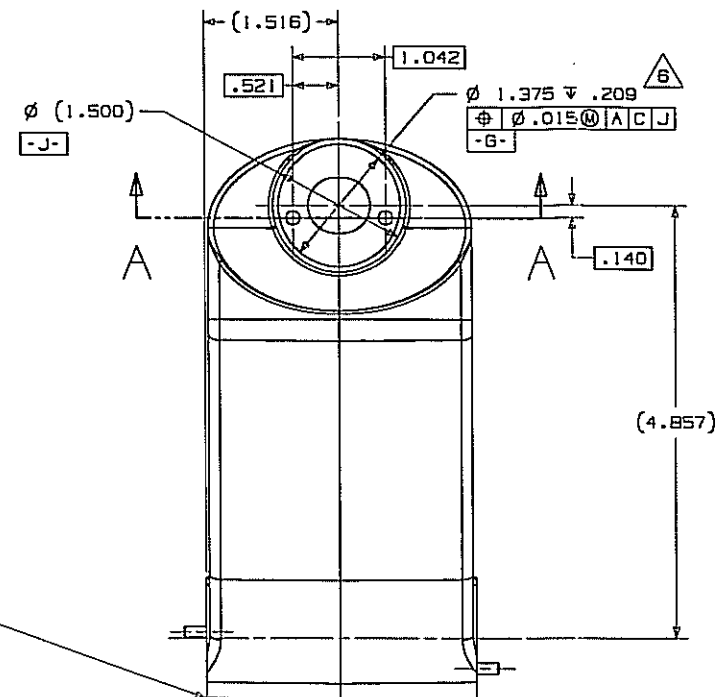
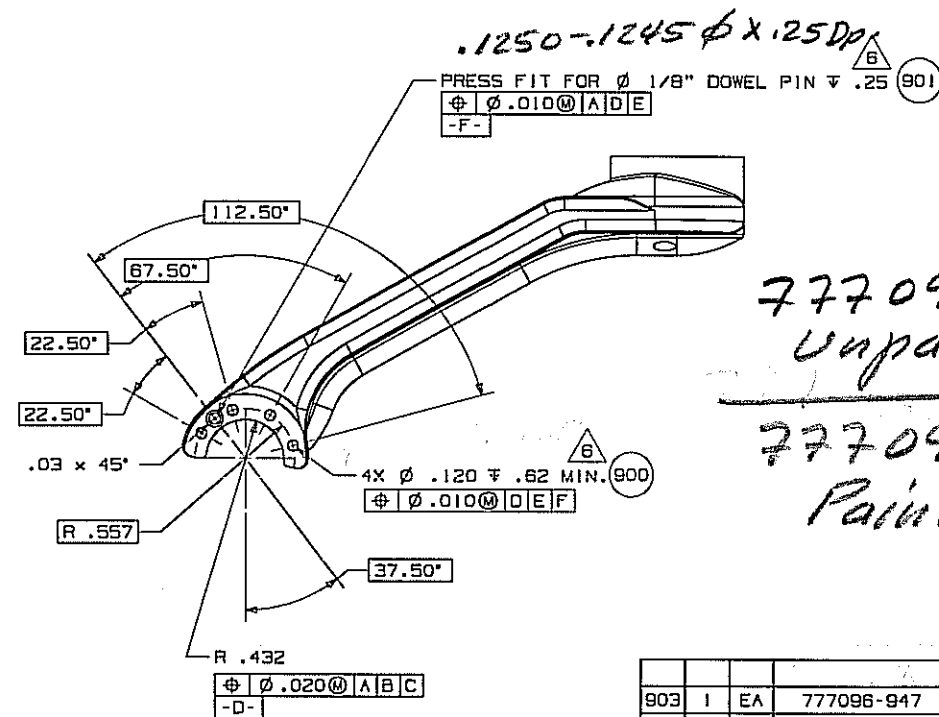
