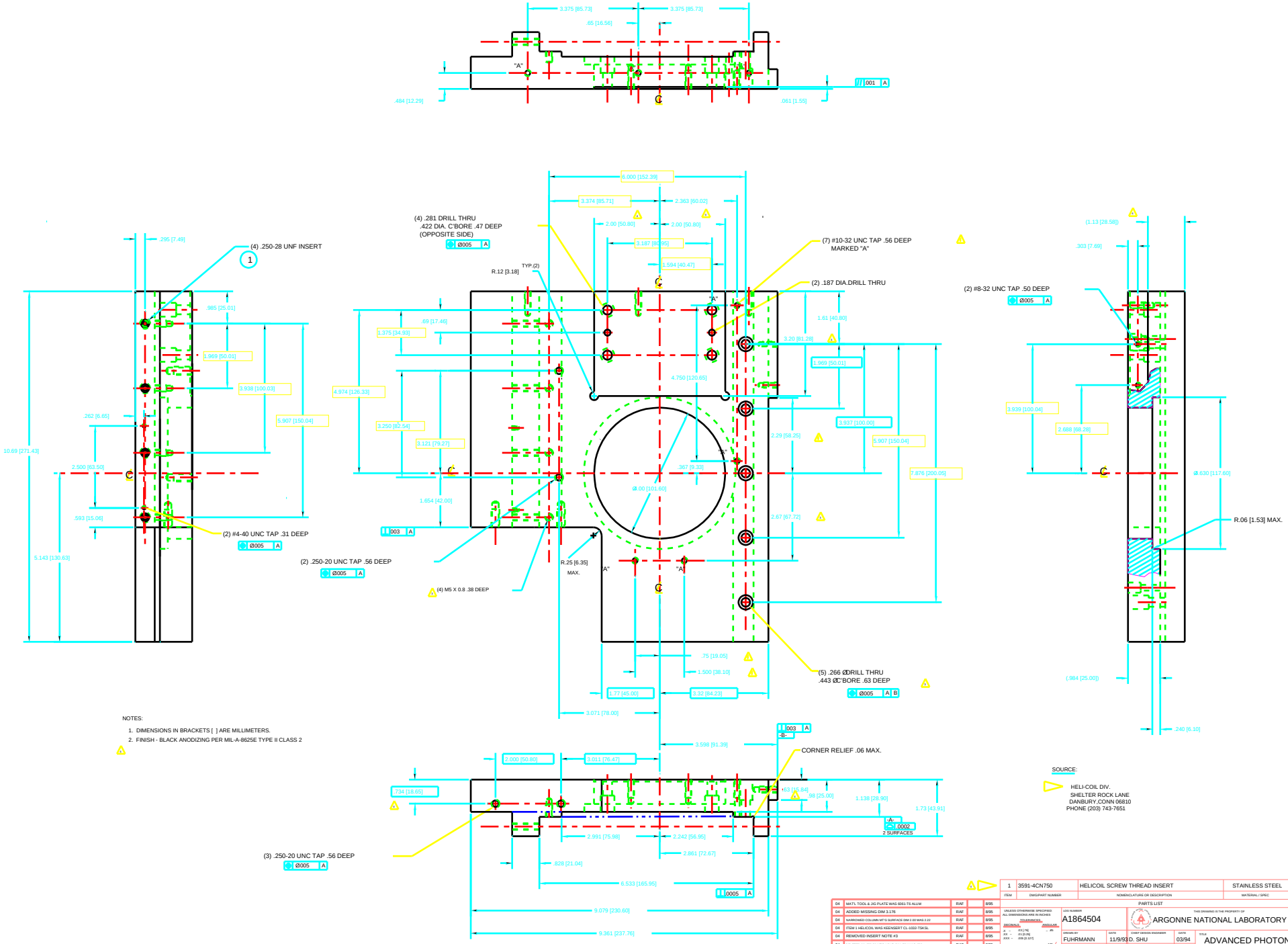
(4) .250-28 UNF INSERT
(4) .281 DRILL THRU
.422 DIA. C'BORE .47 DEEP
(OPPOSITE SIDE)
(7) #10-32 UNC TAP .56 DEEP
MARKED "A"
(2) .187 DIA.DRILL THRU
(2) #8-32 UNC TAP .50 DEEP
(2) #4-40 UNC TAP .31 DEEP
(2) .250-20 UNC TAP .56 DEEP
(4) M5 X 0.8 .38 DEEP
(5) .266 ØDRILL THRU
.443 ØC'BORE .63 DEEP
R.12 [3.18]
TYP.(2)
R.25 [6.35]
MAX.
