

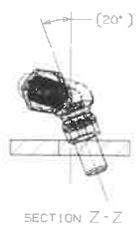
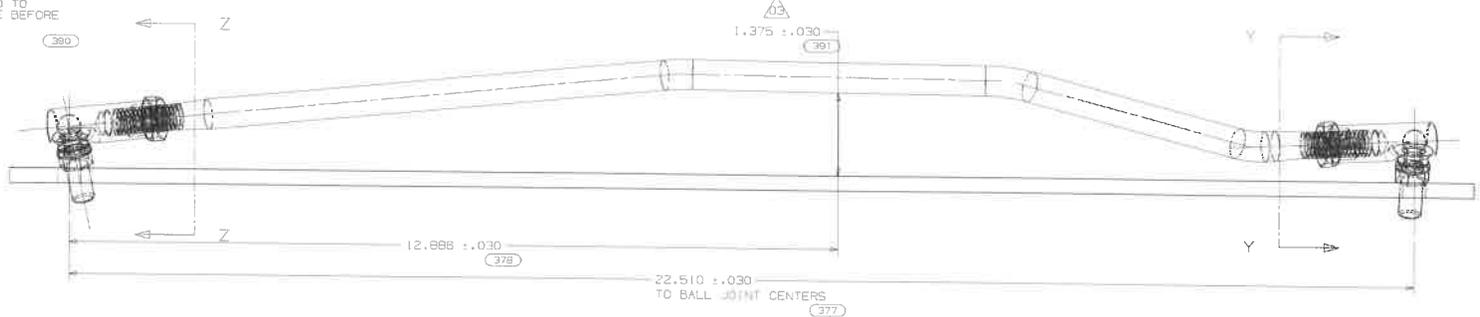
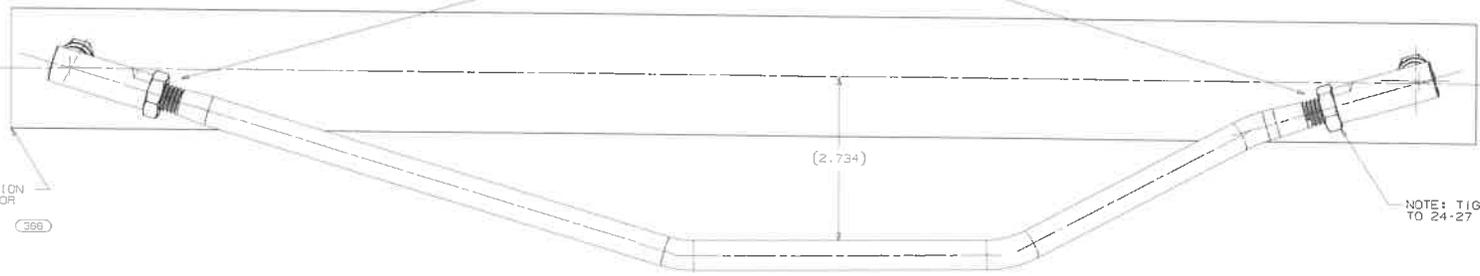
ITEM NO. 647-05050		STATUS	P-Production	REV	03
REVISIONS					
REV	DESCRIPTION	DATE	BY	CHK	APP
01	ADDED 747-06457, 723-05009 WAS 723-0448A	04/17/2014			
02	712-05093 WAS 712-0240, 723-05009 WAS 723-0448A, ADDED INSTALLATION NOTES	05/06/2014			
03	1.375 WAS 1.689, 20° WAS 30°	08/09/2014			

NOTE: EACH SIDE TO HAVE EQUAL AMOUNT OF ENGAGED THREADS

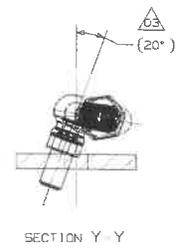
NOTE: INSTALLATION FIXTURE SHOWN FOR REFERENCE ONLY

NOTE: TIGHTEN JAM NUTS TO 24-27 FT-LBS TORQUE

NOTE: BALL JOINTS SHOWN AT ROTATED POSITION. BOTH BALL JOINTS TO BE SECURED TO INSTALLATION FIXTURE BEFORE TIGHTENING JAM NUTS



