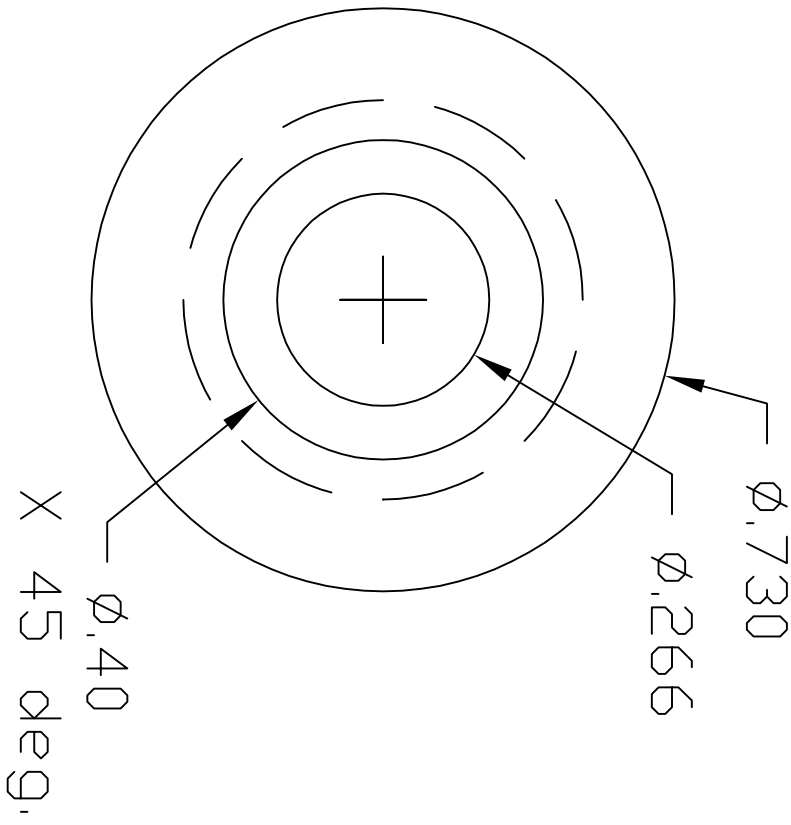
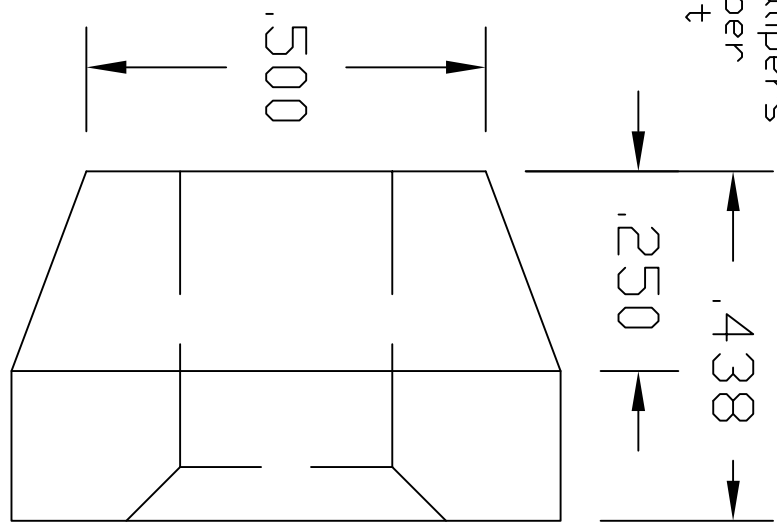


1. Use material in drawer
2. Lathe
 - a. Face End
 - b. C-Drill, drill and Chamfer (.4 x 45°)
 - c. Turn OD to size
 - d. Use Hermaphrodite Calipers
To mark start of taper
 - e. Rotate compound rest
 - f. Turn taper
 - f. Cutoff in lathe +.010
 - g. Face to length
 - h. Deburr
3. Inspect



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

South Adams Area 18 Precision Machine Technology
MAT'L. 1018 HDT ROLLED
3/4" RD

C-CLAMP		PAD	
SIZE	CHECKED BY:	DWG BY:	REV
SCALE	PART NO.:	PMT1-2c	SHEET
	J. DAILEY		