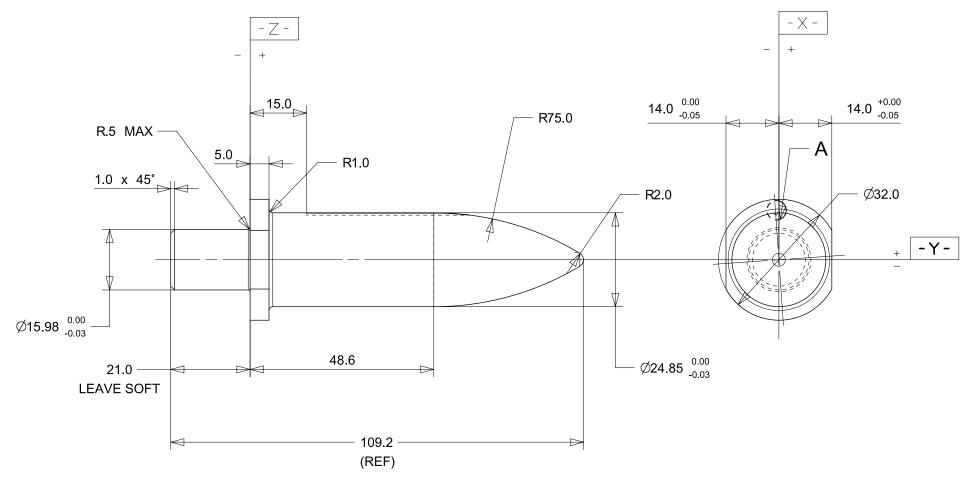
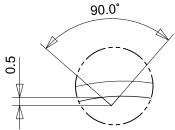
CHANGE DESCRIPTION CHK'D DATE Χ Ζ **HOLE SIZE** NUM





DETAIL A **SCALE 4:1** 

MATERIAL: SAE 8620 STK: 1 1/2" DIA X 115MM (4.53")

LIQUID CARBURIZE & HARDEN 0.5MM TO 2.0MM DEEP ROCKWELL "C" 58-62

## NOTE:

ALL MACHINED SURFACES TO BE FLAT, PARALLEL AND PERPENDICULAR TO WITHIN 0.015 T.I.R. TO DATUMS Y & Z AND CONCENTRIC TO WITHIN 0.03 T.I.R.

S1-140-02

THIS DRAWING MAY USE BOTH INCH AND METRIC (\* INDICATES INCH DIMENSIONS)

MAXIMUM ALLOWANCE ROUGHNESS OF ALL

1 PLACE mm FINISH DIMENSIONS TO BE 3.2 MICRONS

2 PLACE mm FINISH DIMENSIONS TO BE 1.6 MICRONS 3 PLACE mm FINISH DIMENSIONS TO BE 0.5 MICRONS

3 PLACE mm FINISH DIMENSIONS TO BE 0.5 MICRONS ALL GROUND SURFACES TO BE 0.4 MICRONS.
METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINING ±0.3
1 PLACE FABRICATION ±1.5
2 PLACE ±0.08 BETWEEN MACHINED SURFACES

±0.03 BETWEEN SINGLE DOWEL AND A HEEL SURFACE ±0.03 BETWEEN DOWELS IN THE SAME PLANE

±0.10 BETWEEN DOWELS IN DIFFERENT PLANES ±0.13 TO SCREW HOLES, NON ACCUMULATIVE

ALL  $\boldsymbol{\varphi}$  SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN SUFACES.

## 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 HEAD AND / OR WASHERS IS INFRINGED UPON BY WELD BEADS.

ALL EDGES OF PART CONTACT SURFACES ON LOCATING BLOCKS AND FINGERS TO HAVE .12 INCH / 3.00 mm AFTER SPOTTING.

BUILD VENDOR TO BE RESPONSIBLE FOR ACCURACY OF STANDARD PRODUCTS AFTER ALTERATION.

DOWEL HOLE TOLERANCES FOR PRESS FIT USE H6 FOR SLIP FIT USE F7

DOWEL TOLERANCE

MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS. PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK. DO NOT SCALE DRAWING



SHOWN ON SHT 1 OF 1 SHTS A-DT1-M311-U04 DET BY DES BY TITLE **LOCATING PIN** CSG CSG CHK BY DATE DRAWING NO. OR TOOL NO.
A-DT1-M311-U04-D01-PS CSG 06/20/16

SAFETY ORANGE **PAINT** NO PAINT

**BLACK OXIDE** 

JOB #15142

SCALE DIVISION: AUTOMOTIVE ANT: METALSA LV APODACA NONE

LOCATION/ACTIVITY: APODACA,N.L. MEXICO