NOTE: WITH WIREFORM AT SPECIFIED HEIGHT, ROTATE BALL JOINTS TO STOP AND HOLD BEFORE TIGHTENING JAM NUTS

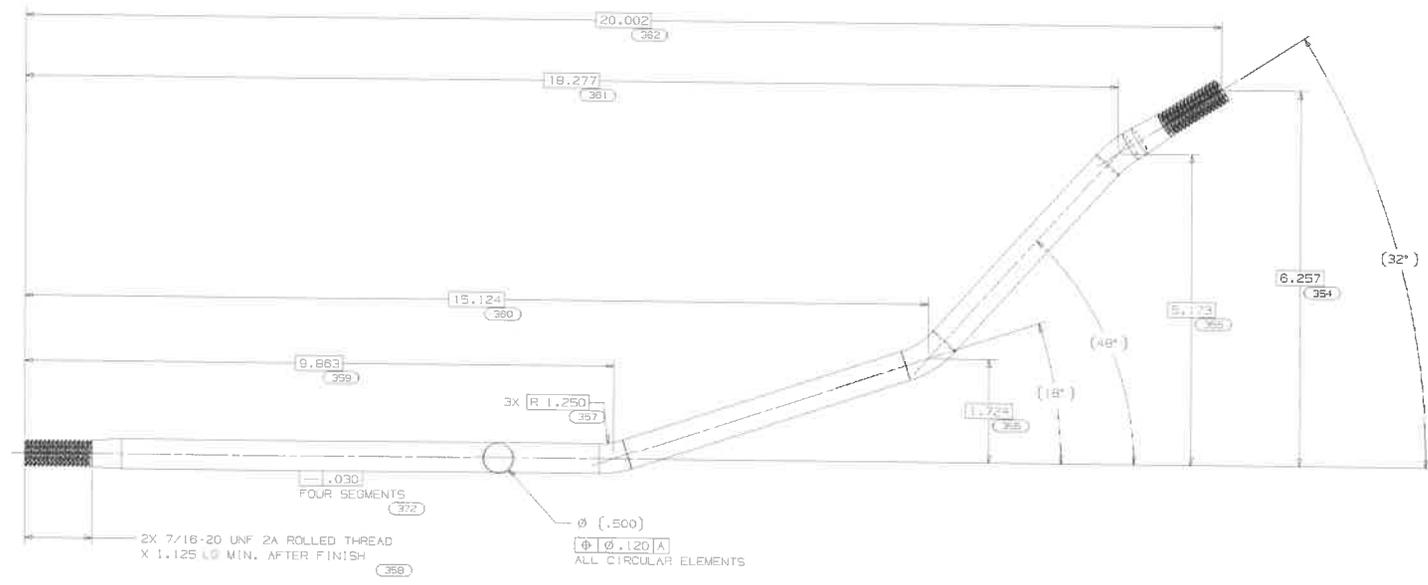
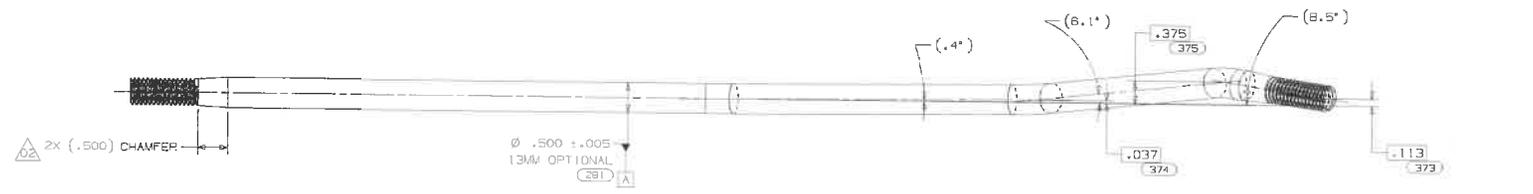


QTY	DESCRIPTION
1	ROD:TIE:STRG:RH
2	B/JNT:7/16-20:LOCK:BLK
2	NUT:JAM:7/16-20:GR2:BLK

PRODUCTION NO. 647-05050	DATE 08/05/2014	ITEM DESCRIPTION
PROJ. NO. R350	APPROVED BY [Signature]	ASM:ROD:TIE:STRG:RH
DRAWN BY C2/LAB/EM	DATE 08/06/2014	SIZE 0
STATUS P-Production	MATERIAL SEE BOM	SCALE N/A
FINISH 000000	EST. WT.	SHEET 03

