



NOTES:
1-FINISH 125/
2-ALL EDGES SHALL BE BROKEN .005+ .010 UNLESS OTHERWISE SPECIFIED.
3-MATERIAL:
A- FOR WROUGHT MATERIAL:
STEEL, SPEC ASTM A304, A322, A331, 8620.
B- FOR PRECISION CASTING:
STEEL, MIL-S-22141: 1C-8620.
TENSILE TEST SHALL NOT APPLY.
CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH CLASS 2, GRADE B, SPEC MIL-STD-2175, CLASS 2.

4-HEAT TREATMENT: (FOR MATERIALS A AND B) CARBURIZE AT 1575°-1600° F FROM .008 TO .012 DEPTH. OIL QUENCH. TEMPER 30 MIN AT 350° TO 375° F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. MIL-W-13855 SHALL APPLY.

POSITION NUMBERS	NUMBER OF POSITIONS	NO. OF FILMS	NO. OF VIEWS PER FILM	FILM SIZE
1	1	1	400 TO 420	14 X 17

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