

38 HOLES $\phi 3$

ALL SLOTS
WIDTH
 1.0 ± 0.1

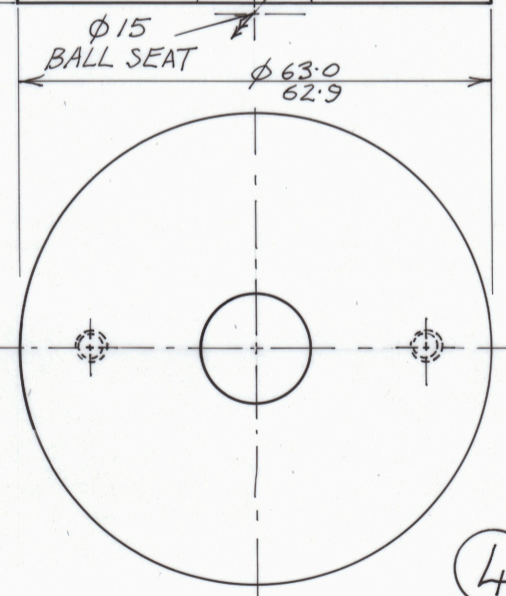
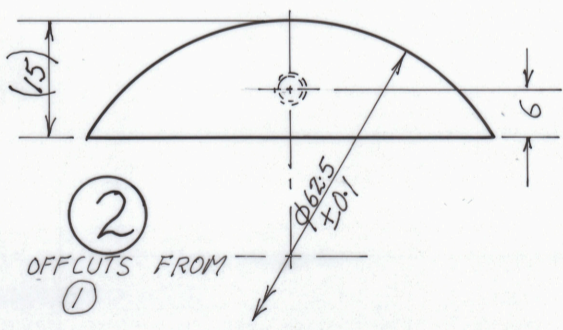
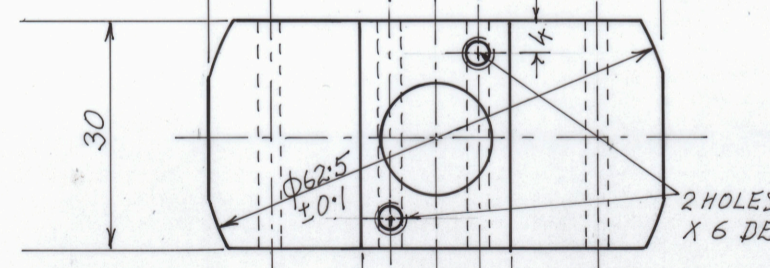
