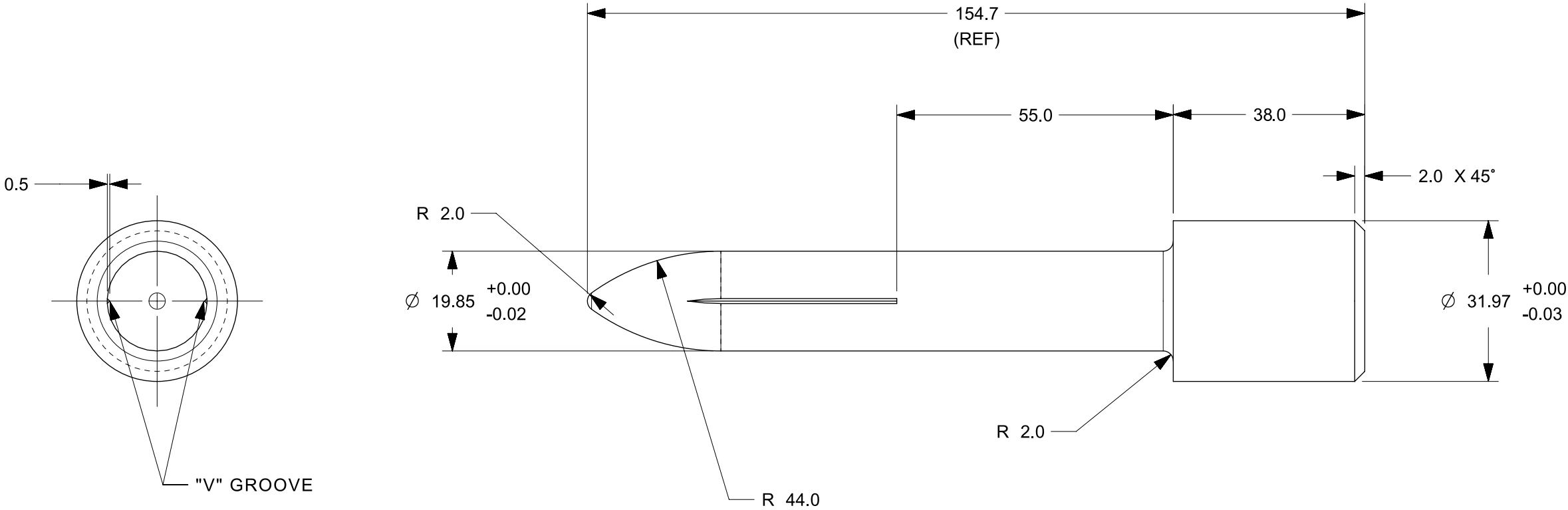


NUM	X	Y	Z	HOLE SIZE	REV	CHANGE DESCRIPTION	CHK'D	DATE



MATERIAL: SAE 8620
STK: 1 3/8" DIA X 165MM (6.5")

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 X & Y
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

OP #M595
UNIT #04
JOB #15143

	SAFETY ORANGE
	PAINT
X	NO PAINT
	BLACK OXIDE

SHT 1 OF 1 SHTS		SHOWN ON		A-DT1-M595-U04	
DET BY	DES BY	TITLE			
JS	DR			LOCATING PIN	
CHK BY	DATE				
CEV	08/18/16	DRAWING NO. OR TOOL NO.		A-DT1-M595-U04-D14-PS	
SCALE	DIVISION: AUTOMOTIVE				
	PLANT: METALSA LV APODACA				
	LOCATION/ACTIVITY: APODACA,NL, MEXICO				
NONE					