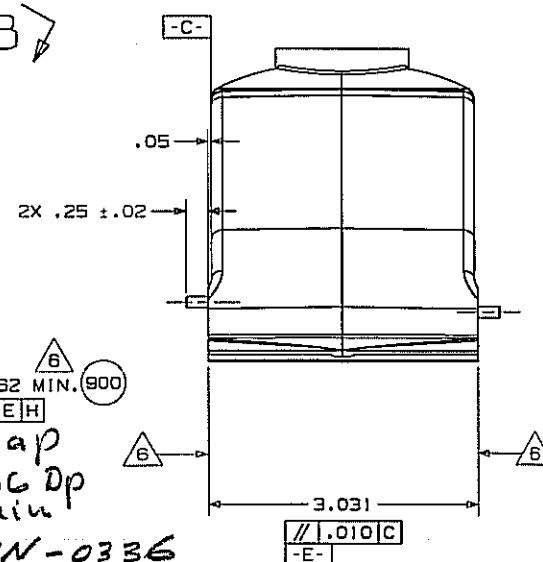
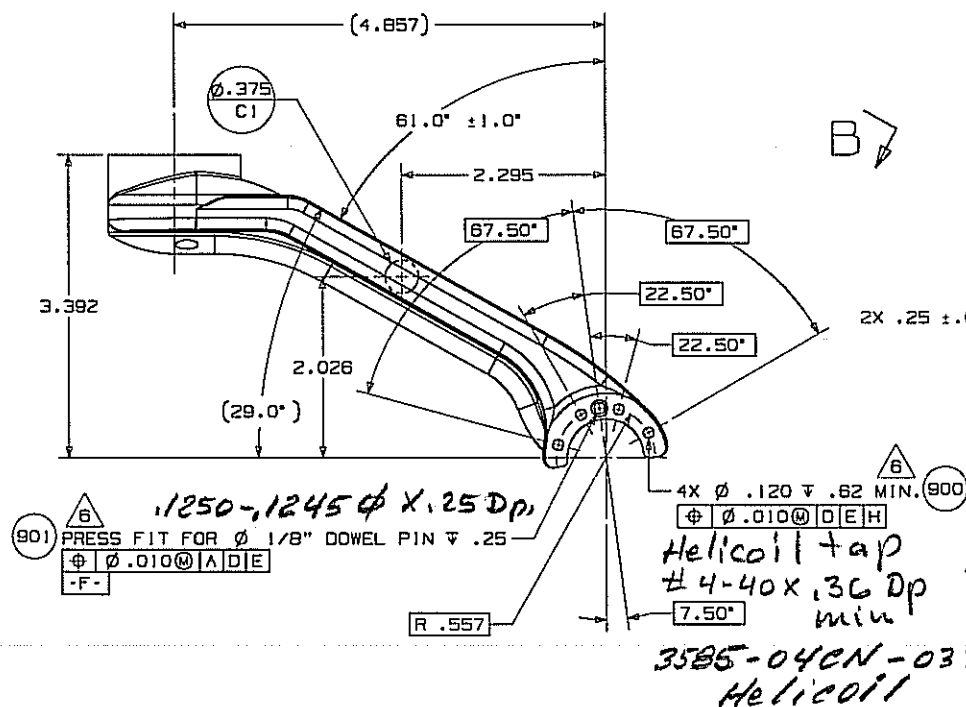


- NOTES:
1. THE THREE "A" DATUM TARGET POINTS MAKEUP DATUM -A-
 2. THE TWO "B" DATUM TARGET POINTS MAKEUP DATUM -B-
 3. ▽ INDICATES KEY DIMENSIONS TO BE CHECKED BY INCOMING O.C..
 4. PART TO BE FREE OF BURRS ON MACHINED SURFACES AND EDGES.
 5. FINISH: PAINT OPTIA DARK GREY PER BOR 902.
 6. AREAS INDICATED TO BE FREE OF PAINT.

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	INITIAL RELEASE, SIM TO 777096-948	MG	09/14/00	017752



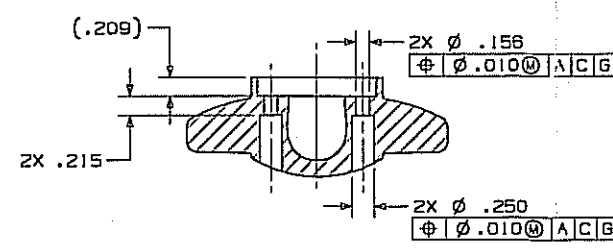
SEE SHT. 2



777094-410-1
Unpainted

777094-410
Painted

5-22-09 408



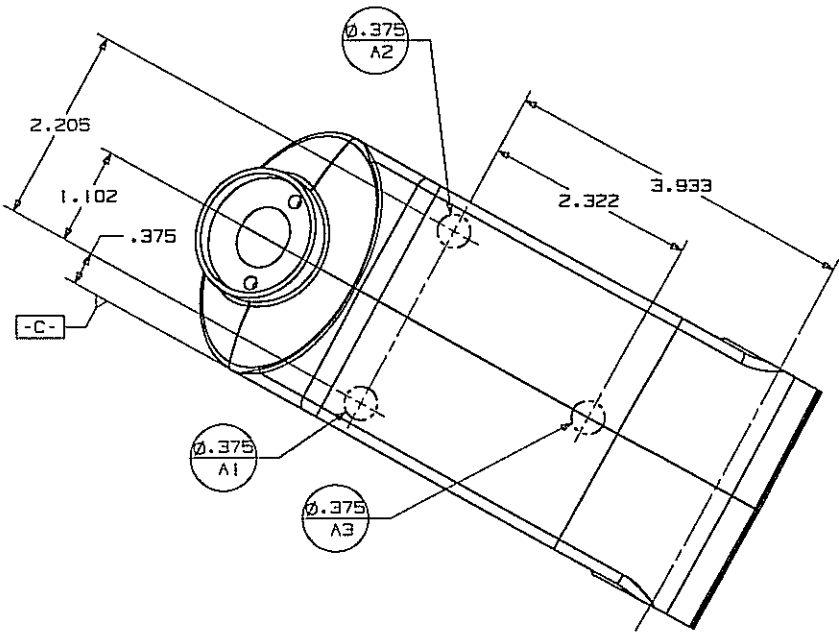
SECTION A - A

US DWG.

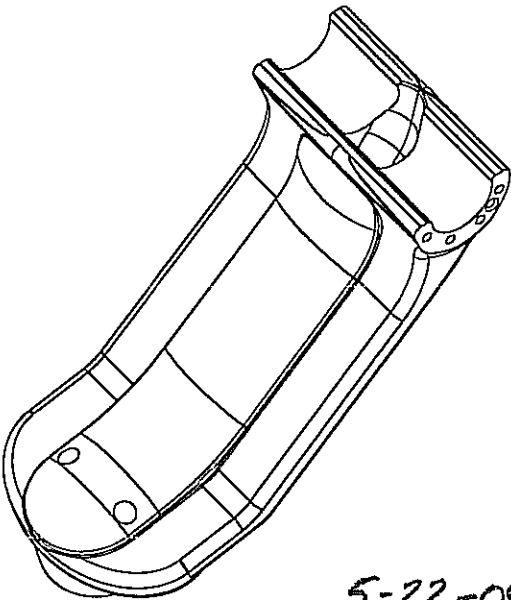
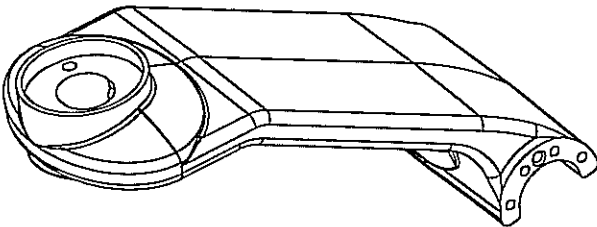
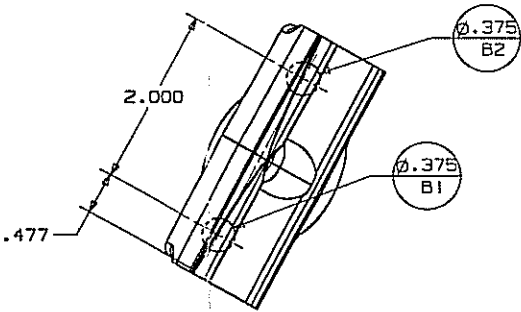
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION
903	1	EA	777096-947	CASTING, DISPLAY ARM
902	1	EA	777094-338	SPECIFICATION, PAINT, OPTIA
901	2	EA	779029-408	DOWEL PIN, SST, $\phi 1/8 \times .50$ LG.
900	8	EA	779213-214	THREAD INSERT, LOCKING #4-40 UNC

BILL OF REFERENCE			
TO ENHANCE AND ENHANCE THE QUALITY OF THE PRODUCT, THE FOLLOWING DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		GAMBRO, BCT	
MATERIAL: GAMBRO BCT #777096-947		TITLE: MACHINING, DISPLAY ARM OPTIA	
ORIGINATOR: M. GLOVER		DATE: 09/15/00	
SCALE: 1:1		PART NO.: 777094-410	
REV: A		SHEET: 1/2	

