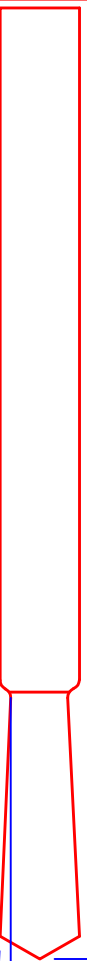
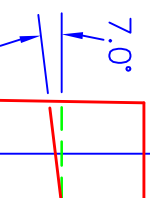
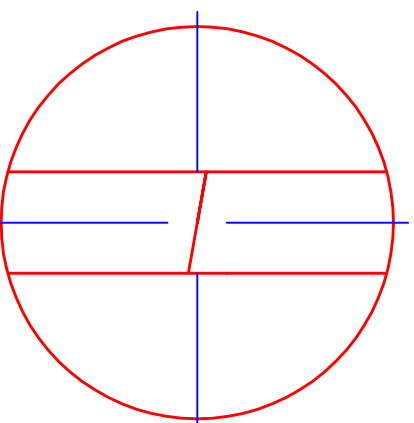
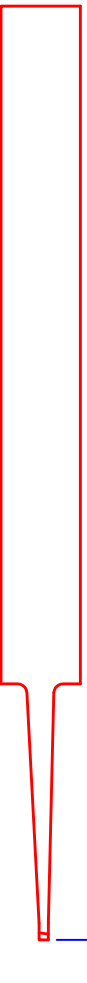


DRILL LENGTH

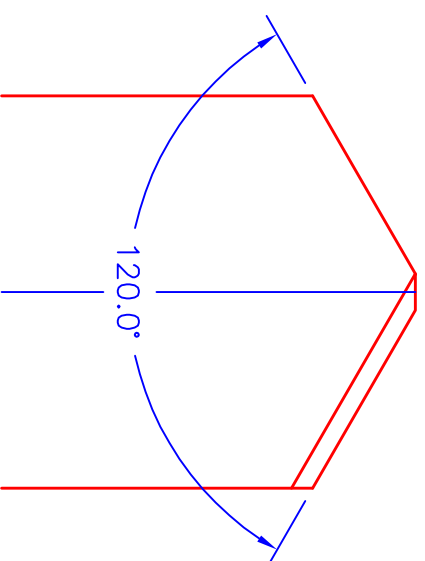


3°

DRILL LENGTH



7.0°



120.0°

NOTES:

1. TURN 120 ° RADIUS ON END OF MATERIAL.
2. TURN DOWN LENGTH OF DRILL TO A 3° TAPER.
3. FILE FLATS 180° APART.
4. FULLLY HARDEN.
5. LAP CUTTING SURFACES TO 7°.
6. MATERIAL DRILL ROD

MATERIAL DRILL ROD OR CARBIDE		SIZE A		FCSM NO.		DWG NO.		DATE		SHEET		REV	
DWN BY M DEMPSEY		SCALE TO FIT		02-13-09		030609		1 OF 1				-	
TITLE SPADE DRILL													
COMPANY CLOCKS AND THINGS													