

2A-3B11 Spines (2)  
Heim Joint Insert

4/24/24

1) face

2) turn OD (.514 - .003)

3) angle  $5^\circ$  <sup>neutral</sup> .283 - .316 ~~flange~~

30-50 thou plunge,  
then move ~~z~~

4) boss

5) part-off

6) face

7) turn

8) drill

speed	turn 470	face 600	angle 470-520?
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feed BD20

overall length: .413 - .003 (add .200 for part off)

so .613 part off length

OD  $\phi$ : .75

turn to .514, z .613	angle $z$ .283 - .316	x .514 - .3
.75		.7
.7		.45
.65		.4
.6 .6502		.35
.55		.3
.52 .5209		
.514 .514		

boss  $z$  .2 ~~z~~ .375 - .002

cone length

flange  $\phi$

.514	<sup>18</sup> before final
.5	
.45	
.4	4
.375	.3761
	.3757
	.3744

.2196

.3996

.213 - .003

