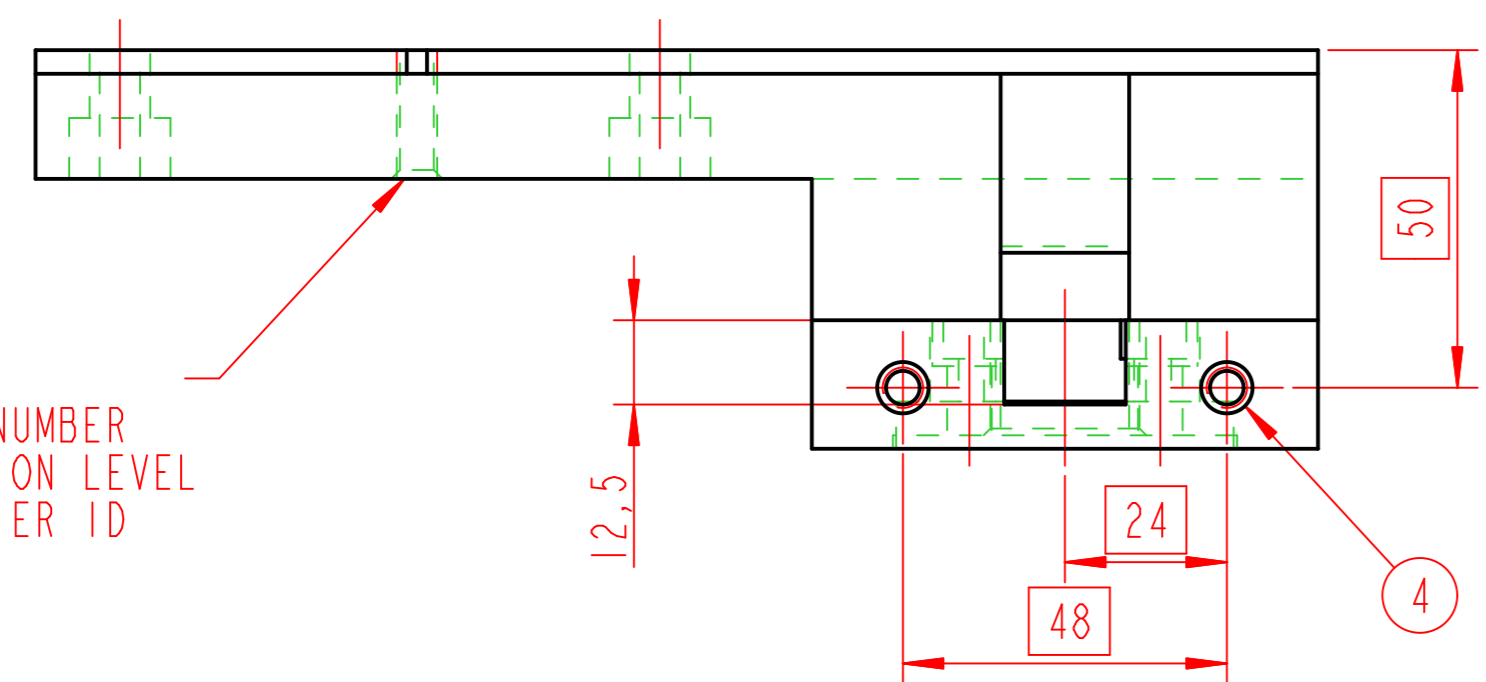
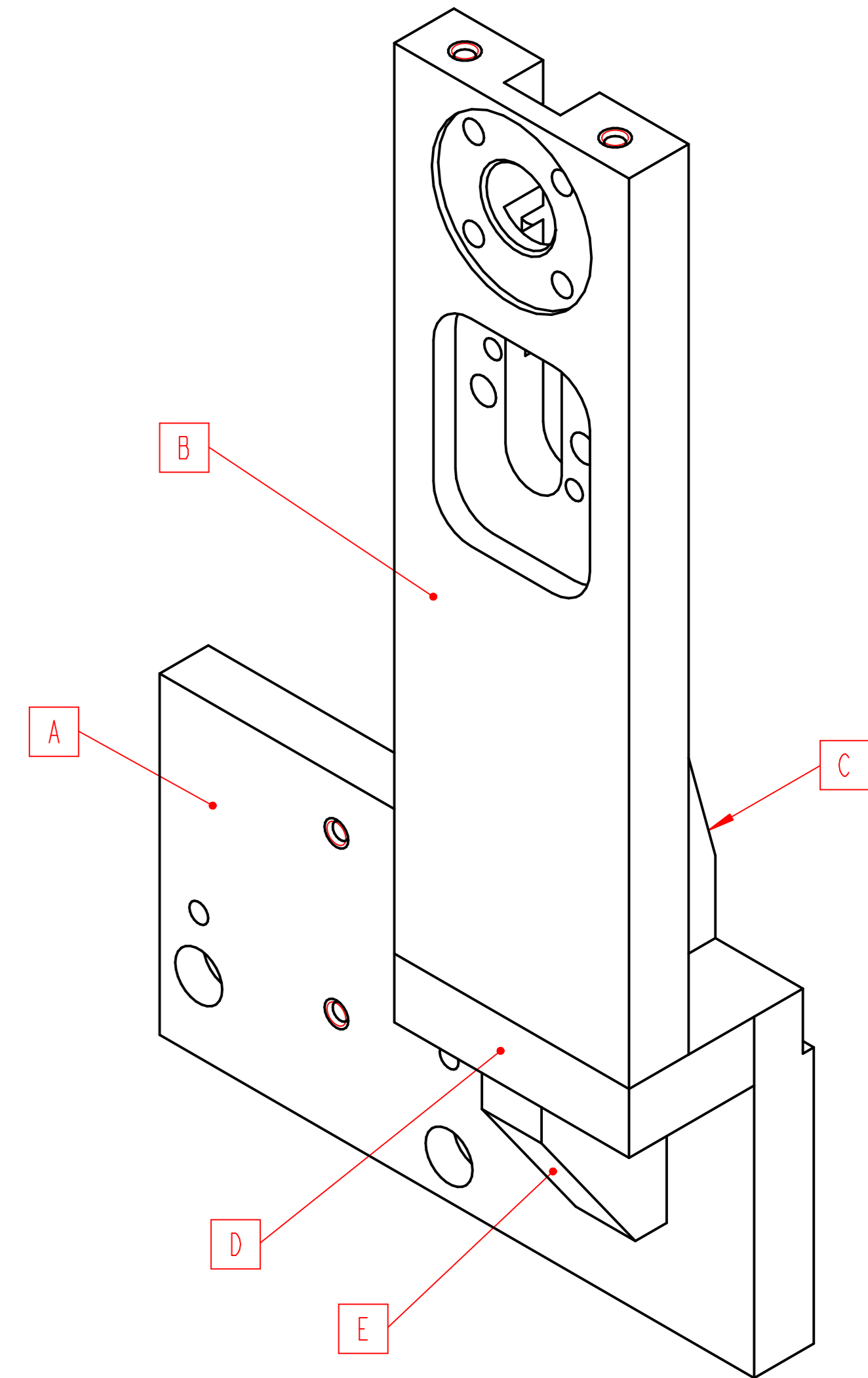
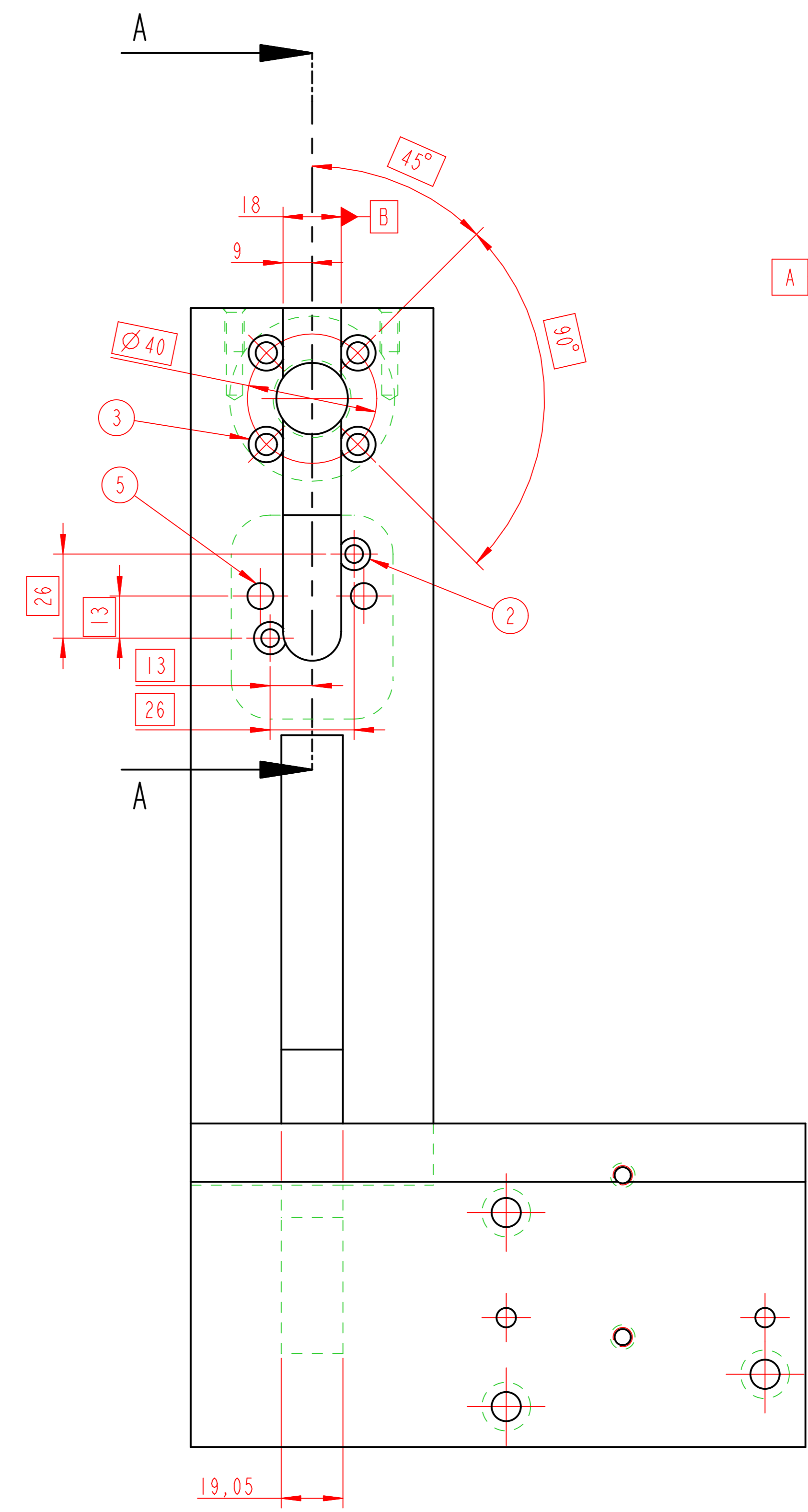
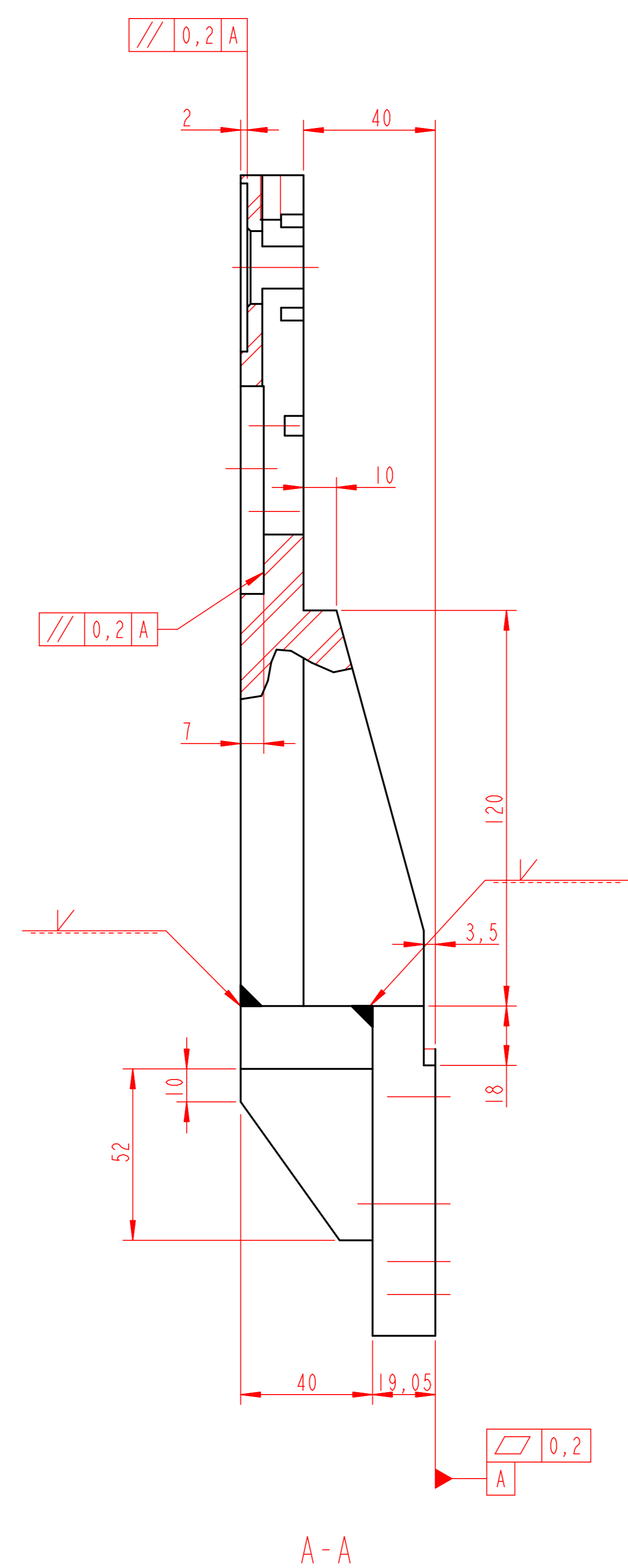
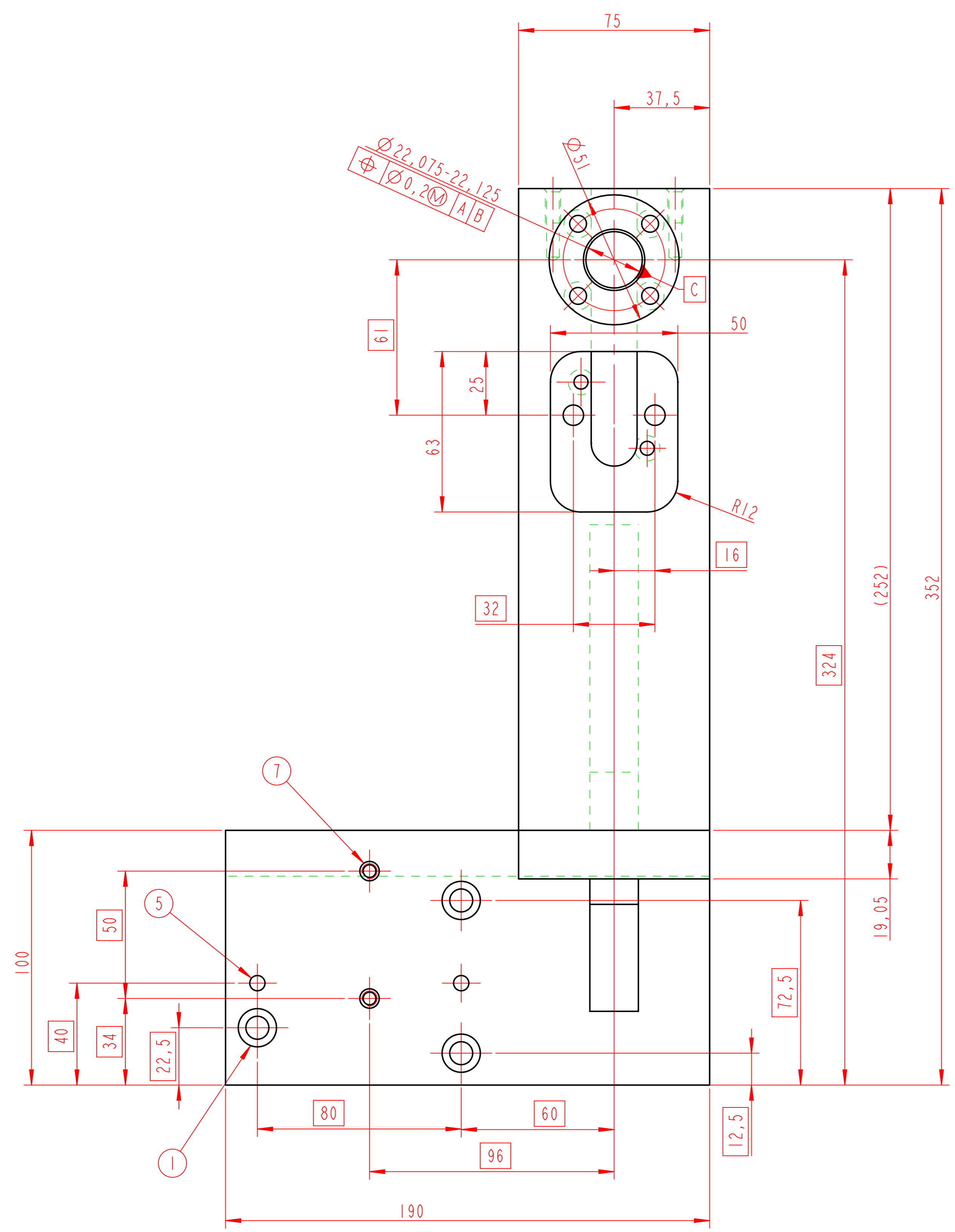


MARK:
PART NUMBER
REVISION LEVEL
SUPPLIER ID



ITEM Pos.	QTY Stck	PART NAME BENENNUNG	MATERIAL SIZE Rohmaße	MATERIAL Werkstoff
A	1	DETAIL 1	22 X 100 X 190	1018