REV	REVISION DESCRIPTION	BY	DATE	ECO #
	SEE SHT. #1 FOR REV HISTORY			



VIEW B - B
FROM SHT #1



5-22-09 408

<small>THESE DRAWINGS AND SPECIFICATIONS ARE THE PROPERTY OF GAMBRO BCT, INC. AND SHALL NOT BE REPRODUCED, COPIED, OR USED FOR ANY PURPOSES OR SALE OF ANYTHING WITHOUT WRITTEN PERMISSION OF GAMBRO BCT, INC.</small>				<small>10813 California Avenue, Lakewood, Colorado 80226-4440 USA</small> GAMBRO. BCT	
<small>TOLERANCES AND SURF. FINISH UNLESS OTHERWISE SPECIFIED:</small> .XX1 0.10 .XX4 0.01 .XXX 0.005 .XXXX 0.0020		<small>ANGLES</small> $\pm 2^\circ$ <small>SURF. FINISH</small> 125 RMS		<small>DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED</small> MATERIAL SEE SHT. 1	
<small>DATE</small> 11/11/09		<small>DESIGNED BY</small> M. GLOVER		<small>DATE</small> 10/15/09	
<small>SIZE</small> 11:11		<small>SCALE</small> 1:1		<small>PART NO.</small> 777094-410	
<small>REV</small> A		<small>SHT</small> 2		<small>OF</small> 2	

NOTES:

1. DIMENSIONS NOT SPECIFIED ON THE DRAWING ARE CONTAINED IN THE DATABASE FOR THIS PART NUMBER AND REVISION.

UNSPECIFIED TOLERANCES ARE AS FOLLOWS:

RADI: EDGE/CORNER RADI SHALL BE 0.09 MAX. UNLESS OTHERWISE NOTED. FILLET RADI SHALL BE 0.09 +/- .03 UNLESS OTHERWISE NOTED.

DATUM/TOLERANCES:

INDICATES DATUM TARGETS OR MACHINE LOCATING POINTS.

DATUM TARGETS TO BE FREE OF CAST RAISED FOUNDRY SYMBOLS, GATES AND RISERS. DATUM TARGETS ARE LOCATED AT A TRUE POSITION WITHIN ϕ .030.

GENERAL PART TOLERANCE:

ALLOWABLE DRAFT ANGLE $0^{\circ} 30'$. ALL DRAFT ALLOWANCE SHALL BE ADDITIONAL MATERIAL.
LINEAR TOLERANCES: ± 0.020
TOOLING CHANGES AFTER APPROVED "FIRST ARTICLE INSPECTION" REQUIRES APPROVAL FROM COBE BCT, INC.

