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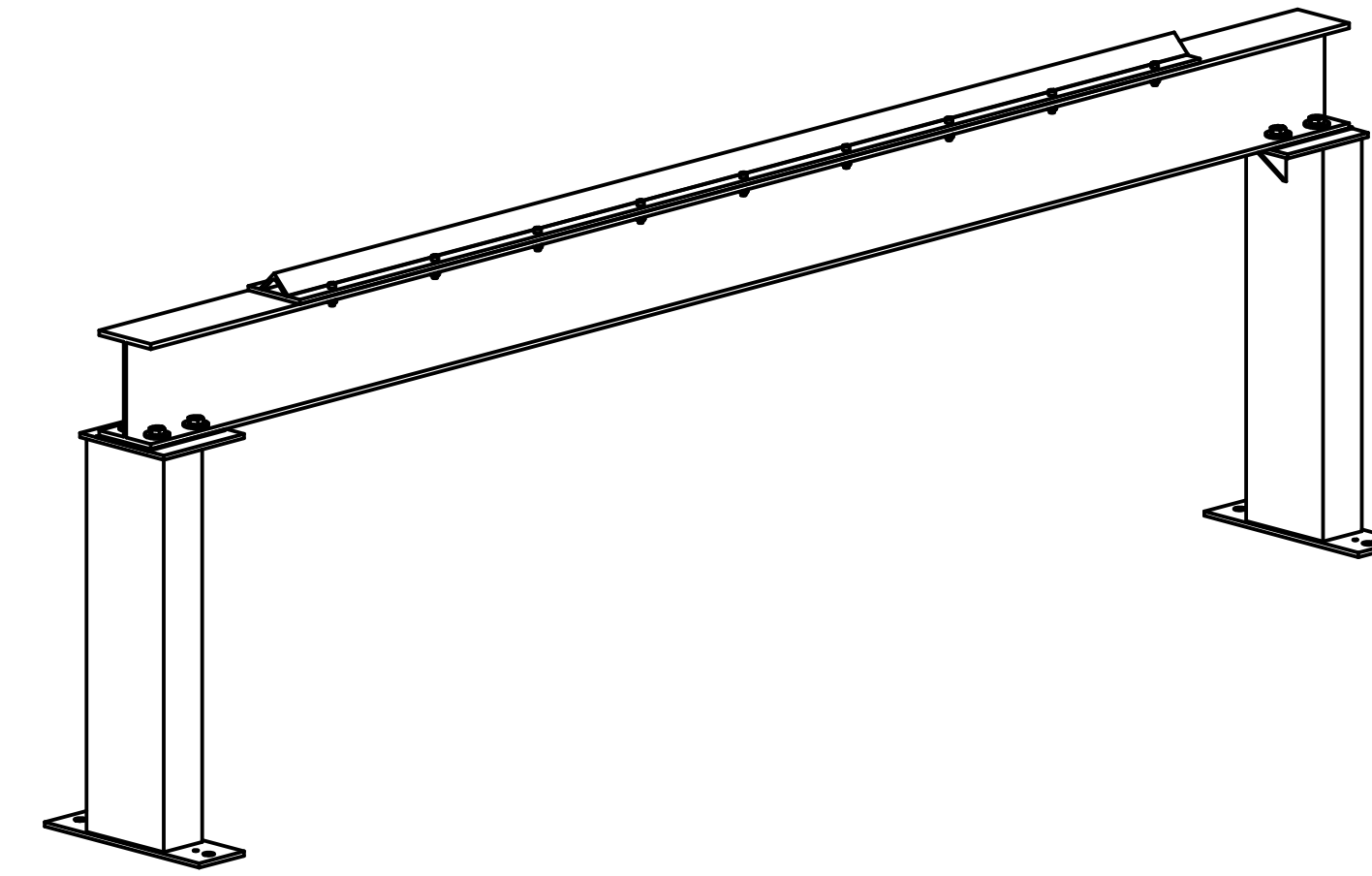
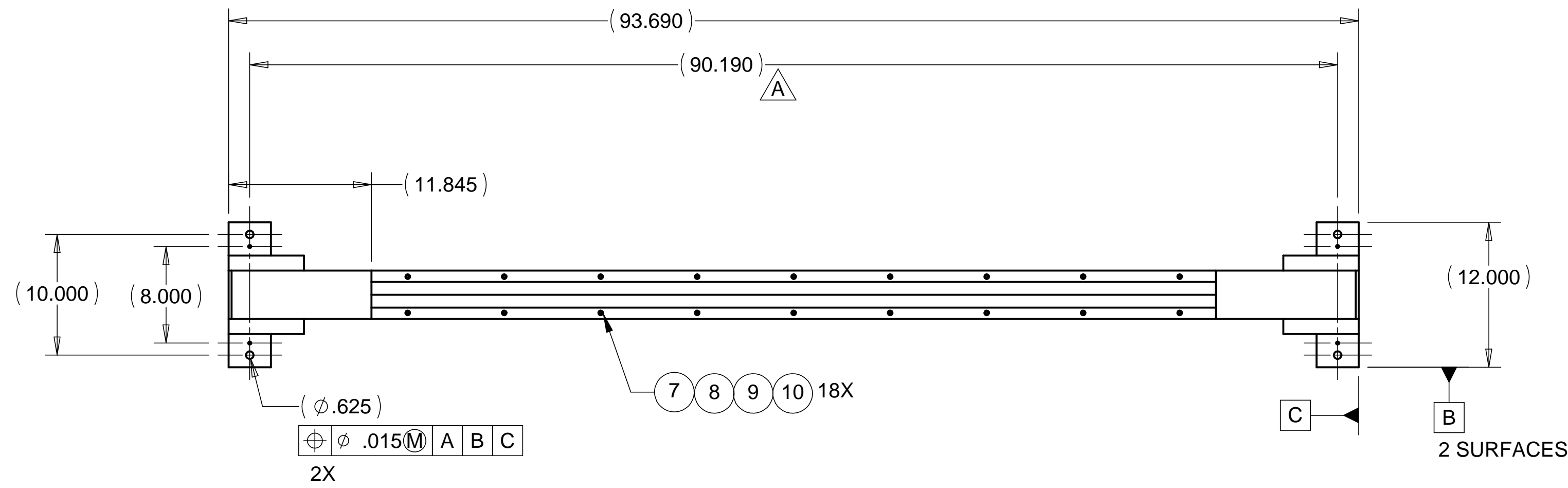
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	REVISED ASSORTED DIMENSIONS	314/98	WKM

