

Die Requisition Form

DIE MAKER

Die

DATE

3/4/25

1 - 9 X 2 1 HOLE 1/2 POCK

DIE#

874418 # 1

DIES

1 - 9 X 3 BK 74418

USE BK

BKS

W/NITROGEN

1 - 9.5 X 4.5 BOL 74418

USE BOL

BOLS

W/NITROGEN

1 - X WC

USE WC

WCS

DIE LOCATION:

USE SUB

TAPES

NA

STATUS 2

NITRIDE PLAN

45K

☒ **PRESS I - 6"**

KO

SCRAP#

☒ **PRESS II - 7"**

KR

HOLD#

☐ **PRESS III - 9"**

☒ **CC**

SPARE#

☐ **PRESS IV - 8"**

SIGNED:

(Signature)

CUSTOMER:

Gamco

COMMENTS:

ANODIZED FINISH QUALITY

NOTES:

TIME IN BOX:

START BILLET:

2ND BILLET:

BOLSTER IN BOX:

USE GAUGE:

* STRUCTURAL STREAKING IS EXPECTED

LIGHT PAINT COVERAGE EXPECTED IN THIS AREA

STANDARD COMMERCIAL TOLERANCES FOR EXTRUDED PRODUCTS APPLY UNLESS SPECIFIED OTHERWISE

S-74418

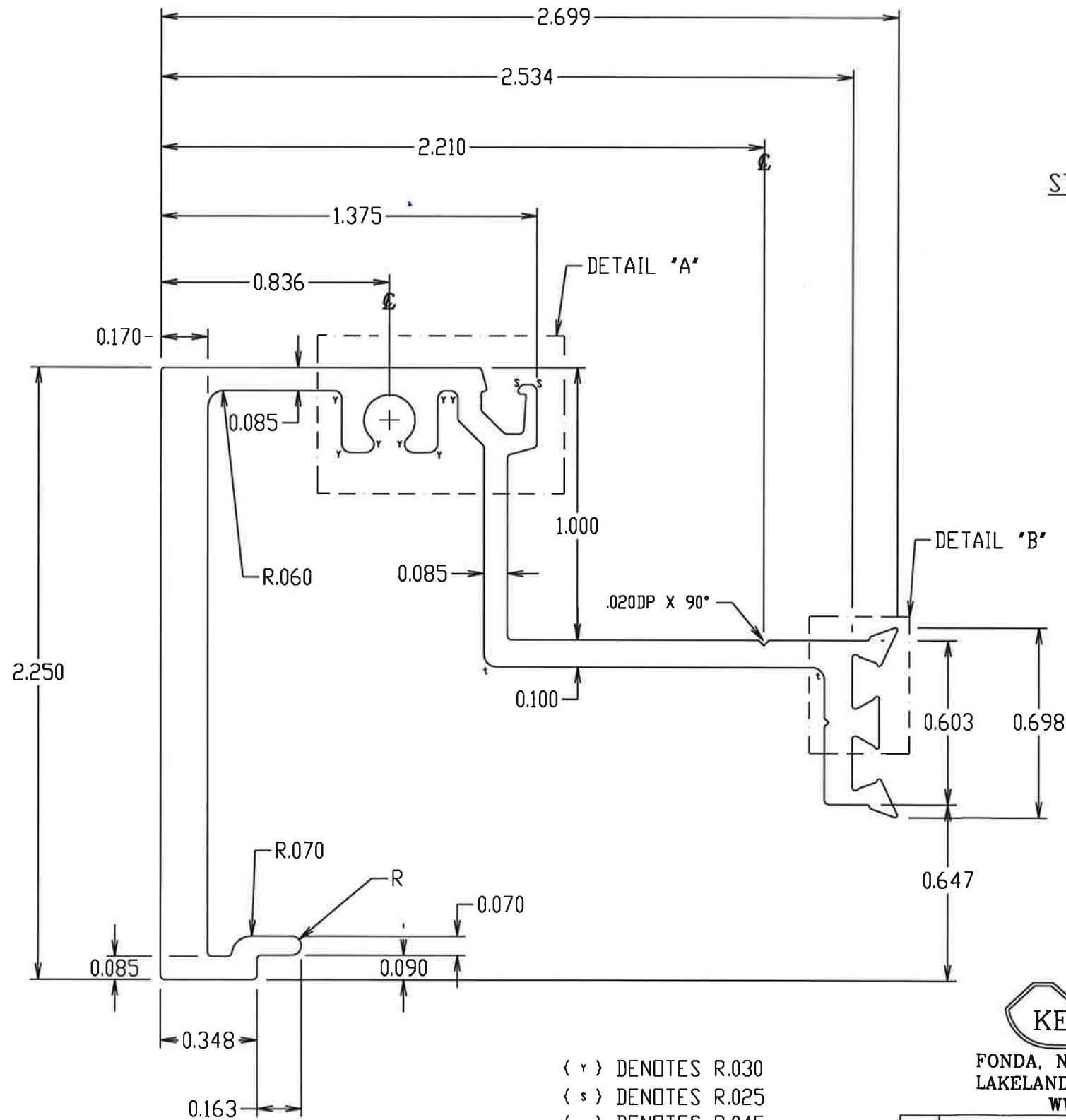
Die Number

T-62268

Temp. Number

Design Number

Customer signature on this print indicates approval of design and dimensions as shown, and customer agrees to accept all legal responsibilities for patent and or trade mark infringement related to this shape and hold (save) Keymark harmless from any claims, suits, actions or demands arising there from. This drawing is the property of Keymark Corporation and may not be redistributed without written consent