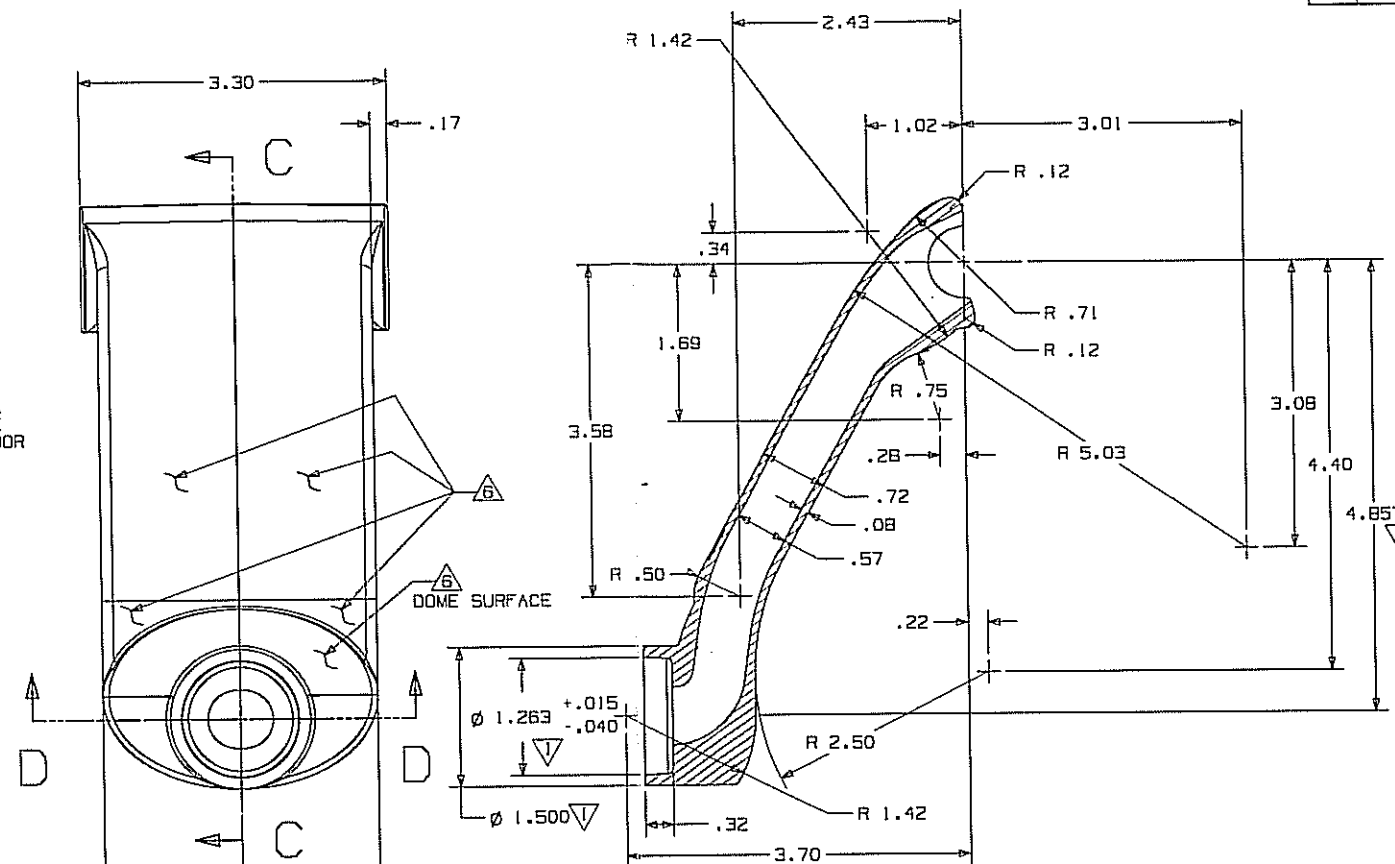
2. CAST SURFACE FINISH TO BE 125 RMS OR BETTER (AS MEASURED BY THE USE OF A CAST SURFACE COMPARATOR). CASTING TO BE FREE OF FLASH, BURRS AND SURFACE POROSITY. LOCATION OF PARTING PLANE IS AT THE DISCRETION OF CASTING VENDOR EXCEPT AS REQUIRED FOR IMPORTANT TOLERANCES AND MACHINE LOCATING POINTS. ALLOWABLE PARTING PLANE MISMATCH 0.005.

3. COSMETIC WELD RESTORATION IS PERMITTED IN ACCORDANCE WITH MIL-STD-2219 OR MIL-W-8804. DATUM TARGETS AND MACHINE LOCATING POINTS MUST BE WELD FREE.

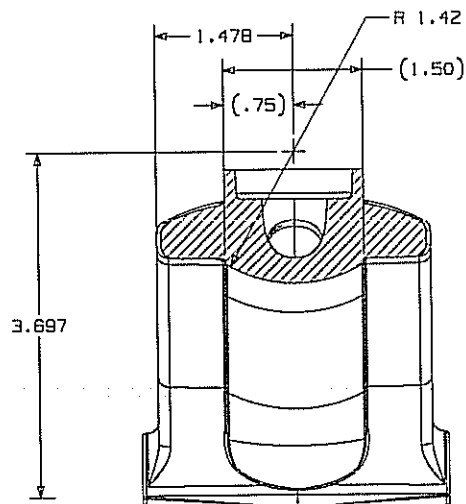
4. INDICATES KEY DIMENSIONS TO BE CHECKED BY INCOMING O.C.

COSMETICALLY IMPORTANT SURFACES TO BE FREE OF GRIND MARKS AND PARTING LINE FLASH. TRANSITIONS BETWEEN SURFACES TO BE CONTINUOUS AND SMOOTH. GATES TO BE GROUND FLUSH TO ADJACENT SURFACE MAINTAINING CONTINUITY TO EXISTING CAST SURFACE.

