MICROMETICS LTD.

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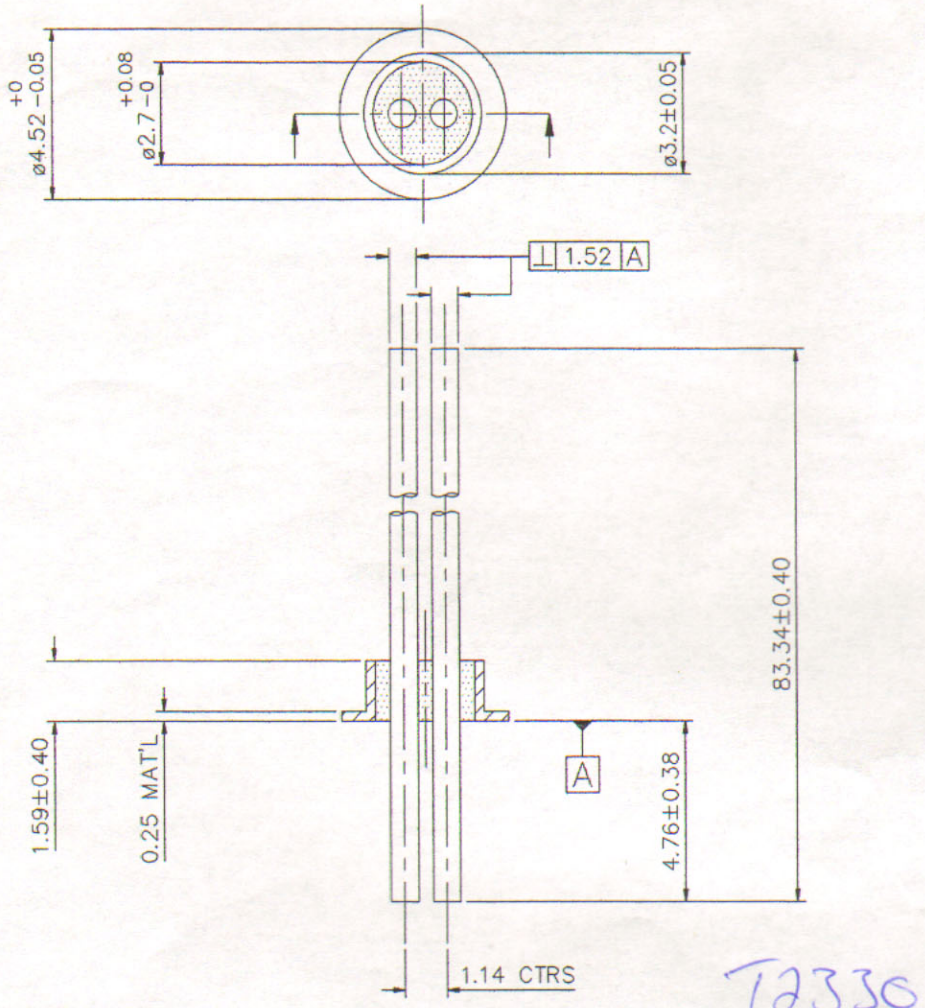
26 HOLLANDS ROAD, HAVERHILL, SUFFOLK. CB9 8PR.

PART NO. MD9183 ISSUE: 1

ITEM NO.	PART NO.	QTY. PER	MATERIAL / SPEC.	ITEM NO.	PART NO.	QTY. PER	MATERIAL / SPEC.
1	MF9183	1	NILO K				
2	MP9088	2	NILO K				
3	M4933	1	M.E.1				



T2330

GENERAL NOTES:
1. THIRD ANGLE PROJECTION. FOR EXPLANATION OF DIMENSIONS ETC. REFER TO B.S.308.
2. ALL DIMENSIONS IN METRIC. (IMPERIAL DIMENSIONS SHOWN IN BRACKETS WHERE APPROPRIATE.)
3. SURFACE FINISH 1.6 MICRON UNLESS STATED OTHERWISE.
4. PARTS TO BE BURR FREE. MAXIMUM DEBURRING CHAMFER 0.25mm x 45°.
5. JIGGING ATTITUDE: AS DRAWN / REVERSED. (DELETE AS APPROPRIATE)

ISSUE	DATE	AMENDMENT NO.	ISSUE	DATE	AMENDMENT NO.
1	17/12/85	–			

FILE NAME:	MD9183
DRAWN:	M.A.C
CHECKED:	
SCALE:	DO NOT SCALE

PART NO. MD9183/1

MANUFACTURING OPERATIONS.

ALL OPERATIONS TO HAVE FIRST OFF INSPECTION.

PART NO. MD9183 ISSUE: 1

1	WITHDRAW AND CHECK PIECE PARTS.
2	DEGREASE ALL PARTS. MF2/1.
3	PRE-CLEAN ALL PARTS. MF2/2.
4	INSPECT FOR GENERAL CLEANLINESS ESPECIALLY
	SEAL BORE ULTRA-SONIC IF REQUIRED.
5	DEGAS ALL PARTS. MF2/3. 1050°C FOR 2 HRS.
6	OXIDISE.
7	RETURN TO STORES.
8	ISSUE TO SHOP.
9	CHECK PIECE PARTS.
10	LOAD JIGS.
11	KILN LOAD.
12	END OF KILN. QA-IP/6.
13	FINAL VIEW DIMENSIONAL. QA-IP/8.
14	FINAL FINISH:- CLEAN AS FROM KILN.
15	FINAL INSPECTION. QA-IP/13.

SPECIAL INSTRUCTIONS.

IF IN DOUBT PLEASE ASK