

24-3B17

Clevis Side Heim Joint Inserts

3/25/24

- basically same process as <sup>upright</sup> ~~upright~~ side heim joint inserts

steps

- 1) free
- 2) turn
- 3) angle (plunge at one end, move to side, out 30-50 thou)
- 4) ~~turn~~ 4) part-off (plunge, move to other side, out...)
- 5) free turn

OD

0.7314

0.7000

0.6400

~~0.5800~~

~~0.5600~~

0.6100

0.5800

0.5600

face down to ~ 0.213 + 0.125

0.213

0.125

0.338

ok... 0.35

0.4 next time!

angle to 70, 135

0.5600

0.5300

0.5000

0.4700

0.4600

angle

0.5013

0.4695

0.4600!

part-off

10 thou over

0.213

+ 0.010

0.223!

OD

~~0.7495~~

~~0.7200~~

~~0.6400~~

~~0.6300~~

~~0.6300~~

0.5700

0.5600

measure

OD

0.7314

0.5798

0.5602

OD

0.7495

0.5794

0.5606

angle

0.5602

0.5000

0.4700

0.4600

angle

0.5606

0.5000

0.4700

0.4600

measure 0.4721

0.4591

measure 0.4694

0.4606

Z4 - 3B17 Spines  
 clear side Halm joint inserts

4/17/24

steps feed BD2G

1) file speed 470 RPM

2) turn to OD (shoulder)

3) angle to ~~40~~ <sup>similar to</sup>

4) part-off

5) file

7) center drill

6) turn

~~7) center drill~~

8) step drill 9) cham

OD (.5600) to 0.47 angle to Z .125 before 1st pass

.6092

.5609

part off length

~~.606~~ .570

.5710

.5300

.2203

~~.60~~ .560

.5609

.5000

.4079

.4600

.4600

angle part-off 80 - 115 RPM increments peck

OD

angle

part-off

.6095

.4695

.2189

.570

.5712

.4602

.560

.5572

length (.213)  
~~part off length~~

+ .000  
 - .003

.220

.2192

.2119

.2134