B	1	DETAIL 2	19,05 X 75 X 252	1018
C	1	DETAIL 3	19,05 X 40 X 120	1018
D	1	DETAIL 4	19,05 X 40 X 75	1018
E	1	DETAIL 5	19,05 X 40 X 52	1018

HOLE BOHRUNG	GRID GITTER	INTER SECT / ABSCHNITT	DESCRIPTION BESCHREIBUNG	*-AT ASSEMBLY
1			3X Ø9-9,22 THRU; \perp Ø15-15,27 ∇ 9	\oplus Ø 0,5 A B C
2			2X Ø5,5-5,68 THRU; \perp Ø10-10,22 ∇ 5,7	\oplus Ø 0,25 A B C
3			4X Ø6,6-6,82 THRU; \perp Ø11-11,27 ∇ 6,8	\oplus Ø 0,3 A B C
4			2X Ø5 ∇ 26,9; ∇ Ø7,6x90°; M6X1-6H PLUG TAP ∇ 13,5	\oplus Ø 0,3 A B C
5			2X Ø5,5 THRU; *Ø5,9 MACHINE REAM; *Ø6 FIN. HAND REAM FOR <>	\oplus Ø 1 A B C
6			2X Ø8 THRU	\oplus Ø 1 A B C
7			2x Ø5 THRU; ∇ Ø7,6x90°; M6X1-6H PLUG TAP THRU	\oplus Ø 0,3 A B C



WELDING NOTES
UNLESS OTHERWISE SPECIFIED:
A. WIP-BEAD SHALL BE 150 mm ± 5. EXCEPT EXTERIOR CORNER WELDS AND LAPPED RELIEFS, WELDS ARE WELDED CONTINUOUS AND DESIGNED TO A UNIFORM APPEARANCE.
B. WELD SIZE TO BE IN THE THICKNESS OF THE THINNER MATERIAL.
C. WELD AND GROUW SMOOTH RELL LOCATING HOLES AND TAPS.
GENERAL DIMENSION TOLERANCES
DIMENSION TYPE TOLERANCE
FORMED PARTS ±0.15 mm
FILL PARTS ±0.30 mm
HOLE ±0.15 mm

BLACK PENTRATE

Measure	0.5-8	8-20	20-120	120-400	400-1000	1000-2000	2000-4000	5
Minimum Interval	±0.1	±0.2	±0.3	±0.4	±0.5	±0.7	±0.8	4
Length/Length	0-10	10-30	30-120	120-400	400+			3
Interval/Interval	±0°	±0°50'	±0°50'	±0°10'	±0°15'			2

Material: AS NOTED
Heat Treat-Hardness: STRESS RELIEVE
Surface Treatment: ROCHESTER
Gleason

Revision: 01/01/70
Material No. 1366046