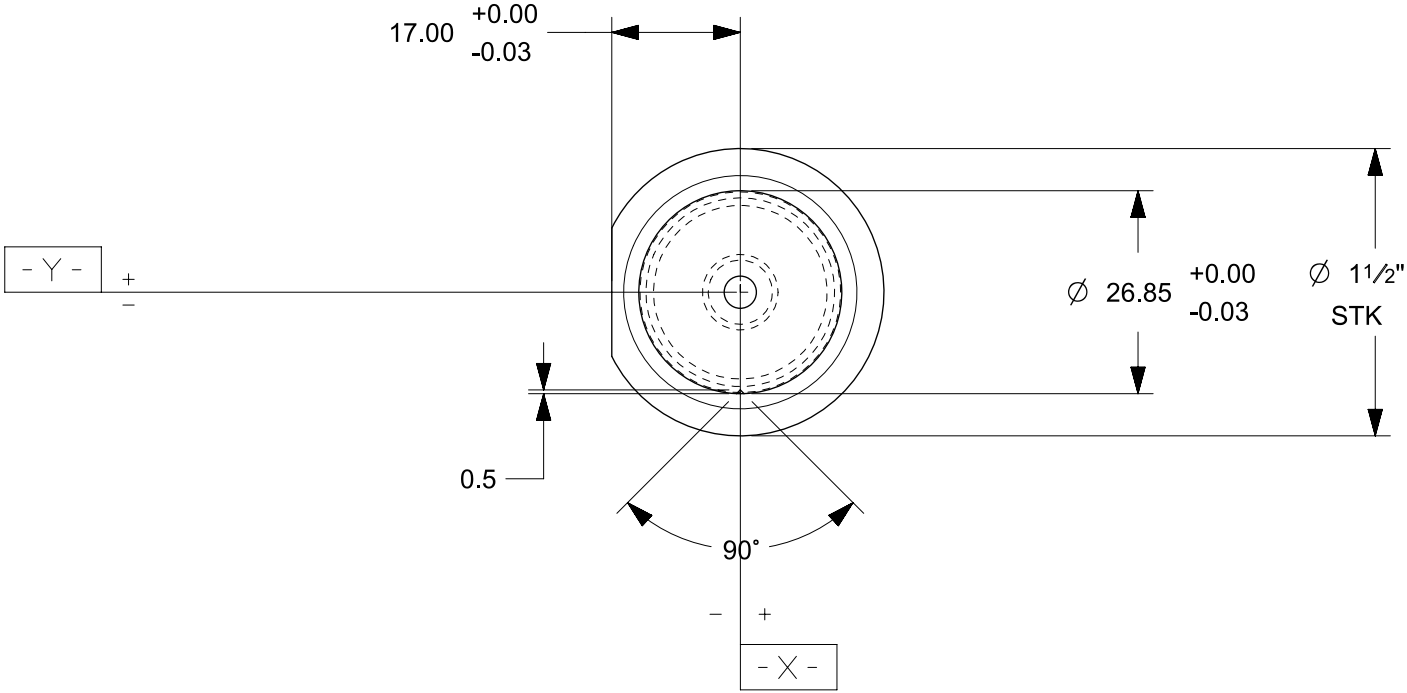


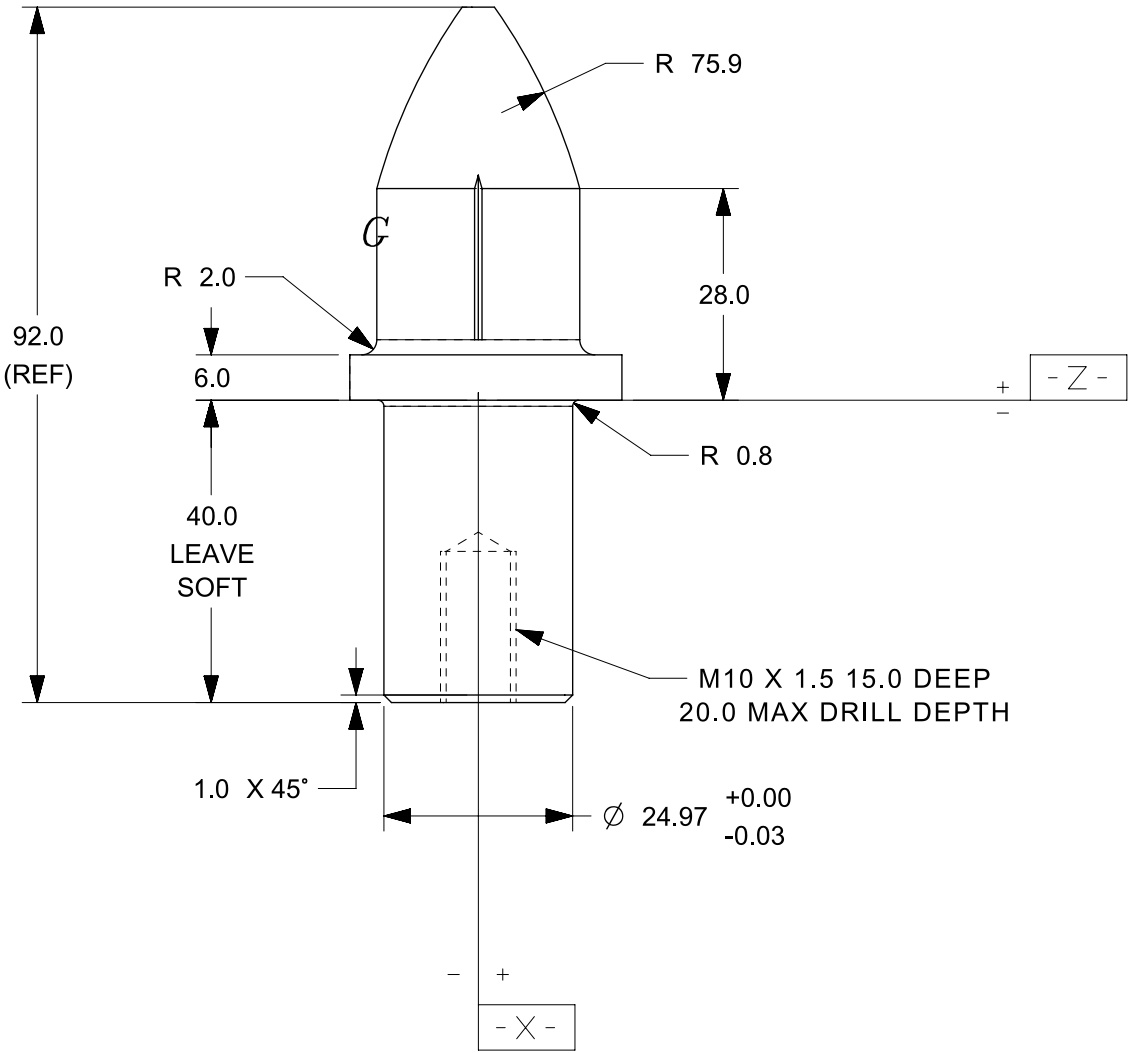
NUM	X	Y	Z	HOLE SIZE	REV	CHANGE DESCRIPTION	CHK'D	DATE



MATERIAL: SAE 8620  
STK: 1 1/2" DIA X 100MM (3.94")

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  
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#R550  
UNIT #02  
JOB #15143

	SAFETY ORANGE
	PAINT
X	NO PAINT
	BLACK OXIDE

SHT 1 OF 1 SHTS	SHOWN ON	A-DT1-R550-U02-L
DET BY JK	DES BY KJM	TITLE LOCATING PIN
CHK BY	DATE	DRAWING NO. OR TOOL NO. A-DT1-R550-U02-L-D19-PS
SCALE NONE	DIVISION: AUTOMOTIVE PLANT: METALSA LOCATION/ACTIVITY:	

