

SECTION A-A

NOTES:

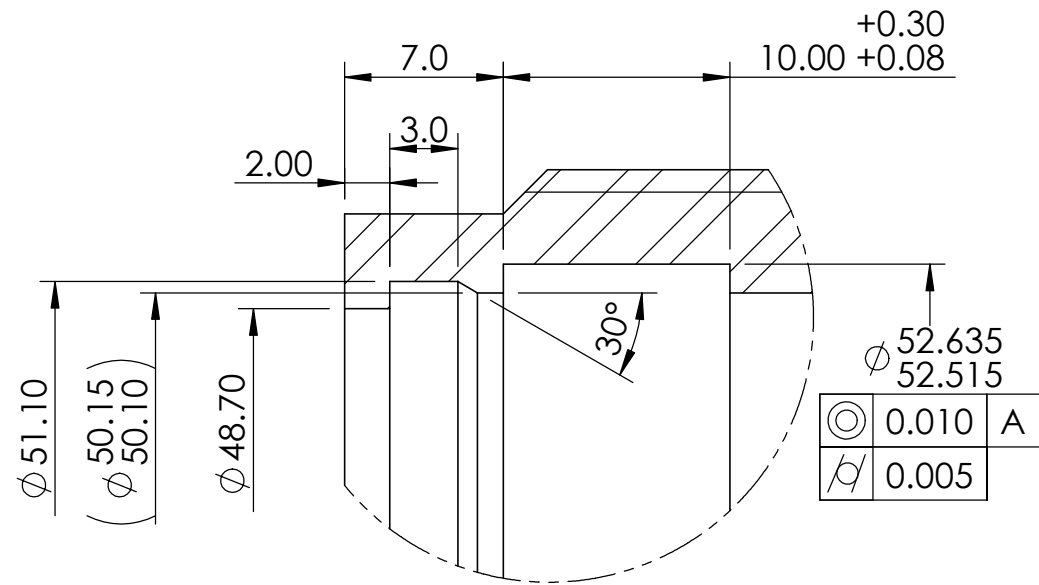
1. MATERIAL- AISI 4130 LOW ALLOY STEEL BAR.
2. CONDITION:
  - QUENCHED AND TEMPERED.
  - 95 KSI MIN TENSILE STRENGTH.
  - 80KSI MIN YIELD STRENGTH.
  - 22 HRC MAX.
  - CARBON CONTENT 0.30% MAX.
3. TURNING DETAILS ONLY ON SHEET 1 & 2. MILLING & DRILLING SHOWN ON SHEET 3.

Rev	ECN No	Description	Date	Drawn by	Checked by
04.0	0398	INTERNAL RAD IN DETAIL C SPECIFIED	07/09/2017	CCr	RLG
03.0	0136	TOL RING GROOVES WERE $\phi 52.47/52.35$	01/10/2013	AR	RLG
02.0	0117	SEE ECN 0117, MATERIAL SPEC CHANGED	21/06/2013	IMI	AC
01.1	--	MAT'L SPEC CLARIFIED, $\phi$ CHANGED	03/06/2013	IMI	AC
01.0	--	FIRST ISSUE	06/09/2013	IMI	RMC

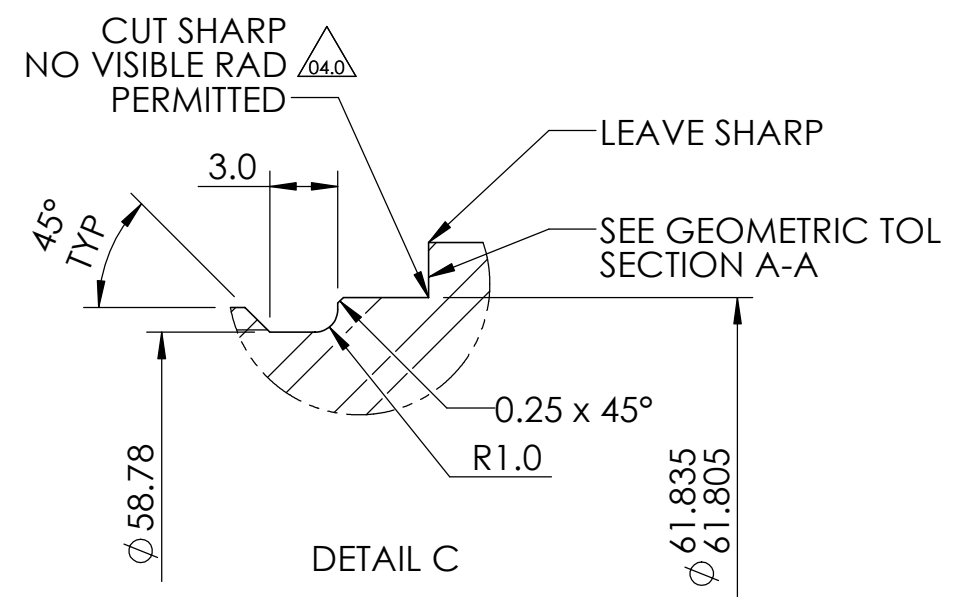
General Limits  
unless otherwise stated

