

1.
- TO BE MACHINED FROM METAL 3D-PRINTED PART PROVIDED.
2.
- DETAILS A AND B ARE FOR REFERENCE ONLY. STANDARD SAE AS5202-02 AND AS5202-03 PORTING TOOLS ARE RECOMMENDED.
3.
- MATERIAL: NICKEL ALLOY 625 (INCONEL-625), ADDITIVELY MANUFACTURE USING DMLS (DIRECT METAL LASER SINTERING) AND HEAT-TREATED WITH HIP (HOT ISOSTATIC PRESSING).
4.
- GUIDELINES DUE TO UNCERTAINTIES IN PRINTED AND HIPPED PARTS:

1.

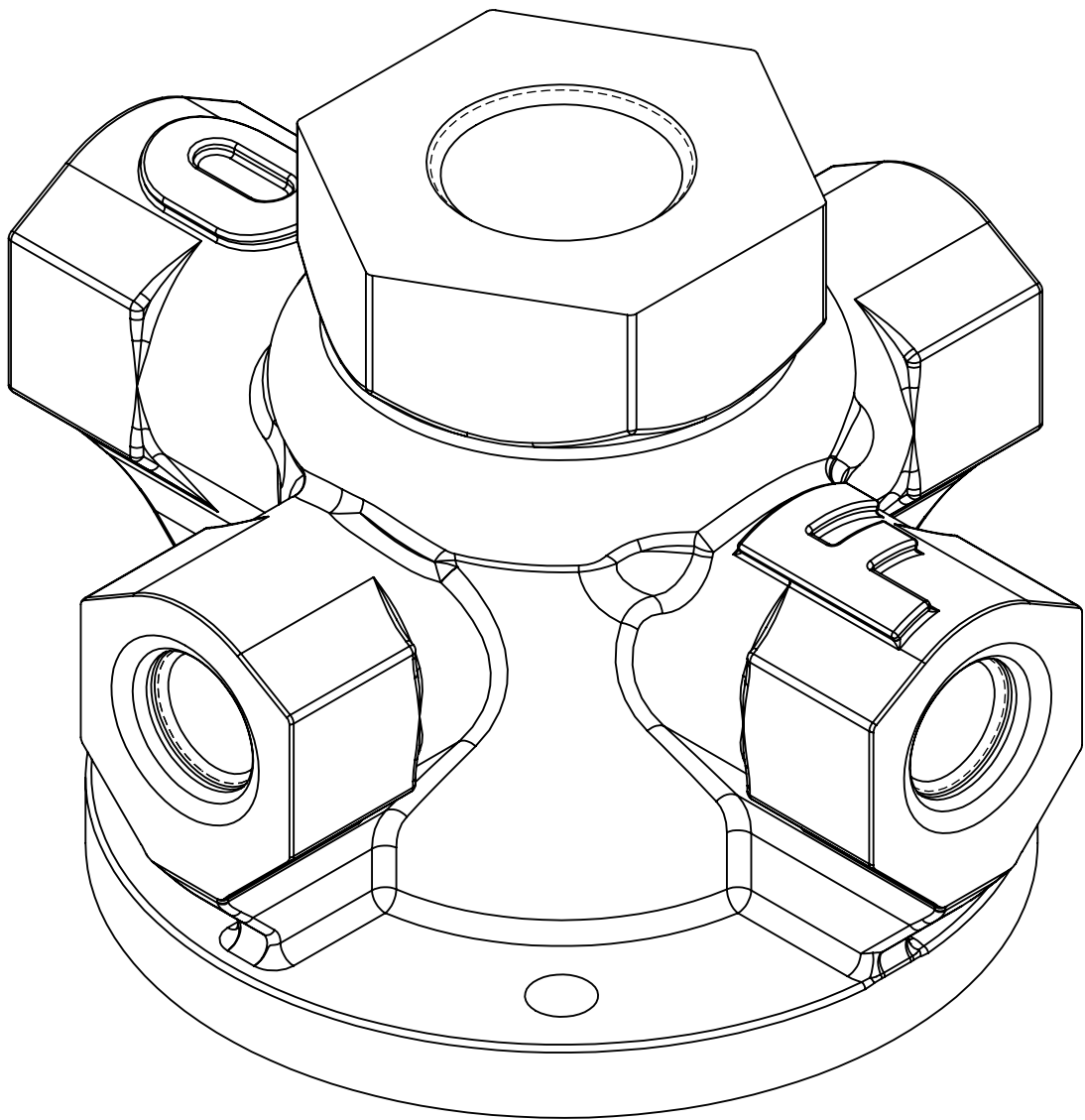
USE SEPARATE DATUM REFERENCE FRAMES FOR EACH FEATURE AS INDICATED IN DRAWINGS.

