


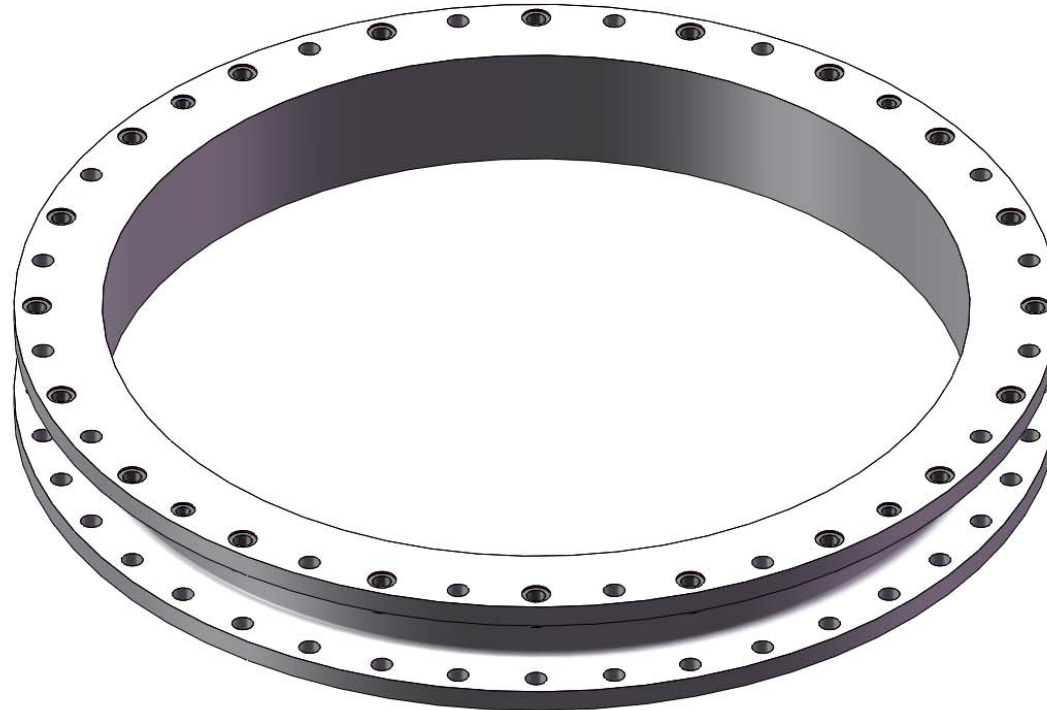


NOTES

1. Material: Al-Aly 6061-T6 per AMS 4025, AMS 4027 or AMS-QQ-A-250/11.
2.  Part Marking: Engrave Part Number, Revision and PO as noted. .15 tall X .010 max depth.
3.  Install Key Insert, McMaster-Carr P/N 92070A245 (or equivalent), 1/4-28 int, 3/8-16 ext thread. Install per manufacturer's specification. Recess .01" to .03" below surface.
4.  Install Key Insert, McMaster-Carr P/N 92070A240 (or equivalent), #10-32 int, 5/16-18 ext thread. Shorten insert such that it is recessed .005" to .015" below both surfaces. Otherwise install per manufacturer's specification.
5. Remove any burrs and break all sharp edges
6. Cleanliness: Part shall be delivered visibly clean, to the normal unaided eye, of all particulate matter and non-particulate film matter.

REVISIONS

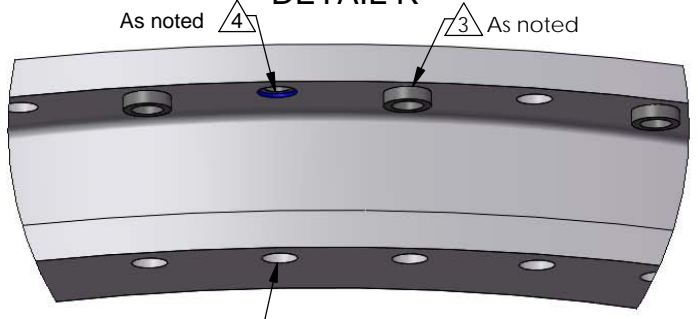
Rev	Change Description	Date	By	Chk
C	Added Key inserts and updated design table	22-Jul -11	RW	RH
D	Made drawing limited dimension. Increased qty. of #10-32 key inserts. Reduced -8 ϕ C. Corrected ϕ C & ϕ D for sizes -11, -18, -19, -23, -38. Added -24 size. Removed -37 and all sizes above -38. Added engraving. Loosened flatness tolerance.	23-Dec-13	RW	RH
E	Notes 3 & 4: Updated key install installation specs. Notes 3 & 4: Removed tang direction requirement. Note 4: Decreased recess depth to increase thread engagement. Sheet 2: Added dimension inspection call-outs, made some dimensions basic. General: Updated to latest PSC standards and format.	28-Jun-16	AZ	CF



