



Ø 1" STK

> MATERIAL: SAE 8620 STK: 1" DIA X 110MM (4.33")

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

ALL MACHINED SURFACES TO BE FLAT PARALLEL AND PERPENDICULAR TO WITHIN 0.015 T.I.R. TO DATUMS X & 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

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  $\boldsymbol{\varphi}$  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

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

DOWEL HOLE TOLERANCES

FOR SLIP FIT USE F7

DOWEL TOLERANCE

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



LOCATION/ACTIVITY: APODACA,N.L. MEXICO

OP #M585 UNIT #09L JOB #15143

	SAFETY ORANGE
	PAINT
Χ	NO PAINT
	BLACK OXIDE

SHOWN ON SHT 1 OF 1 SHTS A-DT1-M585-U09-L DET BY DES BY TITLE PIN DM JK CHK BY DATE DRAWING NO. OR TOOL NO. DM 7/19/16 A-DT1-M585-U09-L-D15-PS SCALE DIVISION: AUTOMOTIVE ANT: METALSA LV APODACA

