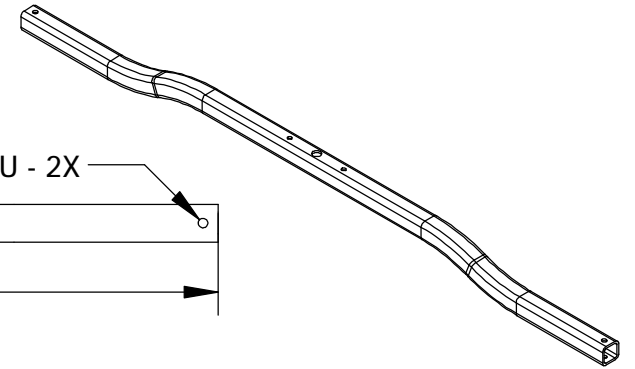
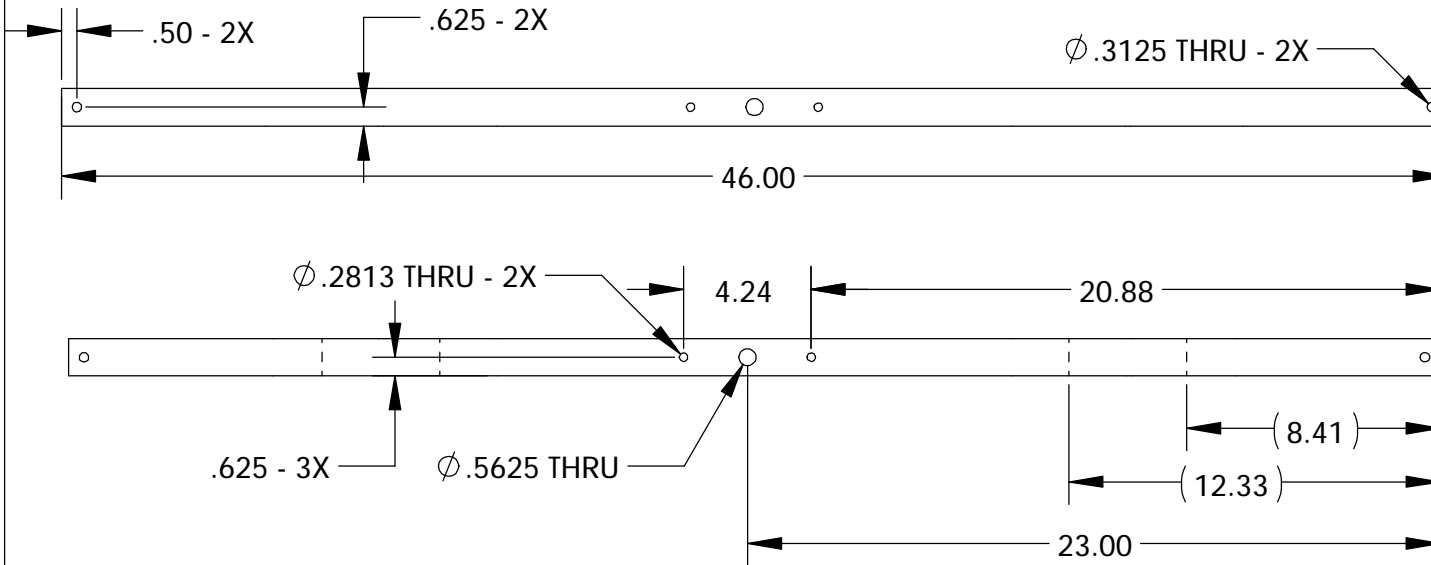
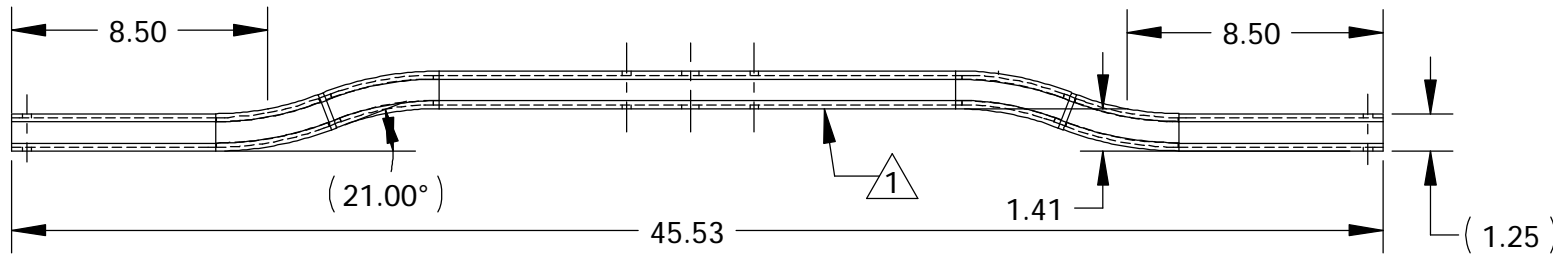


