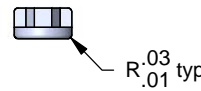
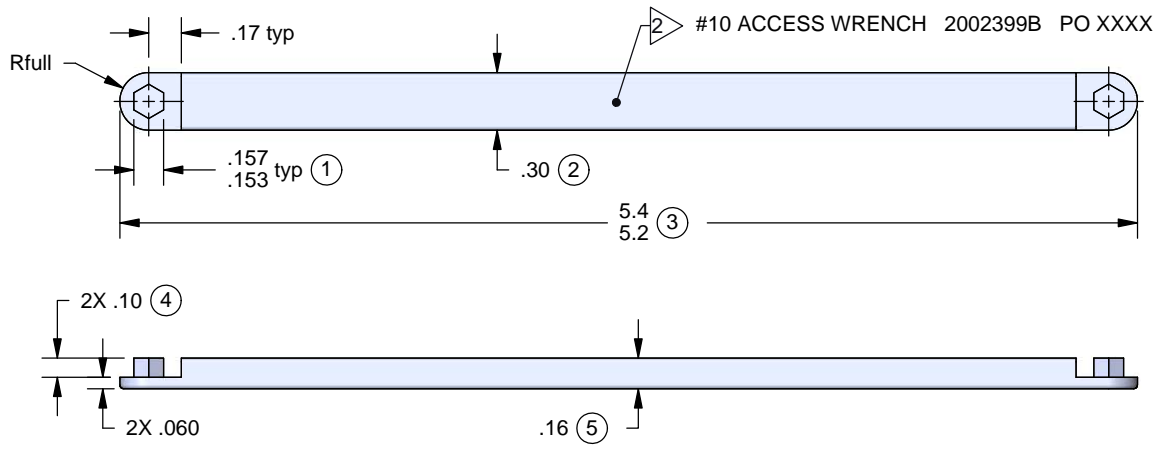
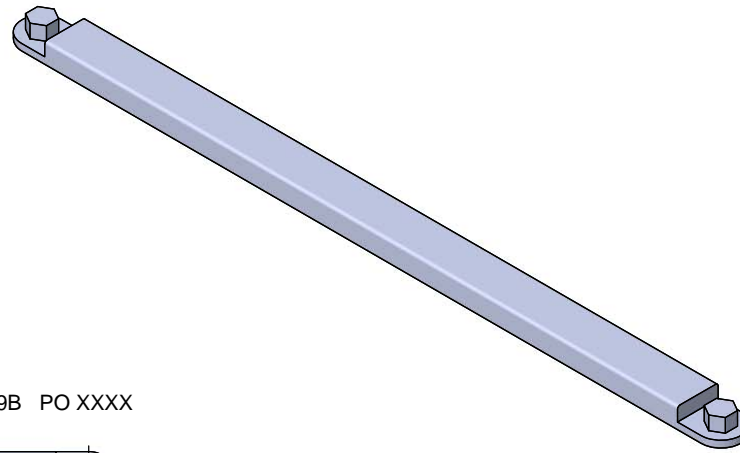


NOTES

1. Material: 8650 or 8650H steel.
2. Part Marking: Engrave as noted. Replace 'XXXX' with PO number.
3. Heat treat using industry guidelines for atmosphere and time.
 - (1) Heat at 1555 °F and oil quench.
 - (2) After quenching, immediately temper at 800 °F (part should still be warm to touch, ~ 300 °F or higher when tempering begins).
4. Dimensions apply after heat treatment.
5. Surface Treatment: None.
6. Cleanliness: Part shall be delivered visibly clean, to the normal unaided eye, of all particulate matter and non-particulate film matter.

Changes						
Rev	Description	Sht	Zone	Date	By	Chk
-	Initial Revision	-	-	21Aug12	RH	FA
A	Defined specific alloy and added heat treatment. Tightened hex tolerance. Modified length and fillets slightly. Added 2nd hex. Added cleanliness.	1	All	12Nov15	RH	RW
B	Changed material from 4130 to 8650. Changed heat treatment accordingly. Added numbered dimensions.	1	All	19Sep16	RH	FA



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Unless Otherwise Specified

1. All dimensions are in inches	Tolerances .XXXX ±.001 .XXX ±.005 .XX ±.01 .X ±.03 X ±.2 Hole diameters ±.003
2. Interpret per ASME Y14.5-2009	
3. Dimensions apply AFTER all surface treatments	
4. Remove all burrs and sharp edges, R.01 max	
5. Internal sharp edges may have R.01 max	
6. Thread depths are a minimum	
7. Inspect all numbered dimensions.	

N7/Max surface roughness Third Angle Projection	Material: see Note 1	TITLE #10 Access Wrench
	Do not scale from drawing	SIZE NUMBER A 2002399 SCALE 1:1 CAGE CODE: 1PHA7 SHEET 1 OF 1
		REV B