



ITEM	DESCRIPTION	REQ'D.
1	1.250-7 X 4.00 LG. SHCS	6

(6) 1 5/16(1.312) DR. THRU
1 15/16(1.938) C'BORE - 2.38 DP.

(3) 1.5005 BORE 1.000 DP
7/16(.437) DRILL THRU
1/2(.500)-13 TAP 1.00 DP
.03 X 45° CHAMFER

(23) 1.5625/1.5640 BORE-1.773/1.778 DP
5/8(.625) DRILL THRU
.03 X 45° CHAMFER

(4) 43/64(.672) DR.- 2.38 DP.
3/4(.750)-10 TAP - 1.50 DP.

STAMP "7863" ON BOLSTER FOR PRESS #27400
"7864" ON BOLSTER FOR PRESS #27446
"7865" ON BOLSTER FOR PRESS #27447

STAMP "FRONT"

TOP AND BOTTOM SURFACES MUST BE PARALLEL WITHIN .001" ON EACH CORNER. VARIATION IN THICKNESS NOT TO EXCEED .001" FOR WIDTHS UP TO 20" AND .002" IN ANY 60" LENGTH. TOP AND BOTTOM SURFACES TO BE FLAT WITHIN .001" IN ANY 60" LENGTH.

CHAMFER ALL TAPPED HOLES AS FOLLOWS:
0.250 THRU 0.750 - 0.06 X 59°
ALL ABOVE - 0.12 X 59°

EST. WEIGHT 1774 LBS.	RAW MATERIAL WEIGHT	MACHINED SURFACES UNLESS OTHERWISE SPECIFIED
GROUP TECH NO P2-100-48-4-005	REFERENCE NO	DIMENSION TOLERANCE ±
SUPERSEDED BY	SUPERSEDES	X AND X X 0.100
PATTERN FILE NO	PATTERN BASIC NO	X XX 0.010
		X XXX 0.001
		X XXXX 0.0005
		FINISH 125 MICROINCHES BREAK SHARP CORNERS 0.03
		[L] 015 [Z] 015 [Z] 015

THE MINSTER MACHINE CO.		LAST REV DATE 10-29-90
MINSTER, OHIO		REV LEVEL CHANGED BY JAF
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DATE 8-7-90	DRAWN BY LMW	CHECKED BY RK
SCALE .25		
NAME OF PART PLATE, BOLSTER		
MATERIAL HR1020	PATT. NO.	
NO. REQ'D ONE	C	PART NO 1165-552