

NOTES

1. BREAK ALL SHARP EDGES AND CORNERS .02 MAX.
2. NO BURRS ALLOWED.
3. ▽ INDICATES FEATURE/DIMENSION TO BE CHECKED AT INCOMING INSPECTION.
4. ▽ MASK PRIOR TO ANODIZE.
5. TEFLON IMPREGNATED HARD ANODIZE. MAKE .002 INCH THICK WITH .001 MAX BUILDUP.

GENERAL SPECIFICATIONS FOR ANODIZED PARTS

1. ANODIZE PER MIL-A-8625C

- | | |
|--|--|
| <input type="checkbox"/> TYPE I (CHROMIC ACID ANODIZE) | <input type="checkbox"/> CLASS 1 (NON-DYED) |
| <input type="checkbox"/> TYPE IB (CHROMIC ACID LOW VOLT) | <input type="checkbox"/> CLASS 2 (DYED) |
| <input type="checkbox"/> TYPE II (SULFURIC ACID ANODIZE) | <input checked="" type="checkbox"/> COLOR: BLACK |
| <input checked="" type="checkbox"/> TYPE III (HARD ANODIC COATING) | <input type="checkbox"/> 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.)

- | |
|--|
| <input checked="" type="checkbox"/> (TYPE III) .002 |
| <input type="checkbox"/> (TYPE II) CLASS 2) .0003 TO .0009 |
| <input type="checkbox"/> (TYPE II) CLASS 1) .0001 TO .0007 |
| <input type="checkbox"/> OTHER: |

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.

- | |
|--|
| <input type="checkbox"/> DO NOT MASK |
| <input checked="" type="checkbox"/> MASKING REQUIRED IN 2 PLACES. SEE NOTE 4 |

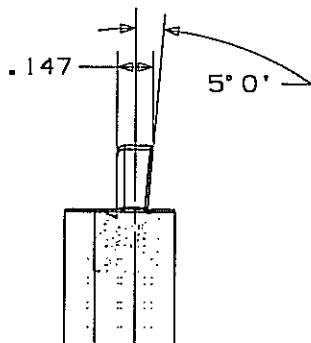
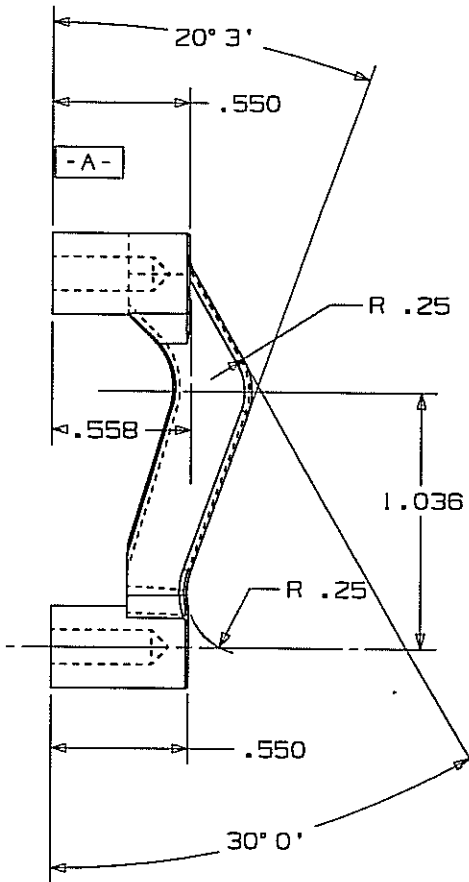
5. RACKING POINTS

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).

