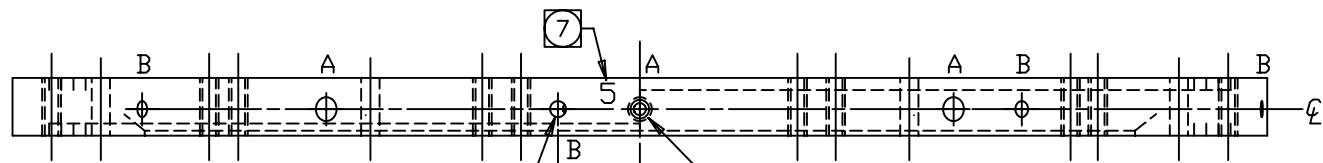
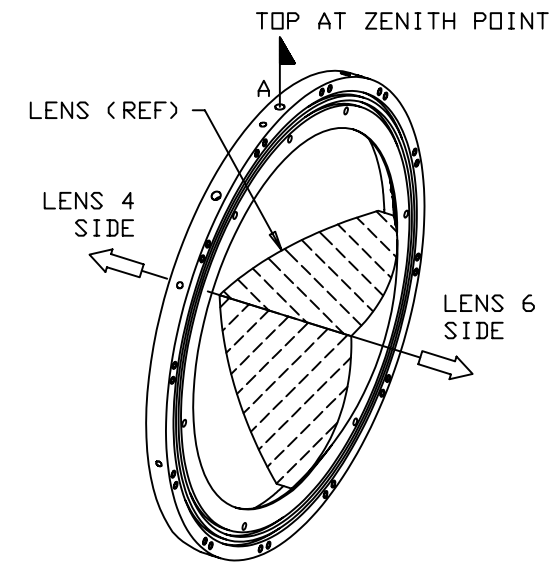
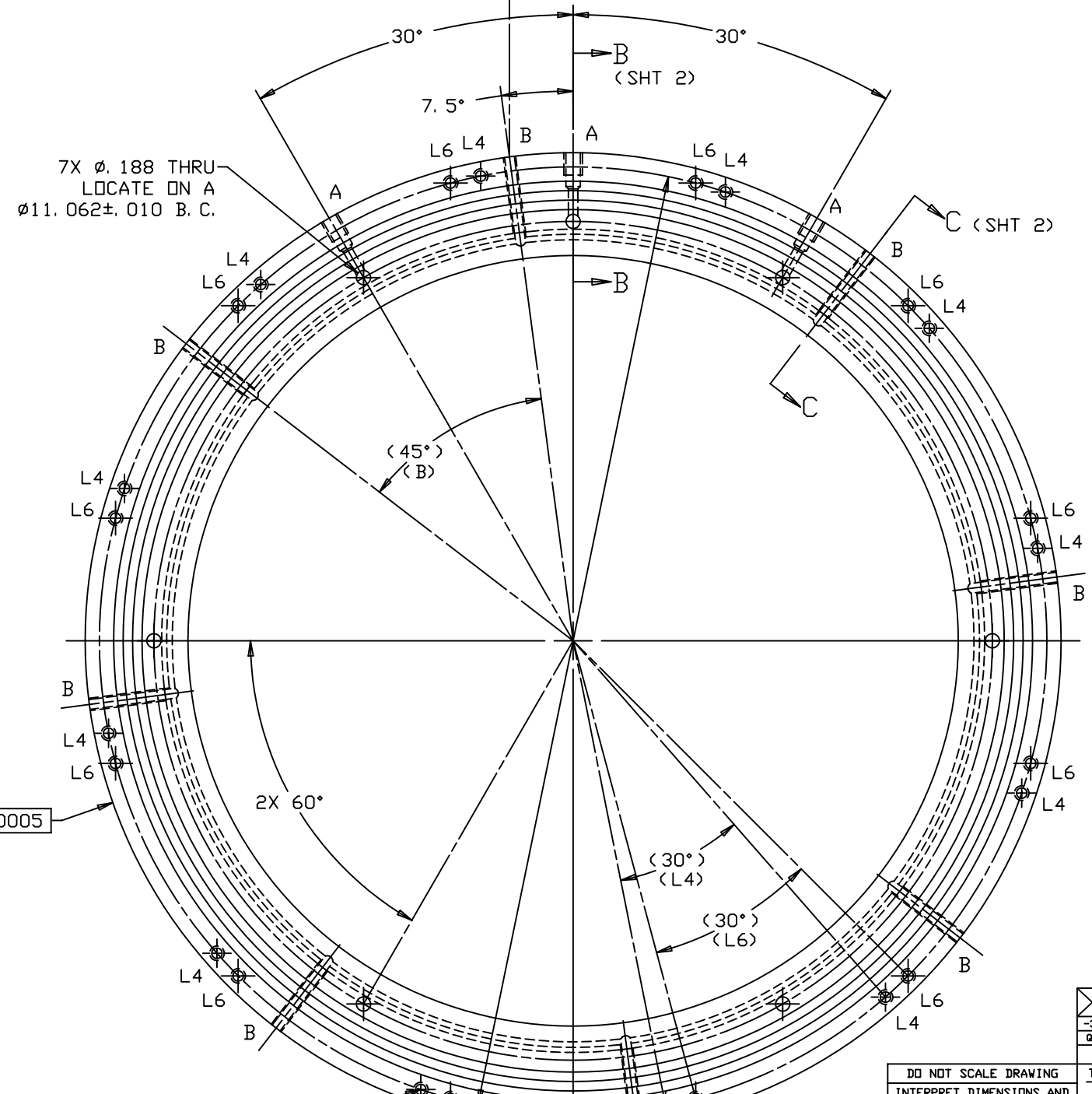
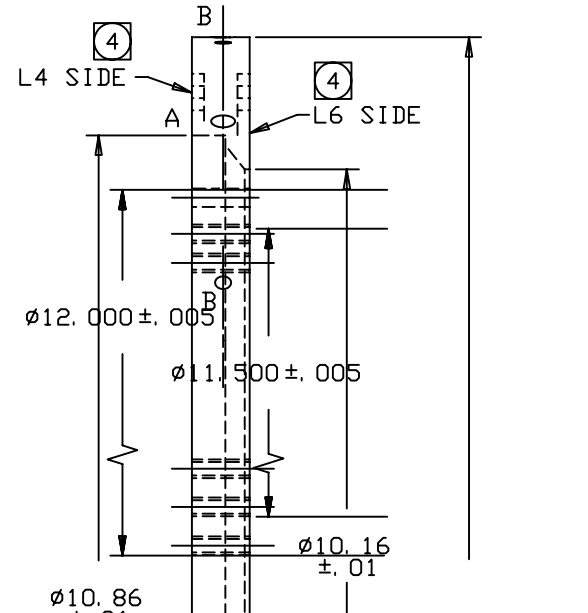


