r		Α		В		С		D		Е		F			G		н		I			J	
		TEC														Chang	REVISION	NS					
1	NOIES														Descri	ption			Sht	Zone	Date	By	Chk
	1. Material: 2002398- Reduced Clicker Head (typically 4140 alloy steel).											Initial Re	vision						-	-	21Aug12	RH	FA
	Weld in 5/32" hex key from top. Recess key to leave sufficient room for weld.											Shorten	ed hex l	length.					1	F7			
	Ensure weld does not protrude above noted surface. It's acceptable to post-grind										A	Allowed	post-gr	inding o	of weld to I	make flu	ish.		1	A1	24May17	RH	RW
	~ `	weld flush	as neces	sary.								Added p	ost-wel	ding he	at-treatme	ent to en	sure nex l	key streng	th. 1	A2			L
	3.>	Shorten h	ex key to	specified l	ength.																		
2	4.	After weld	ling re-hai	rden part to	o strengthe	en hex key	(it may hav	e softened	due to														
	,	welding te	emperatur	e).																			
	1	. Heat t	o 1550 F																				
	2	2. Queno	ch in oil						_														
	- 3	3. Imme	diately aft	er quenchi	ing (ideally	y while still	warm) temp	per at 500	F														
	5. 0	Cleanlines	ss: Part sl	nall be deli	vered visil	bly clean, to	o the norma	l unaided	eye, of all														
3		particulate 	e matter a	nd non-pa	rticulate fil	Im matter.																	
	6.	Torque a	10-32 SH	C screw to	50 in*lb a	and verify h	ex key did n	ot yield.															
	7. 1	Interracing Disharant	g Parts: 10	0-32 SHC :	Screw in C	SD Back I	Plate, CCM	501 Sturte	vant														
	I	Richmont	torque wi	encn.																			
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									1. All dimens	sions are in inche	s Unles	s Otherwi	se Spe	cified		N	B/Max_surfac	e Material	TITLE				
ð	Æ			PROPRIE The information	TARY & CON	FIDENTIAL this drawing, or any re	eproduction thereof. is	proprietary	2. Interpret p 3. Dimension	per ASME Y14.5-2 ns apply AFTER a	2009 all surface tr	eatments	.XXXX ±.	I oleran	ces • Ø .010 A	ыс	/ roughness	see Note 1	We	elded	Clicker H	ead	
		\sim		information for manufac	and the property o	of PSC. It shall not be procurement, witho	disclosed, copied, dup out PSC's express writte	blicated or used en permission.	4. Remove a 5. Internal sh	all burrs and sharp harp edges may h	o edges, R.0 ave R.01 m)1 max ax	.XXX ±.00	05	010 A B	C	Projection	Do not scale from			02/01		REV
	1	BY ROCKE	ET LAB	2303 Kansa	as Avenue, Silver S	pring, MD 20910	(301) 495-0737		7. Inspect al	eptns are a minim I numbered dimer	um Isions.		.x ±.03 X ±.2	Ho	le diameters :	±.003	\oplus	drawing	SCALE 1:1	CAGE	CODE: 1PHA7	SHEET 1	OF 1