

Ø1.25 typ.

1. Lathe

- a. Face to length
- b. Turn first end to size
- c. Chamfer first side
- d. Groove first end
- e. Place in 4-Jaw chuck
- f. Indicate within .001TIR
- g. Turn second end to size
- h. Chamfer second end
- i. groove second end

2. Vertical Mill

- a. Spot drill
- b. Drill to depth
- c. Counterbore to depth
- d. Chamfer hole
- e. Tap (hand)

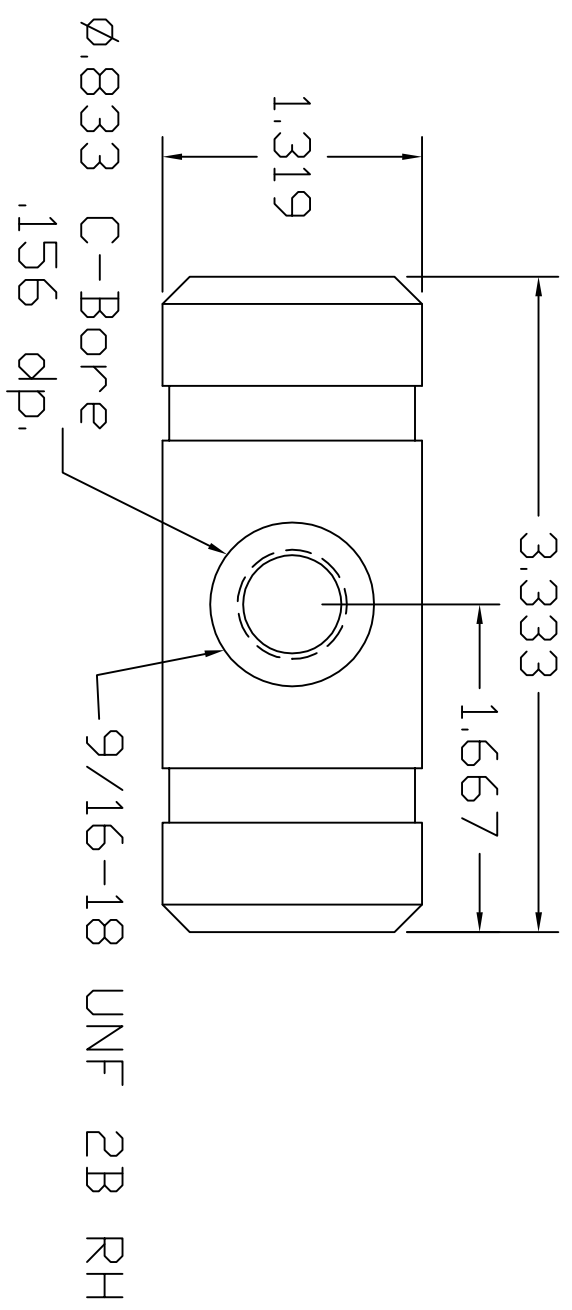
3. Inspect

4. Lathe

- a. Smooth surfaces with file

5. Polisher

- a. Polish to a high luster



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

South Adams
 Area 18
 Precision Machine
 Technology

MATL.
 1 3/8"Ø Yellow Brass

BRASS HAMMER

HEAD

SIZE	CHECKED BY:	DWG BY:	REV
SCALE	PART NO.:	Date:	
	J. DAILEY	8/12/03	