

87654321

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NOTES: (UNLESS OTHERWISE SPECIFIED)

1. GENERAL FABRICATION PRACTICES

1.1. THREADED INSERTS

1.1.1. COMMON NOTES

1.1.1.1. INSTALL ALL THREADED INSERTS AFTER FINISH HAS BEEN APPLIED TO PARTS.

1.1.2. HEAT-SET THREADED INSERTS

1.1.2.1. INSTALL BY USING AN APPROPRIATE SOLDERING IRON CIRCULAR DIAMETER TIP AND SLOWLY PRESS INTO SURFACE OF PART AS SQUARELY INTO THE HOLE AS POSSIBLE. WHEN THE INSERT IS JUST ABOVE THE SURFACE, USE A LARGE FLAT METAL OBJECT (LIKE A STEEL RULER OR SCRAP METAL PLATE) TO PRESS FLAT INTO SURFACE.

1.1.3. THREADED INSERTS FOR WOOD

1.1.3.1. INSTALL PER MANUFACTURER INSTRUCTIONS.

2. FINISHES

2.1. DO NOT PAINT THREADS OF ANY PART UNLESS OTHERWISE SPECIFICALLY INSTRUCTED TO DO SO.

REVISION HISTORY

REV	DESCRIPTION	DATE	APPROVED
-	INITIAL RELEASE	04/01/2022	
A	ADDED "ACRIFUX 1R0192 OR" TO ALL WELD-ON #4 CALLOUTS ON DOCUMENT.	07/26/2024	J. STEENSEN

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES.
DUAL DIMENSIONS ARE IN MILLIMETERS AND ENCLOSED IN SQUARE BRACKETS.
INTERPRET DRAWING IAW ASME Y14.100-2017.
INTERPRET DIM AND TOL IAW ASME Y14.5-2009.
REMOVE ALL BURRS AND SHARP EDGES TO .05 MAX.
DIMENSIONS APPLY BEFORE FINISH.

UOS INCH TOLERANCES ARE:

DECIMALS: .X ± .1
.XX ± .03
.XXX ± .010

ANGLES: MACHINED ± .5°
LOCATING ± .5°
FORMED ± 2°
CHAMFERS ± 5°

DRILLED HOLE DIAMETERS: .0135 - .125: +.004/- .001
.126 - .250: +.005/- .001
.251 - .500: +.006/- .001
.501 - .750: +.008/- .001
.751 - 1.000: +.010/- .001
1.001 - 2.000: +.012/- .001

DESIGNED J. STEENSEN 04/01/2023

CHECKED

DRAWN J. STEENSEN 04/01/2022

CC

BY

NC

SA

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TITLE
COMPONENT FABRICATION METHODS

SIZE D DWG NO OH-SPEC-001 REV A

SCALE N/A SHEET 1/4

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