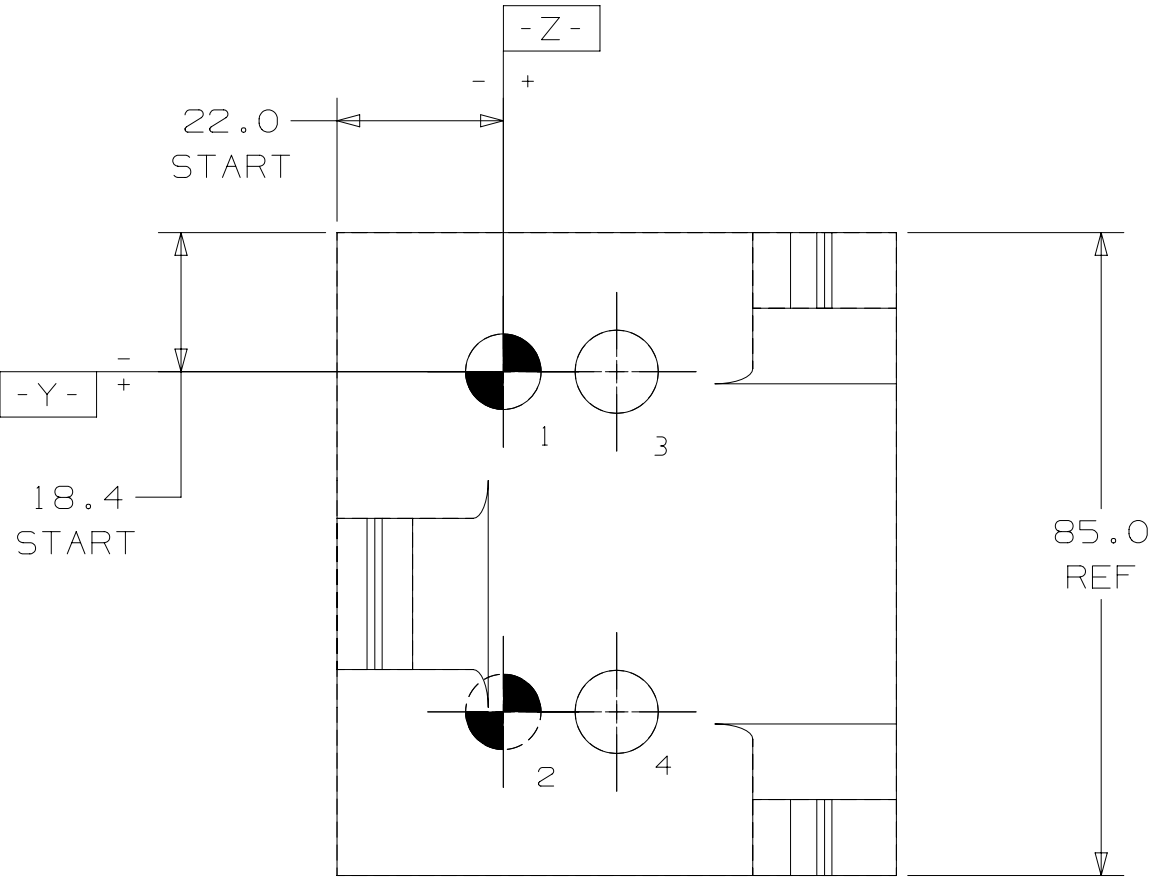
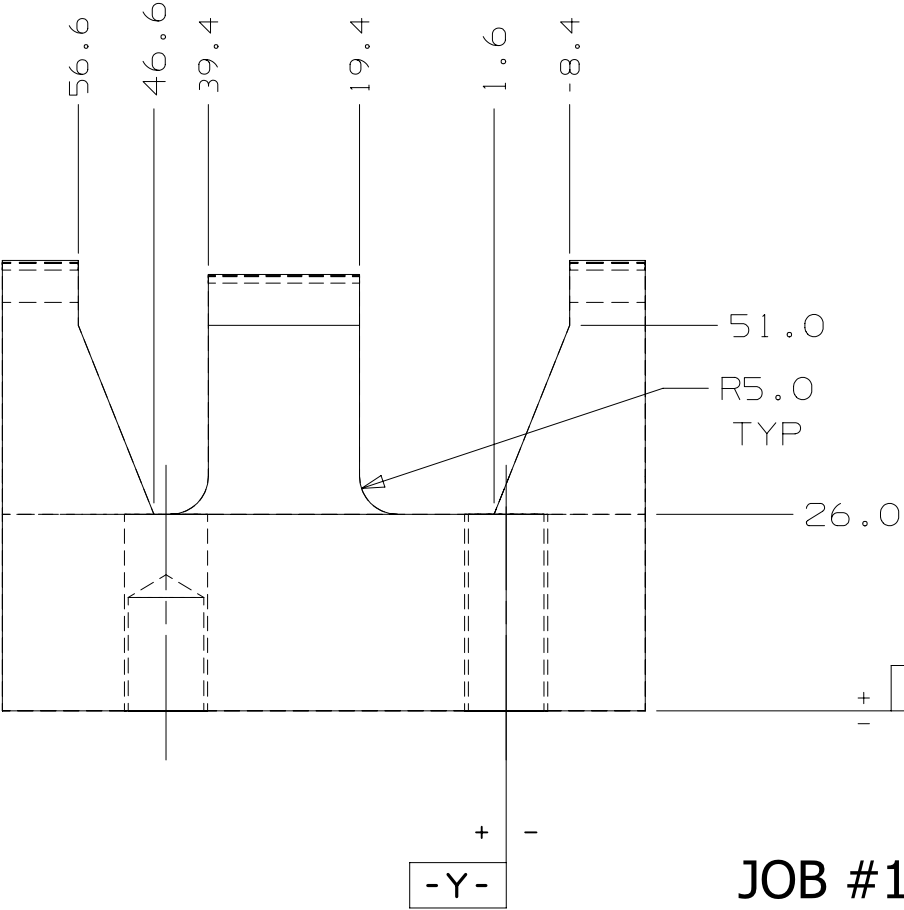
