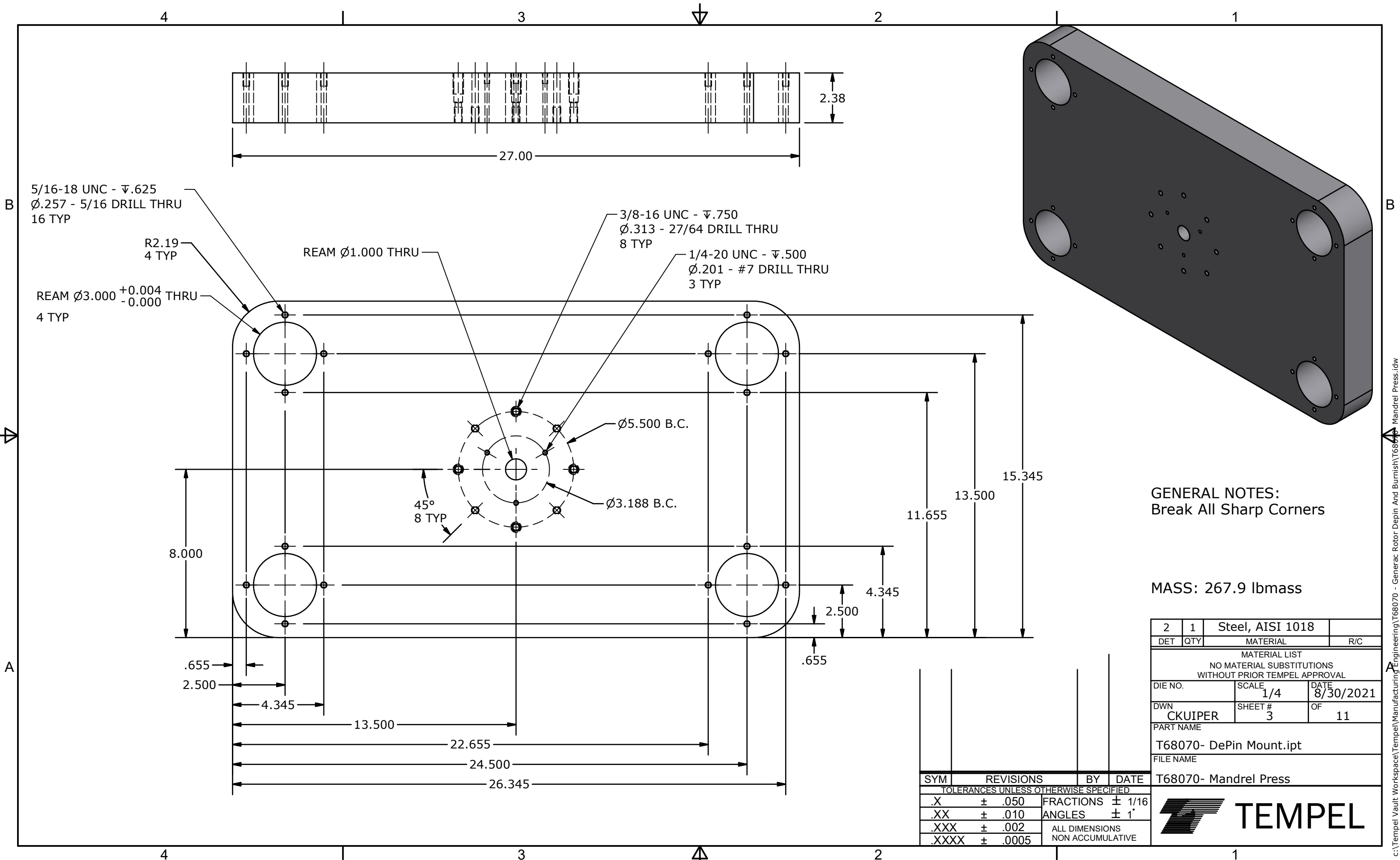
GENERAL NOTES:  
-BREAK SHARP CORNERS

MASS: 213.5 lbmass

1	1	Steel, AISI 1018	
DET	QTY	MATERIAL	R/C
MATERIAL LIST			
NO MATERIAL SUBSTITUTIONS			
WITHOUT PRIOR TEMPEL APPROVAL			
DIE NO.	SCALE	DATE	
	1/4	8/30/2021	
DWN	SHEET #	OF	
CKUIPER	2	11	
PART NAME			
T68070- Cylinder Mount.ipt			
FILE NAME			
T68070- Mandrel Press			

SYM	REVISIONS	BY	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED			
.X	± .050	FRACTIONS	± 1/16
.XX	± .010	ANGLES	± 1°
.XXX	± .002	ALL DIMENSIONS NON ACCUMULATIVE	
.XXXX	± .0005		



