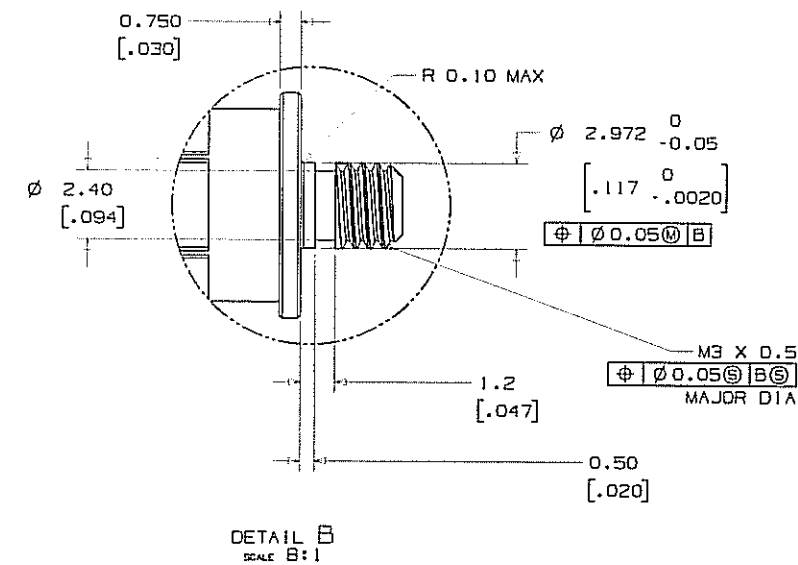
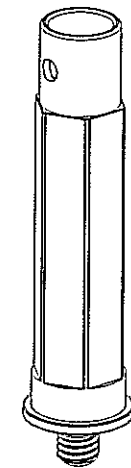
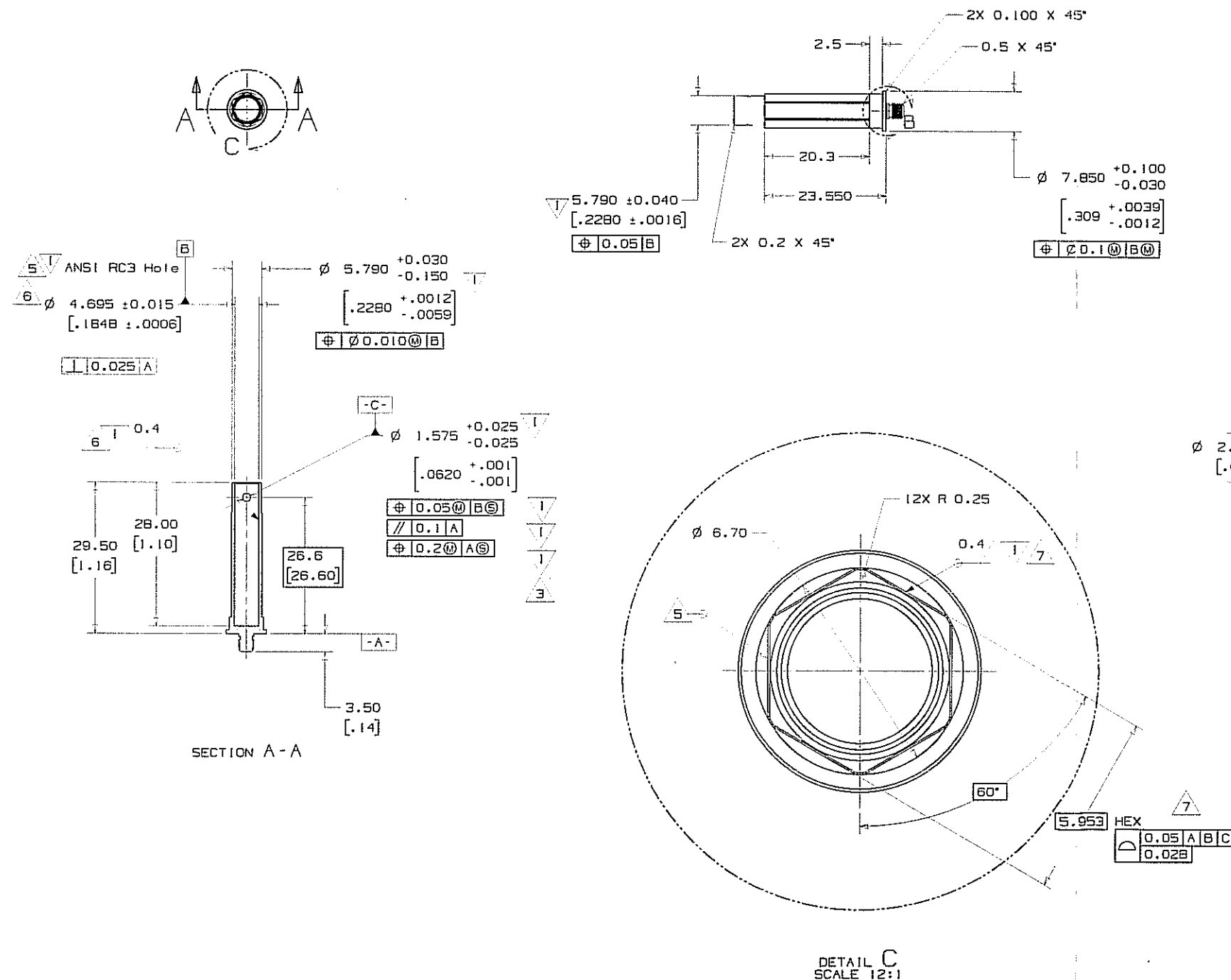



