

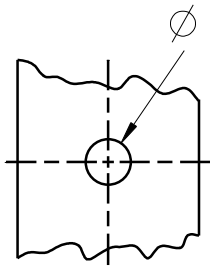
1	2	3	4	5	6				
GENERAL CONSIDERATIONS 1. MANUFACTURING LIMITS ARE EXPRESSED IN MAXIMUM TERMS AND SHOULD NOT BE CONSTRUED AS BEING THE NORMAL OR AVERAGE CONDITION. IN MOST CASES, THE ACTUAL FEATURE WILL FALL WELL WITHIN THE MAXIMUM LIMIT. 2. WHEN A COMBINATION OF CONTROLS EXISTS, THE MORE RESTRICTIVE VALUE SHOULD BE APPLIED. 3. IF THE DISPLAYED TOLERANCE OF A PART IS MORE RESTRICTIVE THAN THIS ESN, THE DRAWING TOLERANCE SHALL APPLY. 4. WHERE INCH DIMENSIONS ARE GIVEN AN ALTERNATE METRIC VALUE WILL BE PROVIDED AS SHOWN: INCH [MM]. OTHERWISE, ALL DIMENSIONS ARE GIVEN IN MILLIMETERS. FORM DIMENSIONS: 1. SCOPE: DIMENSIONS DEFINING SHAPE OF PART, SIZE OF FILLETS, SIZE OF ROUNDS AND LOCATION OF HOLES, SLOTS, ETC... 2. TOLERANCE IS +/- 0.06in [1.5mm] 3. ANGULAR TOLERANCE IS +/- 1 DEGREE HOLE & SLOT DIMENSIONS: 1. SCOPE: DIMENSIONS DEFINING SIZE OF HOLES, SLOTS AND DIMENSIONS BETWEEN HOLES AND SLOTS WITHIN A COMMON HOLE OR SLOT PATTERN. TOLERANCE IS +/- 0.03in [0.8mm] <p style="text-align:center;">HOLE & SLOT DIMENSIONS CONTINUED ON SHEET 2</p>					EO Number <p style="text-align:center; font-size: 1.2em;">090789</p>				
					Drawn/Changed <p style="text-align:center; font-size: 1.2em;">YCY</p>		Date <p style="text-align:center; font-size: 1.2em;">08242009</p>		A
					Approved <p style="text-align:center; font-size: 1.2em;">GJL</p>		Date <p style="text-align:center; font-size: 1.2em;">09032009</p>		
					Position 		Description <p style="text-align:center; font-size: 1.2em;">RELEASED</p>		B
					C				
						D			
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Drawn by <p style="text-align:center; font-size: 1.2em;">YCY</p>		Date <p style="text-align:center; font-size: 1.2em;">08242009</p>	Third angle projection		Drawing No. <p style="text-align:center; font-size: 1.5em;">ESN-0056</p>				

HOLE & SLOT DIMENSIONS (CONT'D):

2. DRILLED HOLES ARE TO MEET TOLERANCES SPECIFIED IN TABLE 1.
3. PUNCHED HOLES SHALL BE WITHIN THE FOLLOWING LIMITS OF ACCEPTABILITY. THE CUT SURFACE (DIMENSION B IN FIGURE 1) SHALL BE AT LEAST 1/3 OF THE MATERIAL THICKNESS (DIMENSION A). DIAMETER THROUGH THIS THICKNESS SHALL BE WITHIN HOLE TOLERANCE ESTABLISHED IN TABLE 1. THE REMAINING SURFACE (A MINUS B) MAY BREAK AWAY AN ADDITIONAL AMOUNT AS SHOWN, WITHIN TOLERANCE C VALUES IN TABLE 2.
4. DRILLED HOLES, PUNCHED HOLES & PUNCHED SLOTS