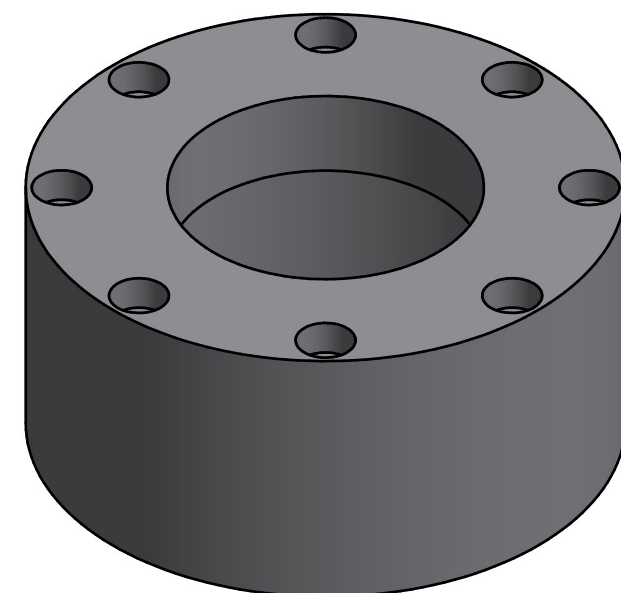
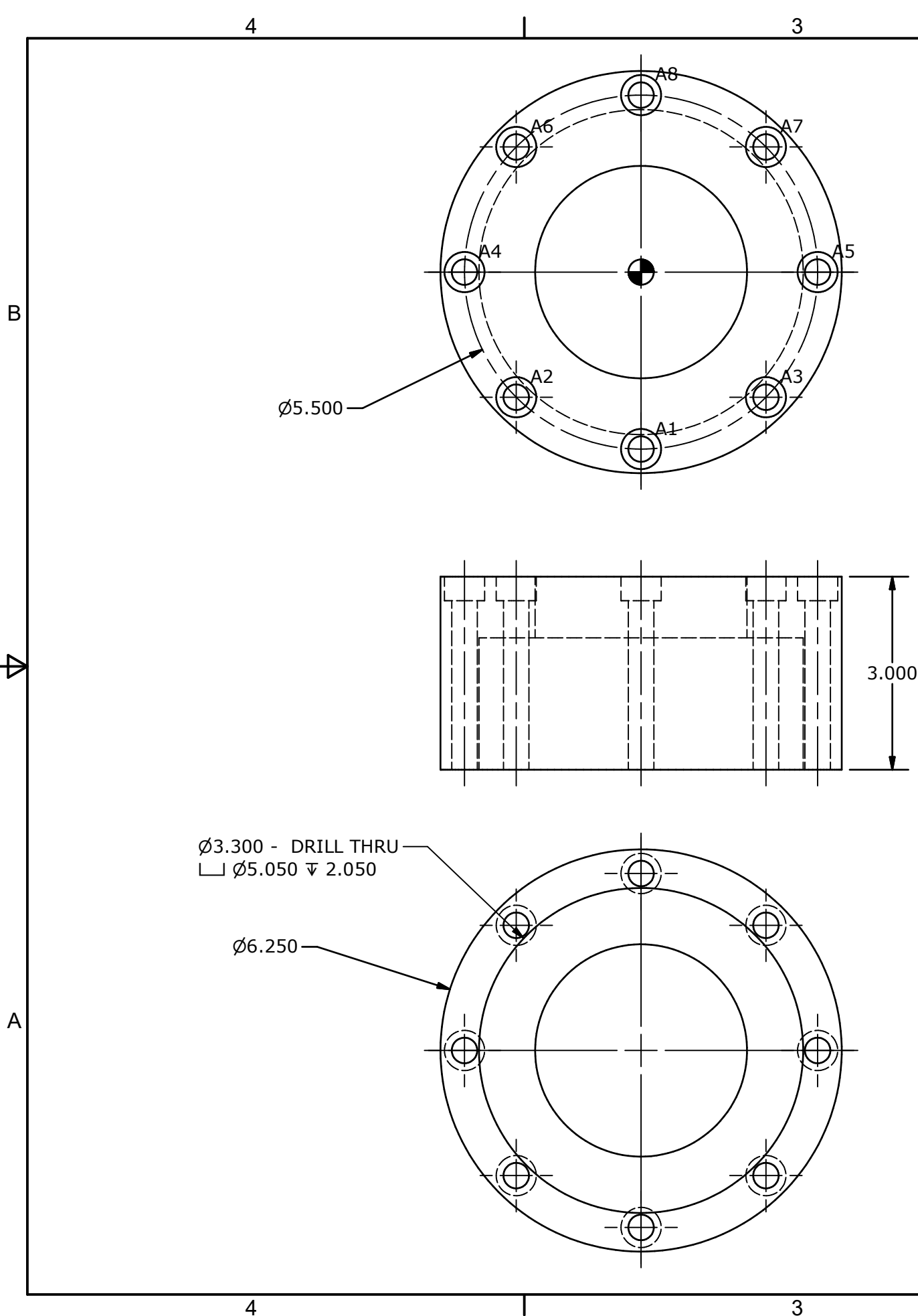


2	1	Steel, AISI 1018	
DET	QTY	MATERIAL	R/C
MATERIAL LIST			
NO MATERIAL SUBSTITUTIONS			
WITHOUT PRIOR TEMPEL APPROVAL			
DIE NO.	SCALE	DATE	
	1/4	8/30/2021	
DWN	SHEET #	OF	
CKUIPER	3	11	
PART NAME			
T68070- DePin Mount.ipt			
FILE NAME			
T68070- Mandrel Press			

SYM	REVISIONS	BY	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED			
.X	$\pm$ .050	FRACTIONS	$\pm$ 1/16
.XX	$\pm$ .010	ANGLES	$\pm$ 1°
.XXX	$\pm$ .002	ALL DIMENSIONS NON ACCUMULATIVE	
.XXXX	$\pm$ .0005		



THIS DOCUMENT AND ITS CONTENTS ARE THE CONFIDENTIAL AND PROPRIETARY INTELLECTUAL PROPERTY OF TEMPEL STEEL COMPANY. BY ACCEPTING THIS DOCUMENT YOU AGREE TO TREAT IT AND ITS CONTENTS AS CONFIDENTIAL. UNAUTHORIZED REPRODUCTION, DISTRIBUTION, DISPLAY OR MISAPPROPRIATION OF THIS DOCUMENT OR ANY OF ITS CONTENTS, IN WHOLE OR IN PART, IS EXPRESSLY FORBIDDEN.



Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
A1	.000	-2.750	Ø.397 - X DRILL THRU └─┘ Ø.625 ▽ .375
A2	-1.945	-1.945	Ø.397 - X DRILL THRU └─┘ Ø.625 ▽ .375
A3	1.945	-1.945	Ø.397 - X DRILL THRU └─┘ Ø.625 ▽ .375
A4	-2.750	.000	Ø.397 - X DRILL THRU └─┘ Ø.625 ▽ .375
A5	2.750	.000	Ø.397 - X DRILL THRU └─┘ Ø.625 ▽ .375
A6	-1.945	1.945	Ø.397 - X DRILL THRU └─┘ Ø.625 ▽ .375
A7	1.945	1.945	Ø.397 - X DRILL THRU └─┘ Ø.625 ▽ .375
A8	.000	2.750	Ø.397 - X DRILL THRU └─┘ Ø.625 ▽ .375

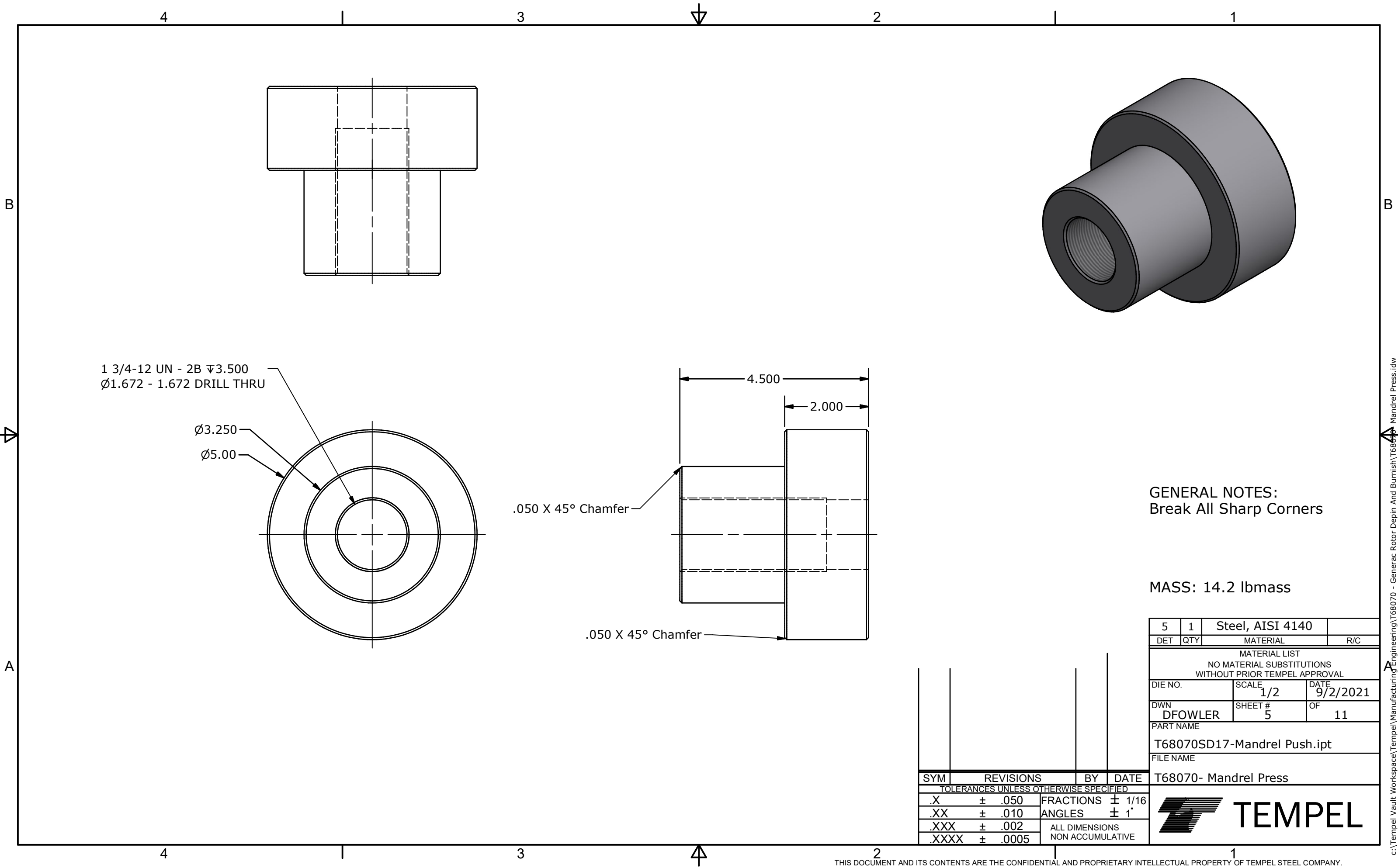
GENERAL NOTES:  
Break All Sharp Corners

MASS: 11.1 lbmass

3	1	Steel, AISI 4140		
DET	QTY	MATERIAL		R/C
MATERIAL LIST				
NO MATERIAL SUBSTITUTIONS				
WITHOUT PRIOR TEMPEL APPROVAL				
DIE NO.		SCALE	DATE	
		1/2	9/2/2021	
DWN		SHEET #	OF	
DFOWLER		4	11	
PART NAME				
T68070SD18-Mandrel Keep.ipt				
FILE NAME				
T68070- Mandrel Press				

SYM	REVISIONS	BY	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED			
.X	± .050	FRACTIONS ± 1/16	
.XX	± .010	ANGLES ± 1°	
.XXX	± .002	ALL DIMENSIONS NON ACCUMULATIVE	
.XXXX	± .0005		





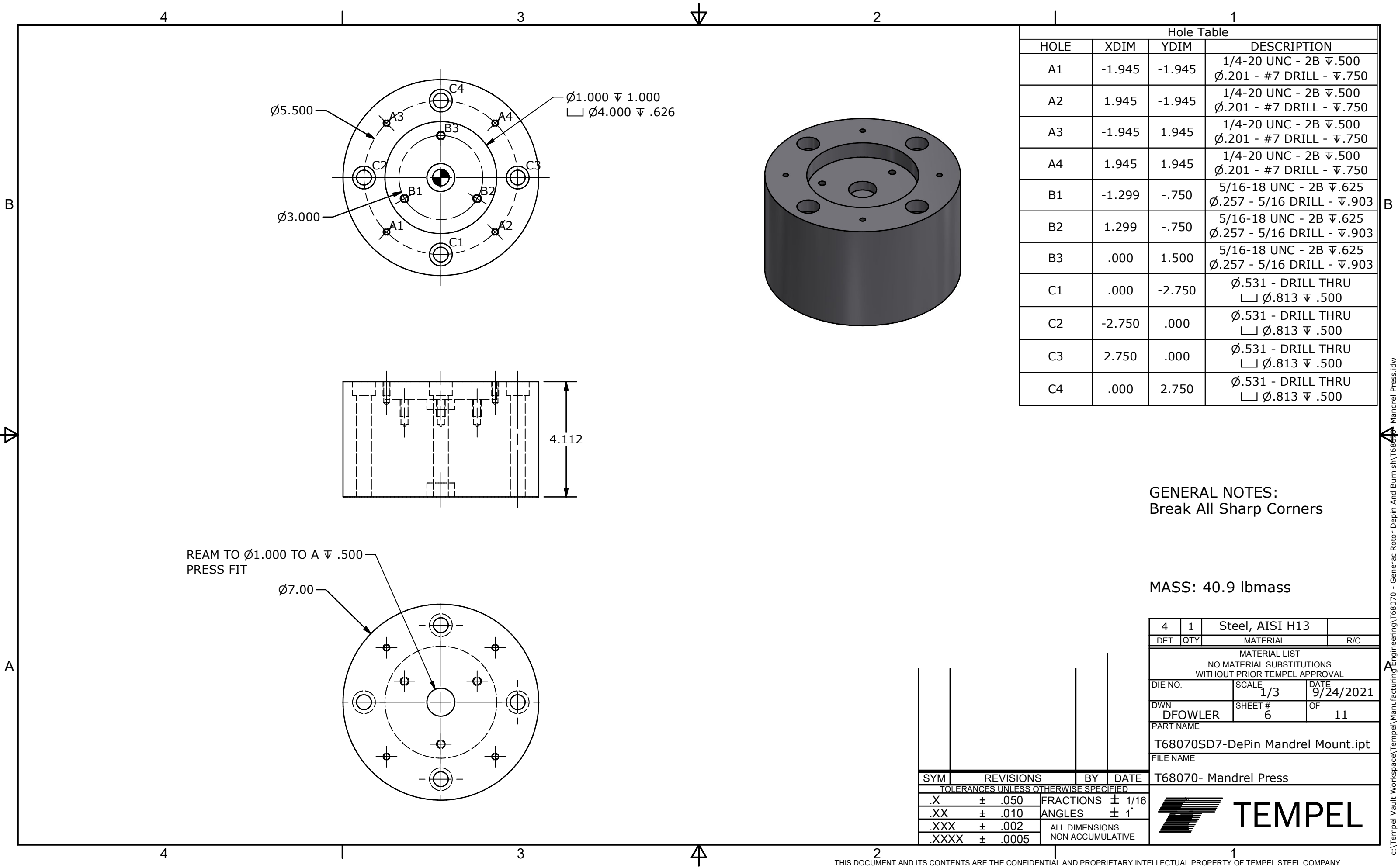
GENERAL NOTES:  
Break All Sharp Corners

MASS: 14.2 lbmass

5	1	Steel, AISI 4140	
DET	QTY	MATERIAL	R/C
MATERIAL LIST NO MATERIAL SUBSTITUTIONS WITHOUT PRIOR TEMPEL APPROVAL			
DIE NO.	SCALE	DATE	
	1/2	9/2/2021	
DWN	SHEET #	OF	
DFOWLER	5	11	
PART NAME			
T68070SD17-Mandrel Push.ipt			
FILE NAME			
T68070- Mandrel Press			

SYM	REVISIONS	BY	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED			
.X	$\pm .050$	FRACTIONS	$\pm 1/16$
.XX	$\pm .010$	ANGLES	$\pm 1^\circ$
.XXX	$\pm .002$	ALL DIMENSIONS NON ACCUMULATIVE	
.XXXX	$\pm .0005$		





Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
A1	-1.945	-1.945	1/4-20 UNC - 2B $\pm .500$ $\varnothing .201$ - #7 DRILL - $\pm .750$
A2	1.945	-1.945	1/4-20 UNC - 2B $\pm .500$ $\varnothing .201$ - #7 DRILL - $\pm .750$
A3	-1.945	1.945	1/4-20 UNC - 2B $\pm .500$ $\varnothing .201$ - #7 DRILL - $\pm .750$
A4	1.945	1.945	1/4-20 UNC - 2B $\pm .500$ $\varnothing .201$ - #7 DRILL - $\pm .750$
B1	-1.299	-.750	5/16-18 UNC - 2B $\pm .625$ $\varnothing .257$ - 5/16 DRILL - $\pm .903$
B2	1.299	-.750	5/16-18 UNC - 2B $\pm .625$ $\varnothing .257$ - 5/16 DRILL - $\pm .903$
B3	.000	1.500	5/16-18 UNC - 2B $\pm .625$ $\varnothing .257$ - 5/16 DRILL - $\pm .903$
C1	.000	-2.750	$\varnothing .531$ - DRILL THRU $\varnothing .813 \pm .500$
C2	-2.750	.000	$\varnothing .531$ - DRILL THRU $\varnothing .813 \pm .500$
C3	2.750	.000	$\varnothing .531$ - DRILL THRU $\varnothing .813 \pm .500$
C4	.000	2.750	$\varnothing .531$ - DRILL THRU $\varnothing .813 \pm .500$

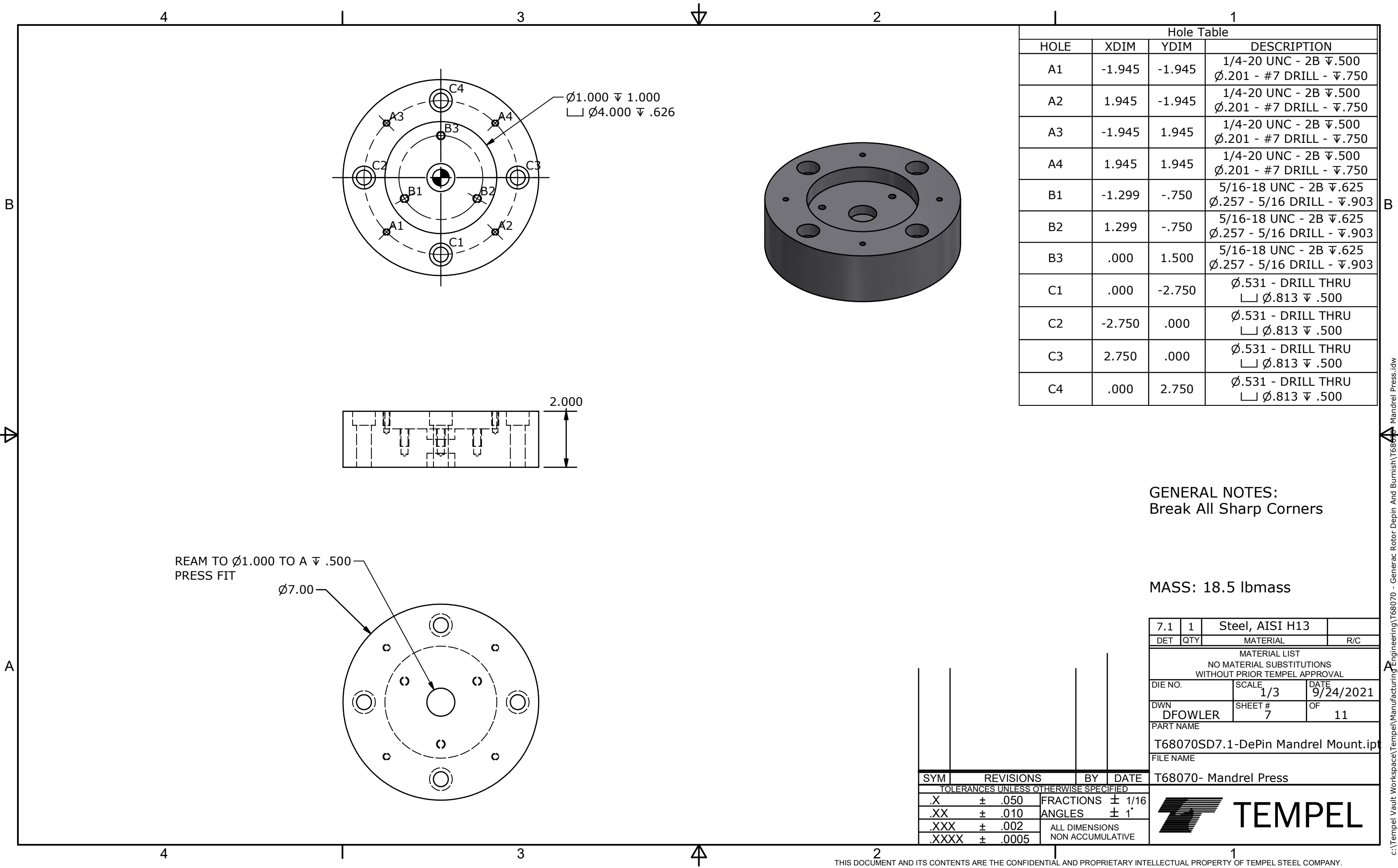
GENERAL NOTES:  
Break All Sharp Corners

MASS: 40.9 lbmass

4	1	Steel, AISI H13		
DET	QTY	MATERIAL		R/C
MATERIAL LIST				
NO MATERIAL SUBSTITUTIONS				
WITHOUT PRIOR TEMPEL APPROVAL				
DIE NO.		SCALE	DATE	
		1/3	9/24/2021	
DWN		SHEET #	OF	
DFOWLER		6	11	
PART NAME				
T68070SD7-DePin Mandrel Mount.ipt				
FILE NAME				
T68070- Mandrel Press				

SYM	REVISIONS	BY	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED			
.X	$\pm .050$	FRACTIONS $\pm 1/16$	
.XX	$\pm .010$	ANGLES $\pm 1^\circ$	
.XXX	$\pm .002$	ALL DIMENSIONS NON ACCUMULATIVE	
.XXXX	$\pm .0005$		





Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
A1	-1.945	-1.945	1/4-20 UNC - 2B $\nabla$ .500 $\varnothing$ .201 - #7 DRILL - $\nabla$ .750
A2	1.945	-1.945	1/4-20 UNC - 2B $\nabla$ .500 $\varnothing$ .201 - #7 DRILL - $\nabla$ .750
A3	-1.945	1.945	1/4-20 UNC - 2B $\nabla$ .500 $\varnothing$ .201 - #7 DRILL - $\nabla$ .750
A4	1.945	1.945	1/4-20 UNC - 2B $\nabla$ .500 $\varnothing$ .201 - #7 DRILL - $\nabla$ .750
B1	-1.299	-.750	5/16-18 UNC - 2B $\nabla$ .625 $\varnothing$ .257 - 5/16 DRILL - $\nabla$ .903
B2	1.299	-.750	5/16-18 UNC - 2B $\nabla$ .625 $\varnothing$ .257 - 5/16 DRILL - $\nabla$ .903
B3	.000	1.500	5/16-18 UNC - 2B $\nabla$ .625 $\varnothing$ .257 - 5/16 DRILL - $\nabla$ .903
C1	.000	-2.750	$\varnothing$ .531 - DRILL THRU $\sqcup$ $\varnothing$ .813 $\nabla$ .500
C2	-2.750	.000	$\varnothing$ .531 - DRILL THRU $\sqcup$ $\varnothing$ .813 $\nabla$ .500
C3	2.750	.000	$\varnothing$ .531 - DRILL THRU $\sqcup$ $\varnothing$ .813 $\nabla$ .500
C4	.000	2.750	$\varnothing$ .531 - DRILL THRU $\sqcup$ $\varnothing$ .813 $\nabla$ .500

GENERAL NOTES:  
Break All Sharp Corners

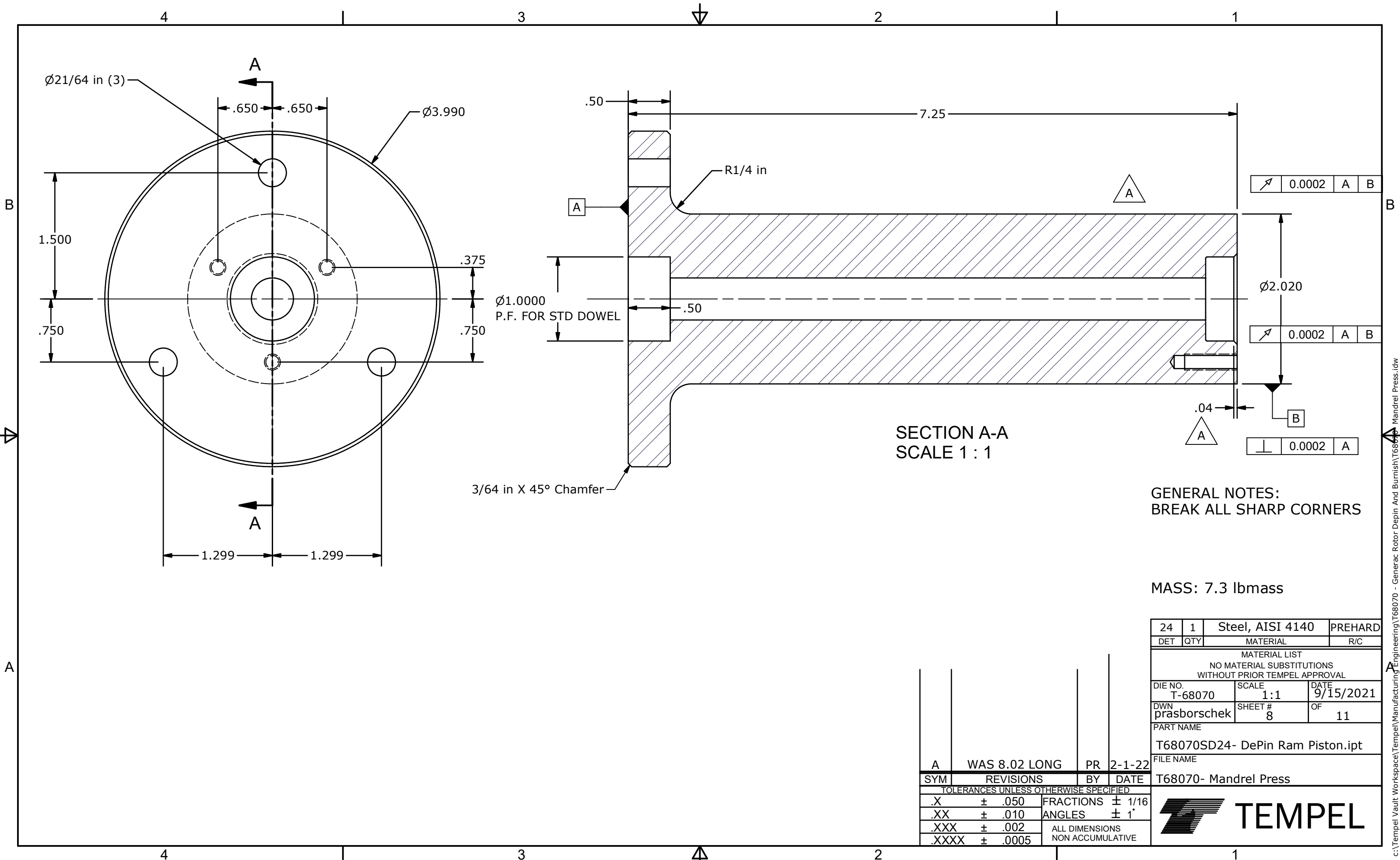
MASS: 18.5 lbmass

7.1	1	Steel, AISI H13	
DET	QTY	MATERIAL	R/C
MATERIAL LIST NO MATERIAL SUBSTITUTIONS WITHOUT PRIOR TEMPEL APPROVAL			
DIE NO.	SCALE	DATE	
	1/3	9/24/2021	
DWN	SHEET #	OF	
DFOWLER	7	11	
PART NAME			
T68070SD7.1-DePin Mandrel Mount.ip			
FILE NAME			
T68070- Mandrel Press			

