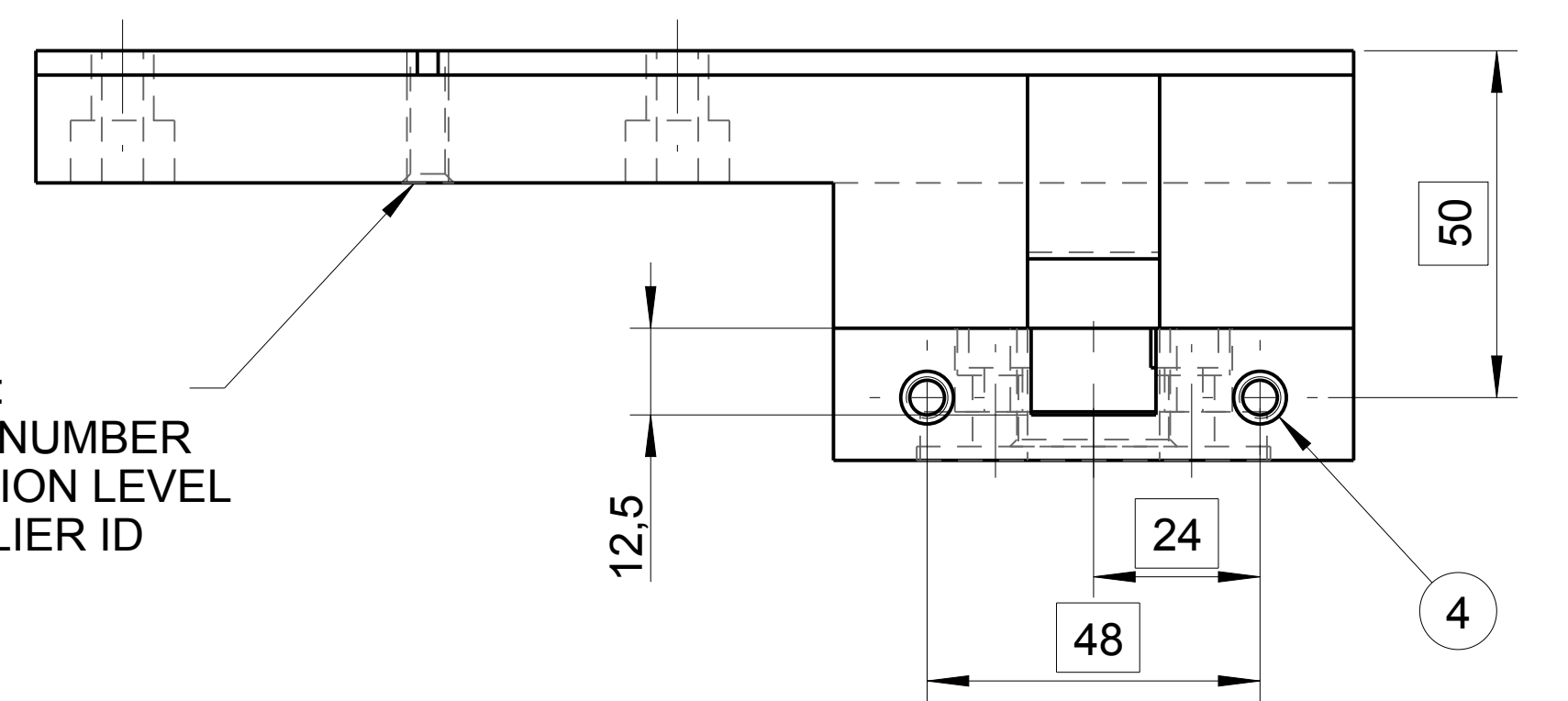
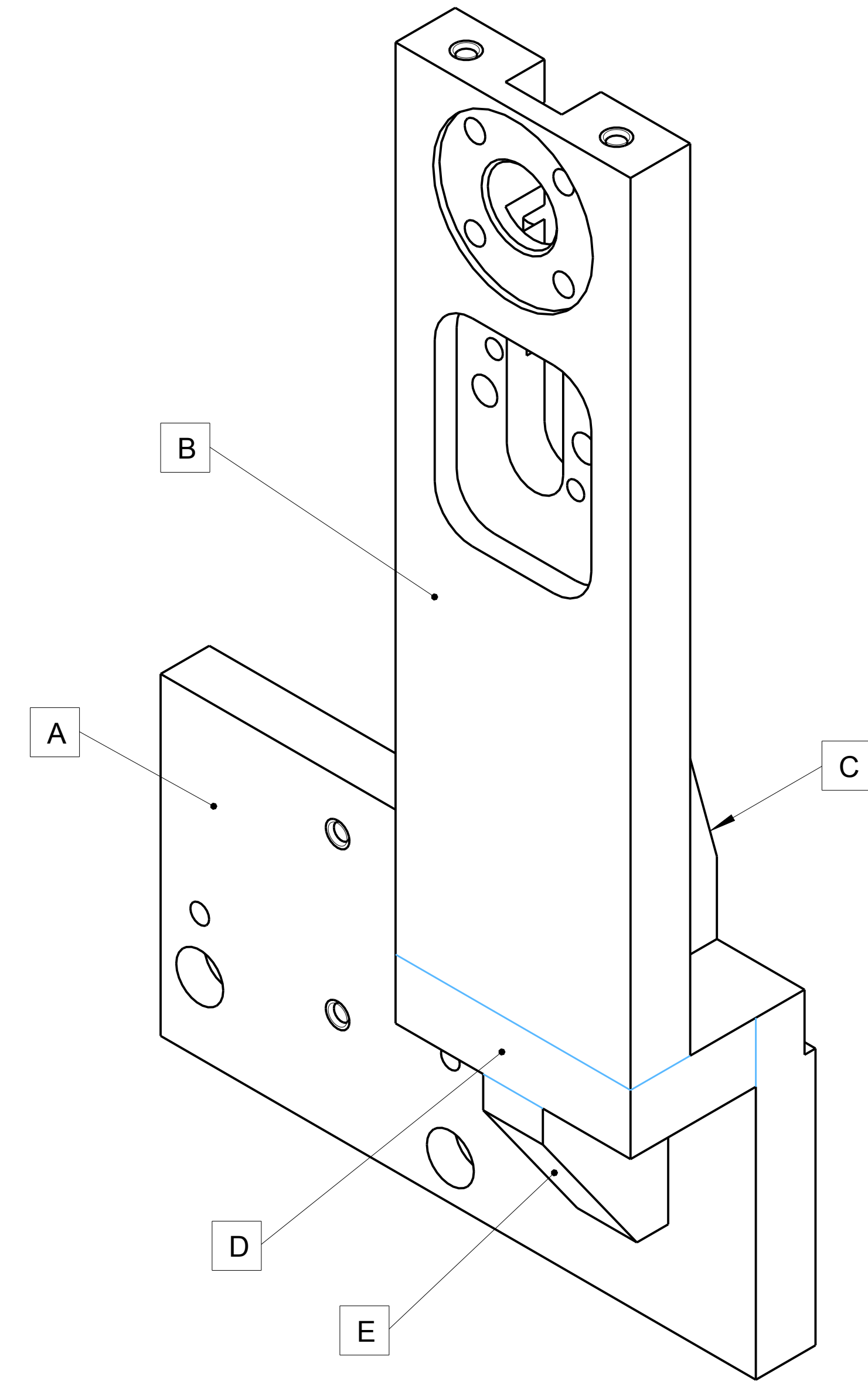
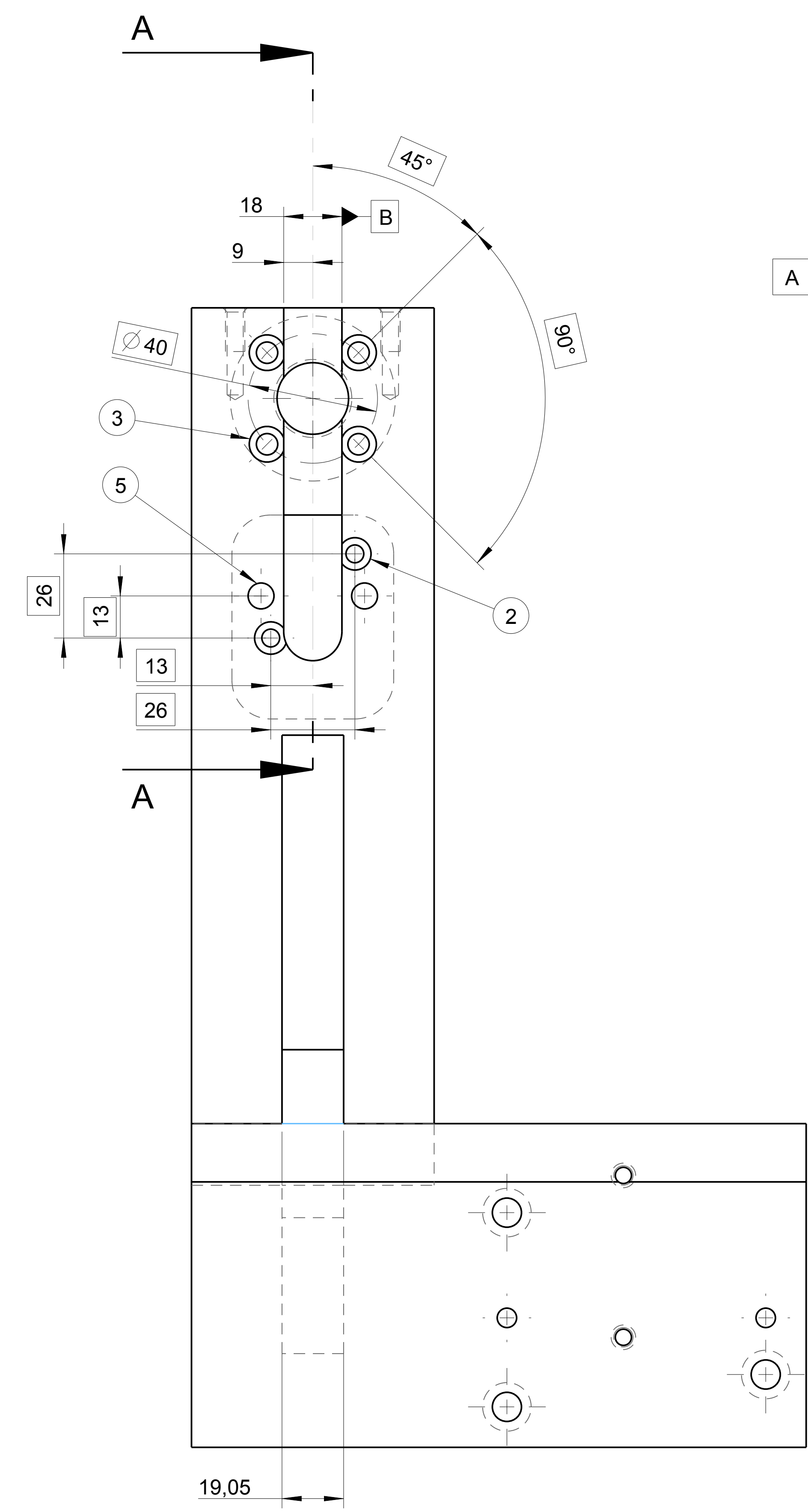
