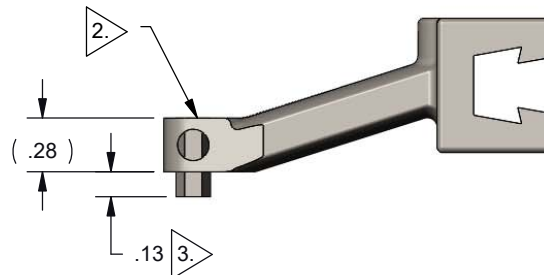
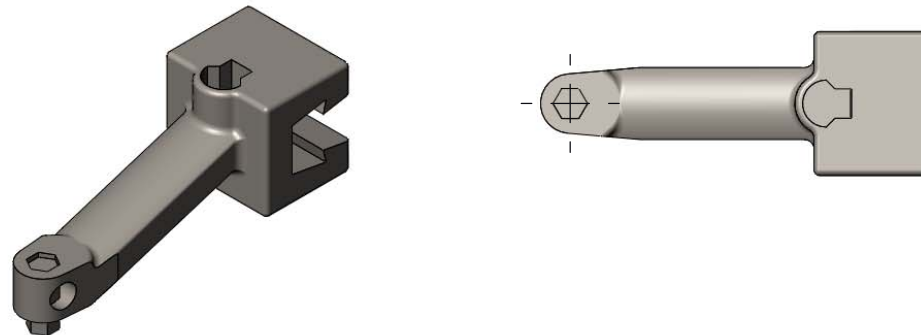


NOTES

1. Material: 2002398- Reduced Clicker Head (typically 4140 alloy steel).
2. Weld in 5/32" hex key from top. Recess key to leave sufficient room for weld. Ensure weld does not protrude above noted surface. It's acceptable to post-grind weld flush as necessary.
3. Shorten hex key to specified length.
4. After welding re-harden part to strengthen hex key (it may have softened due to welding temperature).
 1. Heat to 1550 F
 2. Quench in oil
 3. Immediately after quenching (ideally while still warm) temper at 500 F.
5. Cleanliness: Part shall be delivered visibly clean, to the normal unaided eye, of all particulate matter and non-particulate film matter.
6. Torque a 10-32 SHC screw to 50 in*lb and verify hex key did not yield.
7. Interfacing Parts: 10-32 SHC Screw in CSD Back Plate, CCM 50I Sturtevant Richmond torque wrench.

REVISIONS						
Rev	Changes			Date	By	Chk
	Description	Sht	Zone			
-	Initial Revision	-	-	21Aug12	RH	FA
A	Shortened hex length.	1	F7	24May17	RH	RW
	Allowed post-grinding of weld to make flush.	1	A1			
	Added post-welding heat-treatment to ensure hex key strength.	1	A2			



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- Unless Otherwise Specified
1. All dimensions are in inches
 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.

Tolerances	
.XXXX ±.001	⊕ φ .010 A B C
.XXX ±.005	⊖ .010 A B C
.XX ±.01	Hole diameters ±.003
.X ±.03	
X ±.2	

N8/Max surface roughness
Third Angle Projection

Material: see Note 1
Do not scale from drawing

TITLE		SIZE	NUMBER	REV
Welded Clicker Head		A	2002401	A
SCALE 1:1	CAGE CODE: 1PHA7	SHEET 1 OF 1		