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	INITIAL RELEASE, REPLACES 777096-421	KMK	11/14/00	BCT 000048
B	$\phi 1.263 \pm .015 / -.040$ WAS $\phi 1.263 \pm .000 / -.040$ $2.96 \pm .00 / -.04$ WAS 2.96, REMOVED NOTE #5 - MARK PART PER MIL-STD-130 SECTION A-A DIM. (2.96) WAS 2.96	KMK	08/25/00	BCT007801



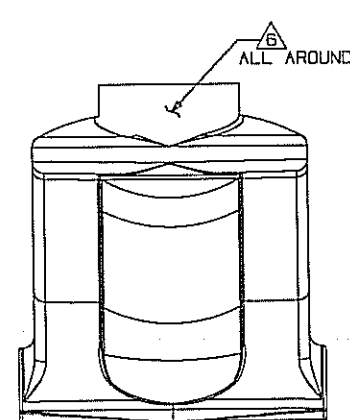
SECTION C - C



SECTION D - D

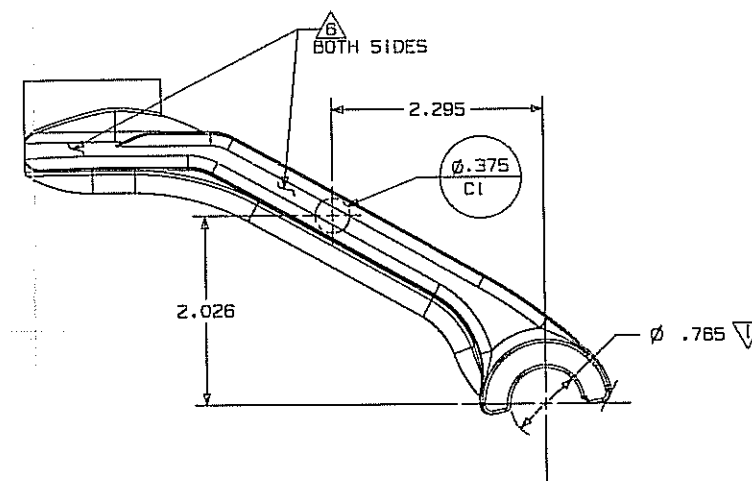
E

E
SEE SHT. #2



B

B
SEE SHT. #2

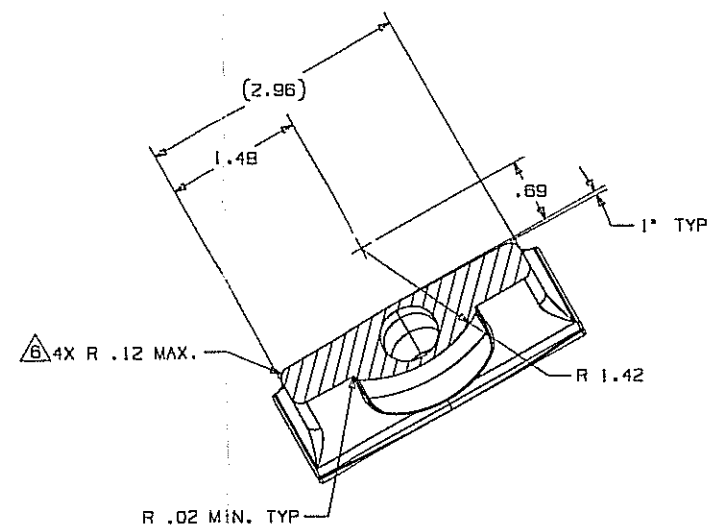
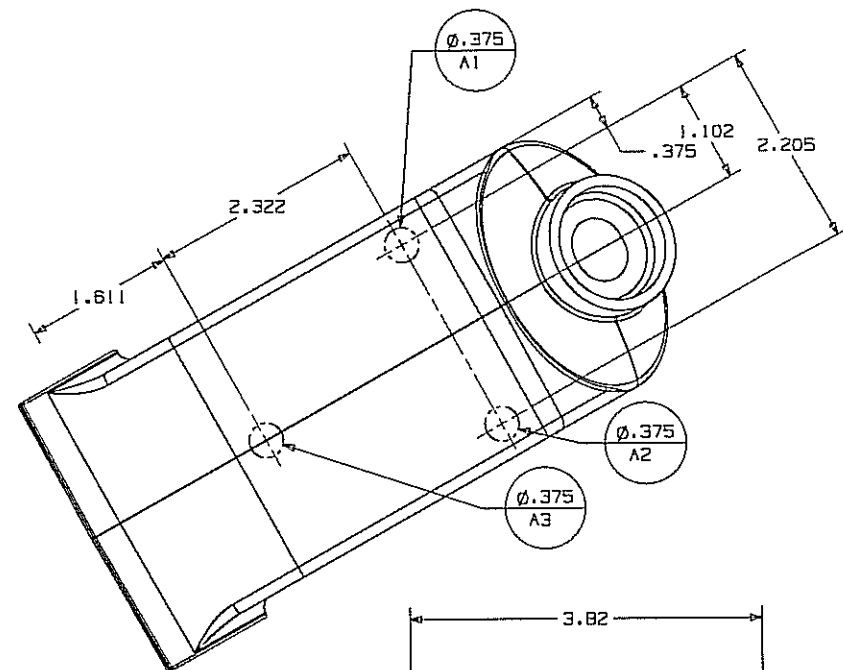