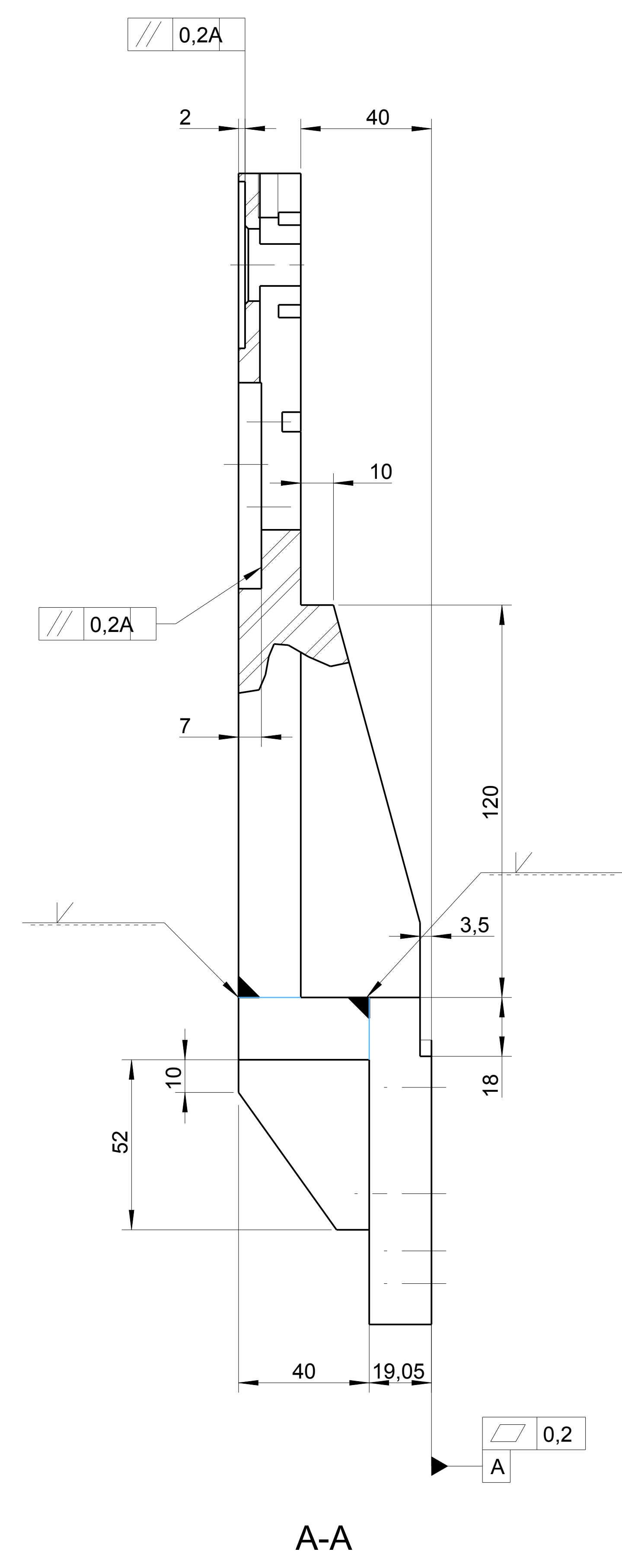
