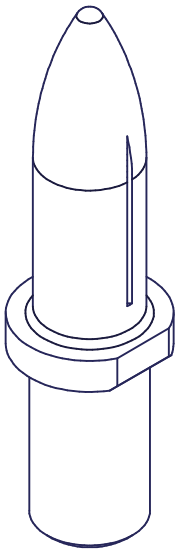
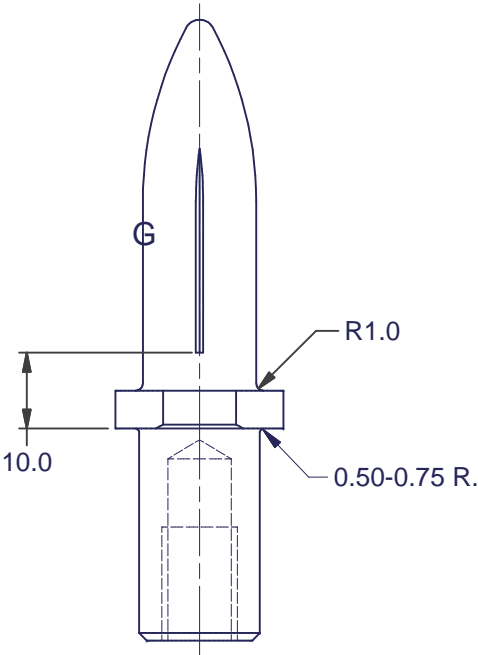
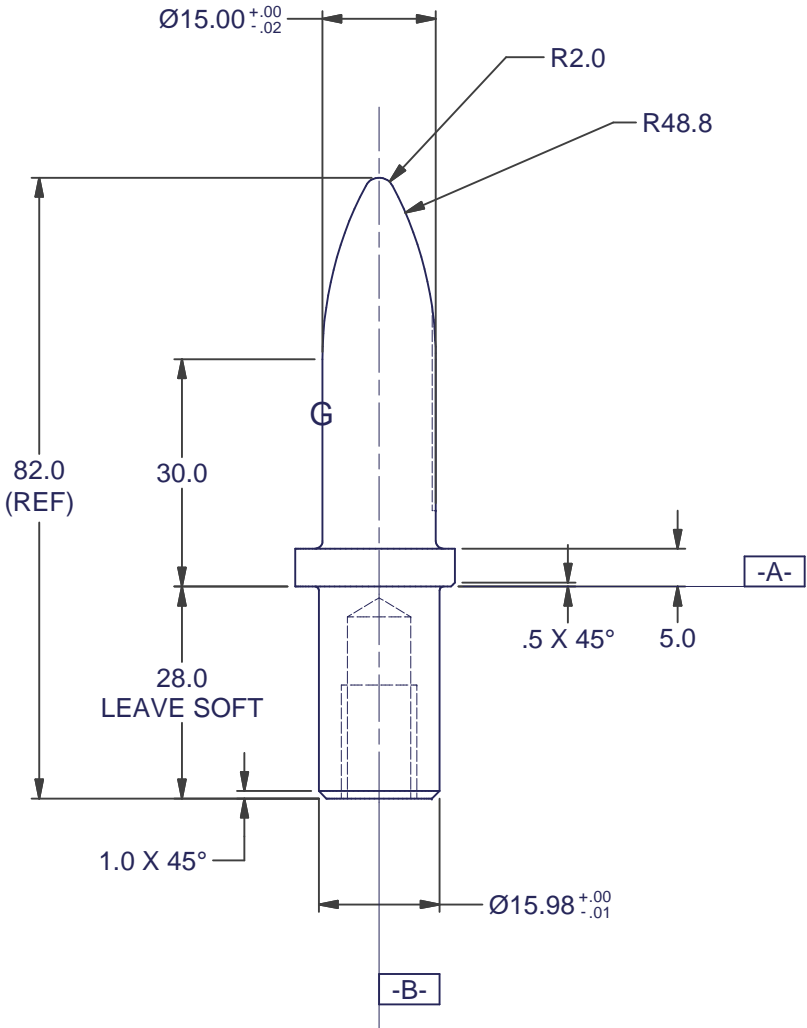
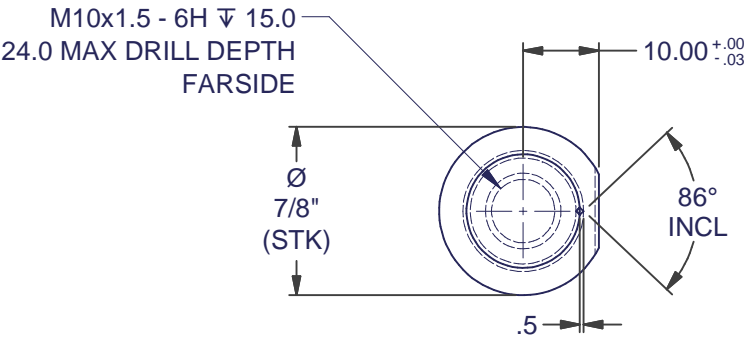


REV	CHANGE	CHK'D	DATE



SAE 8620
STK: 7/8" DIA X 87MM (3.43")
MATERIAL: 8620R-00875
MATERIAL QTY: 3.43

NOTE:
ALL MACHINED SURFACES TO BE FLAT,
PARALLEL AND PERPENDICULAR TO
WITHIN 0.015 T.I.R. TO DATUMS A AND B
AND CONCENTRIC TO WITHIN 0.03 T.I.R.

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

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 .008 BETWEEN MACHINED SURFACES
.003 BETWEEN SINGLE DOWEL AND A HEEL SURFACE
.003 BETWEEN DOWELS IN THE SAME PLANE
.010 BETWEEN DOWELS IN DIFFERENT PLANES
.013 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



M000036328

	SAFETY ORANGE
	PAINT
X	NO PAINT
	BLACK OXIDE

#MH3-425
UNIT # 02

JOB #15143

SHT 1 OF 1 SHTS		SHOWN ON: A-DT1-M425-U02	
DES BY S.J.E.	DET BY K.R.M.	TITLE: LOCATING PIN	
CHK BY T.J.S.	SAFETY OK		
		DRAWING NO. OR TOOL NO.: A-DT1-MH425-U02-D17-PS.000	
DATE 06/20/16	SCALE 1/2	DIVISION: AUTOMOTIVE	
		PLANT: METALSA	
		LOCATION: APODACA, N.L. MEXICO	