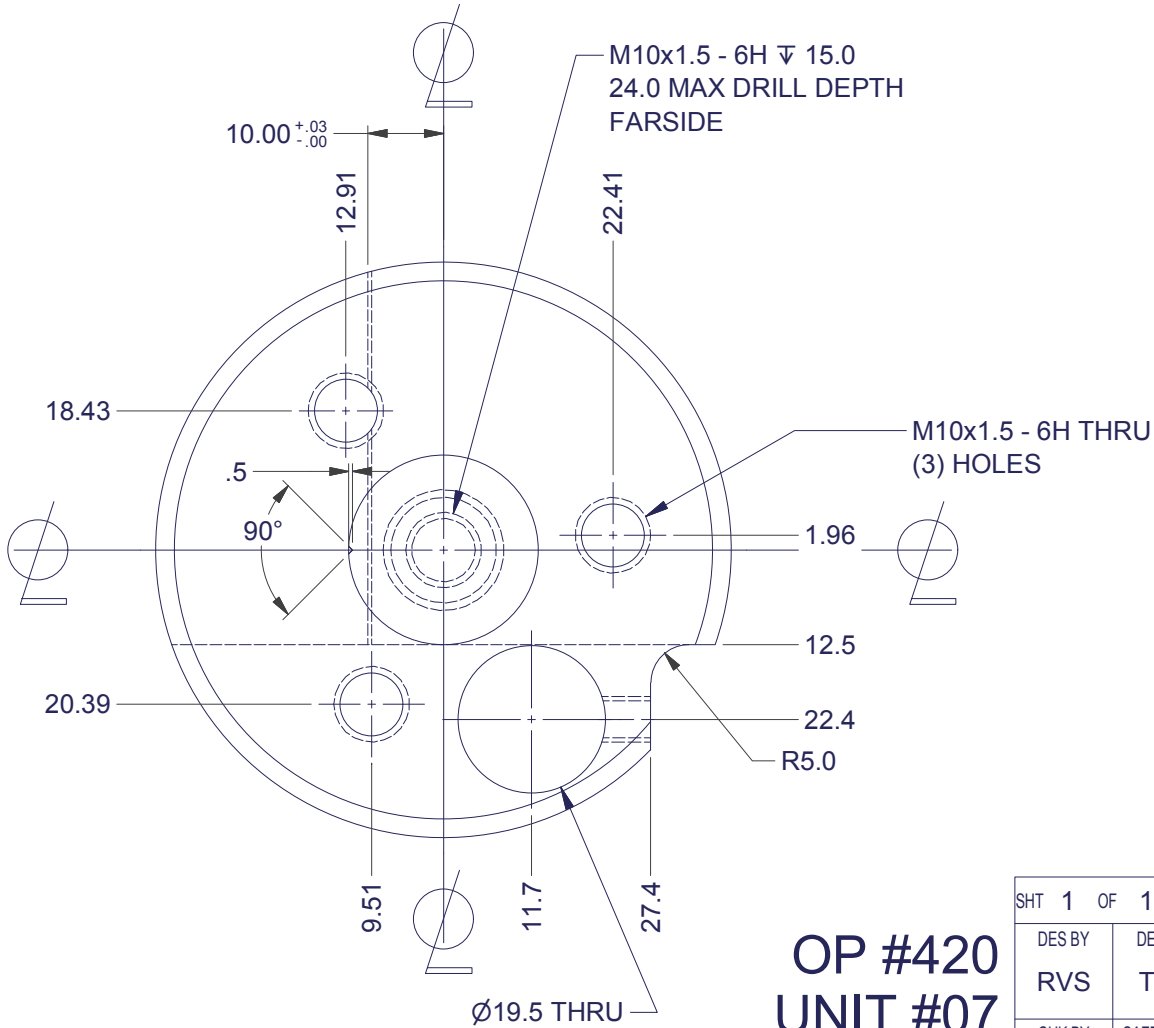


REV	CHANGE	CHK'D	DATE

SAE 8620  
STK: 3" DIA X 102MM (4.02")  
MATERIAL: 8620R-03000  
MATERIAL QTY: 4.02

LIQUID CARBURIZE & HARDEN  
0.5mm TO 2.0mm DEEP  
ROCKWELL "C" 58-62  
AND GRIND

NOTE:  
ALL MACHINED SURFACES TO BE FLAT,  
PARALLEL AND PERPENDICULAR TO  
WITHIN 0.015 T.I.R. TO DATUMS A AND B  
AND CONCENTRIC TO WITHIN 0.03 T.I.R.



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

MAXIMUM ALLOWANCE ROUGHNESS OF ALL  
METRIC.  
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  
ALL GROUND SURFACES TO BE 0.4 MICRONS.  
METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE:  
1 PLACE MACHINING .03  
1 PLACE FABRICATION .15  
2 PLACE .08 BETWEEN MACHINED SURFACES  
.03 BETWEEN SINGLE DOWEL AND A HEEL SURFACE  
.03 BETWEEN DOWELS IN THE SAME PLANE  
.10 BETWEEN DOWELS IN DIFFERENT PLANES  
.13 TO SCREW HOLES, NON ACCUMULATIVE

ALL O SURFACES MUST BE FINISHED EXCEPT FOR COLD  
DRAWN 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 HOLES WHEN  
CLEARANCE FOR SCREW AND / OR BOLT HEAD AND / OR  
WASHERS IS INFRINGED UPON BY WELD BEADS.

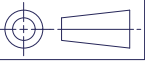
ALL EDGES OF PART CONTACT SURFACES ON LOCATING  
BLOCKS AND FINGERS TO HAVE .12R INCH / 3.00 mm  
AFTER SPOTTING.

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  
m6

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

 DO NOT SCALE  
DRAWING

3rd ANGLE PROJECTION

SHT 1 OF 1 SHTS		SHOWN ON: A-DT1-M420-U02-L	
DES BY RVS	DET BY TJS	TITLE:  LOCATING PIN	
CHK BY RMB	SAFETY OK		
		DRAWING NO. OR TOOL NO.: A-DT1-M420-U07-L-D08-L-PS	
DATE 06/14/16	SCALE FULL	DIVISION: AUTOMOTIVE	
		PLANT: METALSA	
		LOCATION: APODACA, N.L. MEXICO	
			

M000034148

	SAFETY ORANGE
	PAINT
x	NO PAINT
	BLACK OXIDE

OP #420  
UNIT #07

JOB #15143

N:\15143 DT Frame - Front, RR Rails and RR Mod\Tooling\Inventor\Rear Stub\DT1-M420-U07-L-D08-L-PS.000.dwg