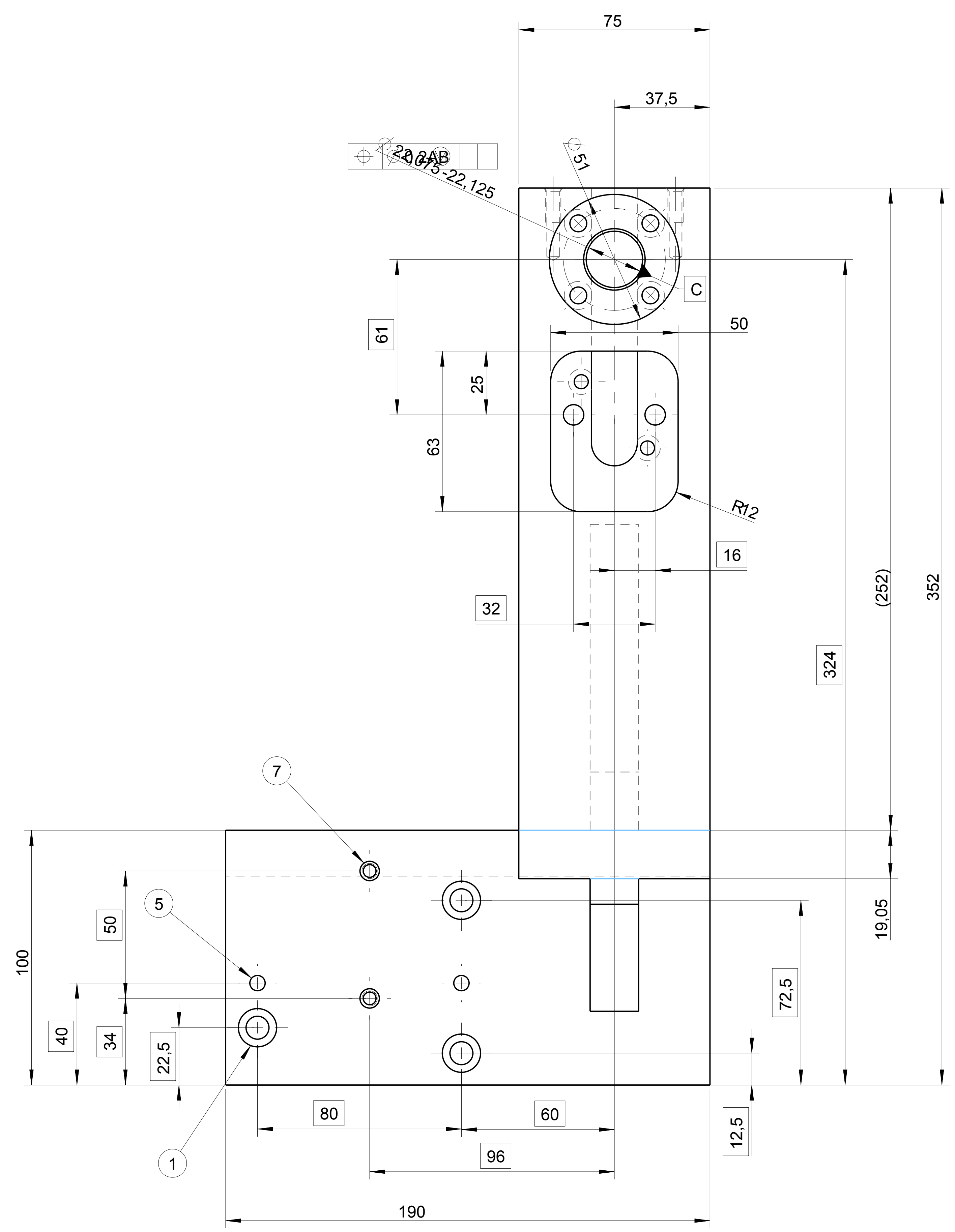