REVISIONS				
LTR	DESCRIPTION	DATE	REVISED BY	APPROVED
A	INITIAL RELEASE	4/27/04	R. NAGY	G. LANDIS

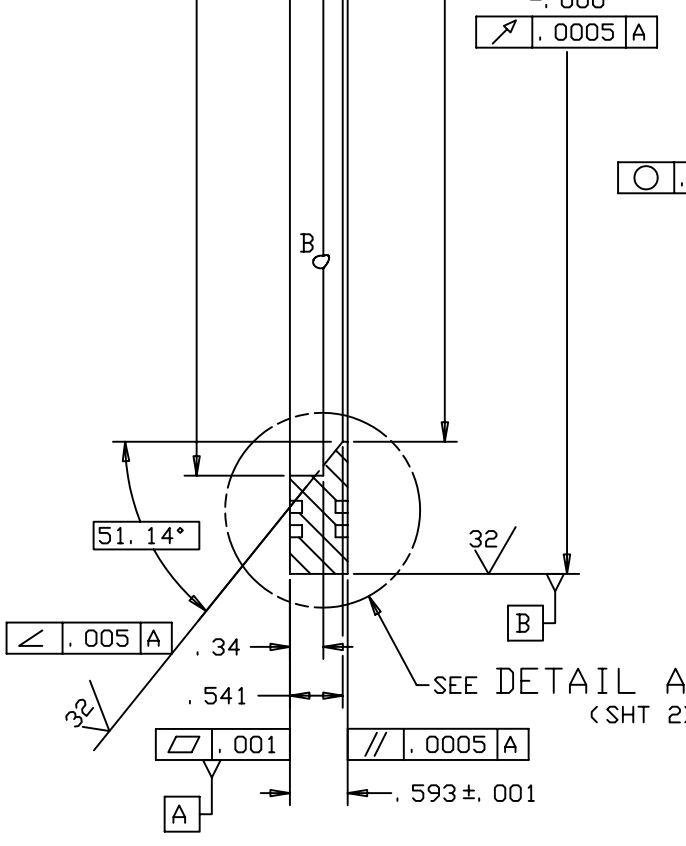


8X .164-32 UNC-2B THRU INTO BORE EQUALLY SPACED AT 45°; INDICATED "B"

3X \varnothing .125 FULL BREAK THRU INTO \varnothing .188 HOLE \varnothing .192 ∇ .45 .250-28 UNF-2B ∇ .30 INDICATED "A"



- NOTES: UNLESS OTHERWISE SPECIFIED
- BREAK SHARP EDGES & DEBURR.
 - MACHINED SURFACE FINISH TO BE 125 RMS OR BETTER.
 - MACHINED FILLETS TO BE .015 MAX.
 - INSTALL INSERTS PER MANUFACTURER'S RECOMMENDATIONS. INSERTS INDICATED "L4" ARE INSTALLED FROM L4 SIDE; INSERTS INDICATED "L6" ARE INSTALLED FROM L6 SIDE.
 - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, BLACK.
 - DIMENSIONS ARE PRIOR TO ANODIZING.
 - BEFORE ANODIZING, PERMANENTLY MARK THE NUMBER "5" WITH .18-.25 HIGH CHARACTERS APPROXIMATELY WHERE SHOWN.



EQUALLY SPACED AT 30° (12)

MINOR DIA OF INSERT $\varnothing 0.024$ (M) A B (4)

EQUALLY SPACED AT 30° (12)

MINOR DIA OF INSERT $\varnothing 0.024$ (M) A B (4)

$\varnothing 12.500$ B.C.

24	90296A107	SCREW-LOCK HELICAL INSERT, 6-32 x .207 LG, SST	MCMaster-CARR OR EQUIV.	1
-3	-2	-1	PART NUMBER	PART DESCRIPTION
QTY PER ASSY			MANUFACTURER or MAT'L SPEC	ITEM NO.
LIST OF MATERIALS				
DO NOT SCALE DRAWING				
INTERPRET DIMENSIONS AND TOLERANCES IN ACCORDANCE WITH ASME Y14.5M-94				
TOLERANCES UNLESS OTHERWISE SPECIFIED				
LINEAR .XX = NA .XX = ±.01 .XXX = ±.005				
ANGULAR ±1°				
DIAMETRICAL SEE SPEC S-002				
DIMENSIONS ARE IN INCHES / DIMENSIONS IN [] ARE METRIC				
MATERIAL	13550	MMT	DESIGNED BY: D. DEAN	DATE: 9/3/03
6061-T651 A1	NEXT ASSY	USED ON	DRAWN BY: R. NAGY	DATE: 9/10/03
FINISH (5)	ASSEMBLY APPLICATION	CURRENT TIME/DATE/FILE LOCATION:	CHECKED BY: G. LANDIS	DATE: 4/14/04
		DRAWING ARCHIVE LOCATION: http://dev1nc1.as.arizona.edu/scad/default.html	APPROVED: S. MATHEWS	DATE: 4/27/04
			APPROVED: M. REED	DATE: 4/27/04
			APPROVED: J. BECHTOLD	DATE: 4/27/04
			PLOT SIZE: D	SCALE: 1/1
			DRAWING NUMBER: 13202	REVISION: A
SHEET 1 OF 2				