Break Sharp Corners	x.xxx [x.xxx] ± 0.02
0.25	
Fillet Radii 0.8	x.xx [x.xxx] ± 0.1
T.I.R. 0.25	
Parallelism 1 in 250	x.x [x.xxx] ± 0.25
Squareness 1 in 250	
Angular Degree ± 0.5	
Surface 1.6 RA	x [x.xxx] ± 0.5

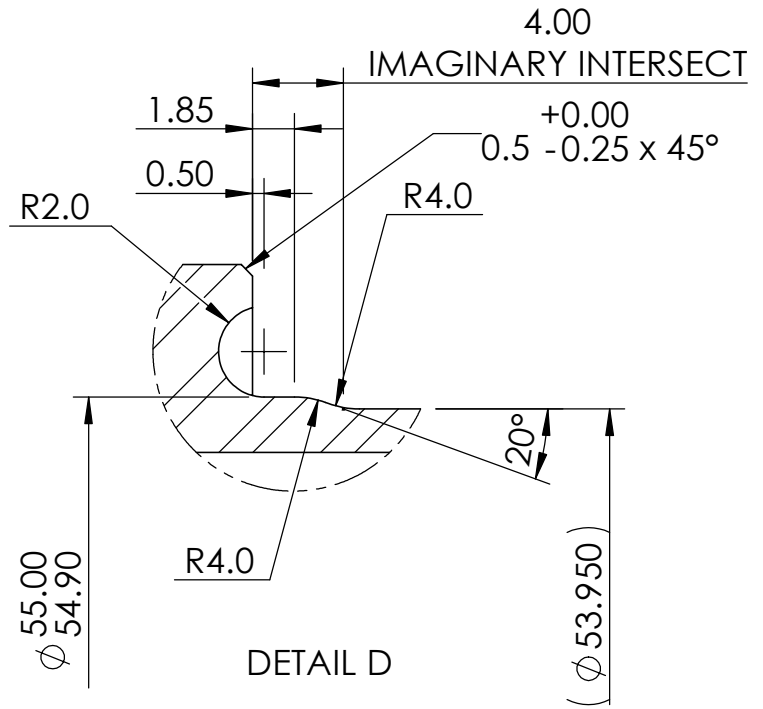
MATERIAL/B.O.M. SEE NOTES		FINISH NONE		HEAT TREATMENT NONE	
DESIGNED BY			CHECKED BY		
PROJECT			TITLE/NAME		
PROJECTION 		SHEET SIZE A3 PRINT FULL SIZE		DRAWING NUMBER 002563	
REVISION 04.0				SHEET 1 of 3	