UG DWG

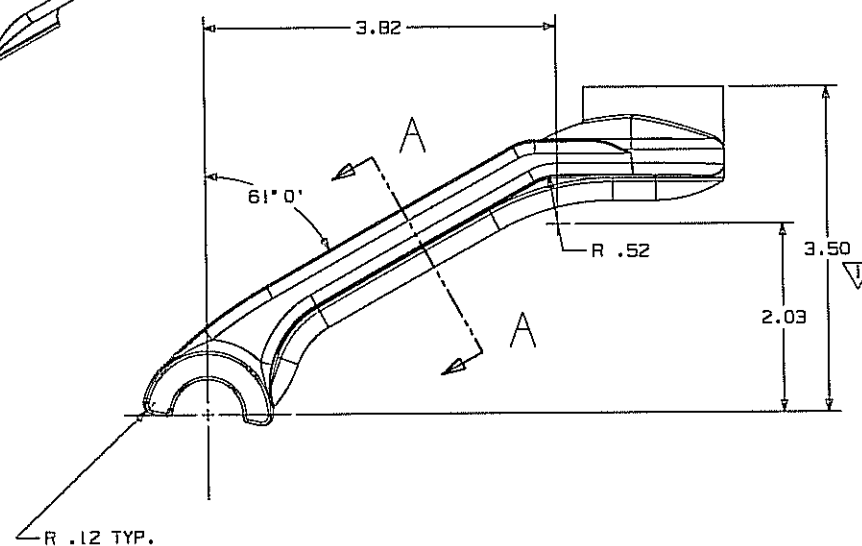
Casting Ref. 5-22-09 408

TOLERANCES AND SYMBOLS FOR FIRST 125 RMS DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		10011 Collins Avenue Livonia, Michigan 48150-4440 USA	
.Xs 0.1	ANGLES	MATERIAL		TITLE	
.Xs 0.02	$\pm 1^{\circ}$	A356-T51 ALUMINUM		CASTING, DISPLAY ARM	
.XXX 0.010	DAVE, FINISH	ORIGINATOR		DATE	
.XXX 0.0050	125 RMS	K .KLIMEK		05/12/00	
SIZE	SCALE	DATE	DATE	PART NO.	REV
D 1:1	1:1	05/12/00	05/12/00	777096-947	B 1/2

REV	REVISION DESCRIPTION	BY	DATE	ECO #
	SEE SHT. #1			

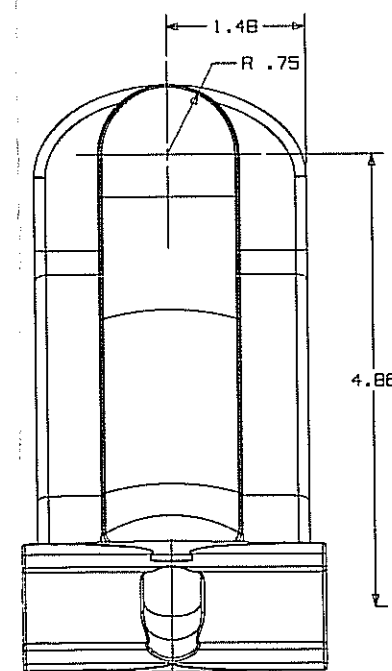
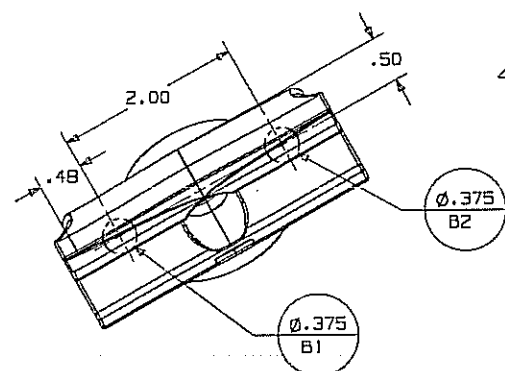