2.

REFERENCE DIMENSIONS ON PRINTED FEATURES MAY NOT BE ACCURATE.

3.

IF NECESSARY TO MATCH DRAWING INTENT, REMOVE IRREGULAR "BURRS"/SPIKES BEFORE USING DATUM SIMULATORS AGAINST PRINTED SURFACES.
5.
- UNLESS OTHERWISE SPECIFIED, DEBURR ALL SHARP EDGES. MATERIAL REMOVAL SHALL NOT EXCEED 10% OF FEATURE DIAMETER WITH A MAXIMUM REMOVAL OF 0.020".
6.
- ALL MACHINED SURFACES ARE A MINIMUM OF 63 MICROINCHES UNLESS SPECIFIED OTHERWISE.
7.
- PART SHALL BE FREE OF OIL, GREASE, DIRT, CHIPS, RUST, SCALE, AND FOREIGN MATTER.



ISO VIEW  
FOR REFERENCE ONLY  
SCALE 5:2

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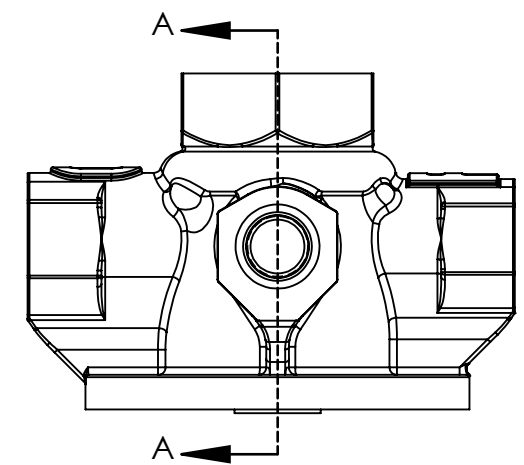
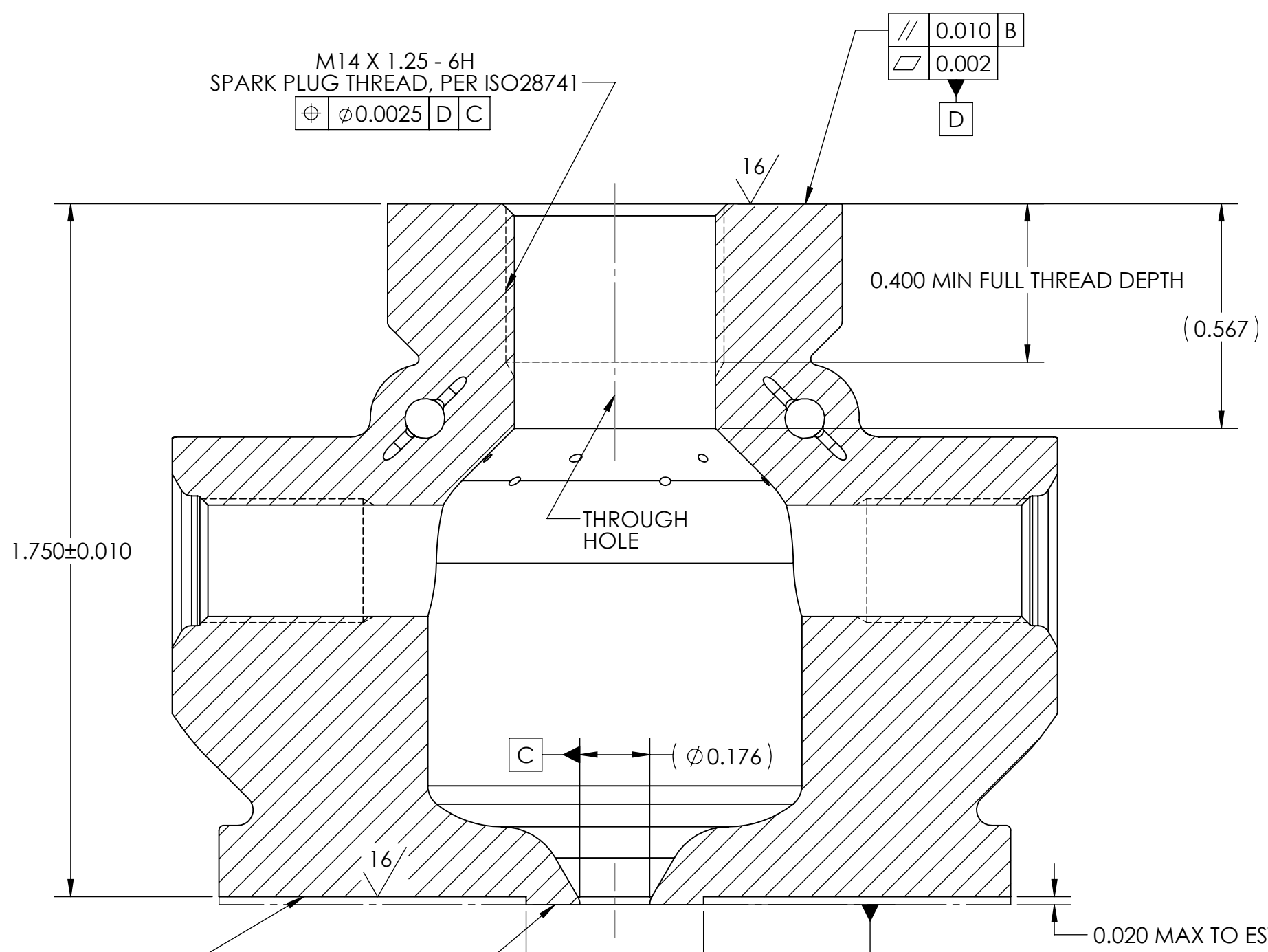
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		DIMENSIONS ARE IN INCHES	DRAWN					
		TOLERANCES:	CHECKED					
		FRACTIONAL ±	ENG APPR.					
		ANGULAR: MACH ± BEND ±	MFG APPR.					
		TWO PLACE DECIMAL ±	Q.A.			SIZE DWG. NO. REV		
		THREE PLACE DECIMAL ±	COMMENTS:					
		INTERPRET GEOMETRIC TOLERANCING PER:						
		MATERIAL				SCALE: 1:1 WEIGHT: SHEET 1 OF 5		
		FINISH						
NEXT ASSY	USED ON							
APPLICATION		DO NOT SCALE DRAWING						

