[redacted]

B	125417

REVISION STATUS OF SHEETS	REL. CLASS
REVISION STATUS OF ALL SHEETS OF THIS DRAWING IS THE SAME AS SHOWN ON SHEET 1	

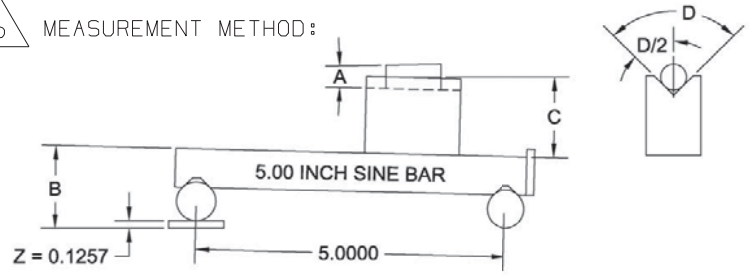
REFERENCE FILE
CHECK REVISION BEFORE EACH USE

REVISIONS

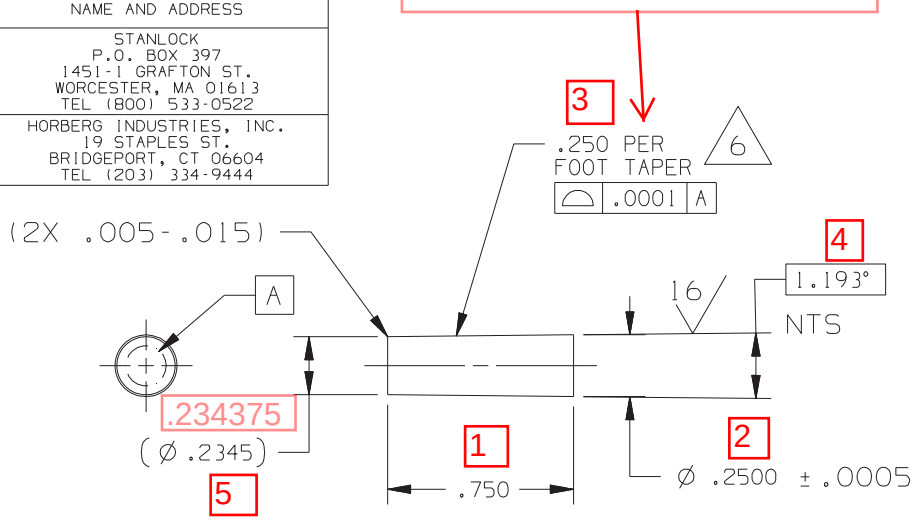
LTR	DESCRIPTION	DATE	APPROVED	
B	SEE EO: UCS025827	20150319	TK	BK

.250 taper per foot = .015625 taper per part

6 MEASUREMENT METHOD:



SUGGESTED SOURCE(S) OF SUPPLY		
SUPPLIER DATA		
CAGE CODE	SUPPLIER PART NO.	NAME AND ADDRESS
02972	124517	STANLOCK P.O. BOX 397 1451-1 GRAFTON ST. WORCESTER, MA 01613 TEL (800) 533-0522
91596	124517	HORBERG INDUSTRIES, INC. 19 STAPLES ST. BRIDGEPORT, CT 06604 TEL (203) 334-9444



VENDOR ITEM CONTROL DRAWING

IDENTIFICATION OF SUGGESTED SOURCE(S) OF SUPPLY HEREON IS NOT TO BE CONSTRUED AS A GUARANTEE OF PRESENT OR CONTINUED AVAILABILITY AS A SOURCE OF SUPPLY FOR ITEM(S) DESCRIBED ON THE DRAWING.

