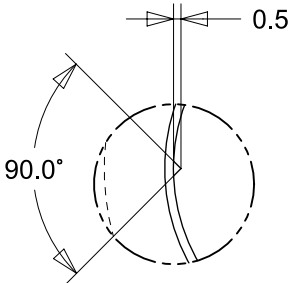
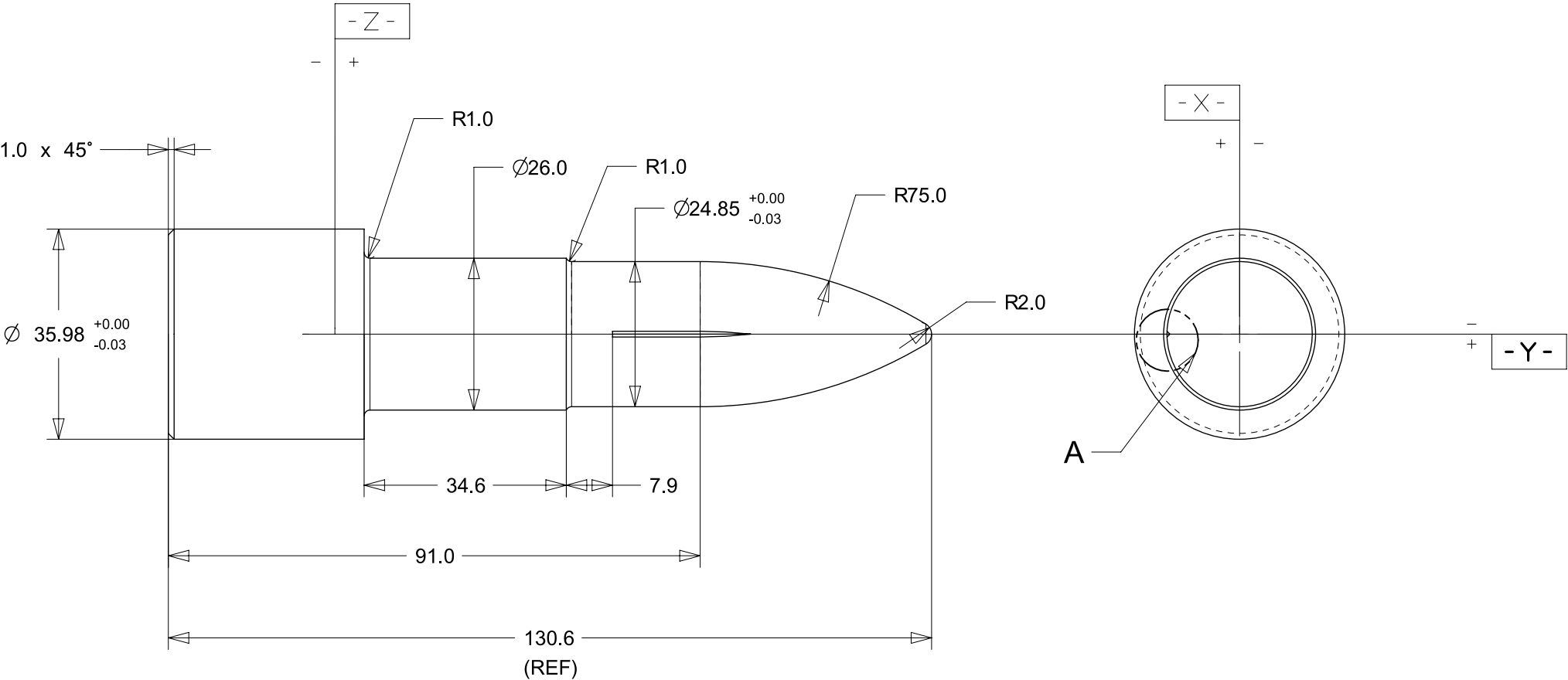


NUM	X	Y	Z	HOLE SIZE	REV	CHANGE DESCRIPTION	CHK'D	DATE



DETAIL A
SCALE 2:1

MATERIAL: SAE 8620
STK: 1 3/4" DIA X 140MM (5.51")

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.

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 ±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 Ø 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 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 DOWEL TOLERANCE
FOR PRESS FIT USE H6 m6
FOR SLIP FIT USE F7

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

3rd ANGLE PROJECTION

S1-140-02
02

JOB #15142

	SAFETY ORANGE
	PAINT
	NO PAINT
	BLACK OXIDE

SHT 1 OF 1 SHTS	SHOWN ON	A-DT1-M311-U02
DET BY	DES BY	TITLE
CSG	CSG	LOCATING PIN
CHK BY	DATE	DRAWING NO. OR TOOL NO.
CSG	06/20/16	A-DT1-M311-U02-D03-PM
SCALE	DIVISION: AUTOMOTIVE	
NONE	PLANT: METALSA LV APODACA	
	LOCATION/ACTIVITY: APODACA,NL, MEXICO	



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