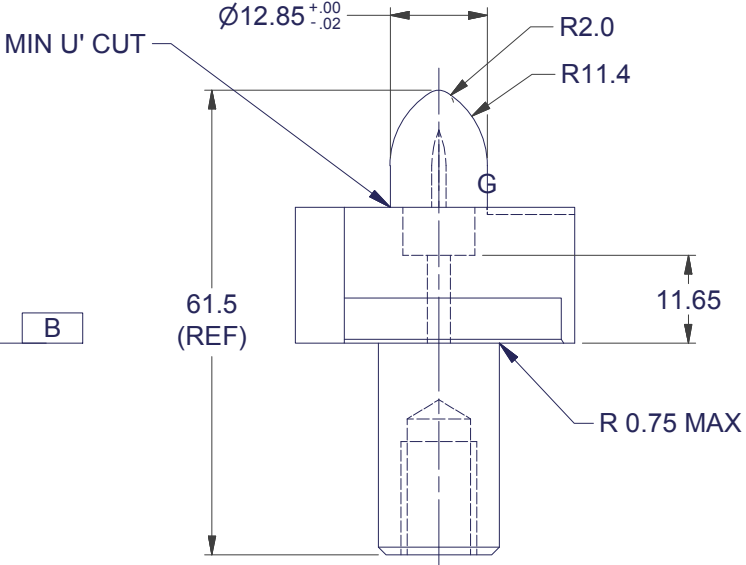
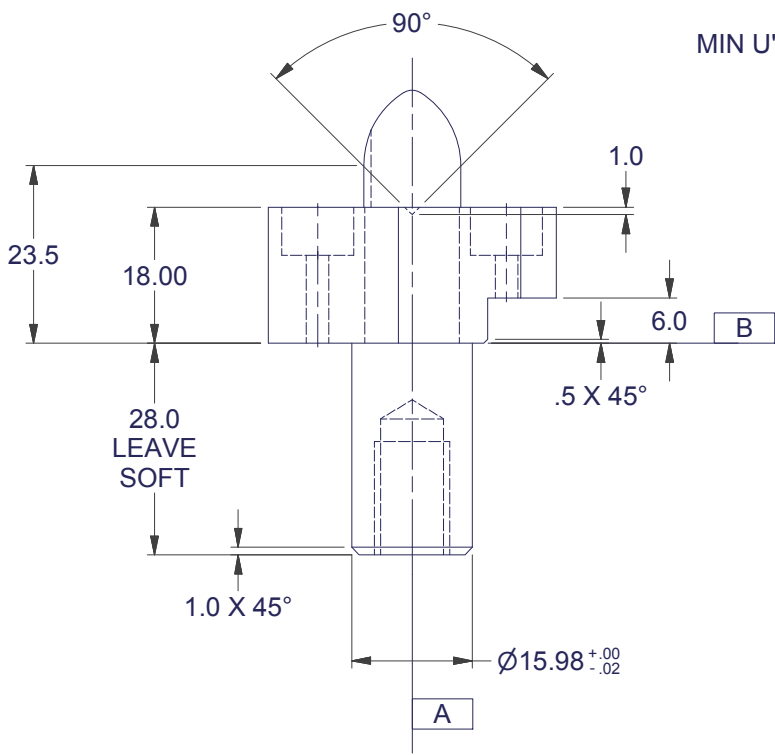
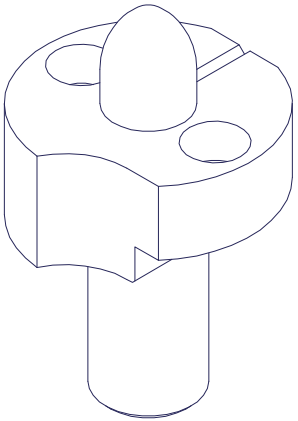
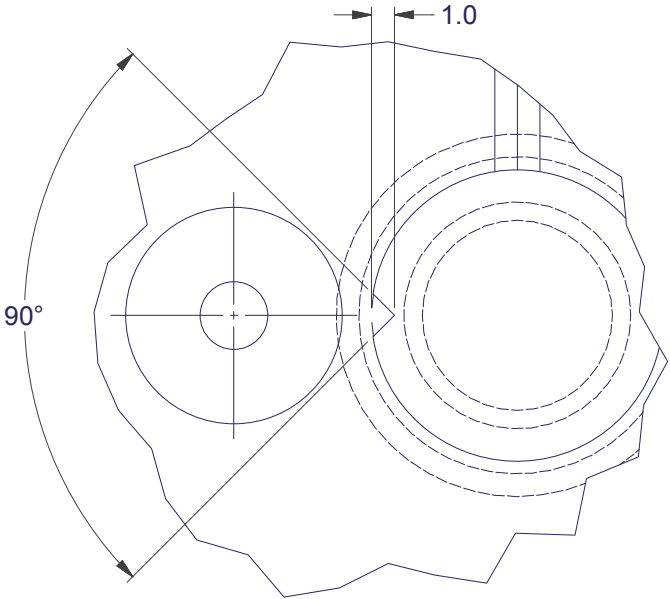
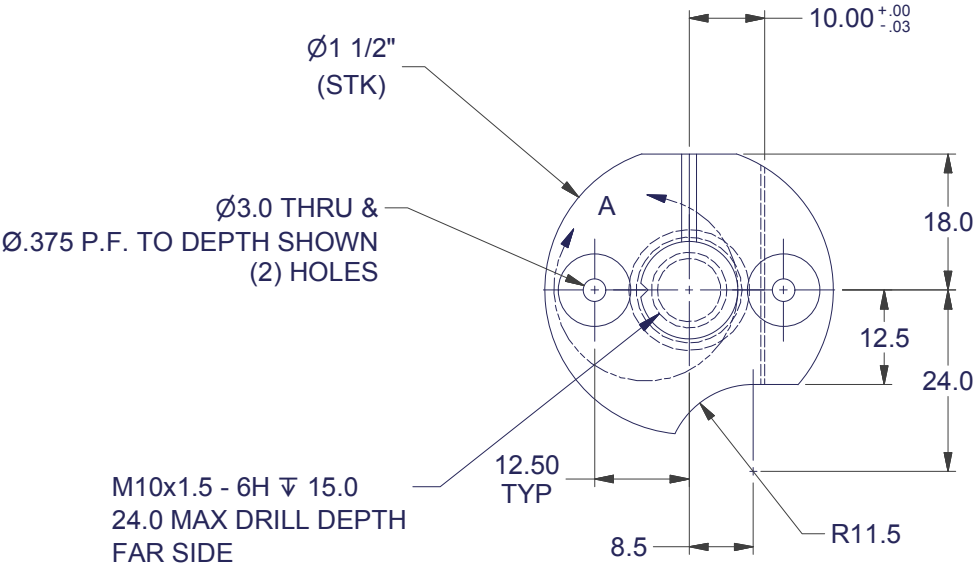