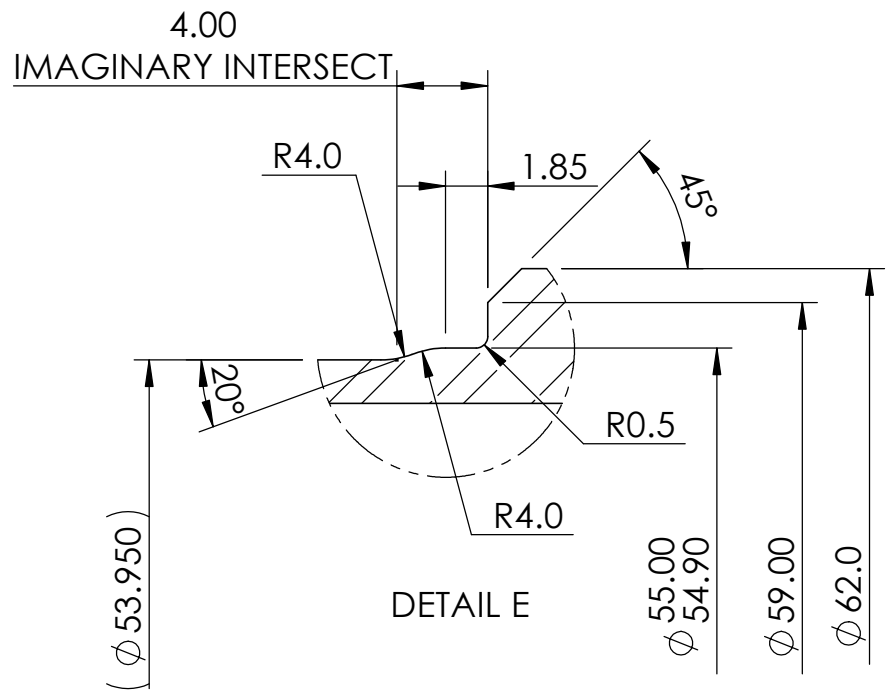
DETAIL B



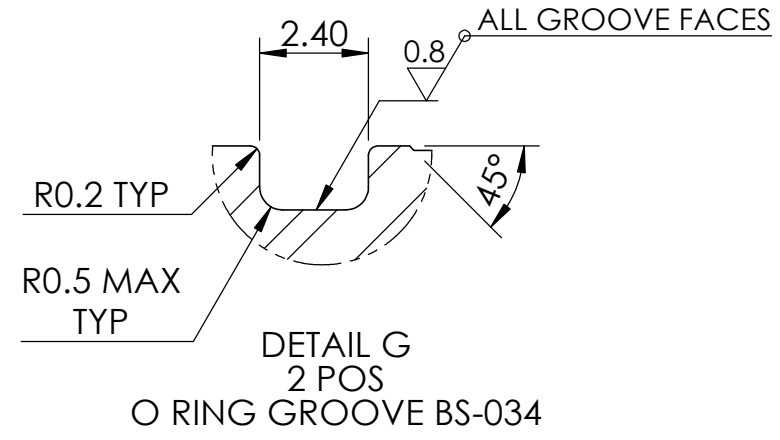
DETAIL C



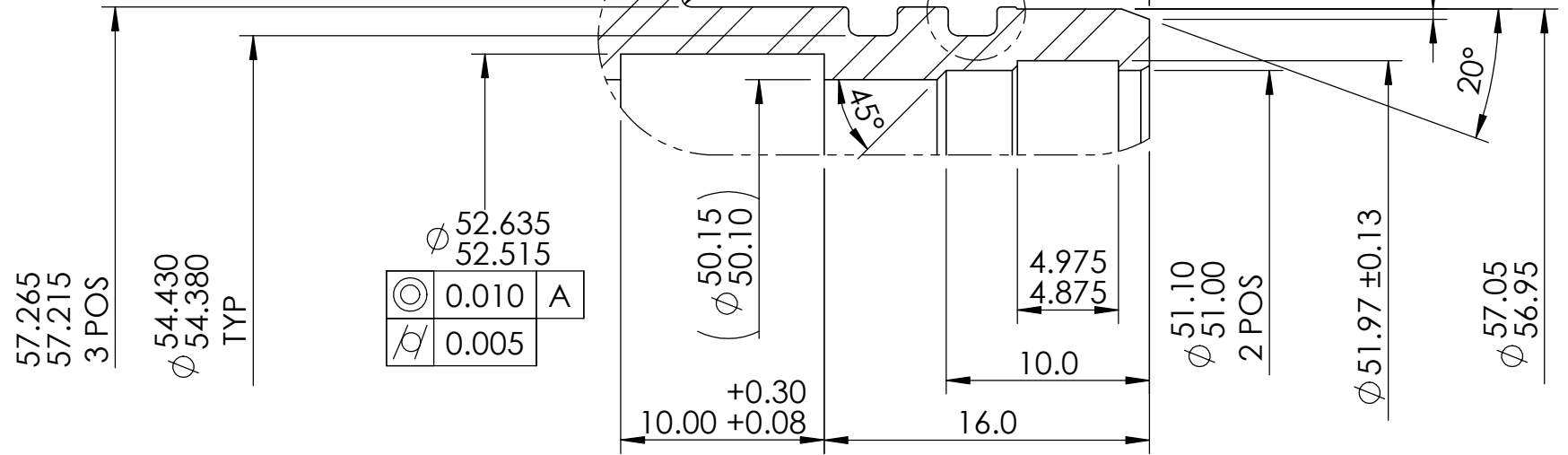
DETAIL D



DETAIL E



DETAIL G  
O RING GROOVE BS-034



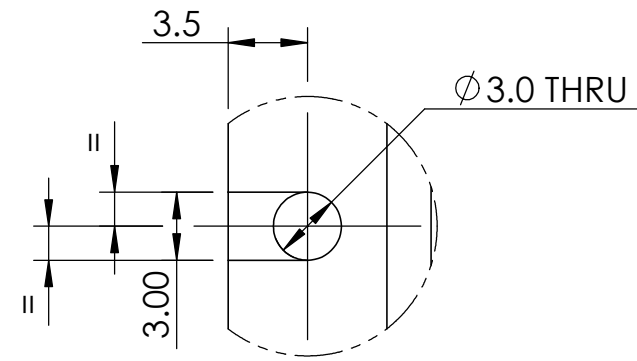
DETAIL F

Rev	ECN No	Description	Date	Drawn by	Checked by
04.0	0398	INTERNAL RAD IN DETAIL C SPECIFIED	07/09/2017	CCr	RLG
03.0	0136	TOL RING GROOVES WERE $\phi$ 52.47/52.35	01/10/2013	AR	RLG
02.0	0117	SEE ECN 0117, MATERIAL SPEC CHANGED	21/06/2013	IMI	AC
01.1	--	MAT'L SPEC CLARIFIED, $\phi$ CHANGED	03/06/2013	IMI	AC
01.0	--	FIRST ISSUE	06/09/2013	IMI	RMC

