



REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	REDRAWN AND RELEASED ON CAD	ADAS	8-28-91
1855	B1	MATERIAL SPECIFICATION WAS AISI 1030 STEEL	KERN	9-6-96
	B2	CORE HARDNESS SPECIFICATION WAS R/C 24-28		
	B3	REVISED DETAIL & ASSEMBLY DESCRIPTIONS		
	B4	ADDED NOTE #4 TO POINT OUT FORGING TOLERANCES		
	B5	ELIMINATED SURFACE HARDENING AND SPECS.		
	B6	ELIMINATED CARBONITRIDING AND SPECS.		
	B7	DRAWING TRANSFERED TO SDRC		

NOTES:

1. RADII TO BE .062 UNLESS OTHERWISE SPECIFIED.
2. DRAFT ANGLES TO BE 7° MAX. UNLESS OTHERWISE SPECIFIED.
3. BLACK OXIDE FINISH.
4. TOLERANCES SHOWN IN TITLE BLOCK BELOW HAVE BEEN ADJUSTED TO REFLECT THE FORGING PROCESS.

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(B1)	MATERIAL AISI 4140 STEEL FORGING	REMOVE ALL BURRS AND BREAK ALL SHARP EDGES .015 MAX UNLESS OTHERWISE SPECIFIED	DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED TOLERANCES ARE: FRACTIONS ± .015 .00 ± .015 .000 ± .010 ANGLES ± 0° 30'	DRAWN ADAS CHECKED R.W.D. APPROVED FGS	DATE 12-5-90 DATE 8-29-91 DATE 9-6-96	(B3)	DETAIL NAME CLAMP WASHER FOR 5/8" DIA. BOLT
(B2)	HEAT TREAT R/C 34-38						ASSEMBLY NAME MOLD AND DIE CLAMPS
							SCALE FULL PROJECT NO. 1575
							CATALOG NO. / PART NO. MCW-5
							DRAWING NO. ME-0617-DT-076-B

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ME-0617-DT-076B  
MCW-5