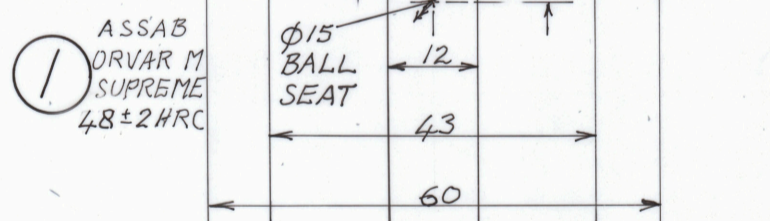
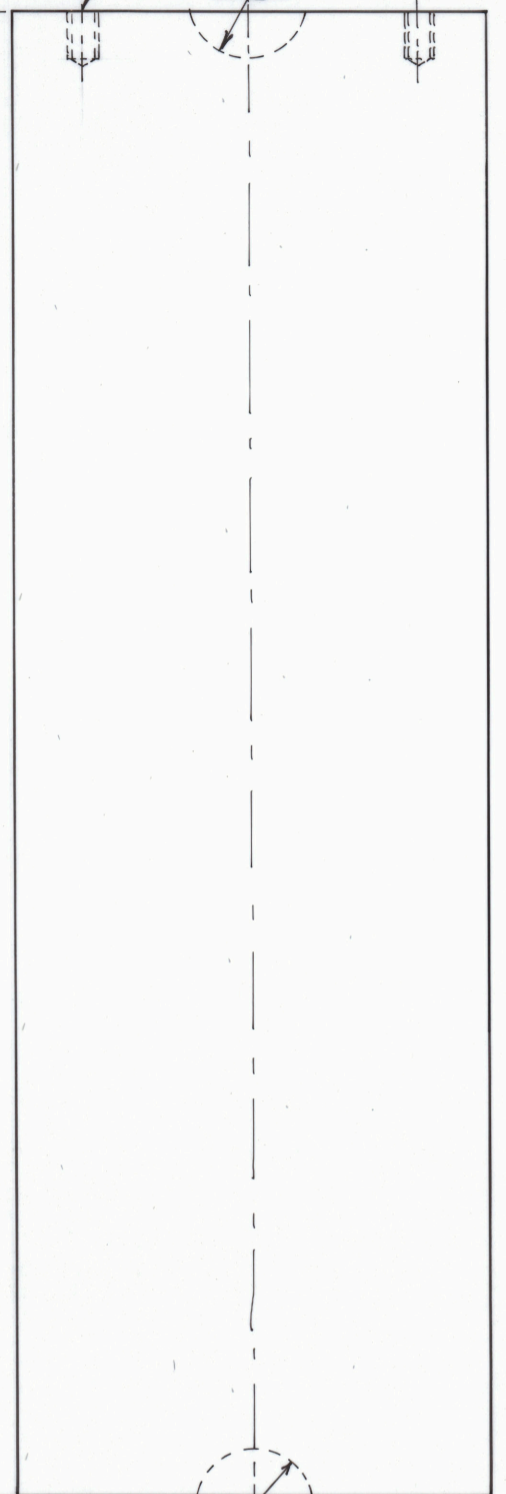
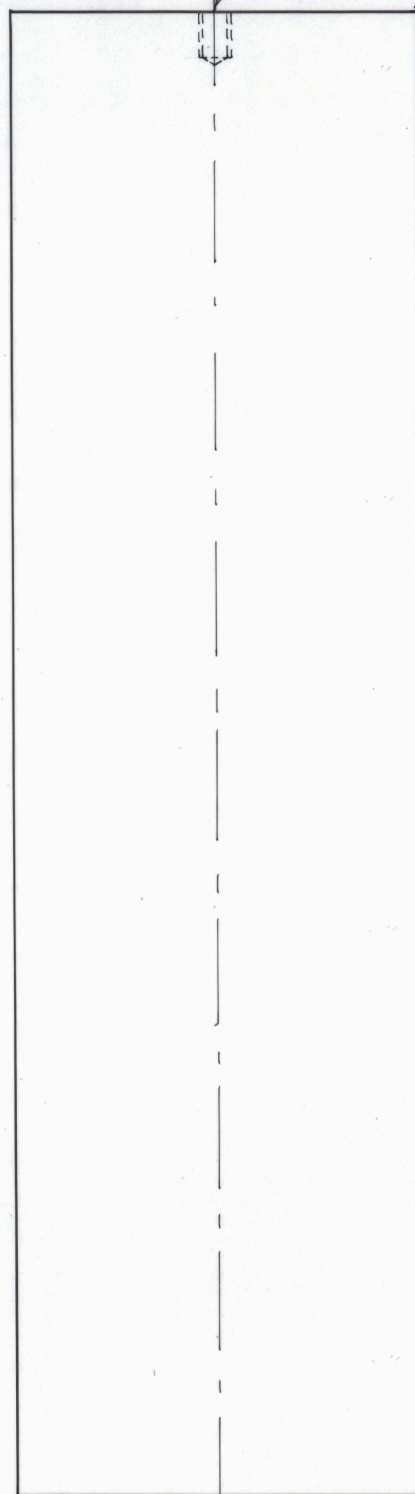
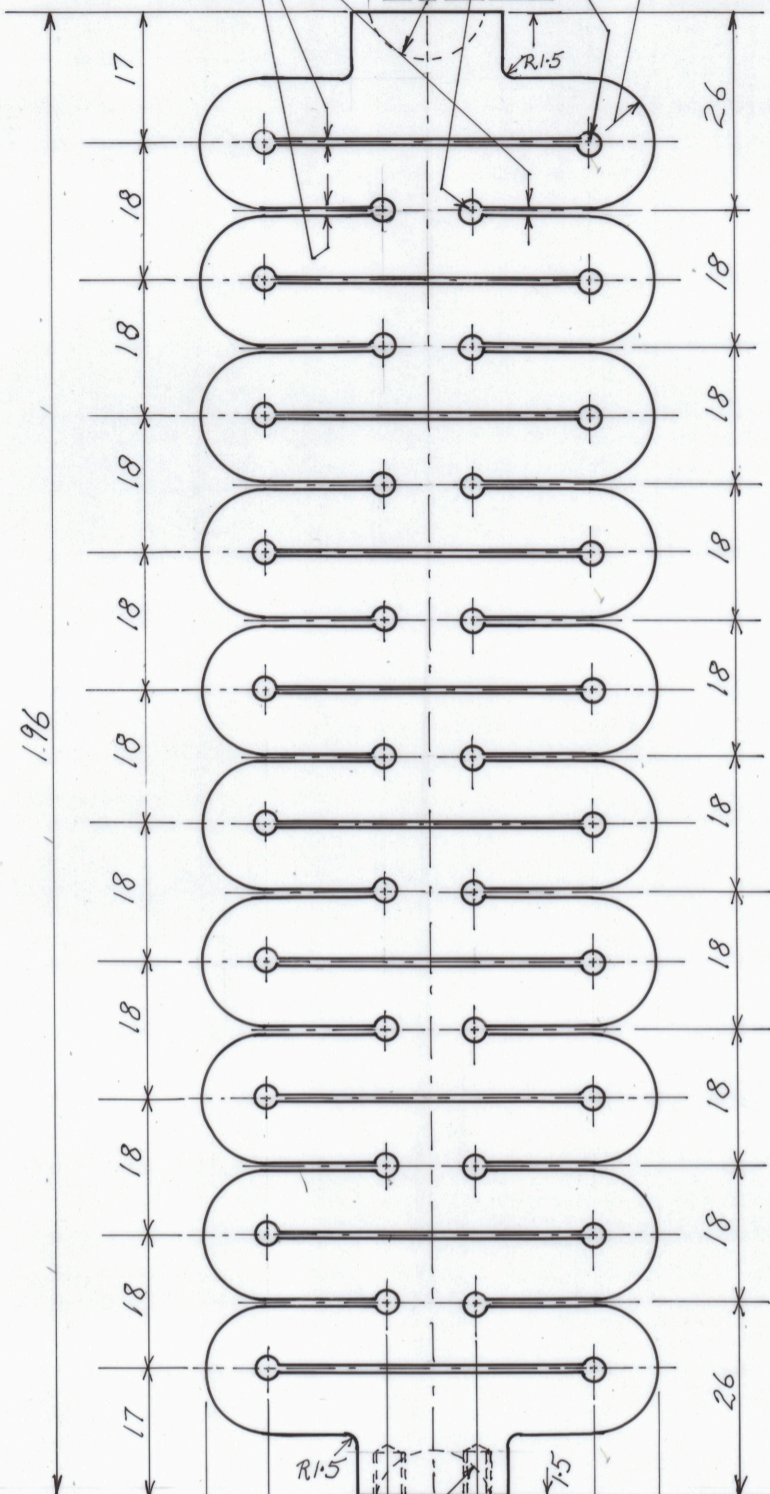
$\phi 15$
BALL SEAT

R8.5

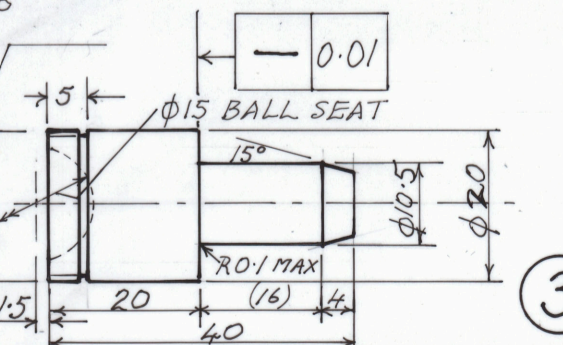
TAP M4
X 6 DEEP

2 HOLES M4
ON PCD 44

$\phi 15$ BALL SEAT



PROCEDURE:
1. CUT OFF SEGMENTS (2), ROUGH MACHINE & DRILL $\phi 3$ HOLES
2. HEAT TREAT
3. EDM CONTOURS & STRESS RELIEVE
4. SURFACE GRIND LATERAL FACES PARALLEL
5. EDM BALL SEATS COAXIAL TO FOUR SIDES, TRUE TO 0.1
BALL SEATS IN (1), (3) & (4) ARE TO CONFORM TO GROUND BALL BEARING WITHIN 0.010



ASSAB IMPAX SUPREME (7/8) 330/290 BH (AS RECEIVED)

(3) ASSAB ORVAR M SUPREME 48 \pm 2 HRC

DIMENSIONS IN MILLIMETRES
DO NOT SCALE

TOLERANCE ± 0.03 UNLESS STATED
BLACK OXIDE FINISH

ANU RESEARCH SCHOOL OF EARTH SCIENCES
HIGH PRESSURE/TEMPERATURE TESTING MACHINE
INTERNAL LOAD CELL CALIBRATION SPRING

A3	SCALE 1:1	DATE DEC 1990 JULY 1994	DRAWING NO 4204 A
----	--------------	-------------------------------	-------------------