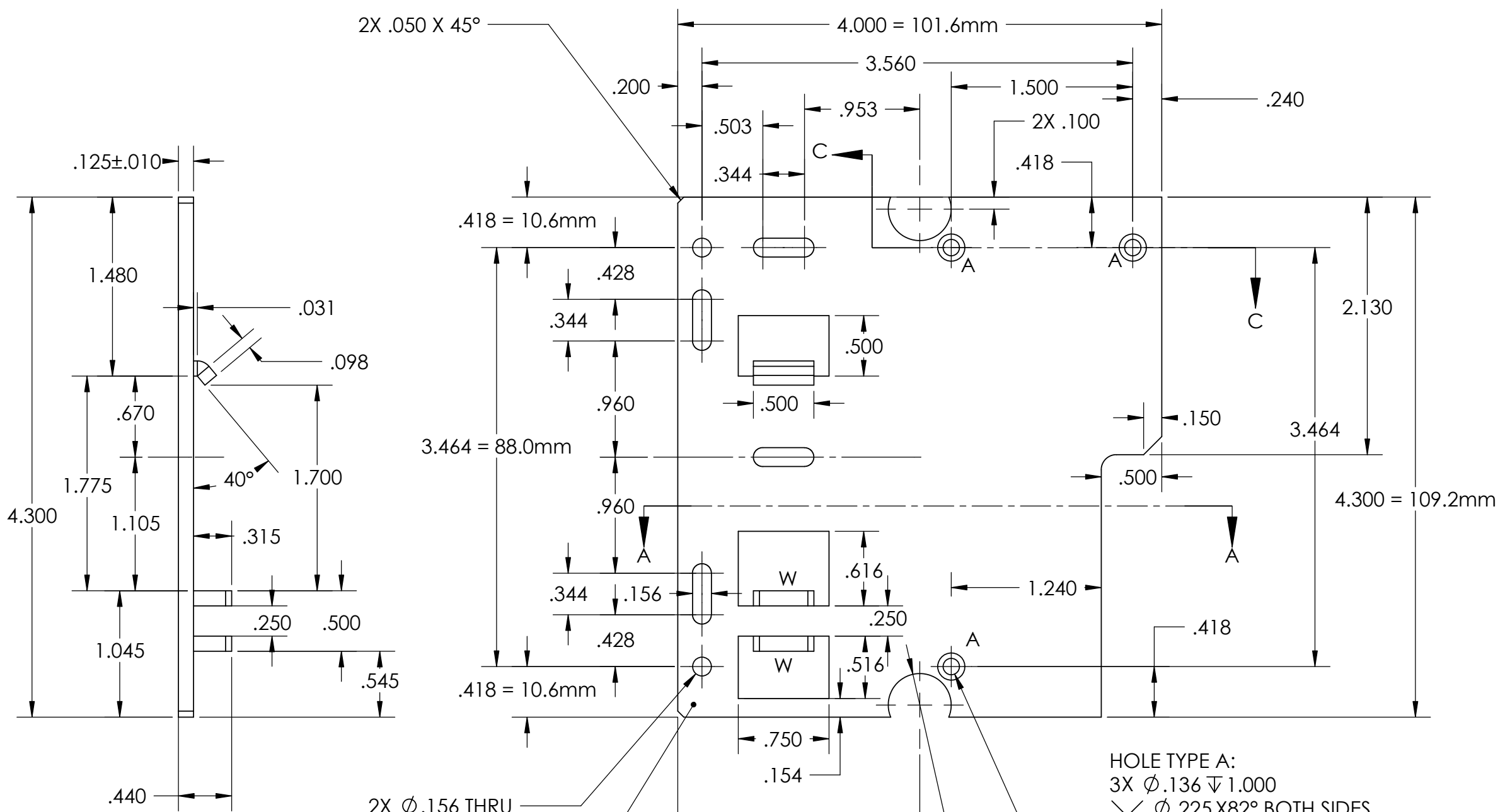
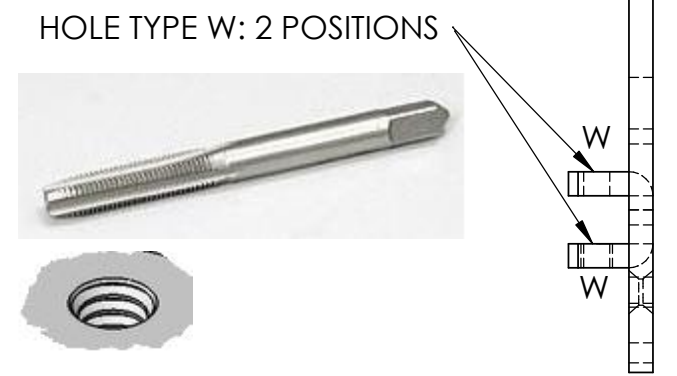