B

B

A

A



SECTION A-A  
SCALE 3 : 1

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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE:	
		DIMENSIONS ARE IN INCHES	DRAWN				
		TOLERANCES:	CHECKED				
		FRACTIONAL ±	ENG APPR.				
		ANGULAR: MACH ± BEND ±	MFG APPR.			SIZE DWG. NO. REV	
		TWO PLACE DECIMAL ±	Q.A.				
		THREE PLACE DECIMAL ±	COMMENTS:			SCALE: 1:1 WEIGHT: SHEET 2 OF 5	
		INTERPRET GEOMETRIC TOLERANCING PER:					
		MATERIAL					
		FINISH					
NEXT ASSY	USED ON						
APPLICATION		DO NOT SCALE DRAWING					

4

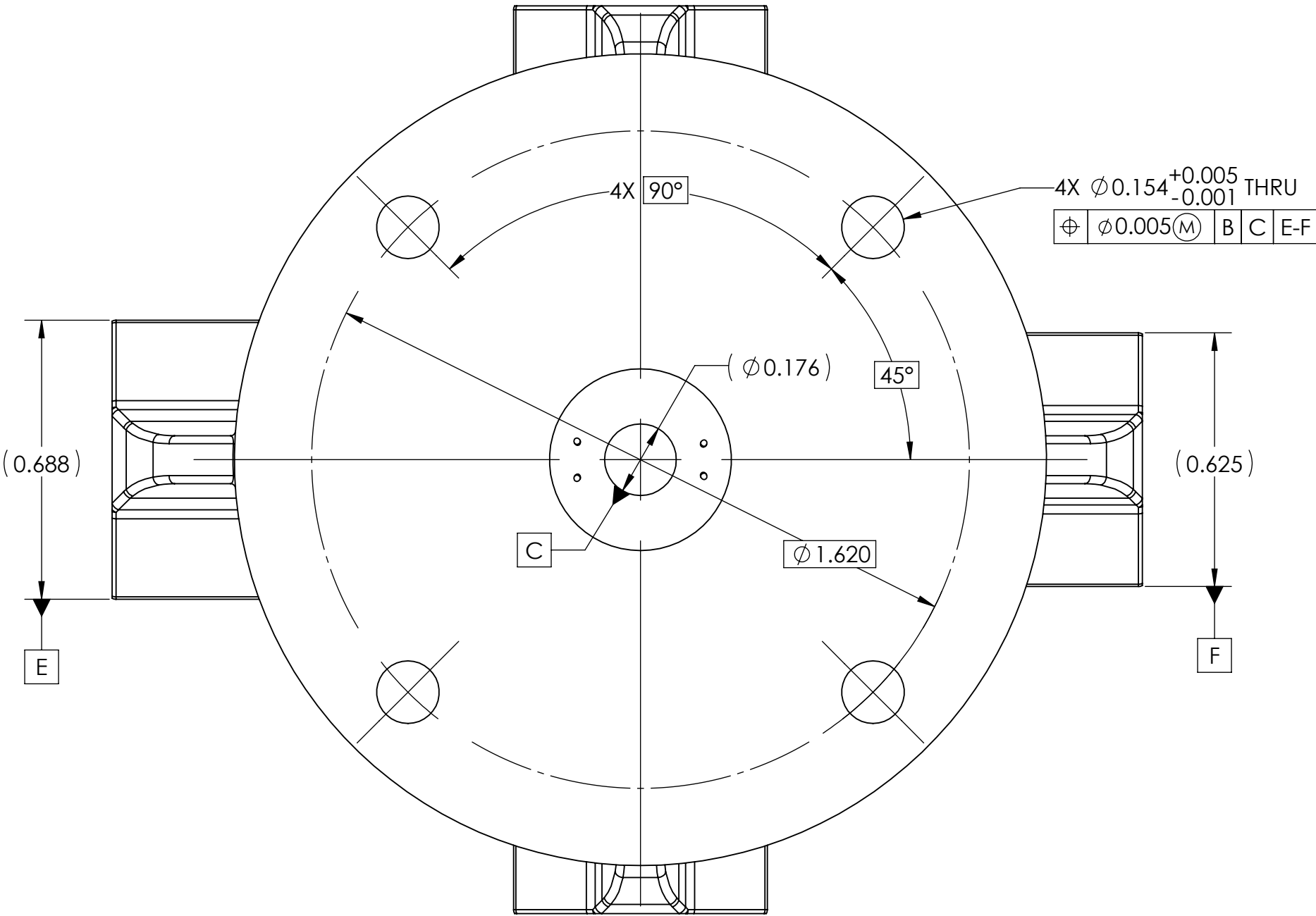
3

2

1

B

B



SCALE 3:1

A

A

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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	TITLE:		
		DIMENSIONS ARE IN INCHES	DRAWN					
		TOLERANCES:	CHECKED					
		FRACTIONAL $\pm$	ENG APPR.					
		ANGULAR: MACH $\pm$ BEND $\pm$	MFG APPR.			REV		
		TWO PLACE DECIMAL $\pm$	Q.A.					
		THREE PLACE DECIMAL $\pm$	COMMENTS:			SIZE	DWG. NO.	
		INTERPRET GEOMETRIC				<b>B</b>		
		TOLERANCING PER:				SCALE: 1:1	WEIGHT:	SHEET 3 OF 5
		MATERIAL						
NEXT ASSY	USED ON	FINISH						
APPLICATION		DO NOT SCALE DRAWING						

