



Notes:
Unless Otherwise Specified

1. MATERIAL:
1/2" ASTM-A36 FLAT BAR
1.00" X1.00" C1018 FLAT BAR

2. PROCESS:
1. WELD ASSY PER PRINT
WIRE FILLER, ER70 (70 KSI TENSILE STRENGTH)
AWS D1.1
2. INSPECTION #1
3. SANDBLAST, 40 GRIT ALUM. OXIDE OR EQUIV.
4. ZINC PHOSPHATE, TYPE Z CLASS 3 MIL-P-16232E
5. BLACK POWDER OCAT, TGIC POLYESTER BASED
T001-BK120,10% GLS
6. INSPECTION #2
3. FINISH: BLACK

4. DEBURR ALL SHARP CORNERS AND EDGES

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL: ± 1/64
ANGULAR: MATCH ± 5°
TWO PLACE DECIMAL: ± .03
THREE PLACE DECIMAL: ± .01

INTERPRET GEOMETRIC TOLERANCING PER:
MATERIAL:
FINISH:

NEXT ASSY:		TITLE: CGF Center of Gravity Head	
USED ON:	PL12-PFB	SIZE:	DWG. NO. 1-0850
SIZE:	B	REV:	01
SCALE: 1:3	WEIGHT: 8.38 LBS	SHEET 1 OF 1	

DO NOT SCALE DRAWING