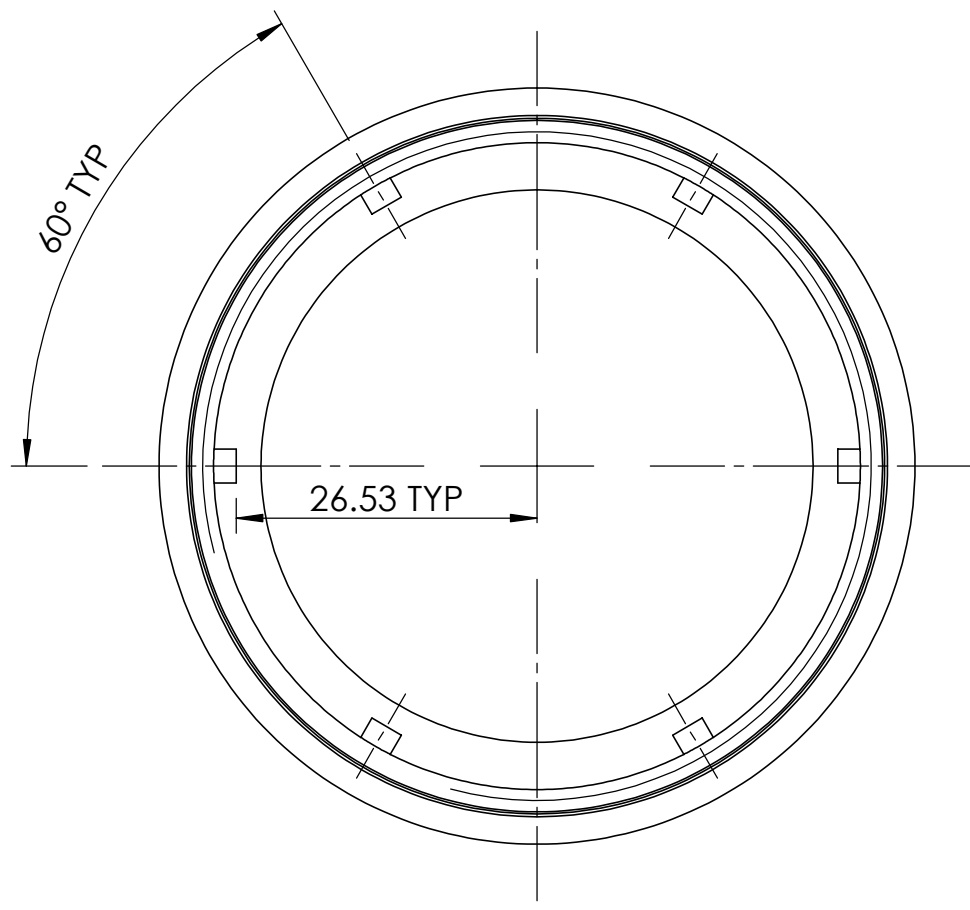
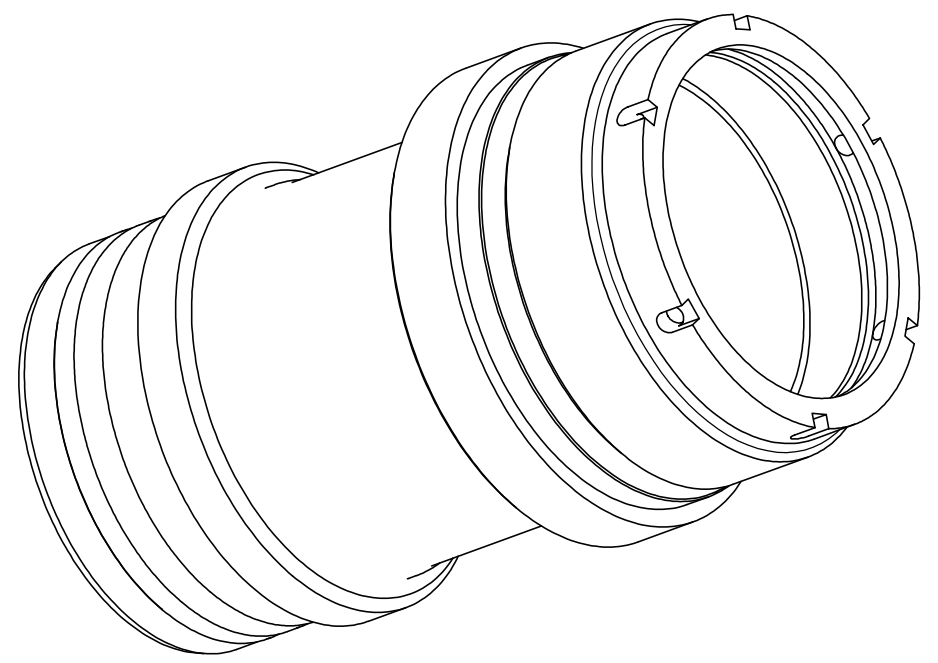
**General Limits**  
unless otherwise stated

Break Sharp Corners	x.xxx [x.xxx] ± 0.02
0.25	
Fillet Radii 0.8	x.xx [x.xxx] ± 0.1
T.I.R. 0.25	
Parallelism 1 in 250	x.x [x.xxx] ± 0.25
Squareness 1 in 250	
Angular Degree ± 0.5	
Surface 1.6 RA	x [x.xxx] ± 0.5