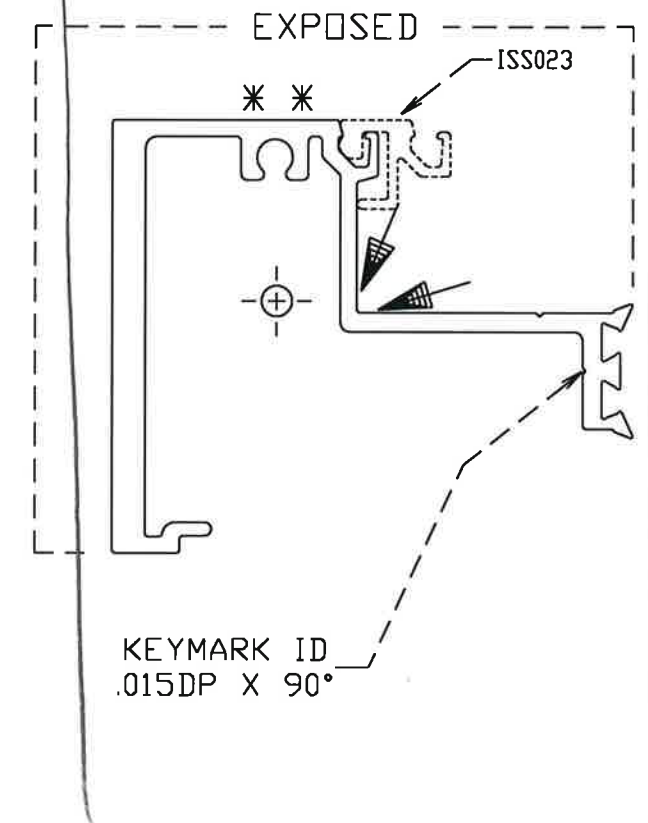
STRUT ASSEMBLY W/ S-74419/ISS025

FOR ASSEMBLY
REFER TO IS0016-GC0

S-74418 MATES WITH:
S-73776 IS021
S-74106 IS023a

FOR ASSEMBLY
REFER TO S-74419

ACTUAL SIZE ASSEMBLY



ANODIZED FINISH QUALITY

{ r } DENOTES R.030
{ s } DENOTES R.025
{ t } DENOTES R.045

KEYMARK CORPORATION



FONDA, NY TEL. (518) 853-3421
LAKELAND, FL TEL. (863) 858-5500
WWW.KEYMARKCORP.COM

Sym.	Revisions	Date

Solid	<input checked="" type="checkbox"/>	Semi-hollow	<input type="checkbox"/>	Class:	Hollow	<input type="checkbox"/>	Class:
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Unspecified Wall Thickness: .170			Break Ext. Corners .015Radius or as Noted	
Customer GAMCO			Customer's Part Number ISS024	
Job Name FG451IS			Scale 2:1	
Part Title HEAD/VERTICAL EXTERIOR			Date 02-28-25	
Alloy 6063	Area (In ²) 0.870	Finish Perimeter (In) 6.853	Drawn MJD	
Temper T-6	Wt./Ft. (Lbs) 1.044	Total Perimeter (In) 15.649	Checked 00	
Cavity Size 10	Circle Size (In) 3.2	Exterior Perimeter (In) 15.649		

