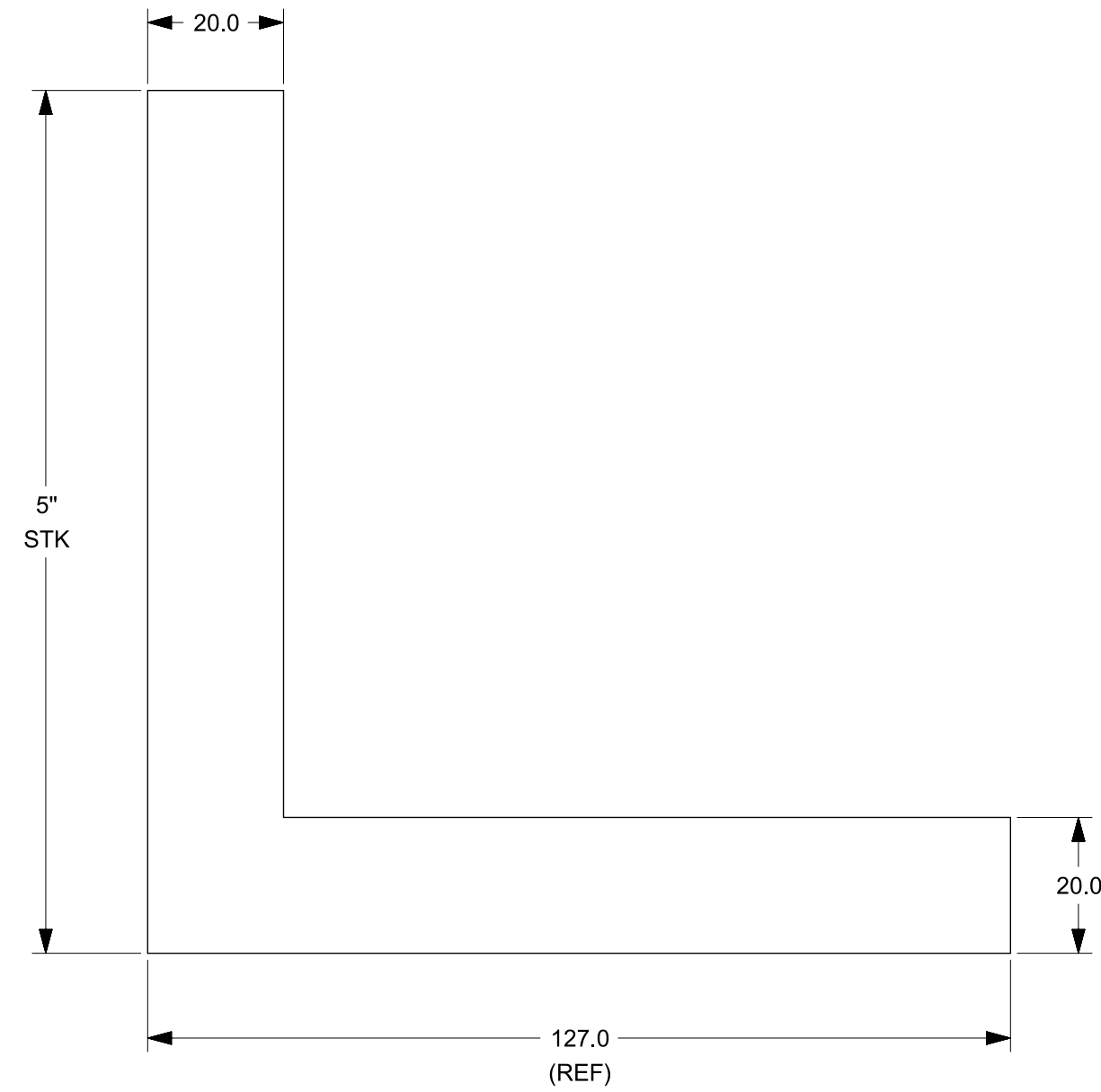
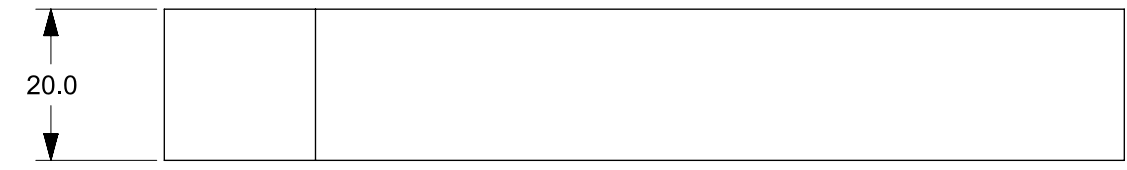


NUM	X	Y	Z	HOLE SIZE	REV	CHANGE DESCRIPTION	CHK'D	DATE



THIS DRAWING MAY USE BOTH INCH AND METRIC UNITS OF MEASUREMENT (* INDICATES INCH DIMENSIONS)

MAXIMUM ALLOWANCE ROUGHNESS OF ALL METRIC

1 PLACE mm FINISH DIMENSIONS TO BE 3.2 MICRONS
 2 PLACE mm FINISH DIMENSIONS TO BE 1.6 MICRONS
 3 PLACE mm FINISH DIMENSIONS TO BE 0.5 MICRONS
 ALL GROUND SURFACES TO BE 0.4 MICRONS.

METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE:

1 PLACE MACHINING ±0.3
 1 PLACE FABRICATION ±1.5
 2 PLACE ±0.08 BETWEEN MACHINED SURFACES
 ±0.03 BETWEEN SINGLE DOWEL AND A HEEL SURFACE
 ±0.03 BETWEEN DOWELS IN THE SAME PLANE
 ±0.10 BETWEEN DOWELS IN DIFFERENT PLANES
 ±0.13 TO SCREW HOLES, NON ACCUMULATIVE

ALL Ø SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN SURFACES.

WELDMENTS.
 ALL WELD FILLETS TO BE 1/4 INCH.
 ALL "V" GROOVES TO BE 90 EXCEPT AS SHOWN.
 ADD VENT HOLES IN ALL WELDMENTS WHERE TRAPPED AIR IS A POSSIBILITY, I.E. TUBING CAPPED AT BOTH ENDS, BOXED FORMS ETC.
 SPOTFACE SCREW AND / OR BOLT HEAD AND / OR WASHERS IS INFRINGED UPON BY WELD BEADS.

ALL EDGES OF PART CONTACT SURFACES ON LOCATING BLOCKS AND FINGERS TO HAVE .12 INCH / 3.00 mm AFTER SPOTTING.

BUILD VENDOR TO BE RESPONSIBLE FOR ACCURACY OF STANDARD PRODUCTS AFTER ALTERATION.

DOWEL HOLE TOLERANCES DOWEL TOLERANCE
 FOR PRESS FIT USE H6 m6
 FOR SLIP FIT USE F7

MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.
 PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK.
 DO NOT SCALE DRAWING

3rd ANGLE PROJECTION

SHT 1 OF 1 SHTS		SHOWN ON
DET BY	DES BY	TITLE
		4140 L-Block
CHK BY	DATE	DRAWING NO. OR TOOL NO.
		FTS-4140-20-5-5
SCALE		
NONE		

*Add'l Fees for Finishes

SAFETY ORANGE PAINT
NO PAINT
BLACK OXIDE

MATERIAL: AISI-4140
 STK: 7/8" X 5" X 127MM (5")