SYM	REVISIONS	BY	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED			
.X	$\pm$ .050	FRACTIONS	$\pm$ 1/16
.XX	$\pm$ .010	ANGLES	$\pm$ 1°
.XXX	$\pm$ .002	ALL DIMENSIONS NON ACCUMULATIVE	
.XXXX	$\pm$ .0005		



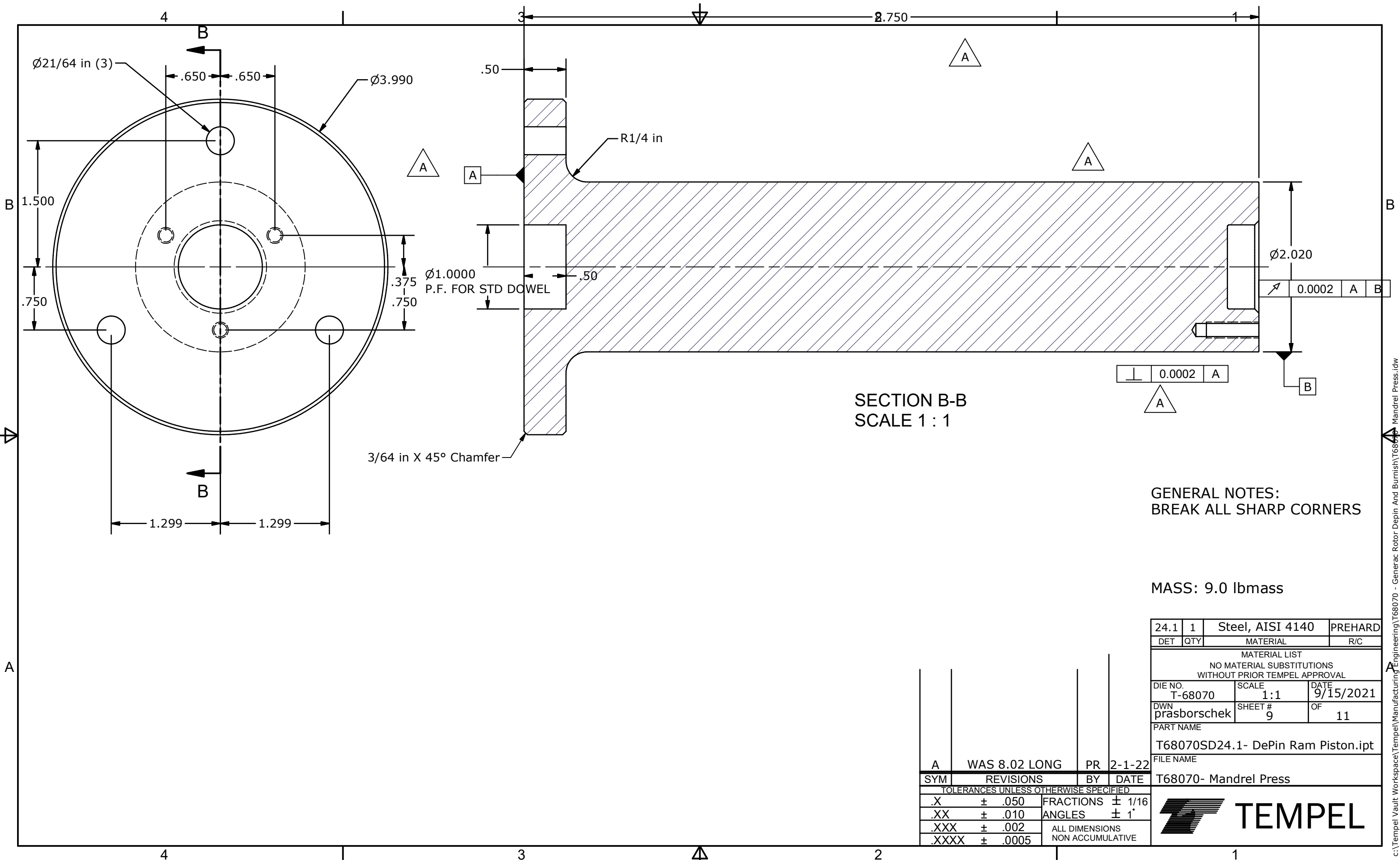




A	WAS 8.02 LONG	PR	2-1-22
SYM	REVISIONS	BY	DATE
.X	± .050	FRACTIONS	± 1/16
.XX	± .010	ANGLES	± 1°
.XXX	± .002	ALL DIMENSIONS	NON ACCUMULATIVE
.XXXX	± .0005		

24	1	Steel, AISI 4140	PREHARD
DET	QTY	MATERIAL	R/C
MATERIAL LIST			
NO MATERIAL SUBSTITUTIONS			
WITHOUT PRIOR TEMPEL APPROVAL			
DIE NO.	SCALE	DATE	
T-68070	1:1	9/15/2021	
DWN	SHEET #	OF	
präsbornschek	8	11	
PART NAME			
T68070SD24- DePin Ram Piston.ipt			
FILE NAME			
T68070- Mandrel Press			