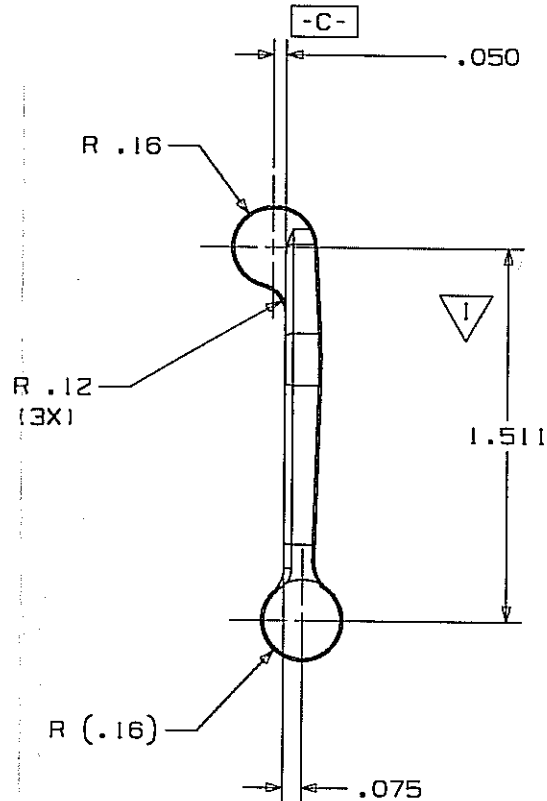
- | |
|--|
| <input type="checkbox"/> RACK ONLY ON FEATURES INDICATED BY NOTE |
|--|

6. SEALING (IF UNSPECIFIED, SEAL WITH WATER)

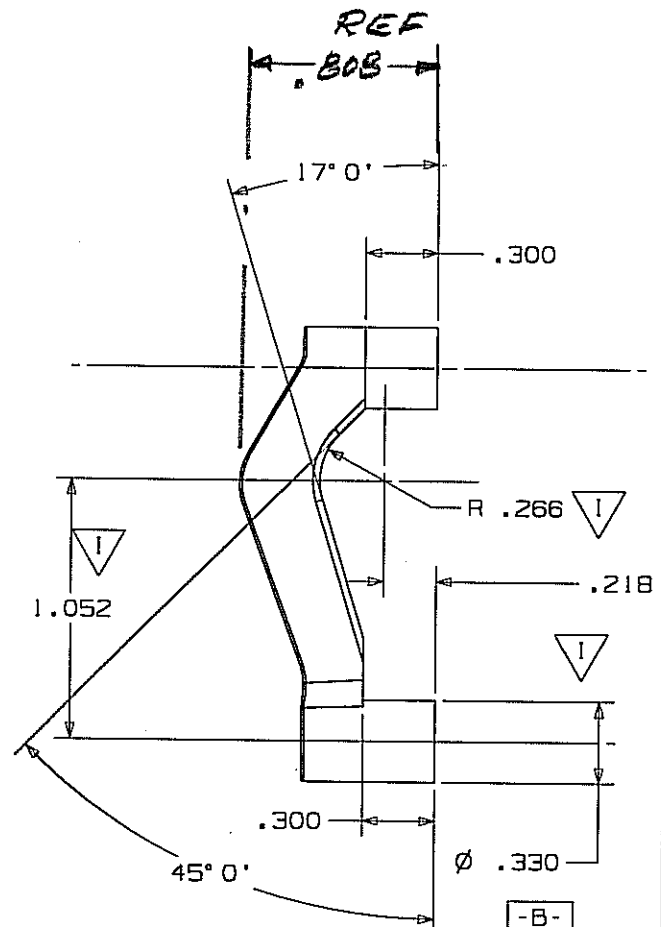
- | |
|--|
| <input checked="" type="checkbox"/> NICKEL ACETATE |
| <input type="checkbox"/> DO NOT SEAL (ONLY FOR TYPE III FOR MAXIMUM WEAR RESISTANCE) |
| <input type="checkbox"/> OTHER: |



DRILL & TAP FOR #6-32
UNC TH'D, 8 TH'D MIN (2X)
DO NOT BREAK THRU



ALLOW
FOR PLATING
.001 PER
SURFACE



6-15-09 408

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	INITIAL RELEASE	JCW	07/18/02	BCT010701

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TOLERANCES AND SYMBOLS PER ASME Y14.5M-1992 DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		MATERIAL ALUMINUM 6061-T6	
.X± 0.10 .XX± 0.01 .XXX± 0.005 .XXXX± 0.0020		ANGLES ± SURF. FINISH 125		ORIGINATOR DATE	
SIZE C 2:1		SCALE DO NOT SCALE DWG		DRAWN J WALKER	
DATE 08/05/07		DATE 08/05/07		PART NO. 777098-149	
REV A		SHT 1		OF 1	

UNIGRAPHICS
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