4

3

2

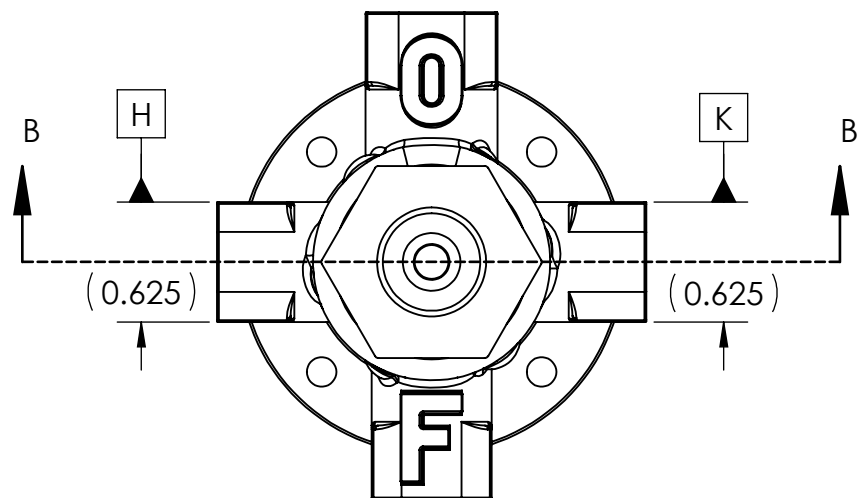
1

4

3

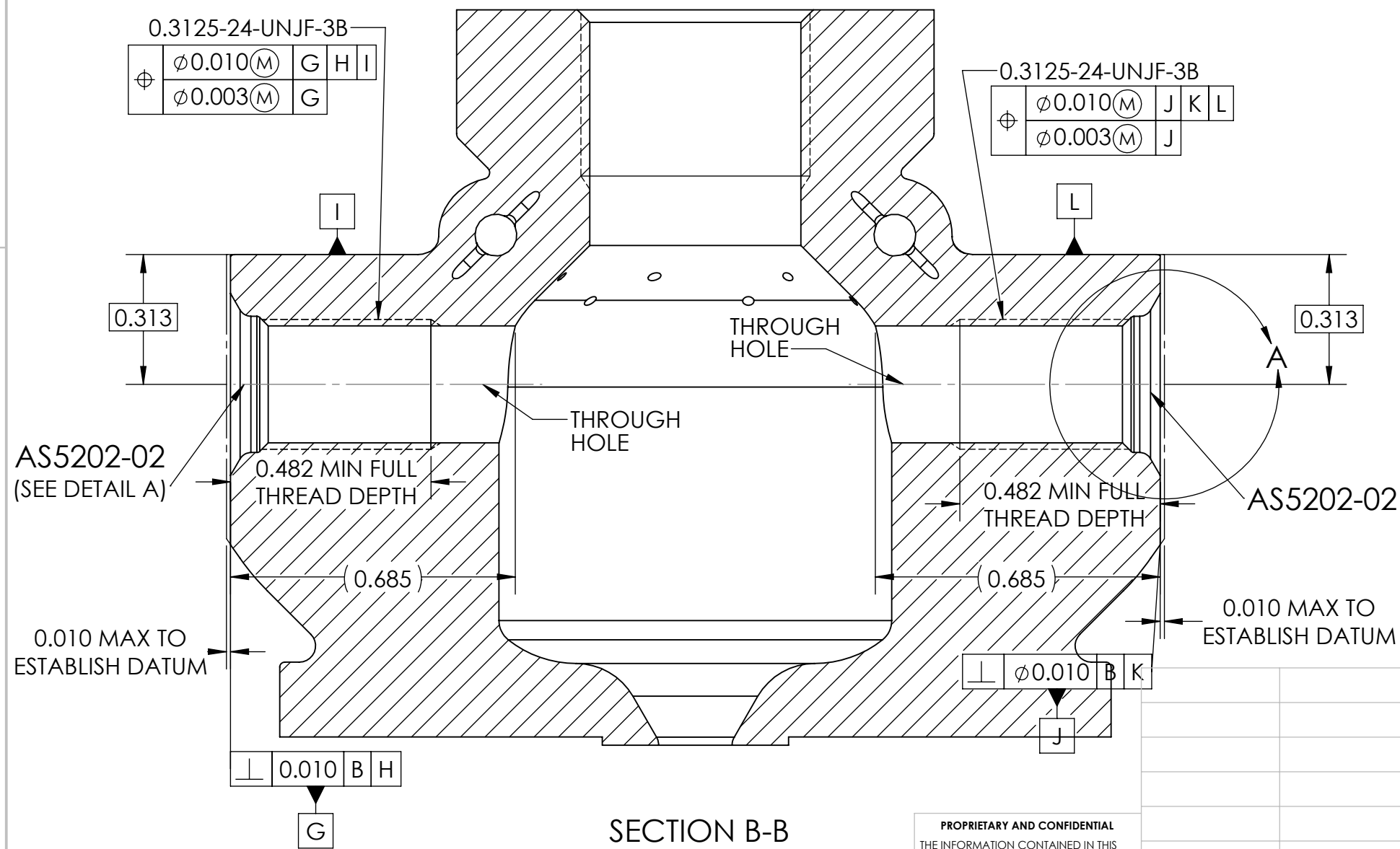
2

1



B

B

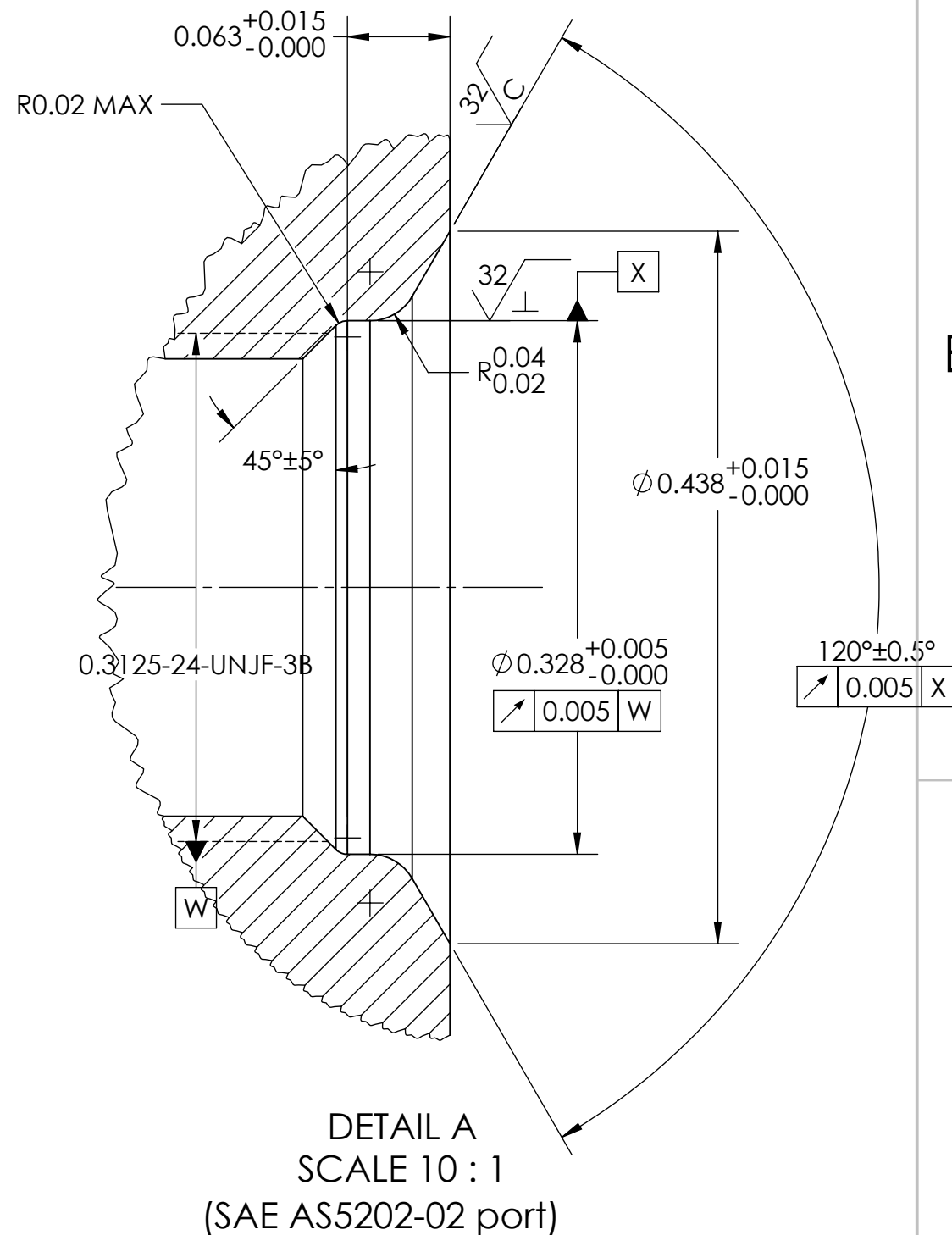


A

A

SECTION B-B  
SCALE 3 : 1

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DETAIL A  
SCALE 10 : 1  
(SAE AS5202-02 port)

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES  
TOLERANCES:  
FRACTIONAL ±  
ANGULAR: MACH ± BEND ±  
TWO PLACE DECIMAL ±  
THREE PLACE DECIMAL ±

INTERPRET GEOMETRIC  
TOLERANCING PER:  
MATERIAL

FINISH

NAME DATE

DRAWN  
CHECKED  
ENG APPR.  
MFG APPR.

Q.A.  
COMMENTS:

TITLE:

SIZE DWG. NO.

REV

SCALE: 1:1 WEIGHT:

SHEET 4 OF 5

3

2

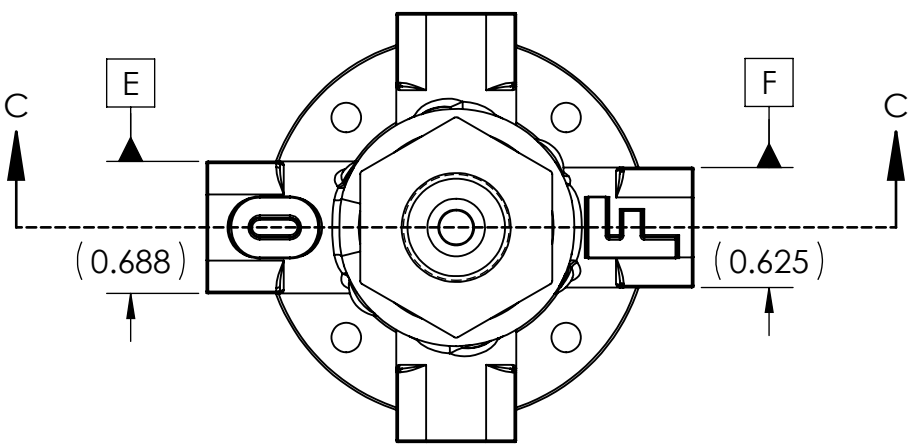
1

B

B

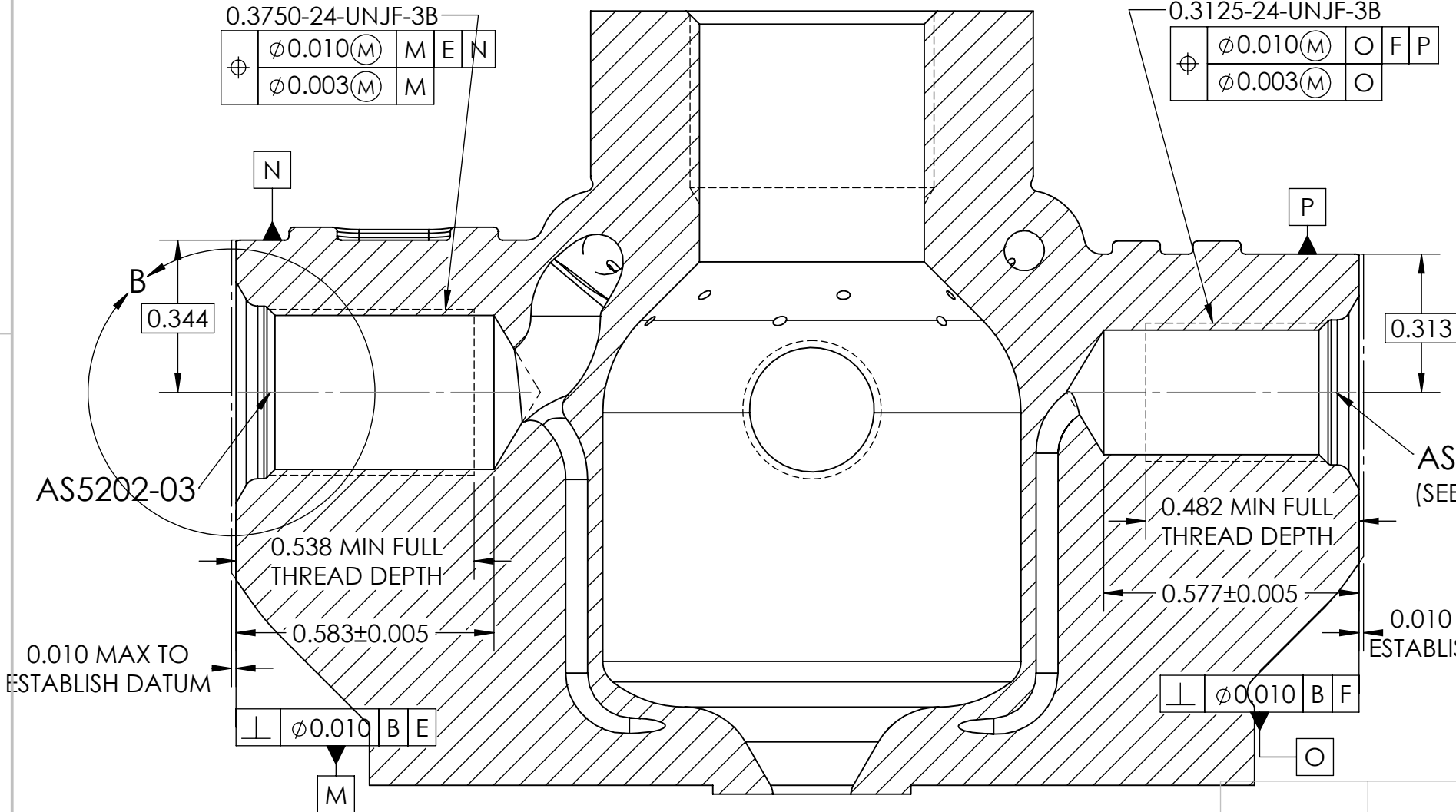
A

A



0.3750-24-UNJF-3B					
⊕	⌀0.010	(M)	M	E	N
	⌀0.003	(M)	M		

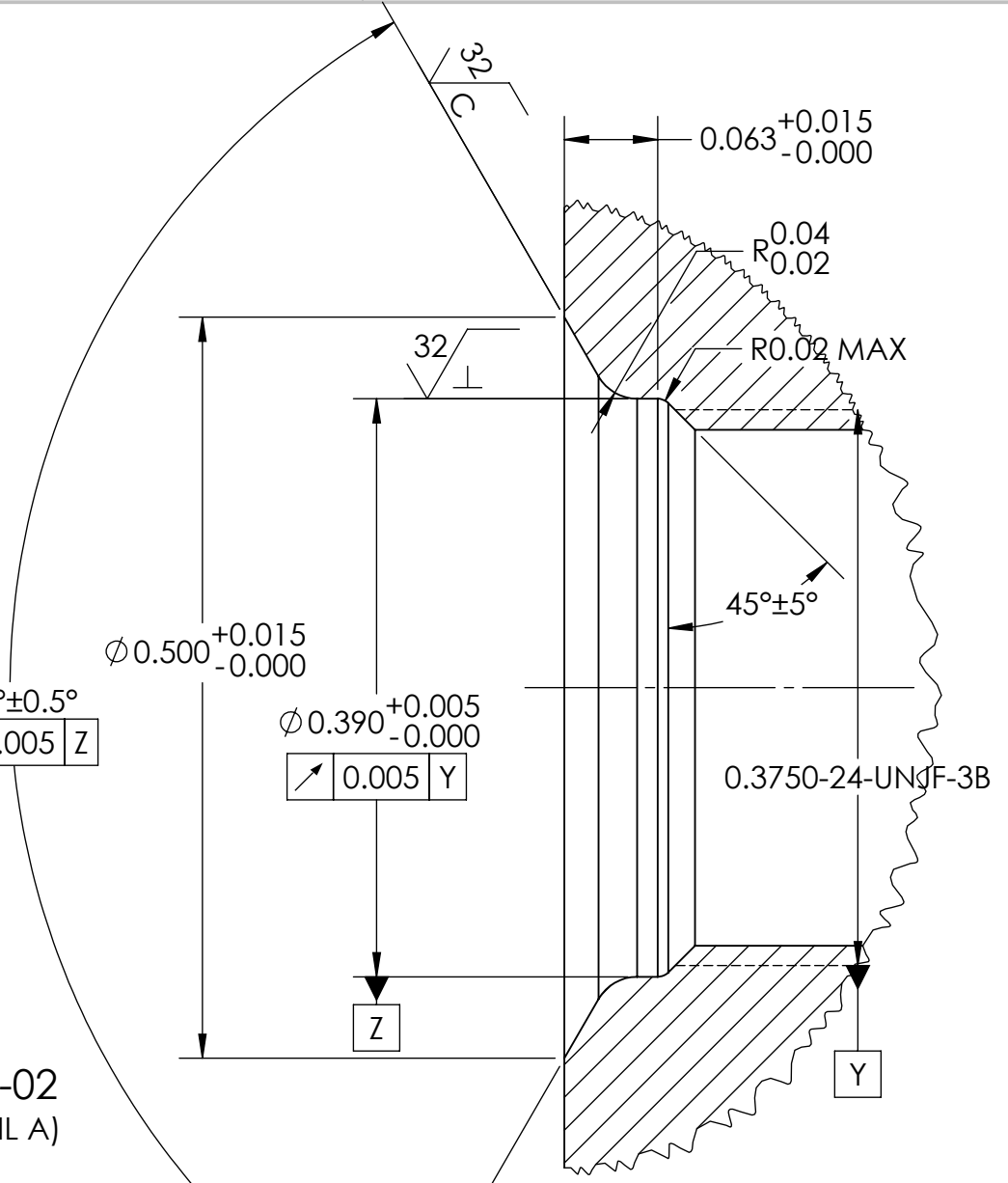
0.3125-24-UNJF-3B					
⊕	⌀0.010	(M)	○	F	P
	⌀0.003	(M)	○		



SECTION C-C  
SCALE 3 : 1

120°±0.5°
0.005 Z

⌀0.500 <sup>+0.015</sup> <sub>-0.000</sub>
⌀0.390 <sup>+0.005</sup> <sub>-0.000</sub>
0.005 Y



DETAIL B  
SCALE 8 : 1  
(SAE AS5202-03 port)

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		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ±    BEND ± TWO PLACE DECIMAL   ± THREE PLACE DECIMAL   ±	DRAWN					
			CHECKED					
			ENG APPR.					
			MFG APPR.					
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.			SIZE   DWG. NO.   REV		
		MATERIAL	COMMENTS:					
		FINISH						
NEXT ASSY	USED ON							
APPLICATION		DO NOT SCALE DRAWING						