GENERAL NOTES:  
BREAK ALL SHARP CORNERS

MASS: 9.0 lbmass

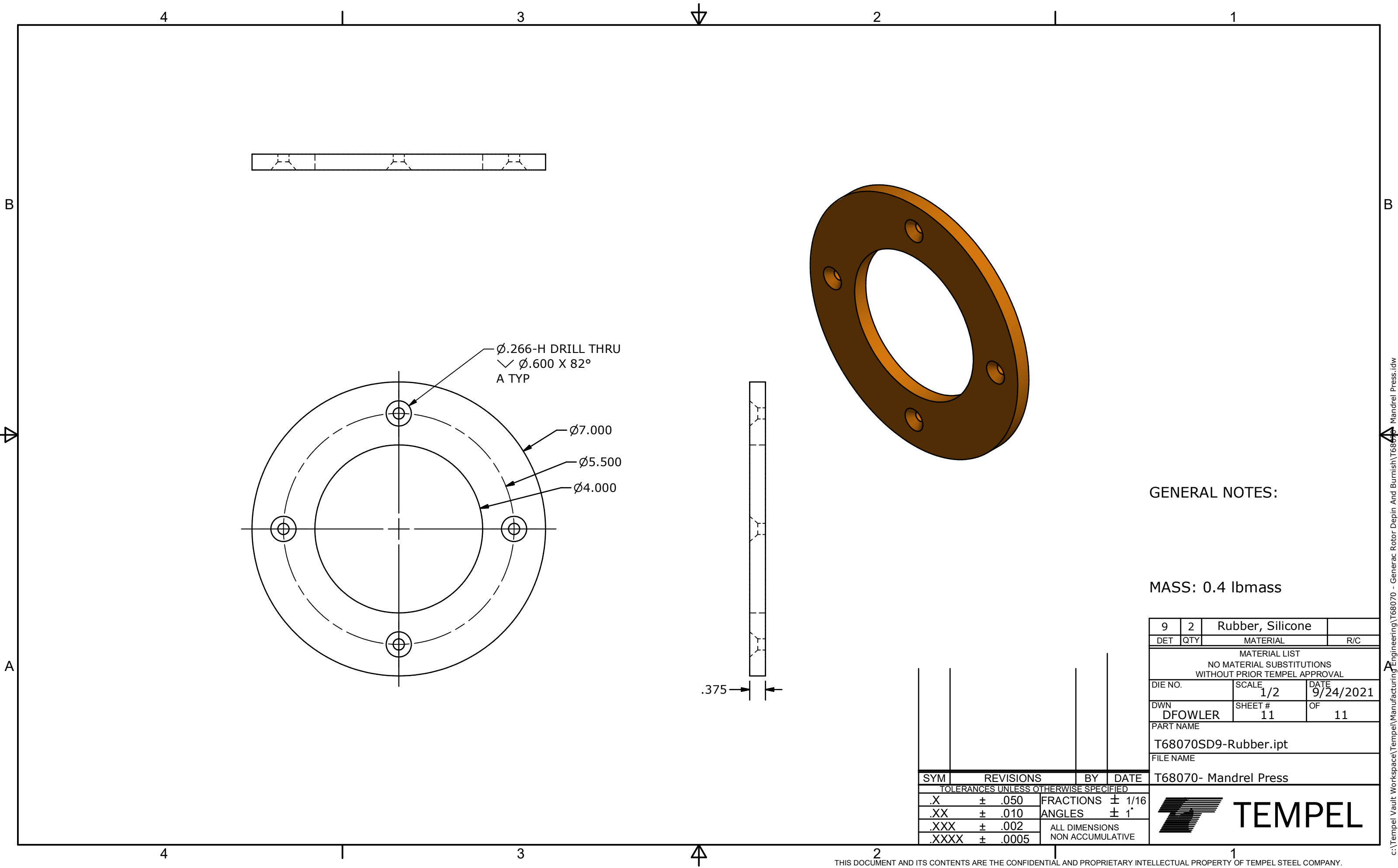
24.1	1	Steel, AISI 4140	PREHARD
DET	QTY	MATERIAL	R/C
MATERIAL LIST			
NO MATERIAL SUBSTITUTIONS			
WITHOUT PRIOR TEMPEL APPROVAL			
DIE NO.	SCALE	DATE	
T-68070	1:1	9/15/2021	
DWN	SHEET #	OF	
prasborschek	9	11	
PART NAME			
T68070SD24.1- DePin Ram Piston.ipt			
FILE NAME			
T68070- Mandrel Press			

A	WAS 8.02 LONG	PR	2-1-22
SYM	REVISIONS	BY	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED			
.X	± .050	FRACTIONS	± 1/16
.XX	± .010	ANGLES	± 1°
.XXX	± .002	ALL DIMENSIONS NON ACCUMULATIVE	
.XXXX	± .0005		









GENERAL NOTES:

MASS: 0.4 lbmass

9	2	Rubber, Silicone	
DET	QTY	MATERIAL	R/C
MATERIAL LIST NO MATERIAL SUBSTITUTIONS WITHOUT PRIOR TEMPEL APPROVAL			
DIE NO.	SCALE 1/2	DATE 9/24/2021	
DWN DFOWLER	SHEET # 11	OF 11	
PART NAME T68070SD9-Rubber.ipt			
FILE NAME T68070- Mandrel Press			

SYM	REVISIONS	BY	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED			
.X	± .050	FRACTIONS	± 1/16
.XX	± .010	ANGLES	± 1°
.XXX	± .002	ALL DIMENSIONS NON ACCUMULATIVE	
.XXXX	± .0005		