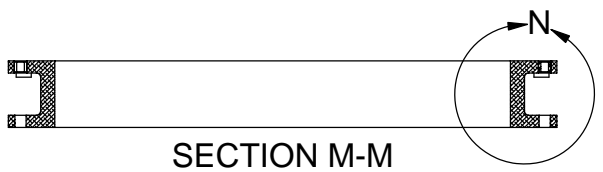
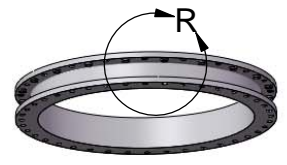
<p>1. All dimensions are in inches. Unless Otherwise Specified</p> <p>2. Interpret per ASME Y14.5-2009.</p> <p>3. Dimensions apply AFTER all surface treatments.</p> <p>4. Remove all burrs and sharp edges, R0.01 max.</p> <p>5. Internal sharp edges may have R0.01 max.</p> <p>6. Thread depths are a minimum.</p> <p>7. Inspect all numbered dimensions.</p>		<p>32/ Max surface roughness</p> <p>Third Angle Projection</p>	<p>Material: see Note 1</p> <p>Do not scale from drawing</p>	<p>Tolerances</p> <table border="1"> <tr> <td>.XXXX ±.001</td> <td>.XXX ±.005</td> <td>.XX ±.01</td> <td>.X ±.03</td> <td>X ±.2</td> </tr> </table> <p>Hole diameters ±.003</p>	.XXXX ±.001	.XXX ±.005	.XX ±.01	.X ±.03	X ±.2	<p>TITLES</p> <p>Transition Ring</p>	<p>SIZE A</p> <p>NUMBER 2000741-</p> <p>SCALE 0.4:1</p>	<p>REV E</p> <p>CAGE CODE: 1PHA7</p> <p>SHEET 1 OF 3</p>
.XXXX ±.001	.XXX ±.005	.XX ±.01	.X ±.03	X ±.2								

A B C D E F G H I J

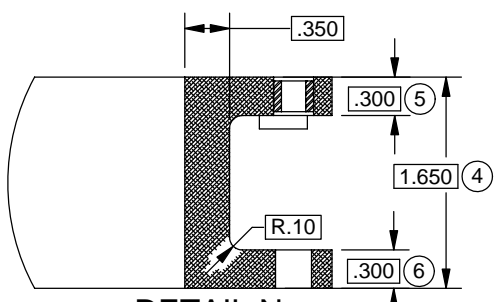
DETAIL R



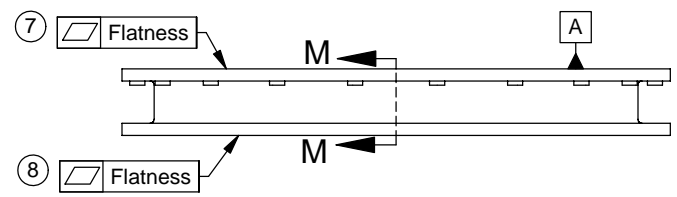
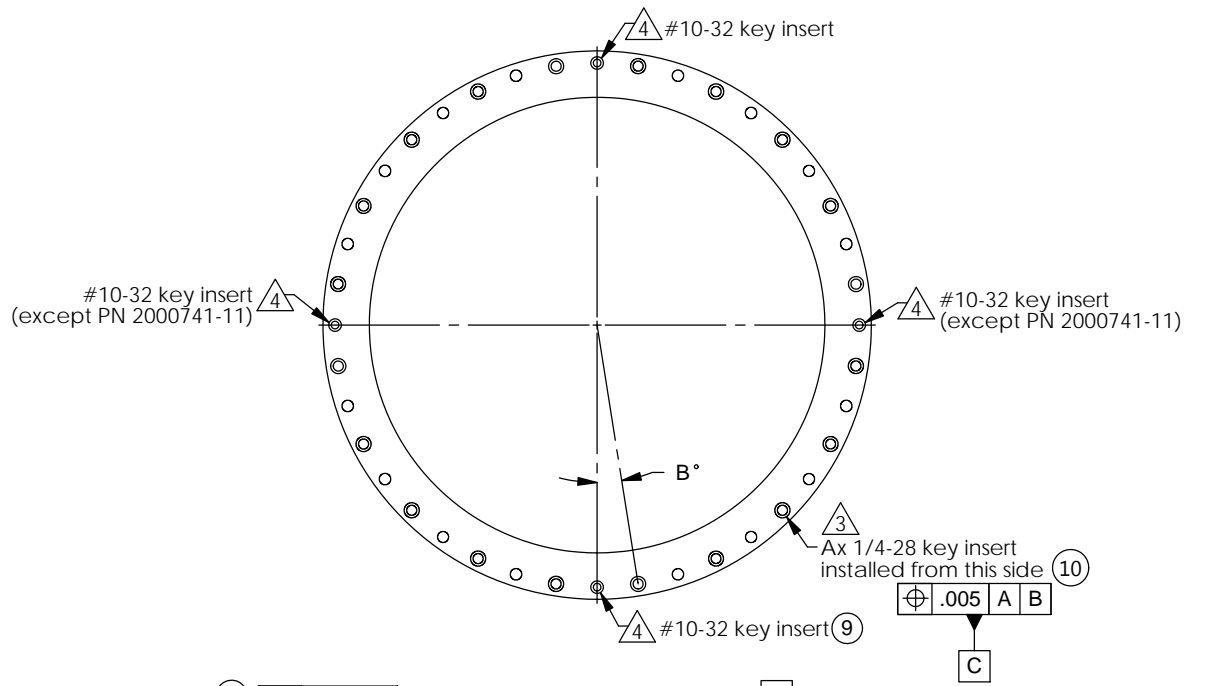
Note: All holes on this flange remain $\phi .281$