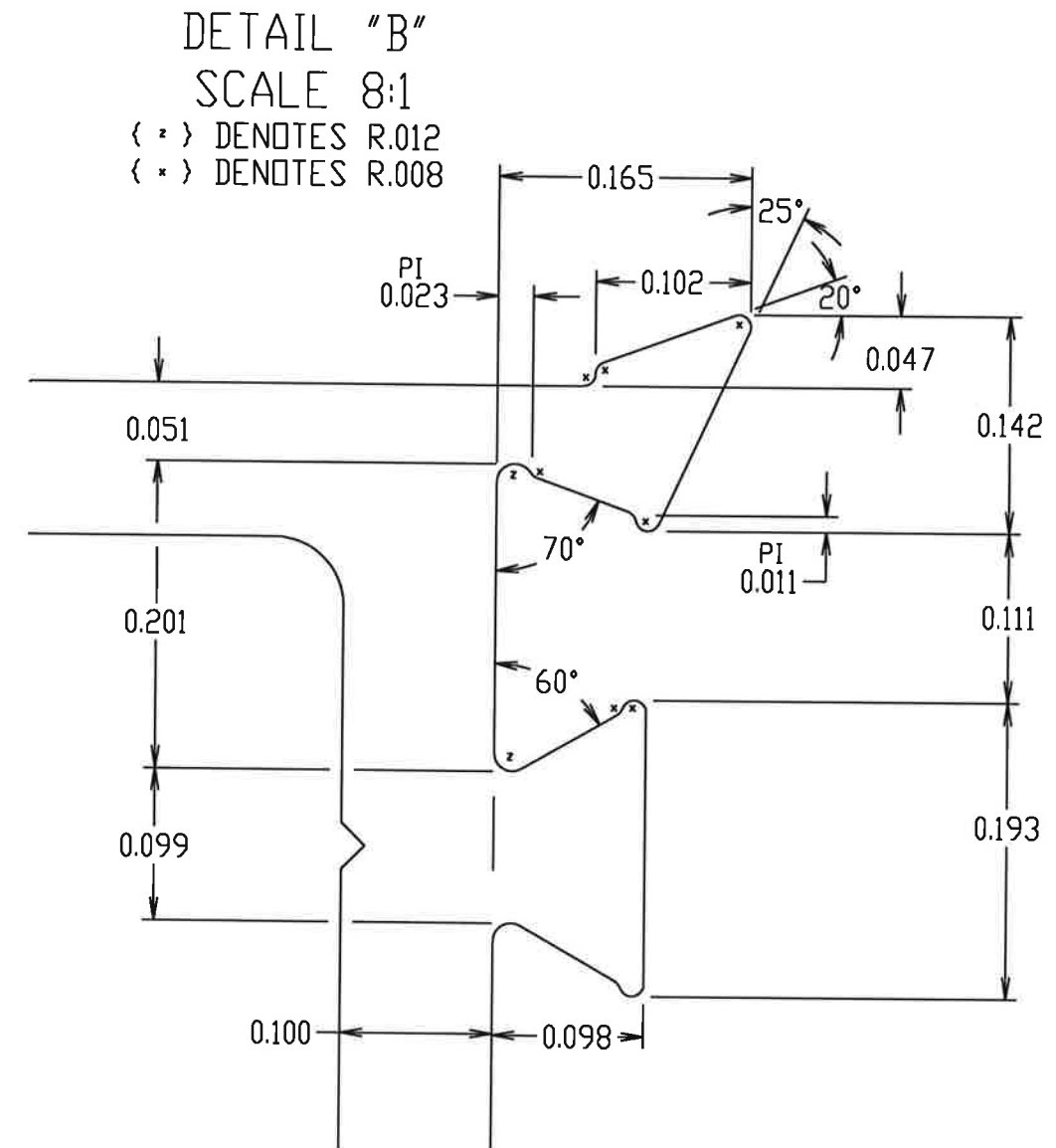
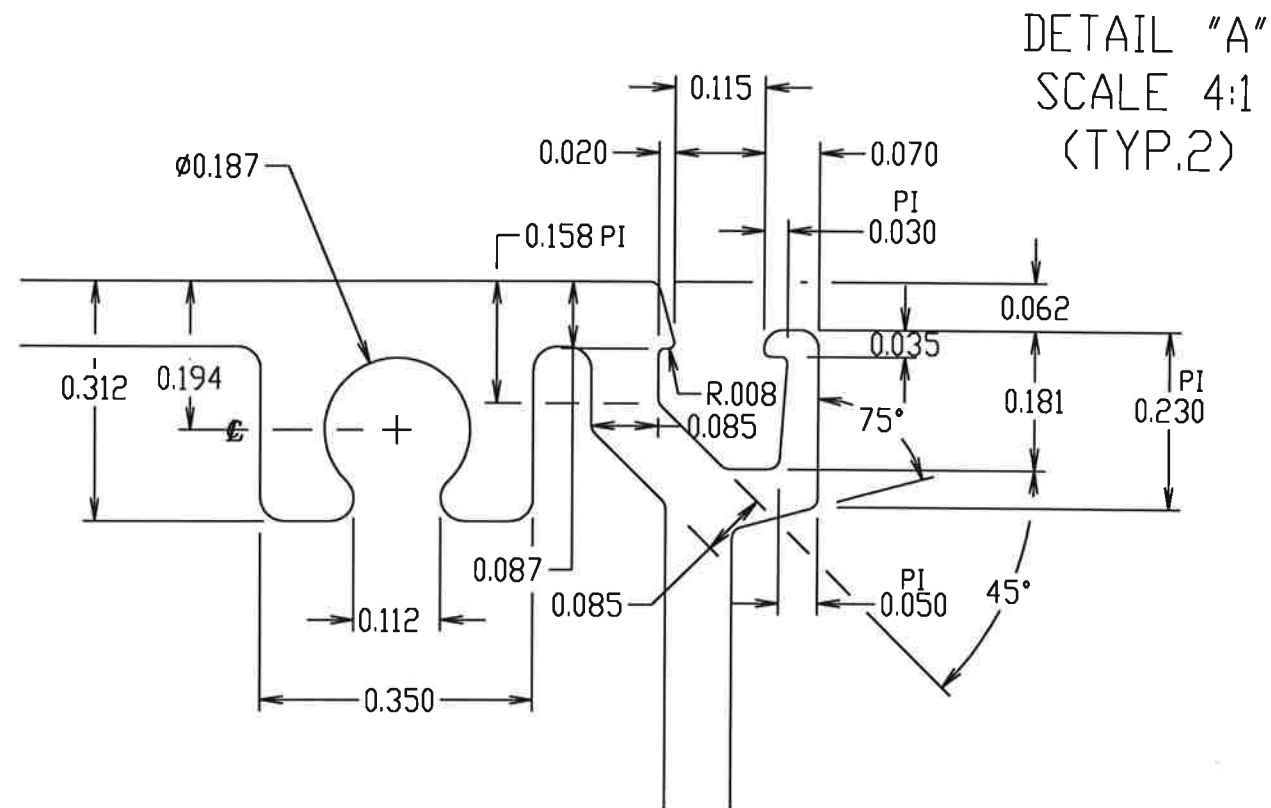
Estimated For Reference Only	I _x = 0.366	I _y = 0.670	Alodine <input type="checkbox"/>	Type: 010	PLEASE MARK PAINTED SURFACES AS PRIMARY & SECONDARY									
	S _x = 0.279	S _y = 0.361	Crimp <input type="checkbox"/>	Factor: 15	Mill <input type="checkbox"/>	Ano. <input checked="" type="checkbox"/>	Drnr. <input checked="" type="checkbox"/>	Drnc. <input checked="" type="checkbox"/>	Pc <input type="checkbox"/>	Solid <input checked="" type="checkbox"/>	Semi-hollow <input type="checkbox"/>	Class:	Hollow <input type="checkbox"/>	Class:

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STANDARD COMMERCIAL TOLERANCES FOR EXTRUDED
PRODUCTS APPLY UNLESS SPECIFIED OTHERWISE

S-74418-D

Die Number



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Unspecified
Wall Thickness: .170

Break Ext. Corners
.015 Radius or as Noted

Sym.	Revisions	Date	Customer	Customer's Part Number
			GAMCO	ISS024
			Job Name	Job Number
			FG451IS	
			Part Title	
			HEAD/VERTICAL EXTERIOR	
			Scale	Date
			AS NOTED	02-28-25
			Drawn	Checked
			MJD	



ALUMINUM EXTRUSION

Die Requisition Form

DIE MAKER <u>Die</u>		DATE <u>3/4/25</u>	
1 - <u>9</u> X <u>2</u> <u>1</u> HOLE <u>1/2</u> POCK	DIE# <u>S74419 # 1</u>	DIES _____	
1 - <u>9</u> X <u>3</u> BK <u>74419</u>	USE BK _____	BK\$ _____	
W/NITROGEN			
1 - <u>9.5</u> X <u>4.5</u> BOL <u>74419</u>	USE BOL _____	BOLS _____	
W/NITROGEN			
1 - _____ X _____ WC _____	USE WC _____	WCS _____	
USE SUB _____		TAPES _____	
DIE LOCATION: _____			

NA

STATUS 2

NITRIDE PLAN 45K

<input checked="" type="checkbox"/> PRESS I - 6"	<input type="checkbox"/> KO	<input type="checkbox"/> SCRAP# _____
<input checked="" type="checkbox"/> PRESS II - 7"	<input type="checkbox"/> KR	<input type="checkbox"/> HOLD# _____
<input type="checkbox"/> PRESS III - 9"	<input checked="" type="checkbox"/> CC	<input type="checkbox"/> SPARE# _____
<input type="checkbox"/> PRESS IV - 8"		