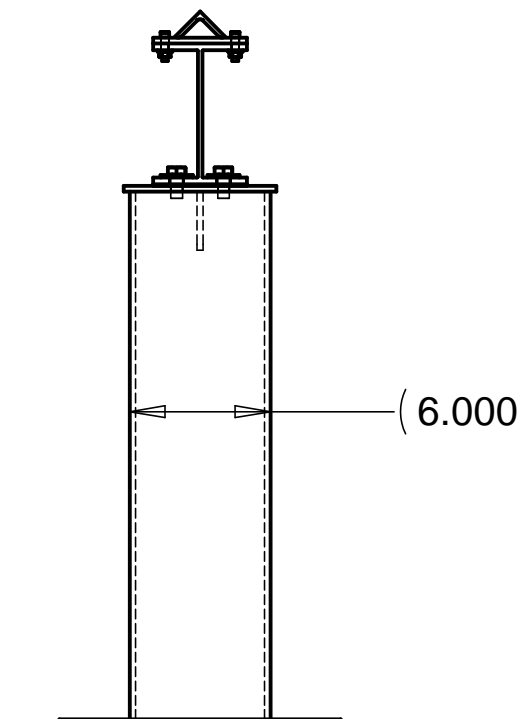
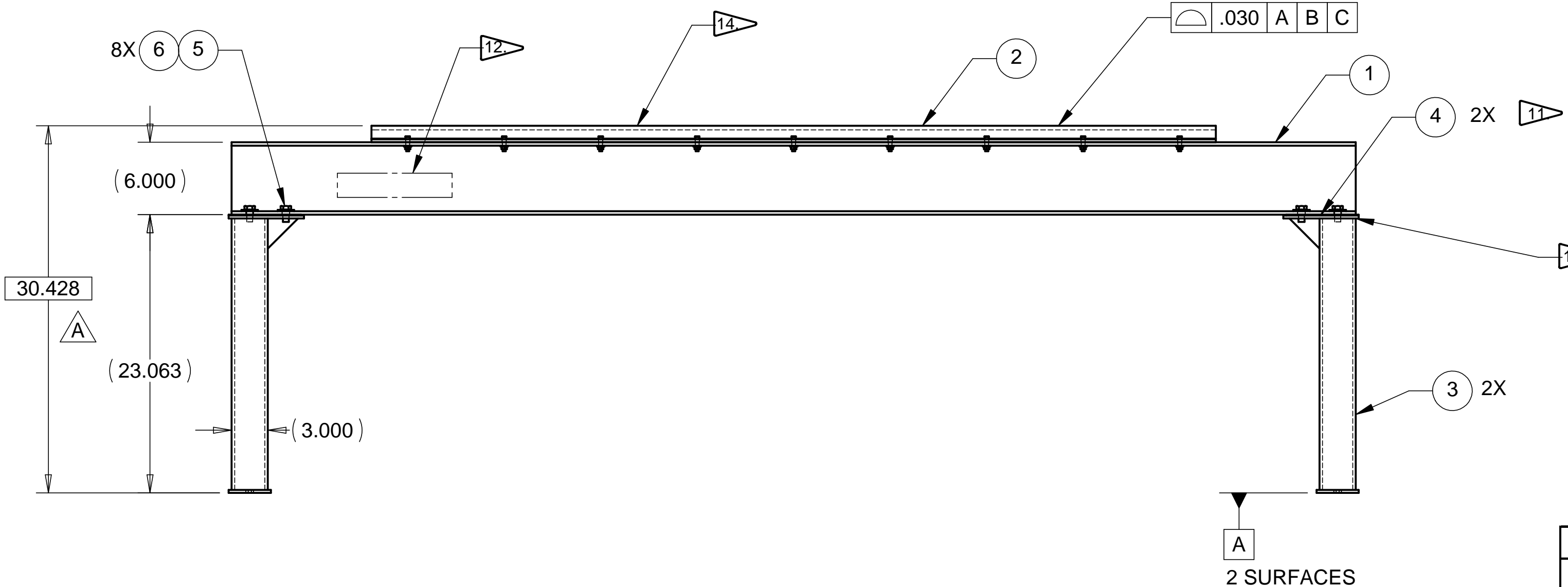
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NOTES: UNLESS OTHERWISE SPECIFIED