REV	CHANGE	CHK'D	DATE



SAE 8620
STK: 1 1/2" DIA X 66.5MM (2.62")
MATERIAL: 8620R-01500
MATERIAL QTY: 2.62

LIQUID CARBURIZE & HARDEN
0.5mm TO 2.0mm DEEP
ROCKWELL "C" 58-62
AND GRIND

HARDEN & TEMPER
Rc 58-62

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 .03
1 PLACE FABRICATION .15
2 PLACE .08 BETWEEN MACHINED SURFACES
.03 BETWEEN SINGLE DOWEL AND A HEEL SURFACE
.03 BETWEEN DOWELS IN THE SAME PLANE
.10 BETWEEN DOWELS IN DIFFERENT PLANES
.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 HOLES WHEN
CLEARANCE FOR 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 .12R INCH / 3.00 mm
AFTER SPOTTING.

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

DOWEL HOLE TOLERANCES
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

DOWEL TOLERANCE
m6

MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.
PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK.

DO NOT SCALE
DRAWING

3rd ANGLE PROJECTION

SHT 1 OF 1 SHTS	SHOWN ON:	A-DT1-M420-U11	
DES BY RVS	DET BY GJS	TITLE: LOCATING PIN	
CHK BY RMB	SAFETY OK	DRAWING NO. OR TOOL NO.: A-DT1-M420-U11-D14-PS	
DATE 06/15/16	SCALE FULL	DIVISION: AUTOMOTIVE	
		PLANT: METALSA	
		LOCATION: APODACA, N.L. MEXICO	

M000034230

	SAFETY ORANGE
	PAINT
X	NO PAINT
	BLACK OXIDE

JOB #15143

OP #420
UNIT #11

N:\15143 DT Frame - Front, RR Rails and RR Mod\Tooling\Inventor\Rear Stub\DT1-M420-U11-D14-PS.000.dwg