



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	(1) DELETED 45° \neq .030 (2) ADDED .062 (MIN) (3) ADDED ∇	5-10-65 DFH	
B	(1) WAS 17-4PH STAINLESS/AMS-5643 (COND. A) (2) WAS CONDITION H-900 (Rc 40 MIN) (3) WAS PASSIVATE (USE AS IS 17-4PH PARTS)	8-4-65	HOADLEY
C	ADDED -Z SEAT	29 MAY 79	

② SEAT - HAND PUMP
SAME AS -1 EXCEPT MATL: 440C ST. STL

① SEAT - HAND PUMP CHECK
MATL: E52100 STEEL / MIL-5-7420 $\text{\textcircled{B}}$
MATL SIZE: $\frac{7}{16}$ DIA. ROD

$\text{\textcircled{C}}$ DENOTES CONCENTRIC WITHIN .005
FULL INDICATOR READING

MACHINED SURFACES TO BE 125/ \neq NOTED

HEAT TREAT: Rc 50-60 $\text{\textcircled{B}}$

FINISH: LOW SULFUR PETROLEUM OIL $\text{\textcircled{B}}$

NOTE:
 $\text{\textcircled{A}}$ ∇ CHAMFER OR BREAK CORNER IN EXCESS OF .010R BUT NOT TO EXTEND BEYOND .062 DIM.

MANUFACTURING OPERATIONS	
NOTES CHECKED / APPLY TO THIS DRAWING	
STEEL HEAT TREAT ROCKWELL C 50-60 OR TO	MIL-H-6875
STEEL STABILIZE	MIL-H-6875
MAGNIFLUX	MIL-S-1949
ALUMINUM HEAT TREAT	MIL-H-6088
ALUMINUM STABILIZE	MIL-H-6088
FLUORESCENT PENETRANT	MIL-I-6866
PASSIVATE	QQ-P-35
HARD ANODIZE	MIL-A-8625
ANODIZE	MIL-A-8625
CHEMICAL FILM	MIL-C-3541
CHROME PLATE	QQ-C-320
FLASH	WELD THICKNESS
AFTER CHROME PLATING BAKE PARTS WITH RC36 AND OVER AT 375° F ± 25° F FOR ___ HRS	
IMMEDIATELY AFTER CHROME PLATING NEUTRALIZE AND IMMERGE IN MOST PREVENTATIVE OIL	
CADMIUM PLATE	QQ-P-416
AFTER CADMIUM PLATING BAKE CADMIUM PARTS AT 215° F ± 10° F FOR 5 HRS AND PARTS WITH RC40 AND OVER AT 375° F ± 25° F FOR 22 HRS	
BLACK OXIDE	MIL-C-13924
CLASS	

SEAT - HAND PUMP CHECK

SCALE: 2 : 1	APPROVED BY: HOADLEY	DRAWN BY: V.L.K
DATE: 4-1-65	REVISIONS:	
.X = ± .05 .XXX = ± .010	∇ ± 0° 30'	
.XX = ± .02 .XXXX = ± .0050		
A517259	C	DRAWING NO.