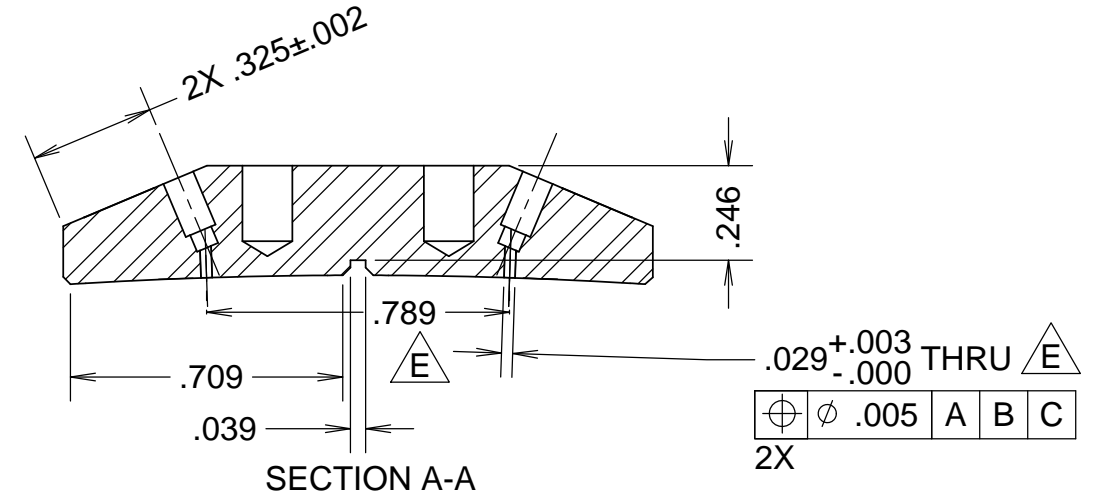
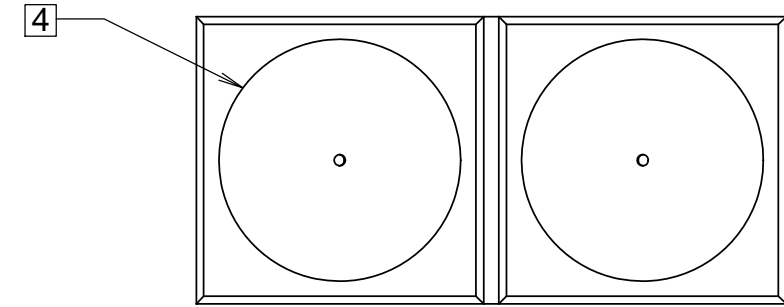
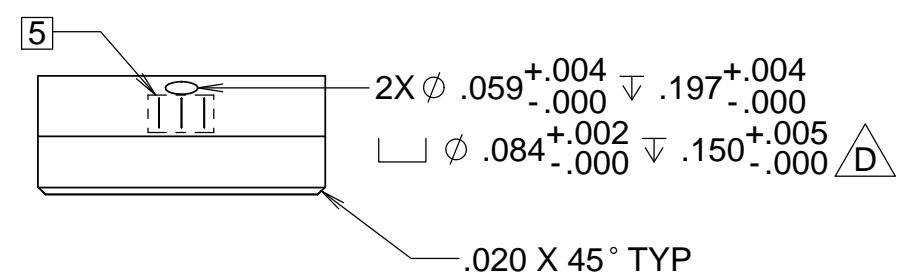
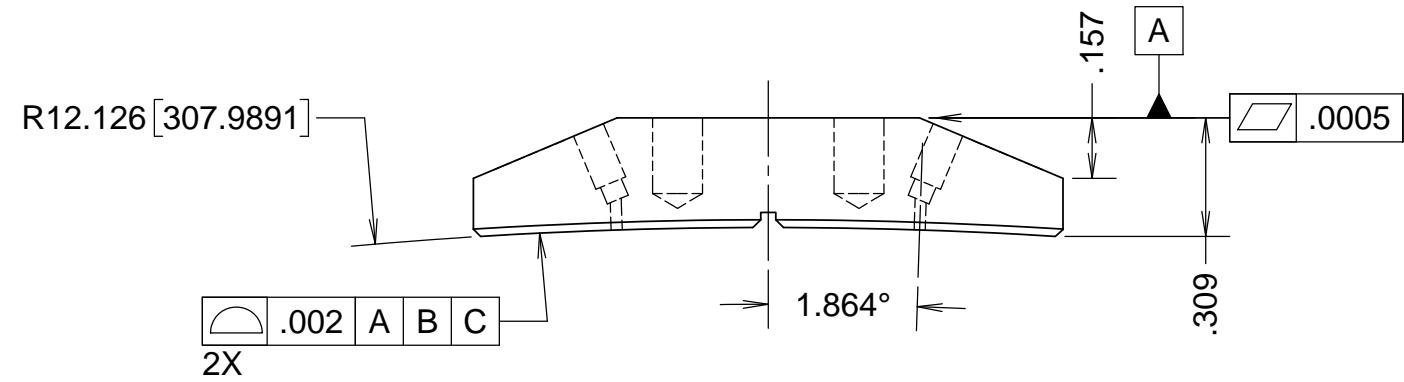
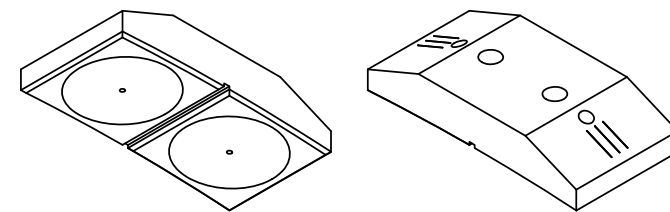
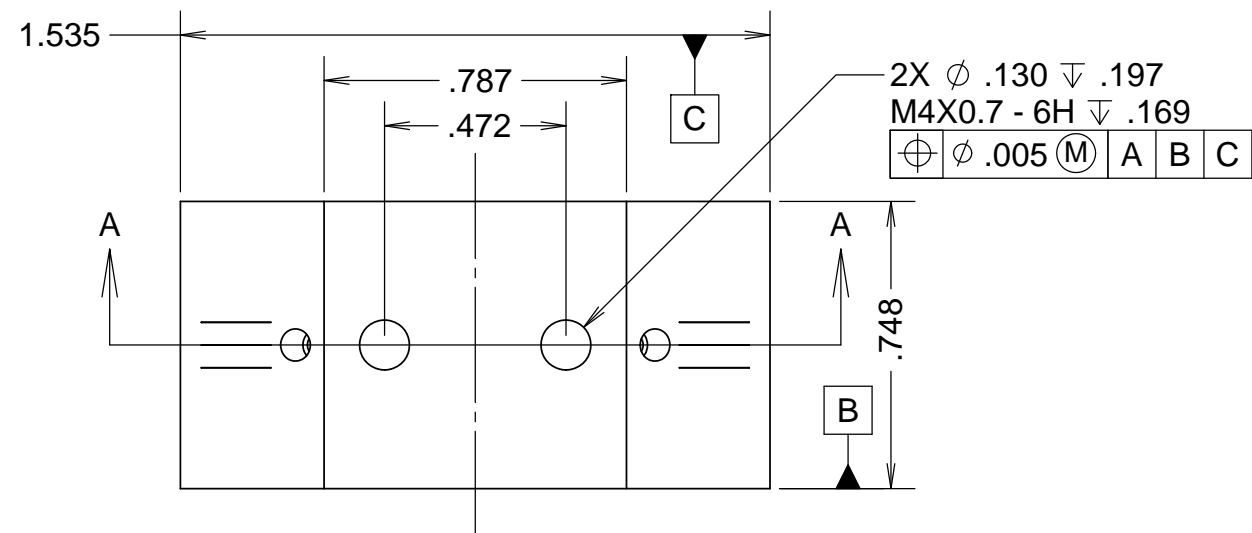


