

5

4

3

2

1

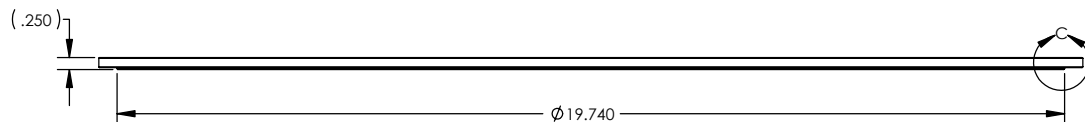
REVISIONS			
ZONE	REV	DESCRIPTION	DATE
	B	ADDED HELICOIL DETAILS	4/5/2003
	C	ADDED #6-32 THRU HOLES	4/20/2003

D

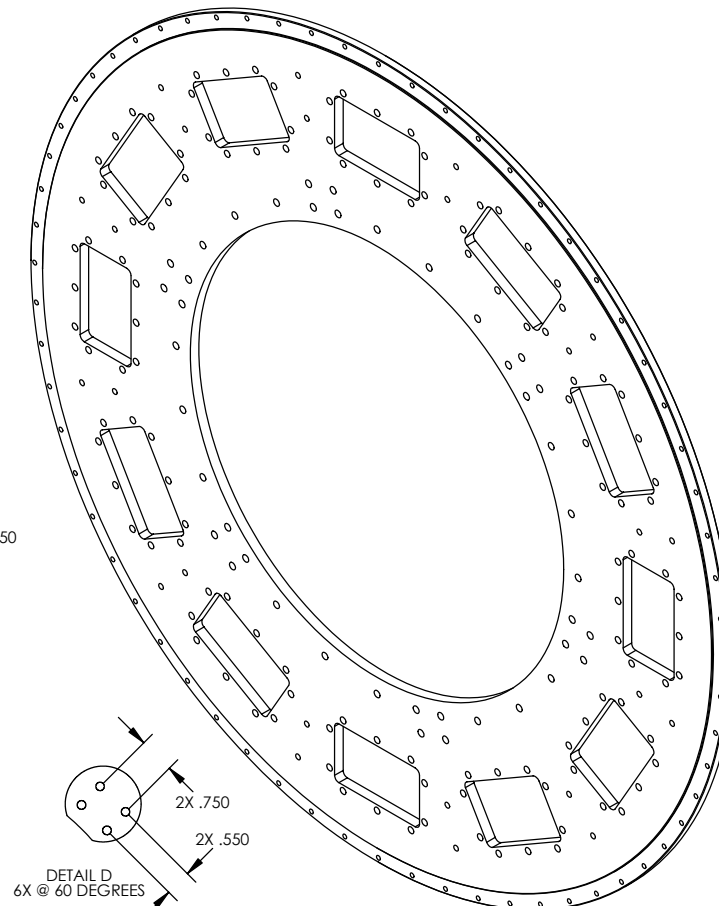
C

B

A



64X #4-40 X 1-1/2L Ph-Br Helicoils

 $\phi 20.250$ B.C. $\phi 19.710$ (CHAMFER) $\phi 20.500$ $\phi 11.850$ $\phi 11.000$ $2X 5.850$ 45° $12X 7.250$ 120X #4-40 UNC THRU
ROLL-FORM THREAD18X $\phi .173$
EVERY 15 DEGREES, EXCEPT BETWEEN
THE TWO-HOLE PATTERNS12X #6-32 THRU
ON 18.00" B.C.12X #6-32 THRU
ON 16.00" B.C.DETAIL D
6X @ 60 DEGREES

12X #8-32 x 1 d Ph Br Helicoils

12X .173 THRU

CHAMFER 45 DEG X .015

12X #6-32 THRU
ON 18.00" B.C.12X #6-32 THRU
ON 16.00" B.C.DETAIL C
SCALE 2 : 1

- NOTES:
1. THE HOLES AT THE LARGER RADIUS IN THE SET OF FOUR ARE TO HAVE HELICOILS.
2. THE HOLES AT THE SMALLER RADIUS TO BE DRILLED .173".

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

DECIMAL TOLERANCES:

X .030 XX .015 XXX .005

ANGULAR TOL: $\pm 1^\circ$ SURFACE ROUGHNESS: $\sqrt{1.6}$ INTERSECTIONS SHALL BE UNIFORMLY FINISHED WITH CHAMFER .005/.010 X 45° OR RADIUS .005/.010CHAMFER ALL THREADED HOLES 110% OF MAJOR DIAMETER X 45°

MATERIAL: 3003 Aluminum

FINISH: N/A

High Precision Devices

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TITLE: p02101-099 Ln2 can ring

CONFIGURATION: 00-Default

SIZE QTY PER ASSM: 1 SCALE: 1:2 SHEET 1 OF 1 REV

C DATE: 5/17/2004 DRAWN BY: C. Danaher C