ITEM NO: 747-06457 STATUS: P-Production REV: 02

REVISIONS			
REV	DESCRIPTION	DATE	BY
00	INITIAL RELEASE	08/11/2014	CZ UBER
01	1039 MATL WAS 1018	08/07/2014	CZ UBER
02	ADDED REFERENCE CHAMFERS, .180 PROFILE TOLANCE WAS .120	08/10/2014	CZ UBER



- NOTE:
1. ROD MATERIAL SHALL MEET PHYSICAL REQUIREMENTS (SEE TABLE)
  2. CAD GEOMETRY CONSIDERED BASIC FOR DIMENSIONS NOT SHOWN
  3. UNLESS OTHERWISE SPECIFIED, ENTIRE PART:  $\triangle (.180) (A)$
  4. INTERPRET DRAWING PER ASME Y14.5-2009
  5. PART SHALL BE FREE OF BURRS AND SHARP EDGES

MINIMUM PHYSICAL PROPERTIES		
TENSILE STRENGTH	YIELD STRENGTH	HARDNESS
85,000 PSI (586 MPa)	75,000 PSI (517 MPa)	170 BHN

(342)

PROJECTION	DRW	CZ UBER	DATE	08/11/2014
PROJ. NO.	R350	APPROVED BY	[Redacted]	
SIMILAR PART	711-04999	STATUS	P-Production	DATE
			07/30/2014	
SEE NOTES			ITEM DESCRIPTION	
			ROD: TIE: STRG: RH	
SIZE	D	ITEM NO.	747-06457	
SCALE	N/A	EST. WT.		

SHEET 1

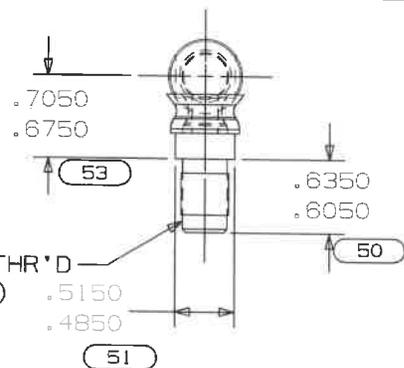
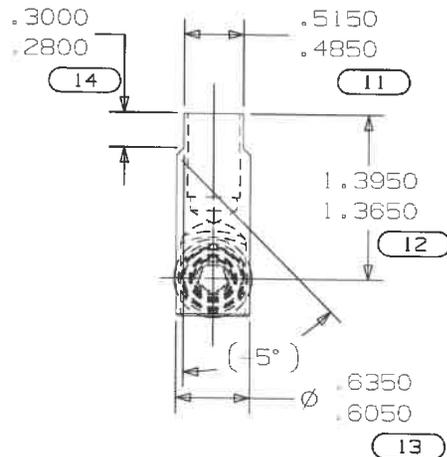
ITEM NO. 723-05009

STATUS P-Production

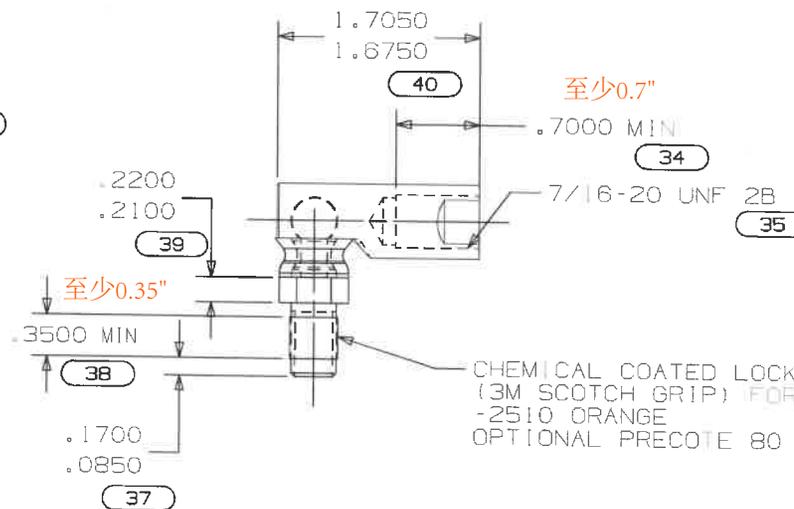
REV 01

REVISIONS

REV	DESCRIPTION	DATE	BY
00	INITIAL RELEASE	04/11/2014	CZIMMERM
01	REMOVED LIMIT FEATURE, FINISH WAS YELLOW ZINC	04/29/2014	CZIMMERM