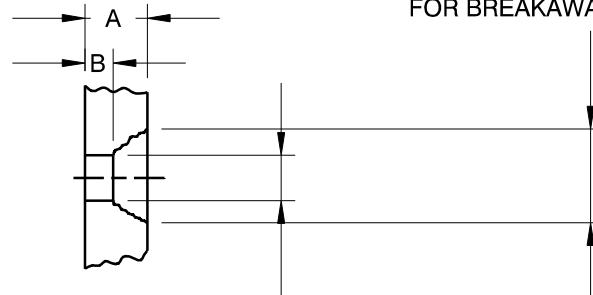
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THIS ON THE DRAWING:



MEANS THIS:

DIAMETER PLUS TOLERANCE C
FOR BREAKAWAY PER TABLE 2



DIAMETER WITH TOLERANCE
PER TABLE 1

FIGURE 1

HOLE & SLOT DIMENSIONS CONTINUED ON SHEET 3

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	Drawn by	Date	Third angle projection	Drawing No.			
	YCY	08242009		ESN-0056			

HOLE & SLOT DIMENSIONS (CONT'D):

**TABLE 1
HOLE AND SLOT TOLERANCE**

DIAMETER		TOLERANCE	
OVER	THRU		
0.000[0.000]	0.125[3.175]	+0.005[0.127]	-0.002[0.051]
0.125[3.175]	0.250[6.350]	+0.006[0.152]	-0.002[0.051]
0.250[6.350]	0.500[12.700]	+0.008[0.203]	-0.002[0.051]
0.500[12.700]	0.750[19.050]	+0.009[0.229]	-0.002[0.051]
0.750[19.050]	1.000[25.400]	+0.010[0.254]	-0.002[0.051]
1.000[25.400]	2.000[50.800]	+0.016[0.406]	-0.002[0.051]
2.000[50.800]	3.000[88.900]	+0.025[0.635]	-0.002[0.051]

**TABLE 2
PUNCHED HOLE SURFACE TOLERANCE**

THICKNESS A		TOLERANCE C
OVER	THRU	
0.000[0.000]	0.015[0.381]	+0.006[0.152]
0.015[0.381]	0.040[1.016]	+0.008[0.203]
0.040[1.016]	0.125[3.175]	+0.020[0.508]
0.125[3.175]	0.250[6.350]	+0.030[0.762]
0.250[6.350]	0.500[12.700]	+0.040[1.016]
0.500[12.700]	0.750[19.050]	+0.063[1.600]

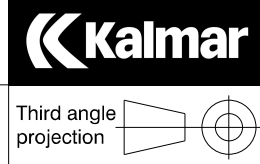
HOLE & SLOT DIMENSIONS CONTINUED ON SHEET 4

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HOLE & SLOT DIMENSIONS (CONT'D):

5. TORCHED OR PLASMA CUT HOLES

- (1) HOLE SIZE TO MEET FORM DIMENSION TOLERANCES.
- (2) THE PIERCE POINT IS TO BE LOCATED AS FAR AWAY FROM THE EDGE OF THE PART AS PRACTICAL AND SHOULD BE INSIDE OF THE MATERIAL TO BE REMOVED. A LOCAL PROTRUBERANCE AT THE PIERCE OR FINISH OF THE CUT IS NOT TO EXCEED 0.063[1.600]. SEE FIGURE 2.

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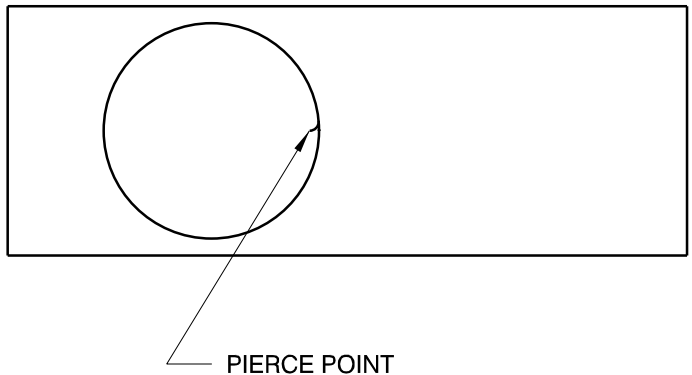