SIGNED: ②CUSTOMER: Gamco

COMMENTS: _____

NOTES: _____

ANODIZED FINISH QUALITY

TIME IN BOX: _____

START BILLET: _____

2ND BILLET: _____

BOLSTER IN BOX: _____

USE GAUGE: _____

STRUCTURAL STREAKING
IS EXPECTED

LIGHT PAINT COVERAGE
EXPECTED IN THIS AREA



STANDARD COMMERCIAL TOLERANCES FOR EXTRUDED
PRODUCTS APPLY UNLESS SPECIFIED OTHERWISE

S-74419

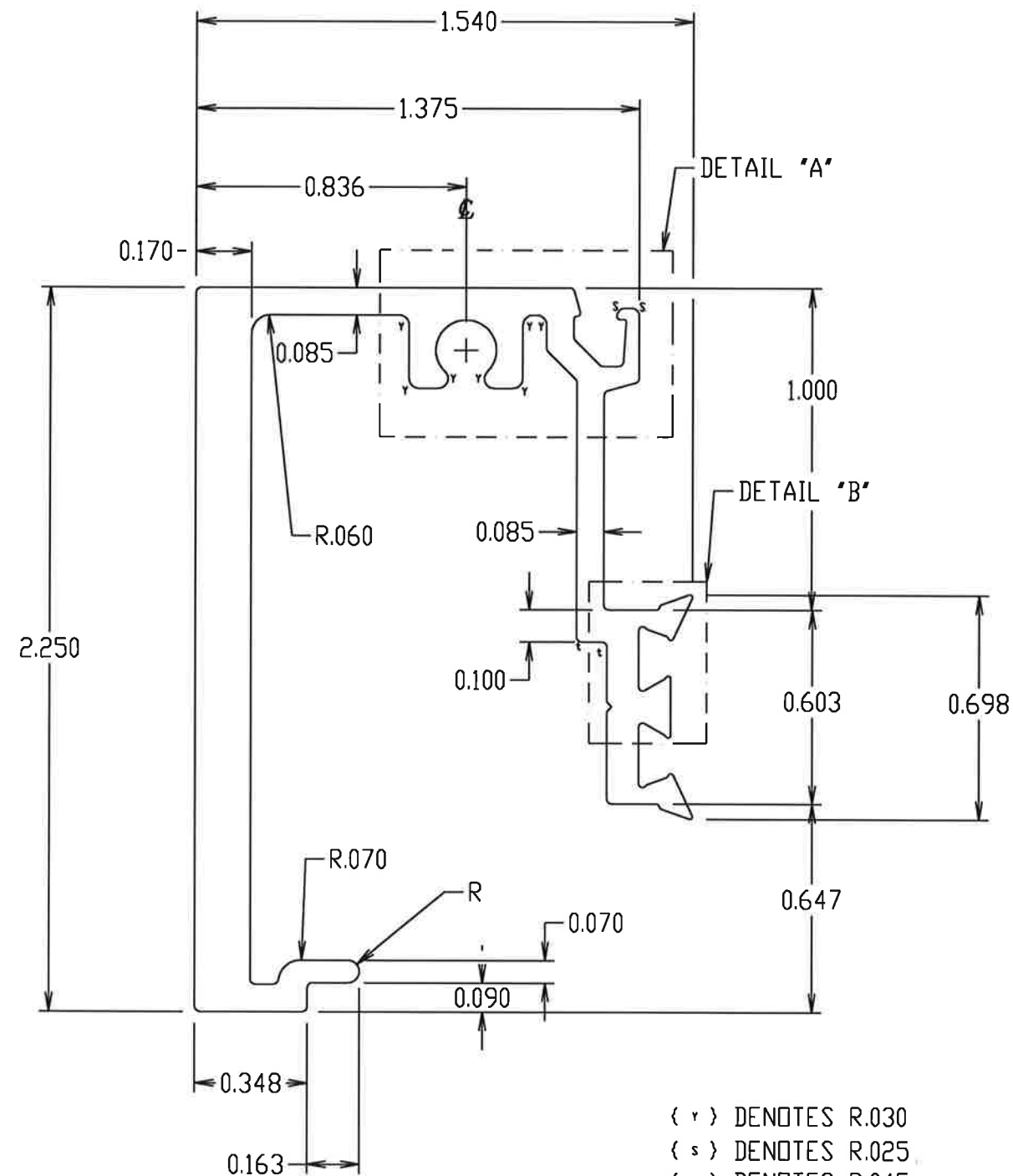
Die Number

T-62269

Temp. Number

Design Number

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{ r } DENOTES R.030
{ s } DENOTES R.025
{ t } DENOTES R.045

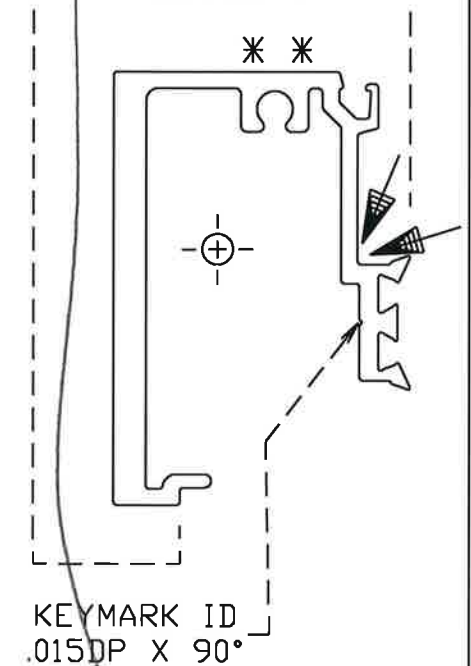
STRUT ASSEMBLY W/ S-74418/ISS024

FOR ASSEMBLY
REFER TO IS0016-GCD

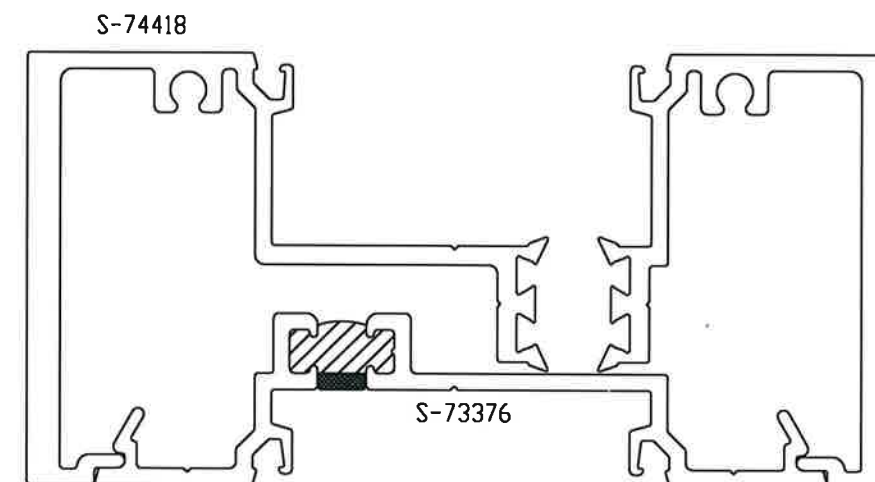
S-74419 MATES WITH:
S-73776 IS021
S-74106 IS023a

ACTUAL SIZE

- EXPOSED -



ACTUAL SIZE ASSEMBLY



ANODIZED FINISH QUALITY



FONDA, NY TEL. (518) 853-3421
LAKELAND, FL TEL. (863) 858-5500
WWW.KEYMARKCORP.COM

Unspecified
Wall Thickness: .170

Break Ext. Corners
.015 Radius or as Noted

Customer
GAMCO

Customer's
Part Number

Job Name	FG451IS
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ISS025

Part Title	HEAD/VERTICAL INTERIOR
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Scale
2:1