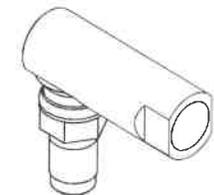
3/8-24 UNF 2A THR'D



至少0.7"

至少0.35"

CHEMICAL COATED LOCK - IFI-125  
(3M SCOTCH GRIP) FOR TEMP 160° TO 200°F  
-2510 ORANGE  
OPTIONAL PRECOTE 80 PINK THREADCOATING



NOTES:

- PATCH MUST CONFORM TO IFI-125
  - PREVAILING ON TORQUE = 48 IN/LBS MAX
  - BREAKAWAY TORQUE = 60 IN/LBS MIN
  - PREVAILING OFF TORQUE = 36 IN/LBS MIN.
- MALE END OF BALL JOINT MUST WITHSTAND 1,500 LBS PULL MINIMUM BEFORE JOINT FAILS.

Key Characteristic  
Major Characteristic

PROJECTION		DRAWN BY	CZIMMERM	DRAWN DATE	04/10/2014
PROJ. NO.	R350	APPROVED BY	emusal		
SIMILAR PART	723-0448A	RELEASE STATUS	P-Production	RELEASE DATE	06/11/2014
MATERIAL		NULL			
FINISH		BLACK ACRYLIC E-COAT PER MTD SPEC-000096			
ITEM DESCRIPTION	B/JNT: 7/16-20:LOCK:BLK				
SIZE	B	ITEM NO.	723-05009	REV	01
SCALE	1/1	EST.WT.		SHEET	1 OF 1

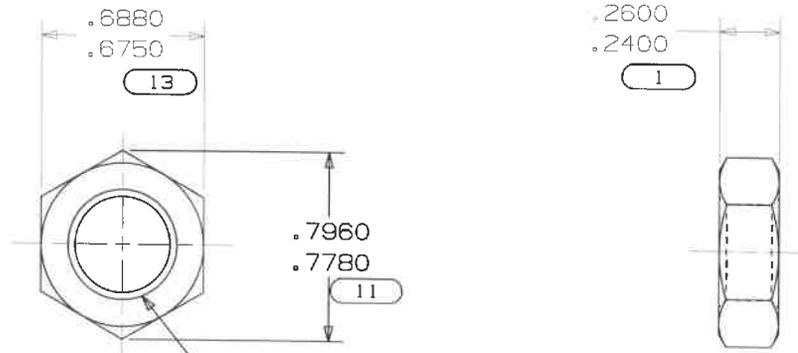
ITEM NO. 712-05093

STATUS P-Production

REV 01

REVISIONS

REV	DESCRIPTION	DATE	BY
00	INITIAL RELEASE	05/02/2014	CZIMMERM
01	FINISH WAS SPEC-000087	08/06/2014	CZIMMERM



7/16-20 UNF 2B THREAD

NOTE:

1. PART MUST CONFORM TO ANSI/ASME B18.2.2
2. MATERIAL: GRADE 2 OF SAE J995 AS SPECIFIED.
3. FINISH: COAT WITH ZINCROSEAL BP

PROJECTION		DRAWN BY	CZIMMERM	DRAWN DATE	04/29/2014	
PROJ. NO.	R350	APPROVED BY	<i>phelin</i>			
SIMILAR PART	712-0240	RELEASE STATUS	P-Production	RELEASE DATE	10/02/2014	ITEM DESCRIPTION
		MATERIAL	SEE NOTE			NUT: JAM: 7/16-20: GR2: BLK
		FINISH	SEE NOTE			SIZE
						B
						ITEM NO.
						712-05093
						SCALE
						2/1
						EST. WT.
						SHEET 1 OF 1
						REV
						01

◇ = Key Characteristic  
△ = Major Characteristic