FIGURE 2

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Third angle

projection

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FORMED SIDES

1. CUT SURFACE TO BEND

- (1) SURFACES SHOWN AT A RIGHT ANGLE (90°) TO A BEND SHALL BE PERPENDICULAR TO THE BEND WITHIN THESE LIMITS, AS SHOWN IN FIGURE 3:
- (2) PERPENDICULARITY TOLERANCE ZONE F:
- (3) THRU FIRST 6.000[152.400] OF LENGTH G.....0.030[0.762]
- (3) OVER 6.000[152.400] THROUGH 12.000[304.800].....0.060[1.524]
- (4) FOR EVERY INCH OVER 12.000[304.800], ADD.....0.002[0.051]

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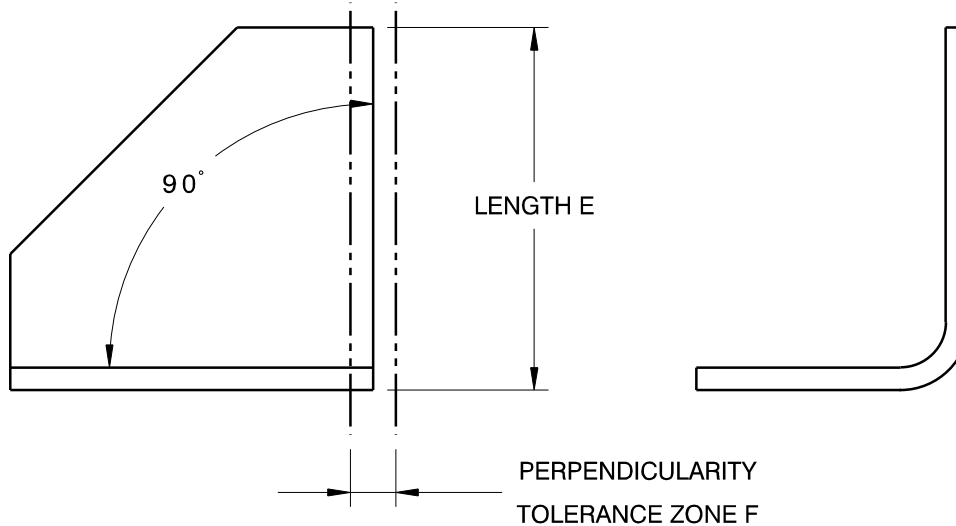
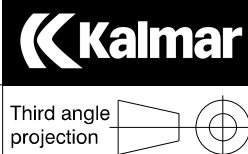


FIGURE 3

FORMED SIDES CONTINUED ON SHEET 6

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FORMED SIDES (CONT'D)

2. BEND TO BEND

- (1) TWO BENDS SHOWN AT A RIGHT ANGLE (90°) TO A BEND SHALL BE PERPENDICULAR TO THE BEND WITHIN THESE LIMITS, AS SHOWN IN FIGURE 4:
- (2) PERPENDICULARITY ZONE H:
- (3) THRU FIRST 6.000[152.400] OF LENGTH G.....0.030[0.762]
- (4) OVER 6.000[152.400] THROUGH 12.000[304.800].....0.060[1.524]
- (5) FOR EVERY INCH OVER 12.000[304.800], ADD.....0.002[0.051]

