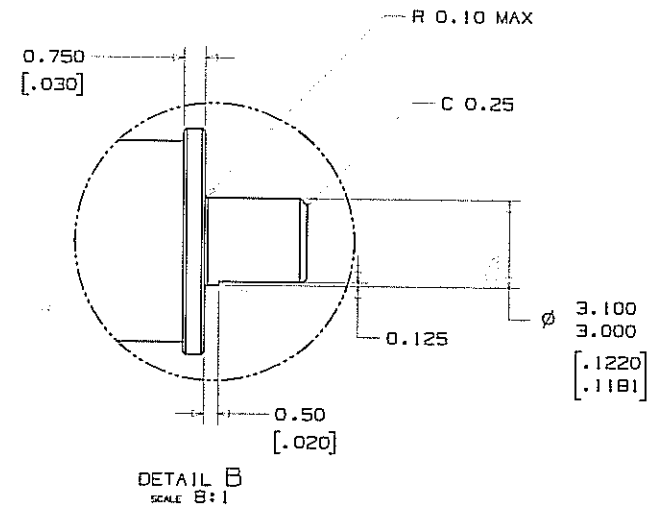
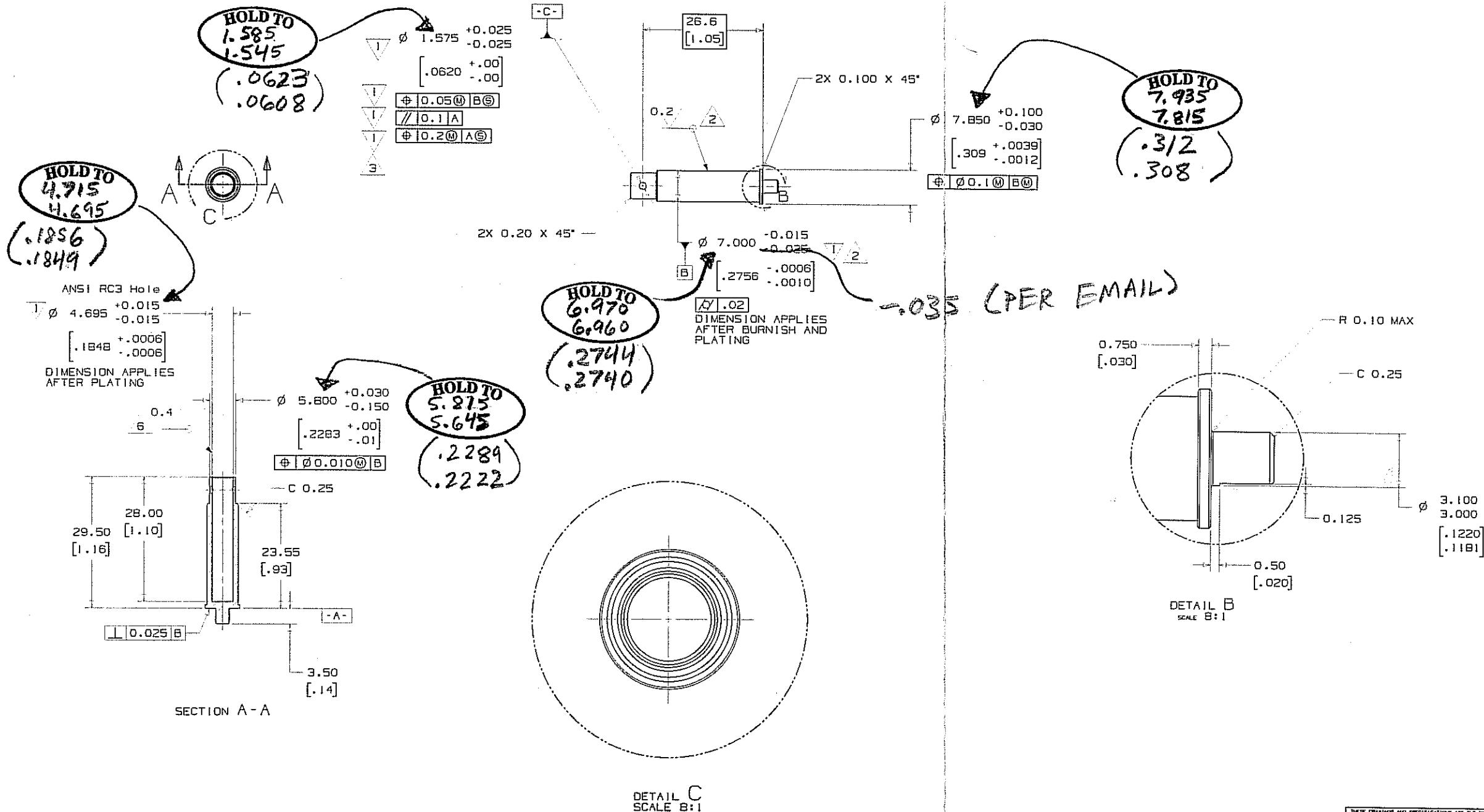


NOTES

1. INDICATES FEATURE/DIMENSION TO BE CHECKED AT INCOMING INSPECTION.
2. ROLLER BURNISH TO FINAL SIZE/FINISH. (INCHES)
3. PLATING: ARMOLOY XADC 0.0002" +/- 0.0001" THICK. LIQUID HONE PART PRIOR TO SURFACE FINISHING.
4. INSPECTION FOR PERPENDICULARITY NOT NEEDED.
5. COAT UNPLATED PARTS WITH A LIGHT OIL FOR CORROSION PROTECTION.
6. INTERNAL SURFACE FINISH APPLIES TO DEPTH OF 12mm.

REV	REVISION DESCRIPTION	BY	DATE	ECO #
01	Prototype Release, replaces 986100-082	LRN	01/27/11	BCT0---



ALLOW  
FOR PLATING  
0.0002 PER  
SURFACE

7-20-11 408

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<p>TOLERANCES UNLESS OTHERWISE SPECIFIED ARE AS FOLLOWS:</p>		<p>ANGLES</p>		<p>MATERIAL</p>		<p>TITLE</p>	
<p>±.001</p>		<p>± 2</p>		<p>4130 OR 4140 Rc 28-32</p>		<p>SHAFT, ROUND RF VALVE, Cr</p>	
<p>±.002</p>		<p>± 1.6</p>		<p>DATE</p>		<p>PART NO.</p>	
<p>±.005</p>		<p>± 1.6</p>		<p>08/08/07</p>		<p>986302-515</p>	
<p>UNIGRAPHICS</p>		<p>SCALE</p>		<p>BY</p>		<p>01</p>	
<p>D</p>		<p>NONE</p>		<p>01</p>		<p>1/1</p>	