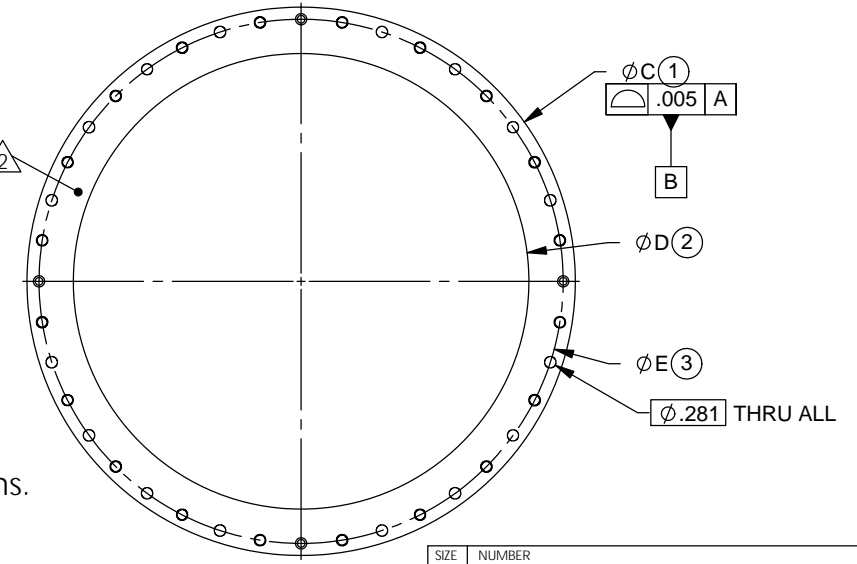
SECTION M-M



DETAIL N
SCALE 1 : 1.5



2000741-XXE PO XXXX



Refer to Table 1 for all variable dimensions.




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SIZE A	NUMBER 2000741-__	REV E
SCALE 0.21:1	CAGE CODE: 1PHA7	SHEET 2 OF 3

TABLE 1

Part Number	A	B	ØC	ØD	ØE	Qty. of #10-32 Inserts 	Flatness
2000741-8	12	15.00	8.540	6.300	8.000	4	0.0014
2000741-11	18	10.00	12.332	10.032	11.732	2	0.0021
2000741-13	20	9.00	13.600	11.300	13.000	4	0.0023
2000741-15	24	7.50	15.600	13.300	15.000	4	0.0027
2000741-18	28	6.43	18.850	16.550	18.250	4	0.0033
2000741-19	28	6.43	20.448	18.148	19.848	4	0.0036
2000741-23	32	5.63	23.850	21.550	23.250	4	0.0042
2000741-24	36	5.00	24.600	22.300	24.000	4	0.0043
2000741-31	48	3.75	32.200	29.900	31.600	4	0.0056
2000741-38	60	3.00	39.410	37.110	38.810	4	0.0069

Dimensions B-E are basic