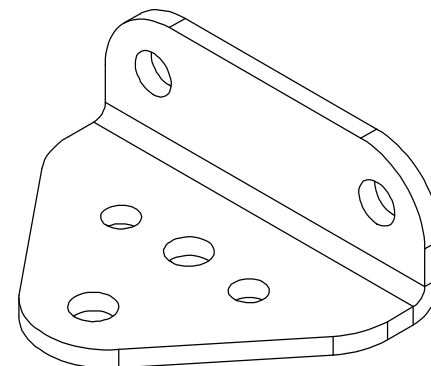
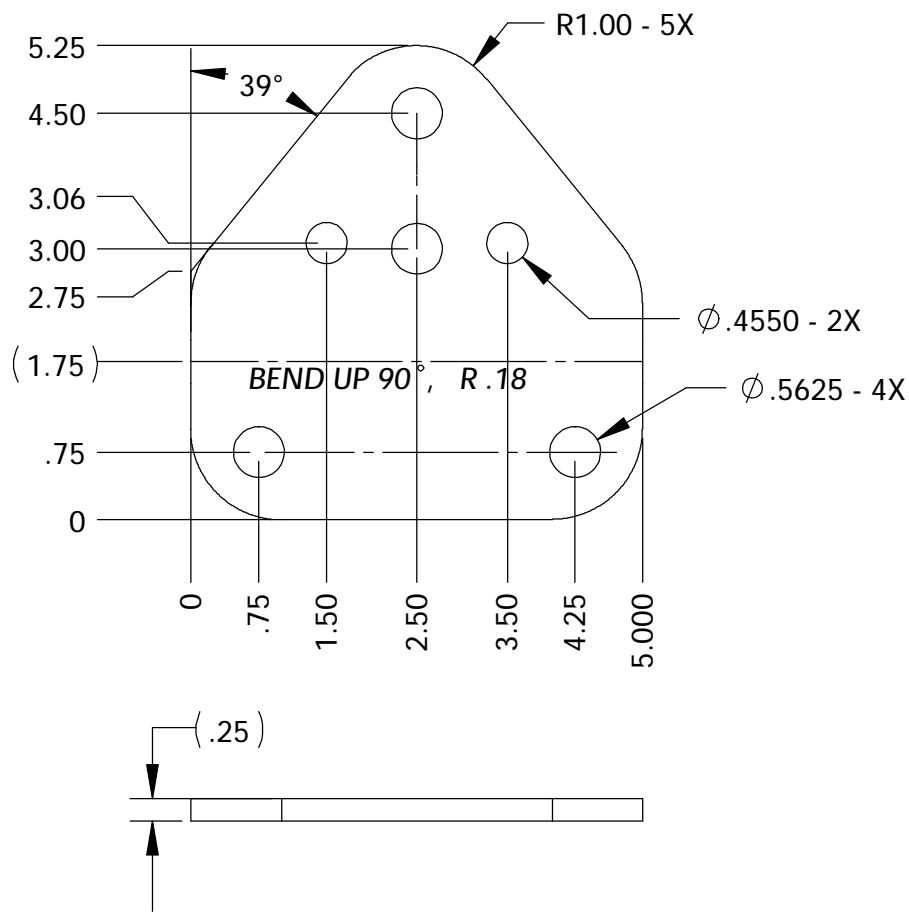
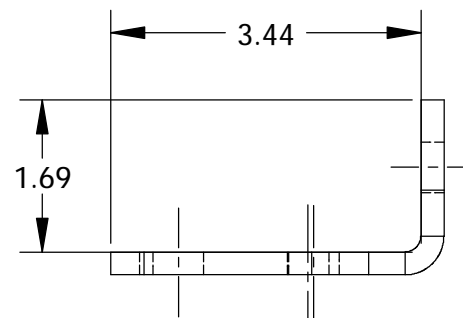


# FLAT VIEW



# FORMED VIEW



### NOTES:

- 1.) DIE # PP - 4
- 2.) SHEAR DIMENSIONS AT 5.00" X SHEET WIDTH.  
(IF MAT'L. IS WARPED IT WILL NOT FIT IN THE PUNCH @10')
- 3.) TUMBLE
- 4.) 10FT. SHEET YIELDS 20 PCS.  
8FT. SHEET YIELDS 16 PCS.

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:  
±1°  
ALL FORMED ANGLES  
EQUAL 90° UNLESS  
NOTED OTHERWISE  
( ) INDICATES REFERENCE

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APPROVED BY:  
DRAWN BY:  
DATE: 09-10-97  
SHEET: 1 OF 1  
SCALE: N/A

**KARAVAN**

TITLE:  
ROLLER BEAM BRACKET, ADJ

MAT'L: .25" H.R.P.O. SHEET

FINISH: -ZN

DWG. #: 100-00994

|           |                |            |          |   |
|-----------|----------------|------------|----------|---|
| F         | 12332          | JLS        | 08-23-02 | MOVED THE TWO .4550 HOLES, 3.06 WAS 2.50, 1.50 WAS .75, 3.50 WAS 4.25 |
| E         | 11629          | MJS        | 07-18-00 | Ø.4550 WAS Ø.4063   |
| DWG. REV. | ECR/NDR NUMBER | REVISED BY | DATE     | DESCRIPTION   |

## First Piece - In Process Inspection Sheet

Vendor \_\_\_\_\_

Description: **Roller Beam Bracket**

Part # **100-00994**

Rev. **F**

QA Approval: D. Dray

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: |
|---|-------------|---------|----------------|-----------|-----|---|-----|---|-----|---|-----|---|-----|---|-----|------------|-----|--------------------|
| <b>LASER</b>  |             |         |                |           |     |   |     |   |     |   |     |   |     |   |     |            |     |                    |
| .25"  | .242 - .258 | Mic     | 1st/Last Piece |           |     |   |     |   |     |   |     |   |     |   |     |            |     | 1 /                |
| H.R.P.O. Sheet  | NA          | Visual  | 1st/Last Piece |           |     |   |     |   |     |   |     |   |     |   |     |            |     | 2 /                |
| 5.25  | ± .060      | Caliper | 1st/Last Piece |           |     |   |     |   |     |   |     |   |     |   |     |            |     | 3 /                |
| 5.000   | ± .030      | Caliper | 1st/Last Piece |           |     |   |     |   |     |   |     |   |     |   |     |            |     | 4 /                |
| Ø.4550 - 2X   | ± .010      | Caliper | 1st/Last Piece |           |     |   |     |   |     |   |     |   |     |   |     |            |     | 5 /                |
| Ø.5625 - 4X   | ± .010      | Caliper | 1st/Last Piece |           |     |   |     |   |     |   |     |   |     |   |     |            |     | 6 /                |
| <b>FORM</b>   |             |         |                |           |     |   |     |   |     |   |     |   |     |   |     |            |     |                    |
| 3.44  | ± .060      | Caliper | 1:100          |           |     |   |     |   |     |   |     |   |     |   |     |            |     |                    |
| 1.69  | ± .060      | Caliper | 1:100          |           |     |   |     |   |     |   |     |   |     |   |     |            |     |                    |
| <b>Inspect parts for scratches, dents, gouges, etc.</b> | NA          | Visual  | Every piece    |           |     |   |     |   |     |   |     |   |     |   |     |            |     |                    |
| <b>No slugs left in lasered holes.</b>                  | NA          | Visual  | Every piece    |           |     |   |     |   |     |   |     |   |     |   |     |            |     |                    |
|   |             |         |                |           |     |   |     |   |     |   |     |   |     |   |     |            |     |                    |