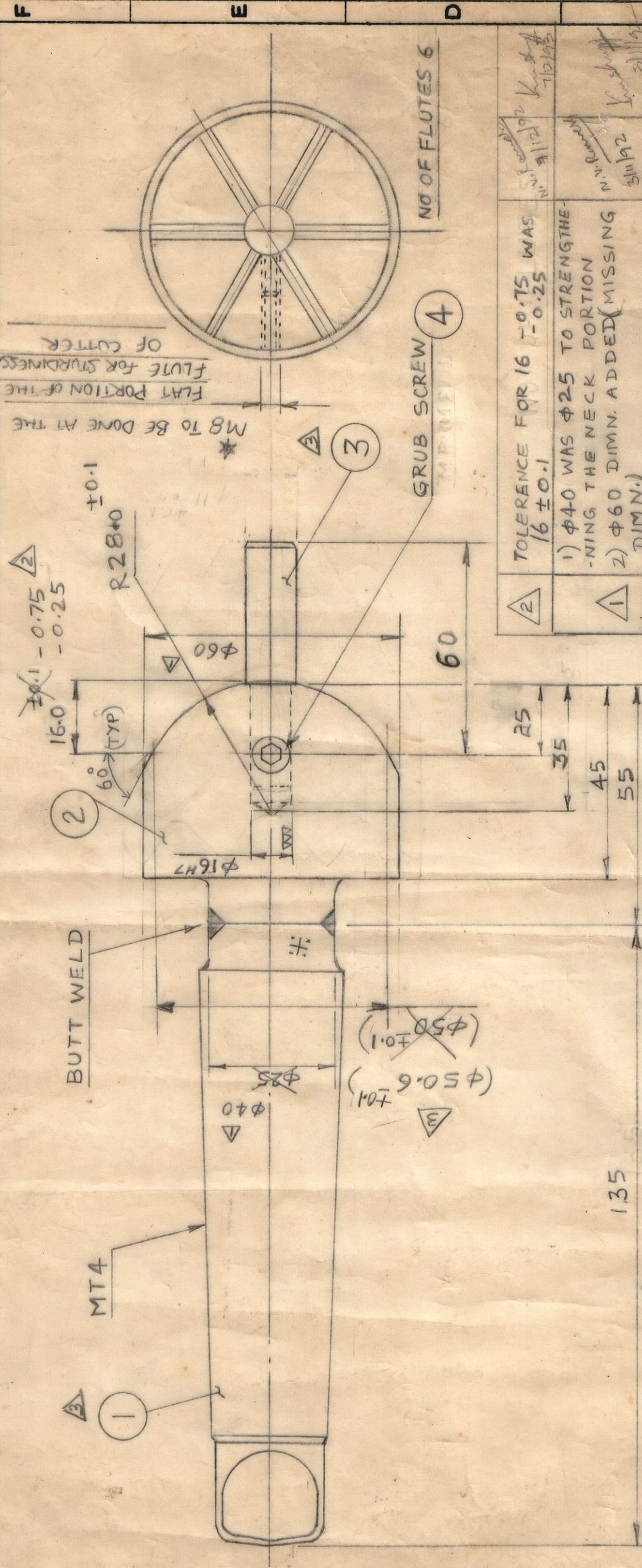


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS										
ABOVE UP TO AND INCLUDING	6		30		120		315		1000	
	6	30	30	120	315	1000	1000	2000	4000	4000
VALUE	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 3	± 3	± 3



ISSUE NO.		MODIFICATION		DRAWN		APPROVED	
4	1	GRUB SCREW	STD IS: 6034	M8-X20			
3	1	PILOT	EN 353	φ25X75			
2	1	CUTTER	HSS M42 8% Co	φ63X60			
1	1	SHANK	EN 19	φ35X135			
ITEM NO.	QTY	DESCRIPTION	MATERIAL	SIZE			
NO.	STD. OR. DRG. NO.	DESCRIPTION	QTY.	MATERIAL	UW	TW	REMARKS

[illegible]

NOTES

1. STAMP TOOL NO. AND COMPT. NO. AT PLACE SHOWN THUS X.
2. CUTTERS ARE USED ON FORGED CLAMPS HAVING CHEMICAL COMPOSITION
C 0.42 to 0.48, Si 0.18 to 0.35, Mn 1.2 to 1.6, P 0.03, S 0.035, Cu 0.3, Ni 0.2, Cr 0.3,
V 0.07 AND HARDNESS 30 ~ 36 HRC. SURFACE FINISH REQUIRED IS 3.2 Ra.
3. ALL OTHER DIMNS. ARE AS PER MANUFACTURER'S SPECIFICATION
4. CASE HARDEN ITEM 3 TO RC 58 ~ 63 (CASE DEPTH 0.8 TO 1.2 mm).
5. HARDEN ITEM 2 TO RC 58 ~ 63 & ITEM 1 TO RC 35-40