FLAT VIEWS



FORMED VIEW



NOTE:

1 WELD SEAM MUST BE ON BOTTOM OF FINISHED PART

DWG. REV.	ECR/NDR NUMBER	REVISED BY	DATE	DESCRIPTION
P/1	15984	JRS	01-09-17	ADDED WELD SEAM NOTE
P	15087	KMH	11-11-13	ADDED ϕ .2813 THRU HOLES - 2X

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE STATED TOLERANCES EXCEPT AS NOTED DECIMALS:
 .X ± 0.100
 .XX ± 0.060
 .XXX ± 0.030
 .XXXX ± 0.010
 ANGLES:
 $\pm 1^\circ$
 ALL FORMED ANGLES EQUAL 90° UNLESS NOTED OTHERWISE
 () INDICATES REFERENCE

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APPROVED BY:
 DRAWN BY:
 DATE: 12-26-96
 SHEET: 1 OF 1
 SCALE: N/A

KARAVAN

TITLE: TIE DOWN BAR

MAT'L: 1.25 X 1.25 X 10GA HRPO TUBE

FINISH: -BL

DWG. #: 100-00118

First Piece - In Process Inspection Sheet

Vendor _____

Description: **Tie Down Bar**

Part # **100-00118**

Rev. **P/1**

QA Approval: S. Mudra

JOB# _____

Characteristic	Tol.	Method	Freq.	1st Piece	A/R	2	A/R	3	A/R	4	A/R	5	A/R	6	A/R	Last piece	A/R	Inspected By/Date:
LASER																		
10 GA	.126 - .142	Mic.	1st/Last Piece															1 /
H.R.P.O.	NA	Visual	1st/Last Piece															2 /
46.00	± .060	Tape	1st/Last Piece															3 /
Ø.5625 Thru	± .010	Caliper	1st/Last Piece															4 /
.63	± .060	Caliper	1st/Last Piece															5 /
23.00	± .060	Tape	1st/Last Piece															6 /
Ø.3125 Thru - 2X	± .010	Caliper	1st/Last Piece															7 /
.63 - 2X	± .060	Caliper	1st/Last Piece															
.50 - 3X	± .060	Caliper	1st/Last Piece															
Ø.2813 Thru - 2X	± .010	Caliper	1st/Last Piece															
.63 - 2X	± .060	Caliper	1st/Last Piece															
2.12 - 2X	± .060	Caliper	1st/Last Piece															
FORM																		
45.53	± .030	Tape	1:100															
8.50 - 2X	± .060	Caliper	1:100															
1.41	± .060	Caliper	1:100															
21°	±1°	Protractor	1:100															
Weld seam must be on bottom of finished part	NA	Visual	Every piece															
Inspect parts for scratches, dents, gouges, etc.	NA	Visual	Every piece															
No slugs left in lasered holes.	NA	Visual	Every piece															