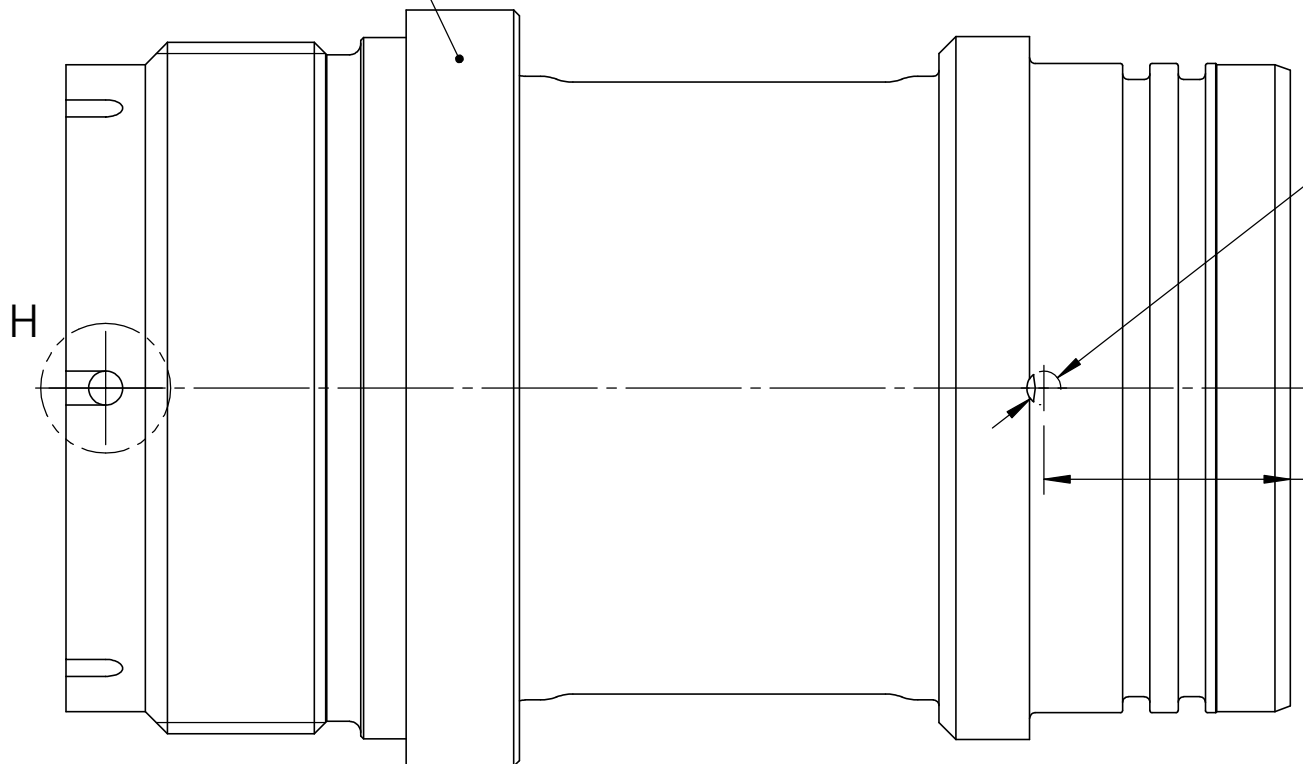
<b>MATERIAL/B.O.M.</b> SEE NOTES		<b>FINISH</b> NONE		<b>HEAT TREATMENT</b> NONE	
<b>DESIGNED BY</b>			<b>CHECKED BY</b>		
<b>PROJECT</b>			<b>TITLE/NAME</b>		
<b>PROJECTION</b> FIRST ANGLE		<b>SHEET SIZE</b> A3 PRINT FULL SIZE		<b>DRAWING NUMBER</b> 002563	
<b>REVISION</b> 04.0				<b>SHEET</b> 2 of 3	



DETAIL H  
6 POS EQUISPACED



ETCH:  
PART No.,  
REVISION,  
ORDER No.



□  $\phi 3.0$   
TO  $\phi 57.215$  (DETAIL F)  
1 POS,  
ORIENTATION NOT CRITICAL

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Rev	ECN No	Description	Date	Drawn by	Checked by

**General Limits**  
unless otherwise stated

Break Sharp Corners	0.25	x.xxx [x.xxx] $\pm 0.02$
Fillet Radii	0.8	x.xx [x.xxx] $\pm 0.1$
T.I.R.	0.25	x.x [x.xxx] $\pm 0.25$
Parallelism	1 in 250	x [x.xxx] $\pm 0.5$
Squareness	1 in 250	x [x.xxx] $\pm 0.5$
Angular Degree	$\pm 0.5$	
Surface	1.6 RA	

<b>MATERIAL/B.O.M.</b> SEE NOTES		<b>FINISH</b> NONE		<b>HEAT TREATMENT</b> NONE	
<b>DESIGNED BY</b>			<b>CHECKED BY</b>		
<b>PROJECT</b>			<b>TITLE/NAME</b>		
<b>PROJECTION</b> FIRST ANGLE	<b>SHEET SIZE</b> A3 PRINT FULL SIZE	<b>DRAWING NUMBER</b> 002563		<b>REVISION</b> 04.0	<b>SHEET</b> 3 of 3

DATE DRAWN  
08/03/2013