REV	DATE	DRWN	CHK'D	DESCRIPTION
A	3NOV15	GFC		PRELIMINARY
B	4MAR16	GFC		DESIGN CHANGE
C	12MAR16	GFC	--	P/N & DESIGN CHANGE
D	4MAY16	GFC	KECK	TOLERANCE CHANGE
E	18MAY	GFC	DM	DIMENSIONS ADDED
F	8JUL16	GFC	--	NOTE 2 CHANGE



NOTES

- 1 ROUGH MACHINE, HEAT TREAT PER NOTE 2, THEN FINISH MACHINE
- 2 HEAT TREAT PER FOLLOWING SCHEDULE:
 - 2.1 1/2 HOUR AT 843C IN VACUUM OR INERT GAS, GAS QUENCH
 - 2.2 1 HOUR AT 316C, AIR COOL
 - 2.3 48 HOURS AT 93C, AIR COOL
- 3 REMOVE BURRS AND SHARP EDGES, **DO NOT CHAMFER EDGE OF $\phi .029$ HOLE**
- 4 SCRIBE $\phi 16$ MM
- 5 SCRIBE ROMAN NUMERAL III FOR IDENTIFICATION

UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES & TOLERANCES ARE AS FOLLOWS		DRAWN: CABAK		PROJECT CODE: K1D3FD			
X.X: $\pm 0.1000^{\circ}$ X.XX: $\pm 0.0100^{\circ}$		CHECKED: --		DWG NO: 872-LM-4012			
X.XXX: $\pm 0.0050^{\circ}$ X.XXXX: $\pm 0.0001^{\circ}$		DESIGNED: CABAK		TITLE: LATERAL PUCK, TYPE 37 DEG			
ANGLES: $\pm 0.5^{\circ}$ FINISH: 125 MICRO INCHES		DRAWN: CABAK		NEXT ASSY: 872-LM4100			
BREAK ALL SHARP EDGES & CORNERS .002" MAX		MATERIAL: INVAR-36		QUANTITY: --			
		FINISH: --		SW DOCUMENT FILE			
				<table border="1"> <tr> <td>F</td> <td>1/1</td> </tr> </table>		F	1/1
F	1/1						