Alloy	6063
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Area (In²)
0.754

Finish Perimeter (In)	5 677
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Date	02-28-25
------	----------

0000	Temper
	T-6

Wt./Ft. (Lbs)
0.905

	0.011	
Total Perimeter (In)	13.339	

Drawn
MID

Cavity Size	10
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Circle Size (I
2.5

n)	Exterior Perimeter (In)	13.339
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Checked	00
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Estimated For Reference Only	$I_x = 0.364$	$I_y = 0.215$	Alodine <input type="checkbox"/>	Type: 010
	$S_x = 0.274$	$S_y = 0.215$	Crimp <input type="checkbox"/>	Factor: 15

PLEASE MARK PAINTED SURFACES
AS PRIMARY & SECONDARY

Mill	<input type="checkbox"/>	Ano.	<input checked="" type="checkbox"/>	Drnr.	<input checked="" type="checkbox"/>	Drnc.	<input checked="" type="checkbox"/>	Pc	<input type="checkbox"/>
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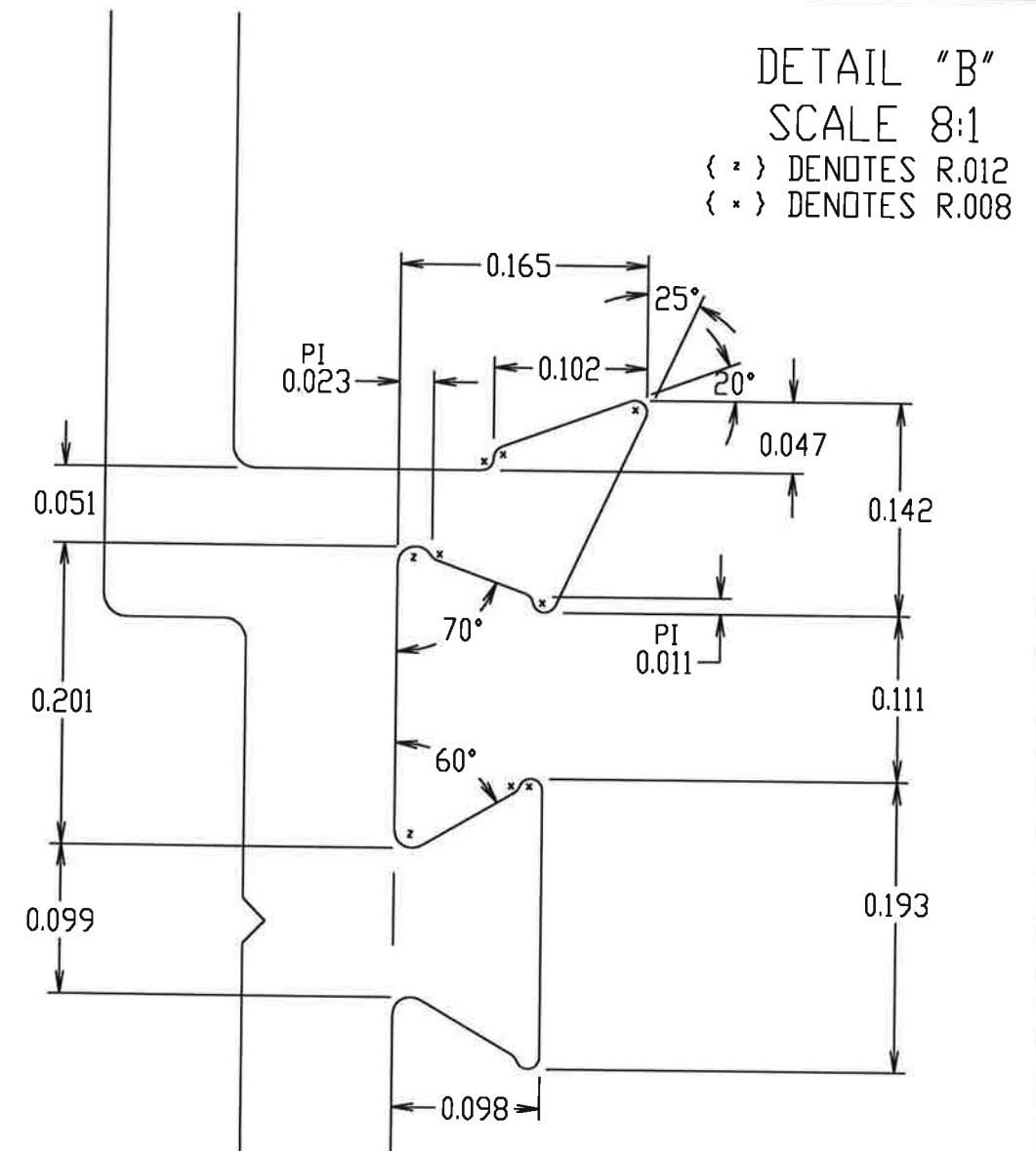
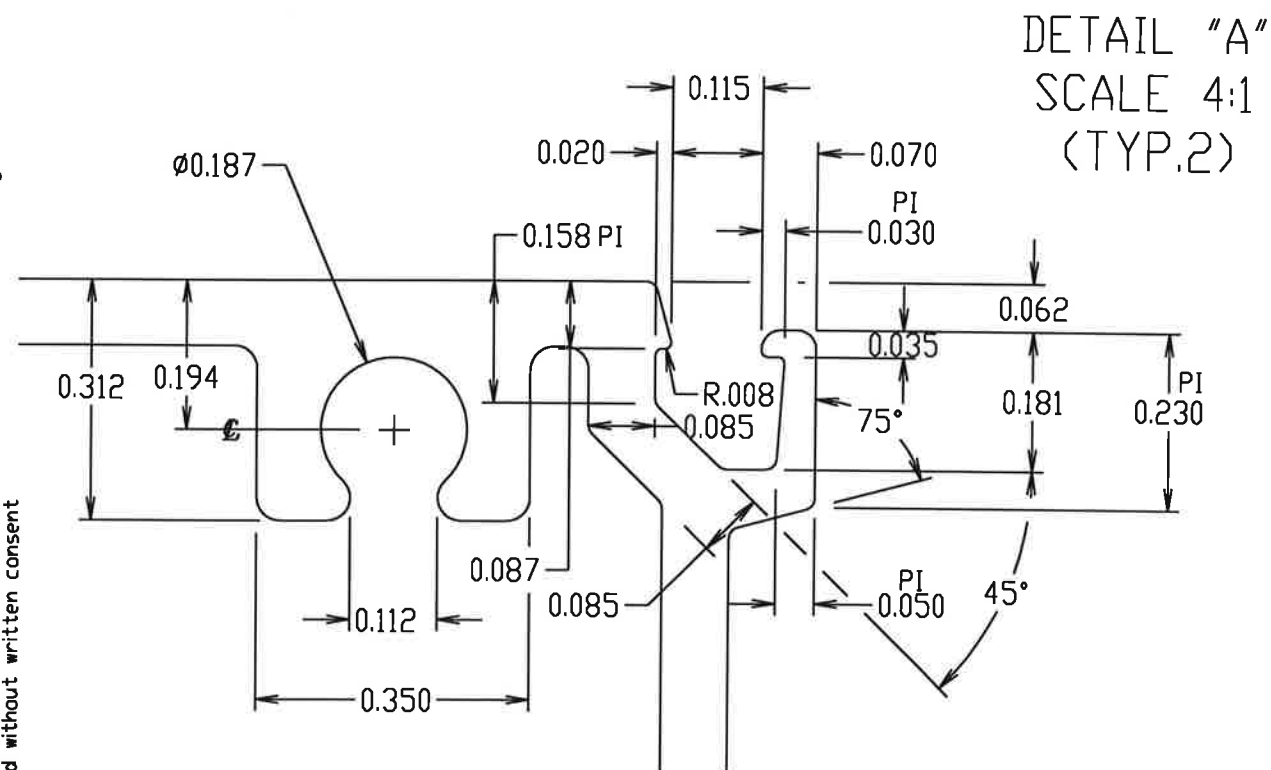
Syn.	Revisions	Date

Solid <input checked="" type="checkbox"/>	Semi-hollow <input type="checkbox"/>	Class:	Hollow <input type="checkbox"/>	Class:	
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S-74419-D
Die Number



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Unspecified
Wall Thickness: .170

Break Ext. Corners
.015 Radius or as Noted

Sym.	Revisions	Date	Customer GAMCO	Customer's Part Number ISS025	
			Job Name FG451IS		
			Part Title HEAD/VERTICAL INTERIOR	Job Number	
			Scale AS NOTED	Date 02-28-25	Drawn MJD
					Checked