EXAMPLE USING A 5.00 SINE BAR AND 90 DEGREE V-BLOCK:
Z = sin(B) * 5.000
B = (C + A/2)
A = INCLUDED ANGLE = atan (.250/12.0) = 1.19349 DEGREES
D = 90 DEGREES

sin C = (sin A/2)/(sin D/2)
sin C = sin (1.19349/2)/(sin (90/2)) = 0.01041/0.70711 = 0.01473

C = asin(0.01473) = 0.84394 DEGREES
B = (C + A/2) = (0.84394 = (0.19349/2)) = 1.44068 DEGREES
Z = sin (1.44068) * 5.00 = 0.1257

5. TRACEABLE BY LOT NUMBER.

4 PASSIVATE PER SAE-AMS 2700 METHOD 1, TYPE 1 OR 2 RESPECTIVELY.

3 CRES: 303 PER ASTM-A582 OR 304 PER SAE-AMS-QQ-S-763.

2. ALL FILLETS R.017 MAX.

1. DEBURR AND BREAK SHARP EDGES.005-.015.

NOTES (UNLESS OTHERWISE SPECIFIED):

[redacted]

QPA	PART NUMBER	DESCRIPTION	REFERENCE DESIGNATOR	ITEM NO.
	125417	PIN, TAPER		

PARTS LIST

UNLESS OTHERWISE SPECIFIED:
APPLICABLE STANDARDS/SPECIFICATIONS
6100-001-010 MOOG DRAFTING ROOM MANUAL
ASME Y14.5-1994 DIMENSIONING & TOLERANCING
DIMENSIONS ARE IN INCHES
DIMENSIONS APPLY AFTER FINISH 32
COAXIAL FEATURES Ø .003 Ⓢ

THIRD ANGLE PROJECTION

DIM. TOLS:	HOLE TOLERANCES:	
.0 ±.03	.0135 - .125	+.004 -.001
.00 ±.01	.126 - .250	+.005 -.001
.000 ±.005	.251 - .500	+.006 -.001
ANGLES ±1°	.501 - .750	+.008 -.001

LAST SECTION/DATUM

CONTRACT NO. 2814
APPROVAL

MATERIAL 3
HEAT TREAT
FINISH 4
SIMILAR TO
NEXT ASSY STD
USED ON STD

[redacted]

TITLE PIN, TAPER

SIZE	CAGE CODE	DWG NO.	REV
B	29371	125417	B

SCALE 2/1 WT SHEET 1 OF 1

[redacted]

Inspected By: Robert Elston

CUSTOMER	PO	DESCRIPTION	REV.	REPORT #	DATE	PAGE 1 OF 1
TRANSPEC FASTENER INC	170626-1	TAPER PIN	B	EMI052215	05/22/15	
	DWG. NO: 125417					

DIM #	BLUEPRINT DIMENSION	TOLERANCE PLUS	TOLERANCE MINUS		METHOD	1	OUT OF TOL.	2	OUT OF TOL.	3 taper	OUT OF TOL.	4 Angle	OUT OF TOL.	5 small dia [Ref Dimen]	OUT OF TOL.	MEAS AS ANGLE	OUT OF TOL.
1	0.750	0.005	0.005	1	INDICATOR 1	0.7504		0.2498		0.2623	0.0122	1.2523	0.0540	0.2334	-0.0011	1.2660	0.0677
2	0.2500	0.0005	0.0005	2	VIDEO 1	0.7498		0.2502		0.2657	0.0156	1.2686	0.0703	0.2336	-0.0009	1.2560	0.0577
3	0.2500	0.0001	0.0001	3	VIDEO 1	0.7518		0.2502		0.2634	0.0133	1.2576	0.0593	0.2337	-0.0008	1.2520	0.0537
4	1.1930	0.0053	0.0053	4	VIDEO 1	0.7509		0.2502		0.2353	-0.0146	1.2667	0.0684	0.2336	-0.0009	1.3060	0.1077
5	0.2345	0.0000	0.0000	5	VIDEO 1	0.7478		0.2501		0.2632	0.0131	1.2567	0.0584	0.2337	-0.0008	1.2570	0.0587
4	1.1930	0.0053	0.0053	6	VIDEO 1	0.7498		0.2502		0.2689	0.0188	1.2839	0.0856	0.2334	-0.0011	1.2960	0.0977
				7		0.7492		0.2502		0.2547	0.0046	1.2161	0.0178	0.2343	-0.0002	1.2990	0.1007
				8		0.7496		0.2499		0.2561	0.0060	1.2231	0.0248	0.2339	-0.0006	1.3130	0.1147
				9		0.7496		0.2503		0.2609	0.0108	1.2460	0.0477	0.2340	-0.0005	1.3090	0.1107
				10		0.7503		0.2503		0.2687	0.0186	1.2830	0.0847	0.2335	-0.0010	1.3120	0.1137

[redacted]