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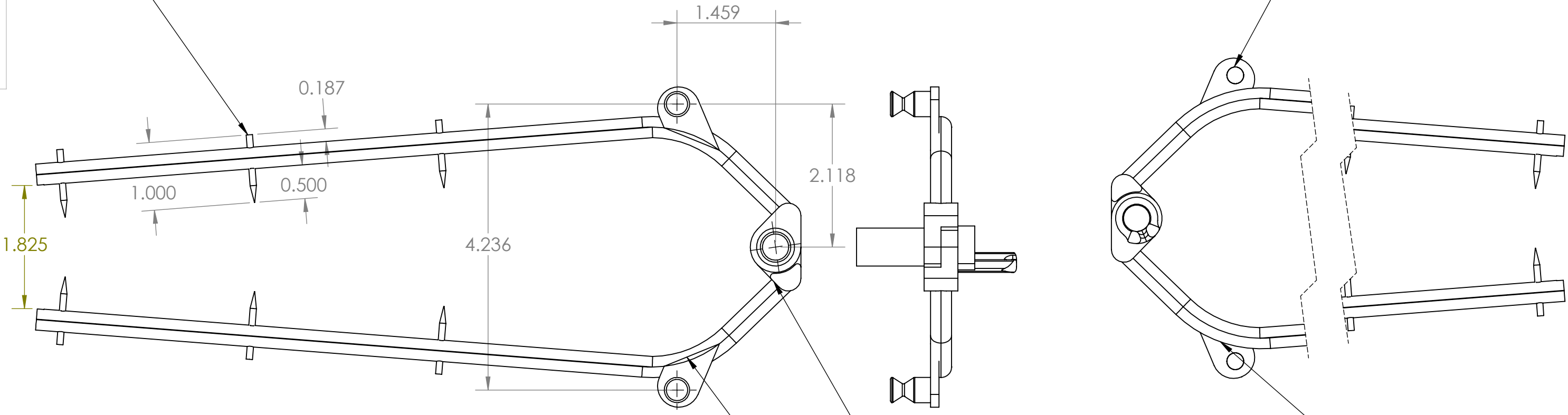
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE		

Weld Drawing Shark Cafe Clamp Assembly

20 each assemblies

Fuse weld flush 6 places No filler

Fuse weld all around
No filler 2 places



Manufacture Notes

- 1. Material is Commercially Pure Titanium Grade 2
- 2. Filler material will be Commercially Pure Titanium Grade 2
- 3. All welds will be GTAW w/!00 % Argon shield gas
- 4. Parts will be cleaned w/acetone prior to welding
- 5. All parts will be provided
- 6. Weldment will be flat & true +/- 1/16"

1/8 " Fillet all around 2 places

1/8 " Fillet 2 places

1/8 " Butt 2 places

BILL OF MATERIALS			
NEXT ASSY Description	NEXT ASSY Number	UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:	APPROVALS DATE
		1 PLACE DIM ±1/16 2 PLACE DIM ±.02 3 PLACE DIM ±.005 ANGLES ±1°	DRAWN 07/15/17
THIRD ANGLE PROJECTION		1. DIMENSIONS ARE IN INCHES 2. DIMENSION LIMITS HELD AFTER PLATING. 3. REMOVE BURRS AND SHARP EDGES .015 MAX. 4. MACHINED FILLET RADII .0150-.030. 5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005 6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.	ENGINEER L. Bird
			CHECKED
			PROJECT NO. 900701
			PROJECT AMP
		DO NOT SCALE DRAWING	WEIGHT
		SCALE 1:4	CAD FILE: SHEET 1 OF 1

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Shark Cafe Clamp

SIZE B DWG. NO. 1002536 Rev A REV

Status: