	CHANGE	MOD. NO.	SGN.
A	DETAIL BROUGHT INTO LINE WITH MAKERS PRINT	FIRST ISSUE	RB 24 9 66
B	10° WAS 15° .25R WAS .50R .12R WAS .25R .876 WAS .400 .239 WAS .369 .075R WAS .06 RAD LIMITS ADDED	FIRST ISSUE	RB 6 9 66
C	METHOD OF DIMENSIONING AMENDED WITH NO CHANGE TO OVERALL LENGTH	Instead of Imm	RB 29 9 66
D	4.153 WAS 3.903 3.967 3.717 1.20 WAS .95	UAC 10 897	RR 4 10 66
E	U'CUT WITH B.S.P. ALSO F...	UAC. 11 12 6	16
F	.050R .010 UNDERSIZE END WAS .015 MAX .050 MAX SWELL ON DIAM ANGLE 120° BEFORE HT	UAC 11 254	
G	.620 .625 DIA BAR SIZE). .625 DIA (BAR SIZE). MAT'L SPEC WAS EN8 U.S. HARDNESS 197 TO 241 BHN.	UAC 11 781	JCP 13/11/67
H	NOTE ADDED	899	JCP 26/11

WORK TO FIGURES. DO NOT SCALE DRAWING.

REFER ALL QUERIES TO THE ENGINEERING DEPT.

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE STATED.

READ THE NOTES AT FOOT OF SHEET.

REMOVE ALL BURRS & SHARP EDGES.

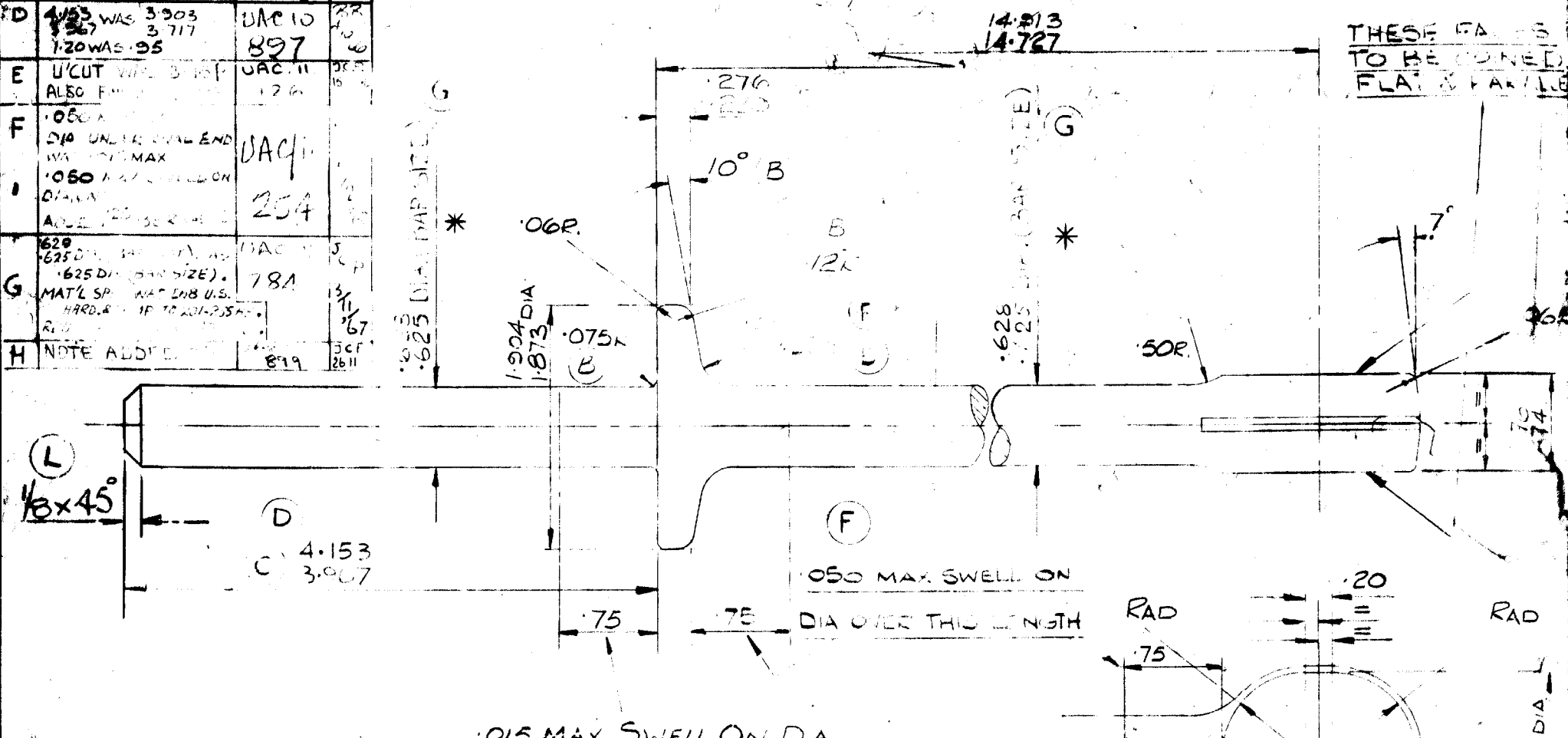
HUMBER-HILLMAN, COVENTRY.

SCALE 1/1 | PREVIOUS REF. OR MAKER'S REF.

1ST. ANGLE PROJECTION UNLESS OTHERWISE STATED.

SAFETY CRITICAL

(H) * AFTER HEAT TREATMENT AND DESCALING BAR SIZE TO BE .620 MIN.



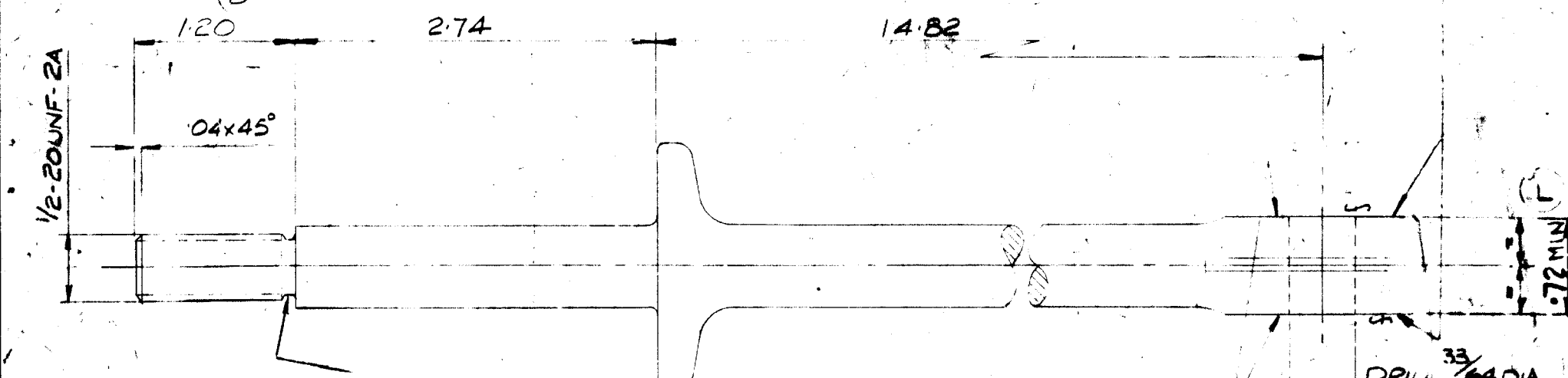
.015 MAX. SWELL ON DIA OVER THIS LENGTH

(B) TOLERANCES FOR RADII TO BE ± .015

P	ALT. MAT. WAS ADDED.	DRAWN: BATENI CTL(1): M.ATRI CTL(2): M.ZAKI APPD.: HAGHDOOST	DATE: 82.7.30
N	ALT FINISH ADDED		Dafso Barman 17.8.82
M	FINISH BECOMES BSA STD B753100 (P26) PLUS SEALING BY IMMERSION IN RESTILLO DW x 30 (PT. NO 4% 00 7100) WAS ROOTES STD (LIST 40A) B3-19 MOD L CANCELLED	151142	VCM 05 03 86

FORGING DIMENSIONS

THESE FACES TO BE FLAT & PARALLEL WITHIN .005 TIR.

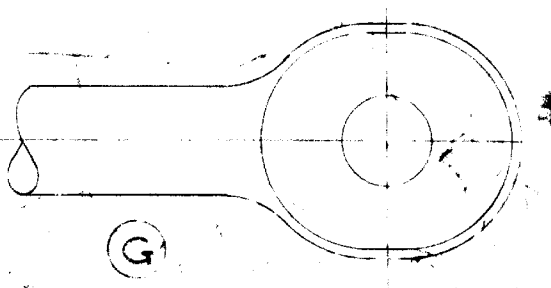


UNDERCUT TO B.S 1936 B-2b

SHANK TO BE STRAIGHT TO WITHIN .030 T.I.R.

HOLE TO BE SQUARE WITH THESE FACES

NOTE:- FINISH UNMACHINED SURFACES B3-19
ALL MACHINED SURFACES TO BE FREE FROM RUST (L)


(G)

MACHINING DIMENSIONS

MATERIAL SPEC. BS 970: En 8(R) GC1

L	MACHINING BOSS FACES TO .72 MIN ADDED FINISH B3-19 WAS AFTER MACHINING FREE FROM RUST NOTE ADDED. 1/8 x 45° FORGING DIMENSION ADDED	UAC 12 684	BJP 1/11
K	ELIMINATE ALL CORNER RADII TO GIVE FLAT FACES INCHES MAX ALL		
J	PART Nº WAS 1237921 DESIGN STD. PANEL ADDED	DAC 12 042	BJP 8/11
	CHANGE	MOD NO	SGN

(N) NOTE:
ALT FINISH: B15 4101 (F.V)

(P) ALT. MAT.: NORMALIZED 30msv6 (b531335)

TRACED			
PASSED			
APPROVED			
CHECKED			
DRAWN	RB	25.8.66	

EST^{D} WGT. (ROUGH)	
EST^{D} WGT. (FINISHED)	2.006 lb.
ACTUAL WGT. (FINISHED)	2.000 lb.
INSPECTION CATEGORY (SEE FORM P 31539)	A

DESIGN STANDARD INDEX

		SAFETY CRITICAL	MICRO-FILMED
MATERIAL —'M'			
PROCESS —'P'			
PERFORMANCE —'F'			
MATL. TREATMENT —'T'			
TECHNICAL ANALYSIS—'A'	J	YES	DATE

(G)

MATERIAL	SEE DRG	ROUGH PART NO.	1190572	MODEL(S)	
SPEC.					
FORM	BAR	PART NAME	BRAKE REACTION ROD		
SECTION		FINISHED			
LENGTH					
FINISH	SEE MOD				

MACHINE SYMBOLS

"m" ROUGH M/C. SURFACE FINISH MEASUREMENT UNNECESSARY

"y" M/C. WITH SURFACE ROUGHNESS NOT EXCEEDING 250 MICRO-INS.

"xx" M/C. WITH SURFACE ROUGHNESS NOT EXCEEDING THE VALUE SHOWN AT "XX"

SEE ALSO STD LIST 61

GENERAL NOTES

UNLESS OTHERWISE STATED:-

ALL UNLIMITED DIMENSIONS CONTROLLING MACHINED SURFACES INCLUDING PRESSWORK BY PRECISION TOOLS TO BE WITHIN ± .010 UP TO 4.00 & ± .015 IF OVER 4.00 WITH THE FOLLOWING EXCEPTIONS

SCREW THREADS (OTHER THAN UNIFIED) TO CONFORM TO B.S.84 MEDIUM OR B.S.93 NORMAL FITS AS APPLICABLE. ADJACENT HOLE CENTRES & P.C. DIAMS. TO BE WITHIN ± .004.

DRILLED OR PIERCED HOLES PRESSWORK & SHEET METAL WORK TO BE AS NEAR AS PRACTICABLE TO DRG FIGURES, BUT THE PART MUST BE USABLE WITHOUT UNDUE ADJUSTMENT