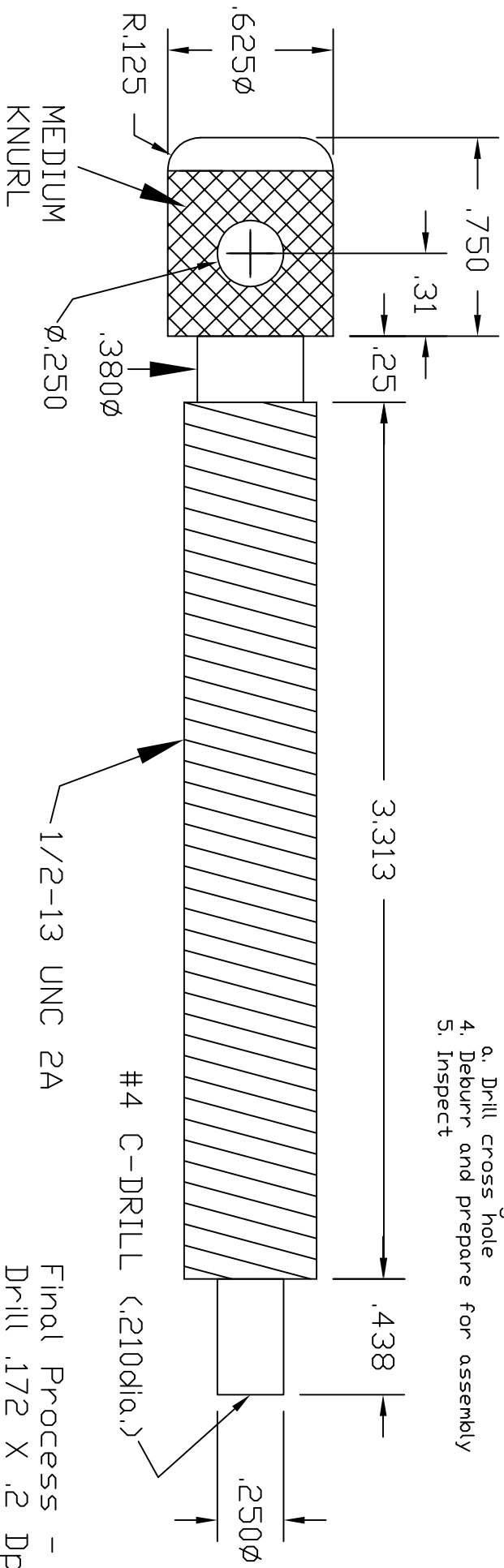


1. Cutoff 4.81 lg. and Deburr
2. Lathe
  - a. Face to length
  - b. Rough turn (.35Ø) and C-Drill small end
  - c. Turn knurled end to .612Ø x 1.00"
  - d. Knurl
  - e. Turn 1/8" radius
  - f. Groove (1/4" wide)
  - g. Place knurled end in chuck (Protect knurls)  
Use tailstock to support opposite end
  - h. Turn for threads and Chamfer
  - i. Thread and deburr
  - j. Inspect threads using Three-Wire method
  - k. Finish turn .250Ø x .438
  - l. Drill .172Ø x .2 dp.
3. Vertical Milling Machine
  - a. Drill cross hole
4. Deburr and prepare for assembly
5. Inspect



#4 C-DRILL (.210dia.)  
Final Process -  
Drill .172 X .2 DP  
This End Only

TOLERANCE BLOCK  
FRACTIONAL: +/- 1/64  
TWO PLACE: +/- .010  
THREE PLACE: +/- .005  
FOUR PLACE: +/- .0005  
ANGLES: +/- 1 deg.

South Adams Area 18 Precision Machine Technology		C-CLAMP	
SCREW		SCREW	
MAT'L.	SIZE	CHECKED BY:	DWG BY:
1018 CR		J. DAILEY	J. DAILEY
5/8" RD	SCALE	PART NO.: PMT1-2a	SHEET