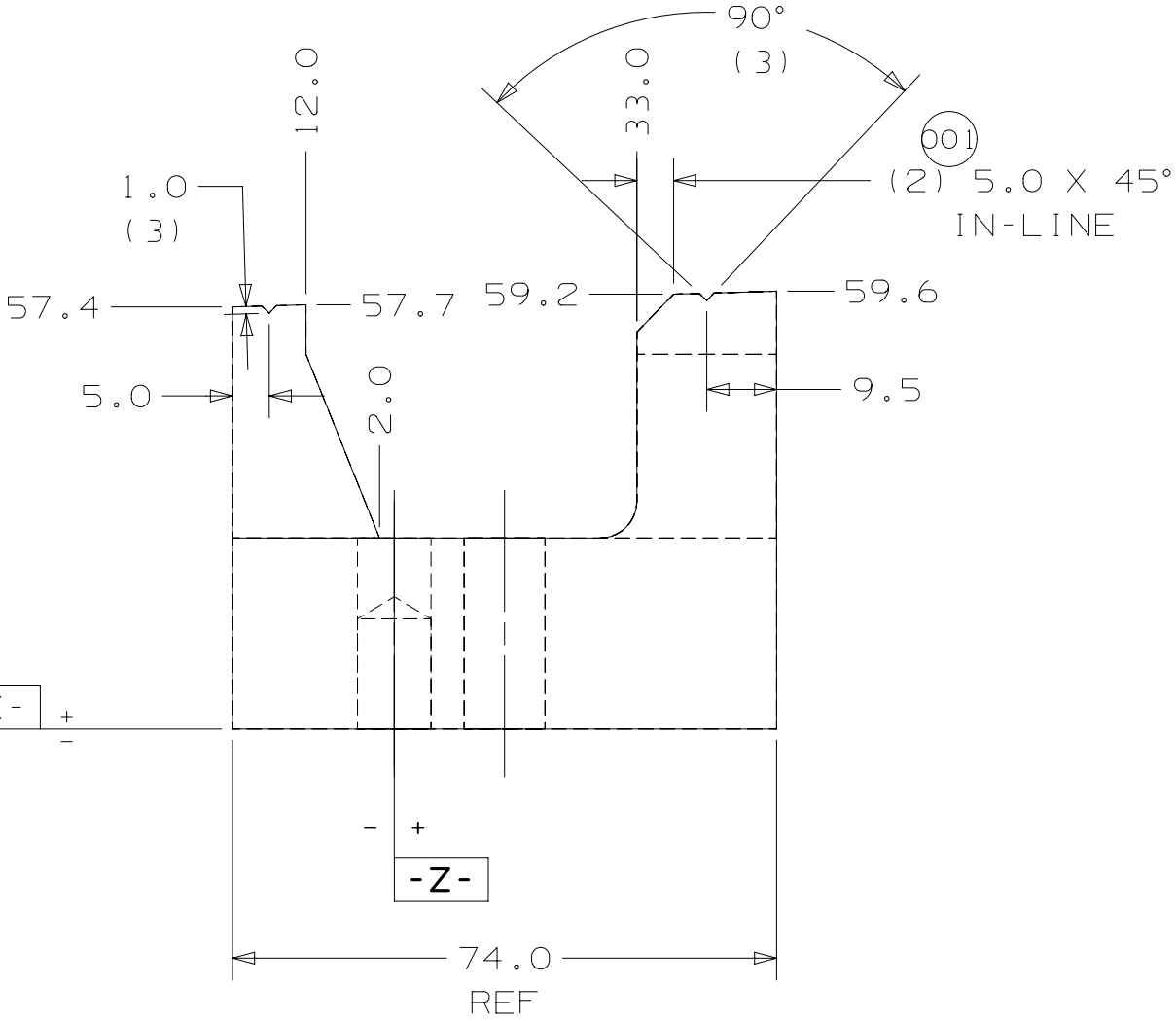