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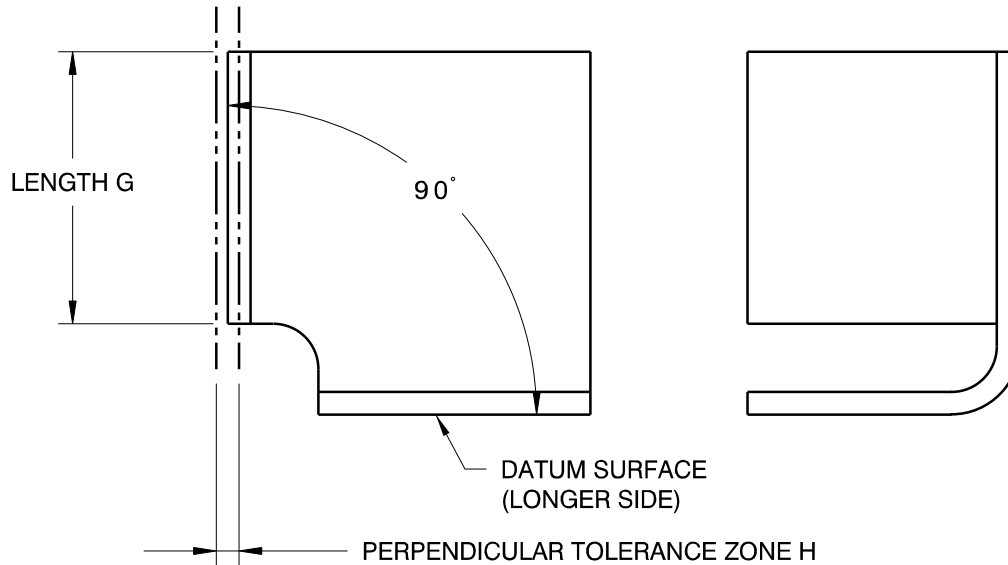
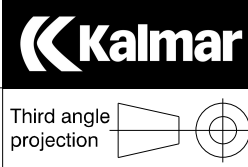


FIGURE 4

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PERPENDICULARITY TOLERANCE-RIGHT ANGLE BENDS

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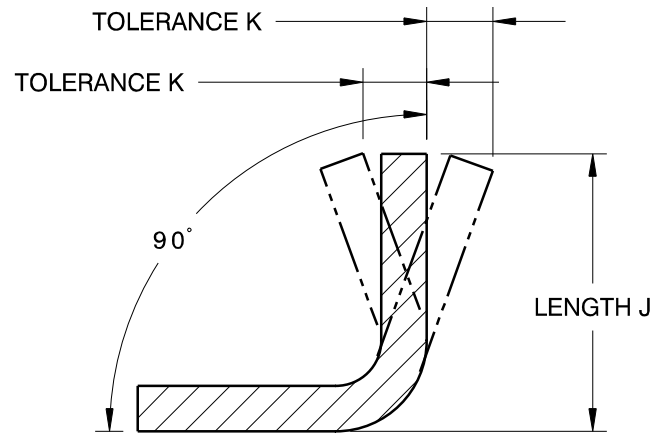
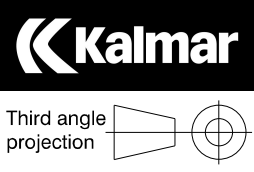


FIGURE 5

J LENGTH SHORT LEG		MATERIAL THICKNESS					
OVER	THRU	THRU	OVER	OVER	OVER	OVER	OVER
		0.015[0.381]	0.015[0.381]	0.035[0.889]	0.083[2.108]	0.125[3.175]	0.250[6.350]
			THRU	THRU	THRU	THRU	THRU
			0.035[0.889]	0.083[2.108]	0.125[3.175]	0.250[6.350]	0.500[12.700]
0.000[0.000]	2.000[50.800]	0.020[0.508]	0.020[0.508]	0.020[0.508]	0.030[0.762]	0.030[0.762]	0.040[1.016]
2.000[50.800]	4.000[101.600]	0.030[0.762]	0.030[0.762]	0.030[0.762]	0.040[1.016]	0.040[1.016]	0.050[1.270]
4.000[101.600]	6.000[152.400]	0.040[1.016]	0.040[1.016]	0.050[1.270]	0.050[1.270]	0.060[1.524]	0.070[1.778]
6.000[152.400]	10.000[254.000]	0.050[1.270]	0.060[1.524]	0.070[1.778]	0.080[2.032]	0.080[2.032]	0.090[2.286]
10.000[254.000]	20.000[508.000]	0.070[1.778]	0.070[1.778]	0.080[2.032]	0.090[2.286]	0.090[2.286]	0.100[2.540]
		TOLERANCE K					

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