1. INDICATES FEATURE/DIMENSION TO BE CHECKED AT INCOMING INSPECTION.
2. TUMBLE TO REMOVE SHARP EDGES. PROTECT THREADS
3. INSPECTION FOR PERPENDICULARITY NOT NEEDED.
4. COAT UNPLATED PARTS WITH A LIGHT OIL FOR CORROSION PROTECTION.
5. NO COATING FIXTURING THIS SURFACE.
6. SURFACE FINISH AND TOLERANCE APPLIES TO A DEPTH OF 12 mm. BELOW.
7. HEX PROFILE TOLERANCE AND SURFACE FINISH APPLIES 5.0 TO 23. DATUM -A-
8. FINISH: ARMOLOY XADC 0.0002" +/- 0.0001" THICK. LIQUID HONE PART PRIOR TO SURFACE FINISHING.
9. ALL MACHINING AND PLATING DEBRIS AND FLUID MUST BE REMOVED.

REV	REVISION DESCRIPTION	BY	DATE	ECO #
05	INITIAL RELEASE-REPLACES 986100-082	LRN	01/27/11	BCT0---
07	REVISED SIZE, FINISH AND TOLERANCES	REM	04/22/11	BCTXXX
08	HEX PROFILE WAS 0.05	REM	04/27/11	BCTXXX



5-13-11 408

THESE DIMENSIONS SPECIFY TOLERANCES AND THE PRIORITY OF COMPLIANCE. THE AND SHALL NOT BE REPEATED, EXCEPT IN CASES FOR MANUFACTURING OF BASE OF APPROVED WRITTEN PERMISSION FROM CARIDIAN BCT, INC.				 CaridianBCT		(2001) Collins Avenue Lubbock, Delaware 00235-4440 USA	
DIMENSIONS AND STANDARD PER AND T19-50-1982. DIMENSIONS SPECIFIED IN MILLIMETERS UNLESS OTHERWISE SPECIFIED. DIMENSIONS SPECIFIED IN INCHES UNLESS OTHERWISE SPECIFIED. DIMENSIONS IN INCHES.				MATERIAL 4130 OR 4140 STEEL, HARDEN HRC 28-32		TITLE SHAFT, HEX RF VALVE, Cr	
INCH TOLERANCES .XX .XXX .XXXX		MILLIMETER TOLERANCES X. 1.0 X.XX 0.2 X.XXX 0.10 X.XXXX 0.050		HOLES $\pm$ 2 SURF. FINISH 1.6		PART NO. 986302-489	
SIZE SCALE D NONE		DRG 08		DATE 08/06/07		REV 08	
UNIGRAPHICS		DANJ		08/1/07		08/1/07	