SECTION A - A



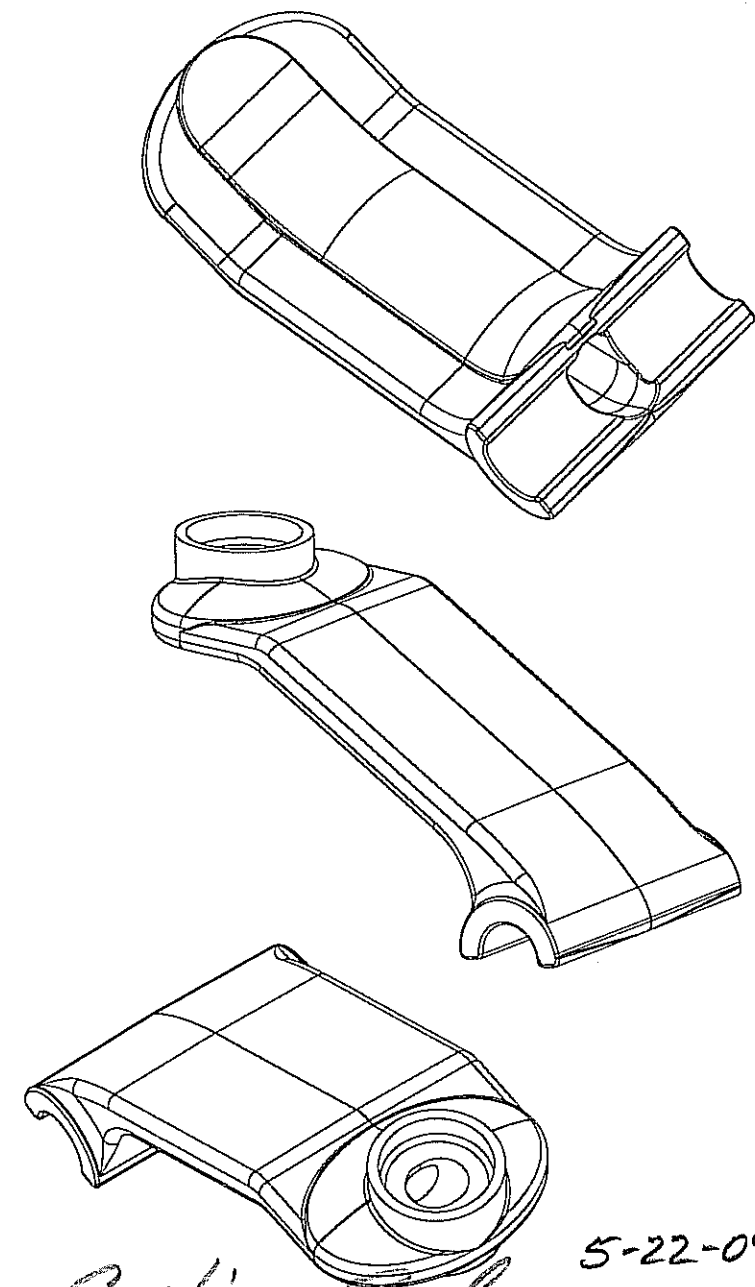
VIEW E - E

FROM SHT. #1



VIEW B - B

FROM SHT #1



Casting ref.

5-22-09 408

TOLERANCES AND FINISHES FRACTIONS AND DECIMALS DIMENSIONS SPECIFIED ARE AFTER FINITIVE FINISH.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		10011 Collins Avenue Lakewood, Colorado 80215-4440 USA	
.XX .0.1 .XXX .0.02 .XXXX .0.010 .XXXXX .0.0020		ANGLES ± 1° SURF. FINISH 125 RMS		MATERIAL SEE SHT. #1	
SIZE D 1:1	SCALE 1:1	DESIGNED BY K. KLIMEK	DATE 05/12/09	REV B	SHT 2/2
UG DWG.		DRAWN BY K. KLIMEK		PART NO. 777096-947	
				TITLE CASTING, DISPLAY ARM	