- ALL DIMENSIONS IN INCHES
- DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
- SURFACE TEXTURE PER ANSI/ASME B 46.1-1985
- REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .015
- ALL INSIDE CORNERS TO BE .015 RADIUS MAX
- COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
- COUNTERSINK 82 DEGREES APPROXIMATELY .015 DEEP ALL DRILLED HOLES
- PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT, AND CHIPS.
- PART NUMBER (DRAWING NO. PLUS DASH NO. PLUS SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF.
- PART WEIGHS 130 Lbs.
- MACHINE SHIM THICKNESS TO ACHIEVE FINAL DIMENSIONS.
- PAINT ON SIDE: DO NOT DIS-ASSEMBLE ASSEMBLY.
- STAMP ALL PIECES OF THE ASSEMBLY WITH AN ASSEMBLY SERIAL NUMBER.
- USE PLATE SHIMS TO ACHIEVE PROFILE TOLERANCE.

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	D972938-1	HAM RAIL SYSTEM MAJOR RAIL
2	1	D972939-1	HAM RAIL SYSTEM MAJOR RAIL WELDMENT
3	2	D972940-1	HAM RAIL SYSTEM SPACER COLUMN WELDMENT
4	AR	D972956-1	HAM RAIL SYSTEM MAJOR RAIL SHIM
5	8	STD HARDWARE	HEX HEAD BOLT, 1/2-13 UNC-2A X 1.25 LONG
6	8	STD HARDWARE	WASHER, 1/2 FLAT
7	18	STD HARDWARE	SOCKET HEAD CAP SCREW, 1/4-20 UNC-2A X 1.25 LONG
8	18	STD HARDWARE	WASHER, 1/4 FLAT
9	18	STD HARDWARE	LOCKWASHER, 1/4"
10	18	STD HARDWARE	HEX NUT, 1/4-20 UNC-2B

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		HYTEC, INC	
DECIMALS .XX = +/- .03 .XXX = +/- .010		ANGULAR = +/- .30° SURFACE FINISH = 250		TITLE HAM RAIL SYSTEM MAJOR RAIL ASSEMBLY	
FINISH		SIGNATURE	DATE	DWG. NO.	SHEET NO.
		DESIGNED	W. K. MILLER	1/3/98	
		DRAWN	W. K. MILLER	1/3/98	
		CHECKED	HARRY SALAZAR	2/4/98	
		ENGR.	T. THOMPSON	2/4/98	
		APPROVED	T. THOMPSON	2/4/98	
PART NO.	D972886-1	SCALE	1/8		REVISION A

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