NUM	X	Y	Z	HOLE SIZE
1	-	0	0	Ø10 H6
2	-	45	0	Ø10 H6 15 DEEP
3	-	0	15	Ø11
4	-	45	15	

REV	CHANGE DESCRIPTION	CHK'D	DATE
001	(2) 5.0 CHAMFERS ADDED, DIMS UPDATED.	MC	11/21/16



BACK-UP 4140, 52-54 RC
MATERIAL: ~~XXXXXX~~
STK: 2 1/2" x 74MM x 85MM



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 O SURFACES MUST BE FINISHED EXCEPT FOR COLD
DRAWN SURFACES.

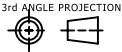
WELDMENTS.
ALL WELD FILLETS TO BE 1/4 INCH.
ALL "V" GROOVES TO BE 90 EXCEPT AS SHOWN.
ADD VENT HOLES IN ALL WELDMENTS WHERE TRAPPED
AIR IS A POSSIBILITY, I.E. TUBING CAPPED AT
BOTH ENDS, BOXED FORMS ETC.
SPOTFACE SCREW AND / OR BOLT HEAD AND / OR
WASHERS IS INFRINGED UPON BY WELD BEADS.

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



LH-SHN
RH-OPP

SHT 1 OF 1 SHTS		SHOWN ON A-DT1-R260-L-U07-L	
DET BY JACOBS	DES BY JACOBS	TITLE BACK-UP	
CHK BY JACOBS	DATE 07/08/16		
		DRAWING NO. OR TOOL NO. A-DT1-R260-L-U07-L-D02-L-PS	
SCALE NONE	DIVISION: AUTOMOTIVE PLANT: METALSA LV APODACA LOCATION/ACTIVITY: APODACA, N.L. MEXICO		

JOB #15142

	SAFETY ORANGE
	PAINT
X	NO PAINT
	BLACK OXIDE