MARK:  
PART NUMBER  
REVISION LEVEL  
SUPPLIER ID



ITEM Pos.	QTY Stck	PART NAME BENENNUNG	MATERIAL SIZE Rohmabe	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

HOLEGRID BOHRUNG	INTER SECT / ABSCH NITT	DESCRIPTION BESHREIBUNG-AT ASSEMBLY	
1		3X 9;9,22 THRU; 15-15,27 9	$\oplus \parallel 0,5$ A B C
2		2X 5;5-5,68 THRU; 10-10,27 5,7	$\oplus \parallel 0,25$ A B C
3		4X 6;6-6,82 THRU; 11-11,27 6,8	$\oplus \parallel 0,3$ A B C
4		2X 5;26,9; 7,6X90°; M6X1-6H PLUG TAP 13,5	$\oplus \parallel 0,3$ A B C
5		2X 5;5 THRU; *5,9 MACHINE REAM;*6 FIN; HAND REAM FOR <=>	$\oplus \parallel 1$ A B C
6		2X 8 THRU	$\oplus \parallel 1$ A B C
7		2x 5 THRU; 7,6X90°; M6X1-6H PLUG TAP THRU	$\oplus \parallel 0,3$ A B C



**WELDING NOTES**  
UNLESS OTHERWISE SPECIFIED:  
A. SHIP WELD SIZE EVERY 100 mm, EXCEPT EXTERIOR CORNER WELDS AND LASER REELS WHICH ARE WELDED CONTINUOUS AND DRESSED TO A UNIFORM APPEARANCE.  
B. WELD SIZE TO BE 1X THE THICKNESS OF THE THINNEST MATERIAL.  
C. WELD AND GRIND SMOOTH ALL LOCATING HOLES AND PINS.

**BLACK PENTRATE**

Measure	0.5-8	8-30	30-120	120-400	400-1000	1000-2000	2000-4000	5
Tolerance	±0.1	±0.2	±0.3	±0.6	±1.2	±2.0	±2.0	4
Length	0-10	10-80	80-120	120-400	400+	400+	400+	3
Deviation	±1	±0.30	±0.20	±0.10	±0.15	-	-	2

Material	AS NOTED	Revision	Modification	Date	Modification by	Responsible
Werkstoff	AS NOTED	0		8/1/10	P. WOERNER	D. DELANEY

Heat Treat Address	STRESS RELIEVE	Revision	Modification	Date	Modification by	Responsible
Wärmebehandlung <td>STRESS RELIEVE</td> <td>0</td> <td></td> <td></td> <td></td> <td></td>	STRESS RELIEVE	0				

Part/Stock	ROCHESTER	Supplier Part	Designation	BRACKET-MOUNTING-STEADYREST
		Machine	210H	Designation

Format	Units	Scale	Sheet	of
FORMED PARTS	mm	1:1	1	1

CAD PROJEKT  
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