R.06 [1.53] MAX.
CORNER RELIEF .06 MAX.
(3) .250-20 UNC TAP .56 DEEP
2 SURFACES
SOURCE:
HELI-COIL DIV.
SHELTER ROCK LANE
DANBURY,CONN 06810
PHONE (203) 743-7651
NOTES:
1. DIMENSIONS IN BRACKETS [ ] ARE MILLIMETERS.
2. FINISH - BLACK ANODIZING PER MIL-A-8625E TYPE II CLASS 2
ITEM | DWG/PART NUMBER | NOMENCLATURE OR DESCRIPTION | MATERIAL / SPEC | QTY
1 | 3591-4CN750 | HELICOIL SCREW THREAD INSERT | STAINLESS STEEL | 4
PARTS LIST
REVISIONS
04 | MAT'L TOOL & JIG PLATE WAS 6061-T6 ALUM | RAF | 8/95
04 | ADDED MISSING DIM 3.176 | RAF | 8/95
04 | NARROWED COLUMN MT'G SURFACE DIM 2.00 WAS 2.22 | RAF | 8/95
04 | ITEM 1 HELICOIL WAS KEENSERT CL-1032-TGK3L | RAF | 8/95
04 | REMOVED INSERT NOTE #3 | RAF | 8/95
04 | DELETED (1) .260-20 MT'G HOLE, DIM .734 WAS .600 | RAF | 8/95
04 | CUTOUT .28 X 1.13 INTERF. W/ BOTTOM PLATE | RAF | 8/95
03 | MISSING DIM. | RAF | 11/94
02 | REDESIGNED FOR SCHNEEBERGER LINEAR BEARINGS | RAF | 8/94
01 | MISSING DIM. | RAF | 5/94
01 | QTY (7) WAS (2) (#10-32 TAP) | RAF | 5/94
SYM | CHANGE DESCRIPTION | BY | CHKD | DATE
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS .XX ± .01 [.76] .XXX ± .010 [0.25] .XXX ± .005 [0.127]
ANGULAR ± .25°
SURFACE ROUGHNESS 125
REMOVE ALL BURRS AND BREAK SHARP EDGES .015 MAX.
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LA-TEST #005 B&B 2
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LA-TEST #005 Y14.5
DO NOT SCALE DRAWING
JOB NUMBER A1864504
DRAWN BY FUHRMANN 11/9/93
CHECKED BY C. BRITE 02/94
DESIGNER FUHRMANN 02/94
RESPONSIBLE ENGINEER C. BRITE 02/94
CHIEF DESIGN ENGINEER D. SHU 03/94
OP. MANAGER T.M. KUZAY 03/94
PROJECT MGR.
APPROVED/RELEASED
THIS DRAWING IS THE PROPERTY OF
ARGONNE NATIONAL LABORATORY
TITLE
ADVANCED PHOTON SOURCE
A1-LINEAR ACTUATOR, X-Z
STEPPING, LIGHT LOAD
TOP PLATE
MATERIAL 1.75 TH'K ALUMINUM TOOL & JIG PLATE
SCALE 1:1
SHEET 1 of 1
SIZE E
DRAWING NUMBER P4105090101-850302-04