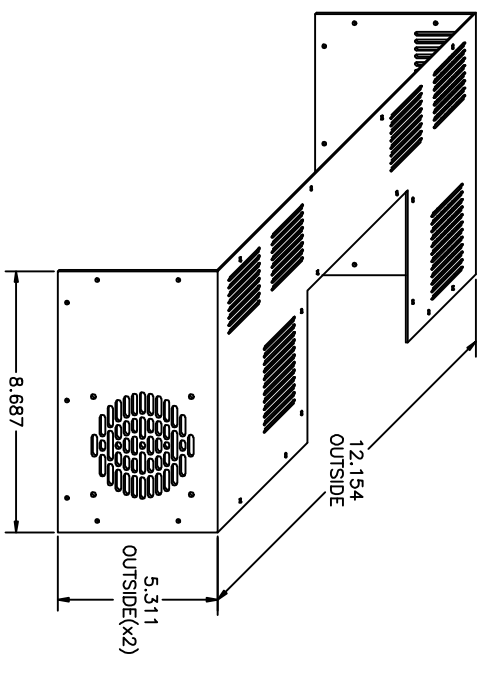


- Notes**
1. Punch from smooth side.
 2. File (3) tabs.
 3. Install (6) Pen nuts 53029 in holes "W,X,Y,Z,AA,AB" from Burr side. (F-440-1)
 4. Bend as shown.
 5. Clean and Wash.
 6. Mask (6) Flush Pens with Plugs.
 7. Paint Black Powder CN-56034T, light texture, outside surfaces and edges.

Shearing Information
 Blank Size: 48,000 x 30,000 (4 Blanks)
 Makes (5) Parts/Blank 8,687 x 22,564
 Material Used Per Part: 288 Sq.In.
 No. of hits per part = 197.6
 No. of Setups = 9

	Dimension	X Position	Y Position
A	0.1366	0.299	7.624
B	0.1366	0.299	4.374
C	0.1366	0.299	1.124
D	0.1366	1.312	0.362
E	0.1366	4.009	0.362
F	0.1366	6.282	0.363
G	0.1366	9.615	0.363
H	0.1366	12.948	0.363
I	0.1366	16.281	0.363
J	0.1366	18.555	0.362
K	0.1366	21.252	0.362
L	0.1366	22.265	1.124
M	0.1366	22.265	4.374
N	0.1366	22.265	7.624
O	0.1366	21.252	8.388
P	0.1366	18.555	8.388
Q	0.1366	16.282	8.389
R	0.1366	14.146	8.389
S	0.1366	7.417	8.389
T	0.1366	6.282	8.389
U	0.1366	4.009	8.388
V	0.1366	1.312	8.388
W	0.1710	8.165	7.519
X	0.1710	8.165	4.126
Y	0.1710	8.913	3.376
Z	0.1710	12.643	3.376
AA	0.1710	13.395	4.126
AB	0.1710	13.395	7.519
AC	0.1870	18.131	4.252
AD	0.1870	18.131	7.502
AE	0.1870	21.381	4.252
AF	0.1870	21.381	7.502



SHEET METAL TOLERANCES		Top Panel MATERIAL 12002 0.062 Aluminum DRAWN Shellie Hudgins 02/09/09	
CENTER TO CENTER ±.006	CENTER TO EDGE ±.015	Top Panel END USE OR CUSTOMER TAPER SCALE T. I. PART NO. E-6410 SHEET 1 OF 1	
SOLE SIZE ±.003	SOLE SIZE ±.015		
BURRS .005 MAX.	±.015		