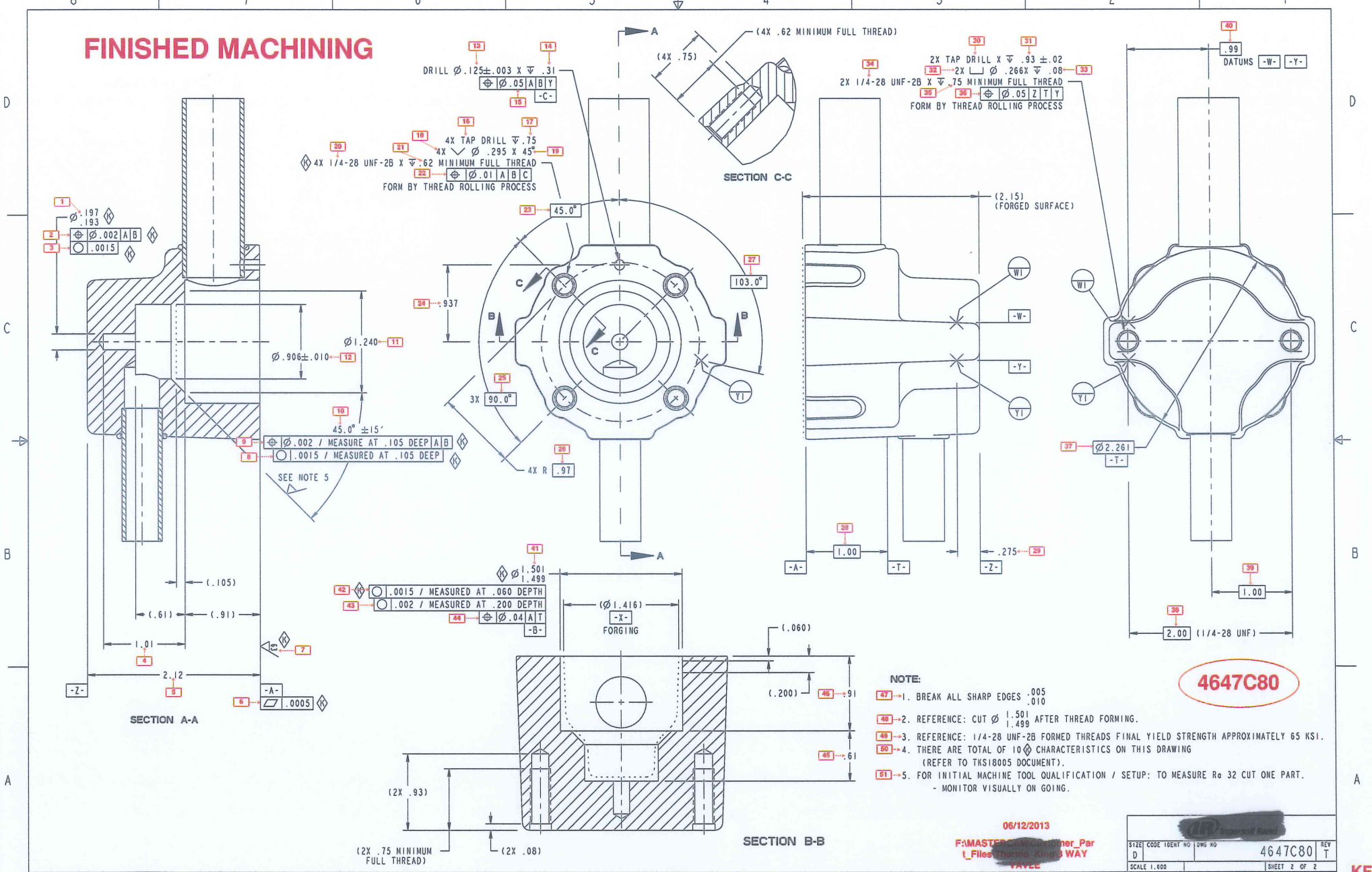


# FINISHED MACHINING



DRILL  $\phi .125 \pm .003$  X  $\nabla .31$   
 $\phi .05$  A|B|Y  
 -C-

4X TAP DRILL  $\nabla .75$   
 4X  $\nabla \phi .295$  X  $45^\circ$   
 4X 1/4-28 UNF-2B X  $\nabla .62$  MINIMUM FULL THREAD  
 $\phi .01$  A|B|C  
 FORM BY THREAD ROLLING PROCESS

SECTION C-C

2X TAP DRILL X  $\nabla .93 \pm .02$   
 2X  $\nabla \phi .266$  X  $\nabla .08$   
 2X 1/4-28 UNF-2B X  $\nabla .75$  MINIMUM FULL THREAD  
 $\phi .05$  Z|T|Y  
 FORM BY THREAD ROLLING PROCESS

DATUMS -W- -Y-

SECTION A-A

SECTION B-B

**4647C80**

- NOTE:**
- 1. BREAK ALL SHARP EDGES  $.005$   $.010$
  - 2. REFERENCE: CUT  $\phi 1.501$  AFTER THREAD FORMING.
  - 3. REFERENCE: 1/4-28 UNF-2B FORMED THREADS FINAL YIELD STRENGTH APPROXIMATELY 65 KSI.
  - 4. THERE ARE TOTAL OF 10 CHARACTERISTICS ON THIS DRAWING (REFER TO TKS18005 DOCUMENT).
  - 5. FOR INITIAL MACHINE TOOL QUALIFICATION / SETUP: TO MEASURE R<sub>a</sub> 32 CUT ONE PART. - MONITOR VISUALLY ON GOING.

06/12/2013  
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 t\_Files...S WAY  
 TAYLOR

SIZE	CODE	IDENT NO	DWG NO	REV
D			4647C80	T
SCALE 1.000			SHEET 2 OF 2	

KF