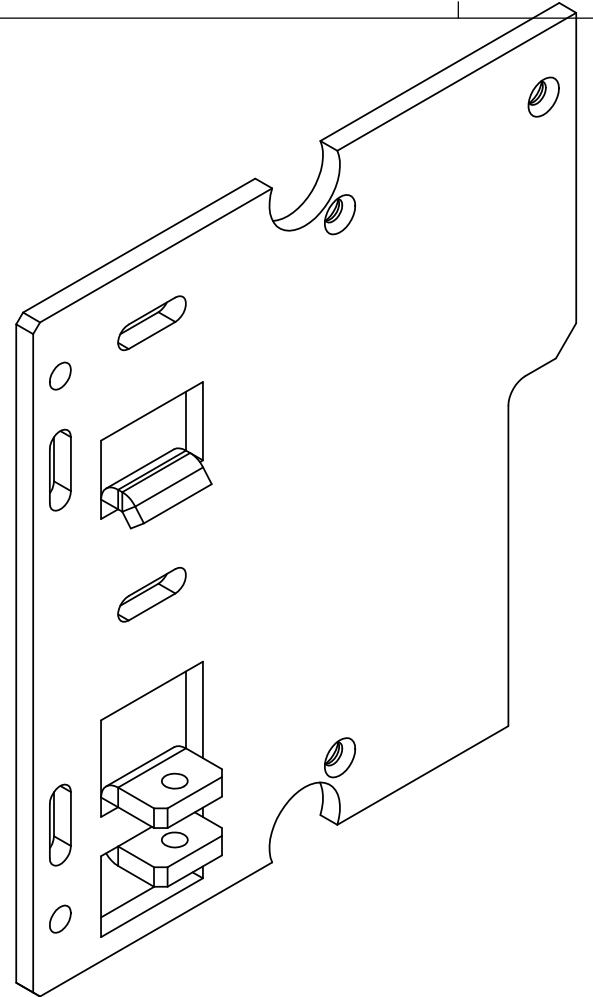
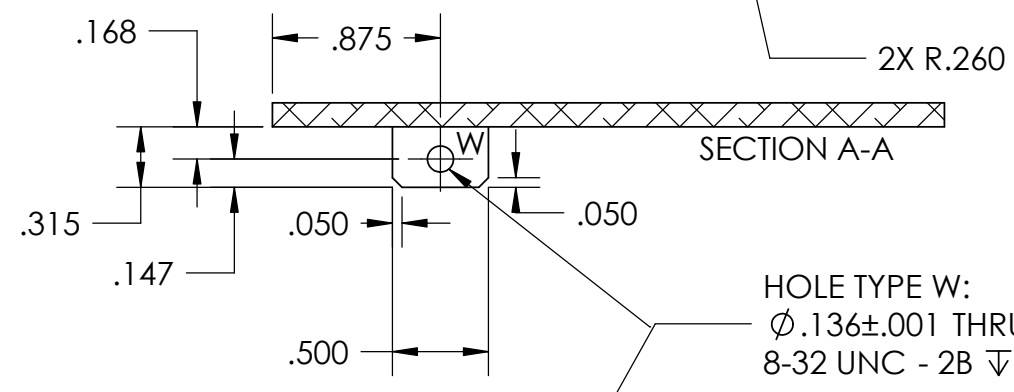


REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	2	ADD 8-32 TAP, MOVE R.25		
	3	REVISED FINISH NOTE		
	5	Made holes symmetrical, 1/20/08		



HOLE TYPE A:  
 3X Ø.136 ±.001  
 ✓ Ø.225 X 82° BOTH SIDES.  
 COUNTER SINK IS DONE FROM BOTH SIDES. THIS ALLOWS FLAT HEAD SCREW FROM EITHER DIRECTION. THIS OCCURS IN 3 PLACES. THIS INVOLVES DRILLING HOLE 0.136" DIAMETER THAT GOES THROUGH THE MATERIAL, AND THEN COUNTER SINK FROM BOTH SIDES SO THAT OUTER RIM DIAMETER IS 0.225" ON BOTH TOP AND BOTTOM SURFACE.



HOLE TYPE W:  
 Ø.136±.001 THRU  
 8-32 UNC - 2B ±.125  
 TAP 8-32 THREADS THRU 2 WALLS WITH THE SAME TAP TO ALIGN THE THREADS IN BOTH WALLS. TAP MUST BE AT LEAST 0.500 INCHES LONG TO ACCESS BOTH 0.125" THICK WALLS AT SAME TIME. THERE ARE 2 WALLS THAT NEED 8-32 TAP. THIS INVOLVES DRILLING .136" DIAMETER THRU TWO WALLS AND THEN TAPPING 8-32 THROUGH TWO WALLS AT THE SAME TIME. THE 0.136" MUST BE 0.136" DIAMETER +0.001 ELSE THE BOLT WILL BE TOO LOOSE OR TOO TIGHT.



- NOTES:
- MAT'L: ALUM ALLOY 5052-H32, 0.125 +-.0010 INCHES THK (e.g. 3.0mm = 0.118)
  - FINISH PER ENCLOSED DOCUMENT "i4xx Standard Product Finish.doc".  
 A) TEXTURE MUST BE APPLIED TO BOTH SIDES (TOP AND BOTTOM), AS NOTED ON DWG
  - REMOVE ALL BURRS AND SHARP EDGES .025 MIN R
  - THIS BRACKET TO INTERFACE WITH:  
 A. QTY 3 SCREW, 82° FLAT HD, 4-40UNC X .25" LG, SS, McMASTER P/N 91771A106  
 B. QTY 1, SCREW, PAN HD PHILLIPS, 8-32UNC X 1.50" LG, SS, McMASTER P/N 91772A203  
 C. QTY 1, NUT, ACORN, 8-32, 0.312 W, 0.281 H, 1 solid machined piece, McMASTER P/N 92718A391
  - WRAP AND PACK SO THAT FINISH IS NOT SCRATCHED IN SHIPPING.

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UNLESS OTHERWISE SPECIFIED:		NAME	DATE
DIMENSIONS ARE IN INCHES	TOLERANCES:	DRAWN	JDM 10/04
FRACTIONAL ±	ANGULAR: MACH ± 1° BEND ±	CHECKED	
TWO PLACE DECIMAL ±.01	THREE PLACE DECIMAL ±.005	ENG APPR.	
		MFG APPR.	
INTERPRET GEOMETRIC TOLERANCING PER:		Q.A.	
MATERIAL		COMMENTS:	
FINISH			
NEXT ASSY	USED ON		
APPLICATION	DO NOT SCALE DRAWING		

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TITLE: MtgBrkt2		
SIZE: C	DWG. NO.	REV 5
SCALE: 1:1	WEIGHT:	SHEET 1 OF 1