

MAT: 6061-T6
 EXTRUSION.
 72 ± 0.25 lengths
 (Part will be cut to 10.00 lg at ENP Ref.)

ALL SHARP CORNER
 $\pm 0.005 - \pm 0.015 R$ or 45°
 64V Finish
 777 094-014
 Tony B 6-4-09
 Extrusion 7-1309 408

GENERAL SPECIFICATIONS FOR ANODIZED PARTS

1. ANODIZE PER MIL-A-8625

- ☐ TYPE I (CHROMIC ACID ANODIZE) ☐ CLASS 1 (NON-DYED)
☐ TYPE II (CHROMIC ACID LOW VOLT) ☒ CLASS 2 (DYED)
☐ TYPE III (SULFURIC ACID ANODIZE) ☒ COLOR: BLACK
☒ TYPE IIII (HARD ANODIC COATING) ☐ COLOR:

2. THICKNESS OF COATING

(AN INCREASE IN DIMENSION, EQUAL TO ONE HALF OF THE THICKNESS OF THE APPLIED COATING, CAN BE EXPECTED FOR EACH SURFACE COATED DUE TO SURFACE GROWTH.)

UNLESS OTHERWISE SPECIFIED THE NOMINAL THICKNESS OF THE COATING SHALL BE 0.002 INCH. THE THICKNESS SHALL NOT VARY BY MORE THAN 20 PERCENT FOR COATINGS UP TO 0.002 INCHES.

3. ALL DIMENSIONS TO BE HELD TO PRINT TOLERANCE AFTER ANODIZATION.

4. MASKING OF HOLE AND/OR OTHER FEATURES

IF UNSPECIFIED, ANY TAPPED OR NOT TAPPED HOLE 1/4 INCH OR LESS IN DIAMETER WILL BE FURNISHED FREE OF ANODIC COATING. IF UNSPECIFIED, ANY TAPPED OR NOT TAPPED HOLE OVER 1/4 INCH IN DIAMETER SHALL BE ANODIZED.

- ☐ DO NOT MASK
☒ MASKING REQUIRED IN 2 PLACES. SEE NOTE 3

5. RACKING POINTS

IF UNSPECIFIED, SIZE AND NUMBER OF CONTACT MARKS SHALL BE AT A MINIMUM CONSISTENT WITH GOOD PRACTICE. IF UNSPECIFIED, THE LOCATION OF CONTACT MARKS SHALL BE AT ANODIZERS DISCRETION (IN AREAS OF MINIMUM EXPOSURE).

- ☐ RACK ONLY ON FEATURES INDICATED BY NOTE

6. SEALING (IF UNSPECIFIED, SEAL WITH WATER)

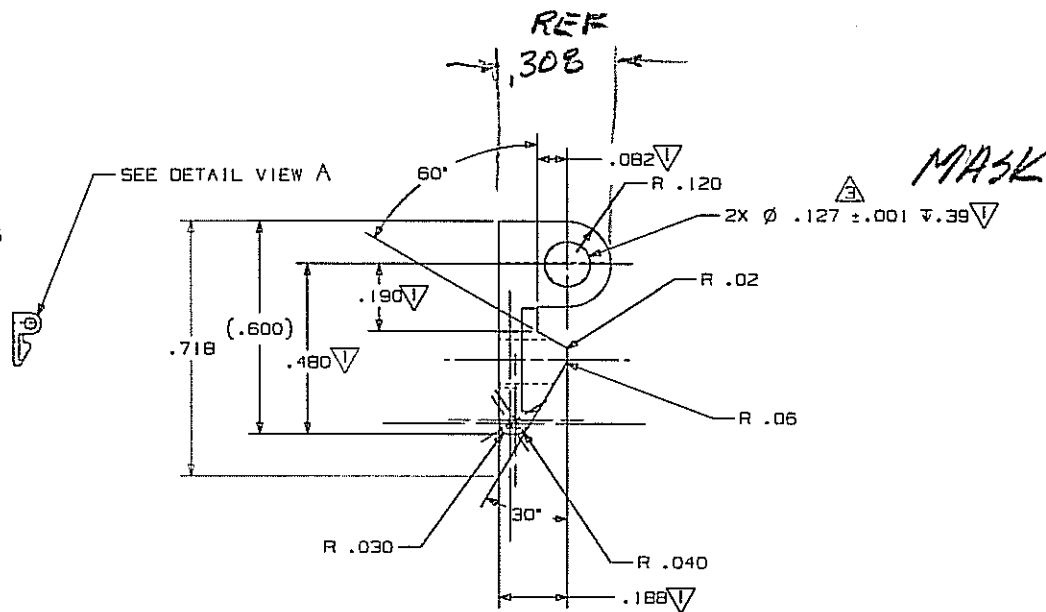
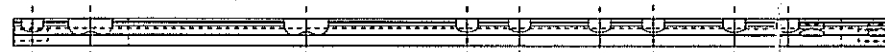
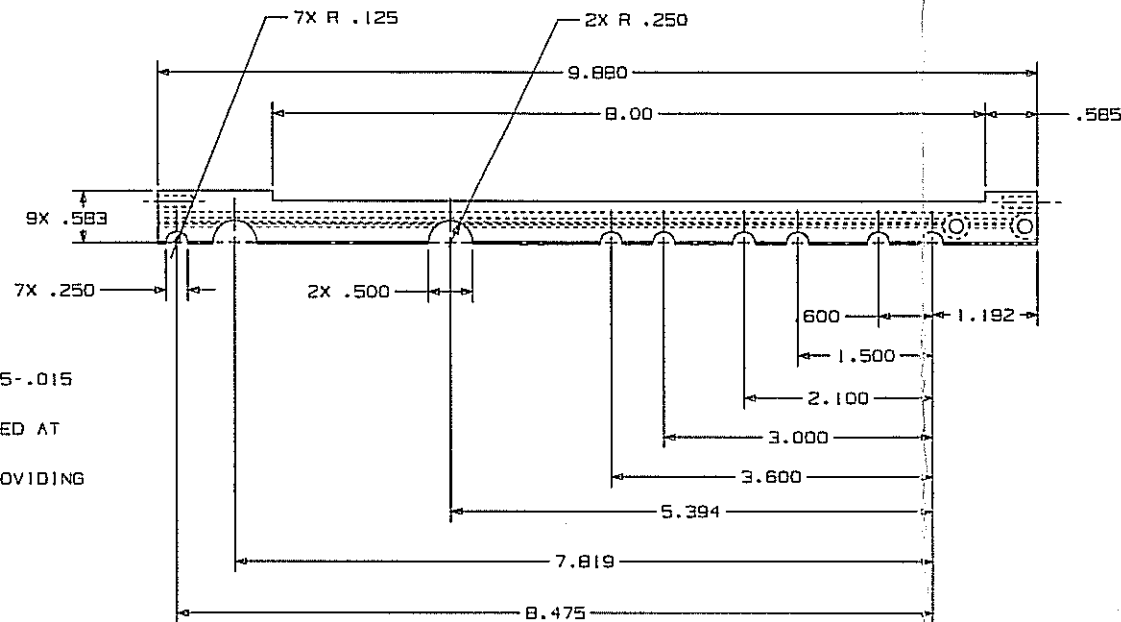
- ☒ NICKEL ACETATE
☐ DO NOT SEAL ONLY FOR TYPE IIII FOR MAXIMUM WEAR RESISTANCE
☐ OTHER SEALANT REQUIRED:

NOTES:

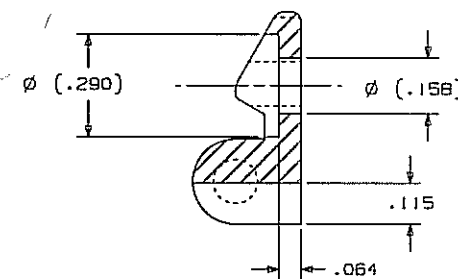
1. BREAK ALL SHARP EDGES AND CORNERS R.005-.015 (OR X 45°).

2. ▽ INDICATES KEY FEATURES TO BE VERIFIED AT INCOMING INSPECTION.

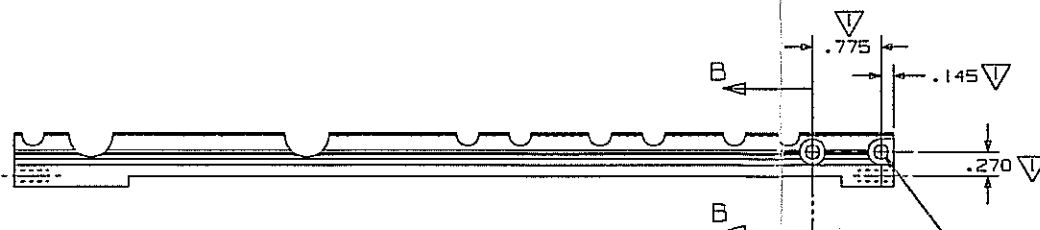
3. MASKING PRIOR TO ANODIZING OPTIONAL PROVIDING SPECIFIED SIZE IS ACHIEVED.



DETAIL VIEW A
SCALE 4X

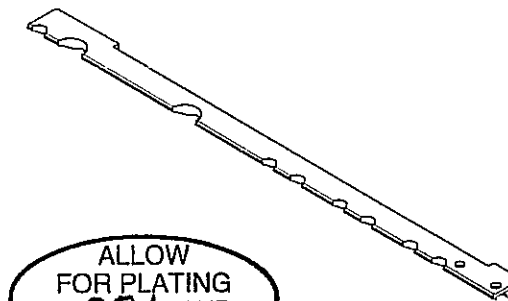


SECTION VIEW B-B
SCALE 4X
2 PLACES



2X Ø .158 ±.006 - .000
Ø .290 ± SHOWN IN VIEW B-B

Rack on these holes.



ALLOW FOR PLATING
.001 PER SURFACE

7-13-09 408

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TOLERANCES AND SYMBOLS DIMENSIONS SPECIFIED ARE AFTER ANODITIVE FINISH.				GAMBRO BCT			
DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED				TITLE			
MATERIAL				OPT I A			
6061-T6 ALUMINUM				LATCH, UPPER PLATE			
ORIGINATOR				DATE			
C. HAKE				2/27/00			
DRAWN				DATE			
D. GIBBONS				2/27/00			
SIZE				PART NO.			
D 1:1				777094-014			
SCALE				REV			
DO NOT SCALE				A 1/1			