NOTES: (DELETED NOTE 1)

(C1) 2. CHROME PLATE THICKNESS MUST BE .0030 +.0005 −.0000 PER AMS 2460A CLASS 2, TYPE OPTIONAL.

3. ALL DIMENSIONS ARE AFTER CHROME PLATING, WHERE APPLICABLE.

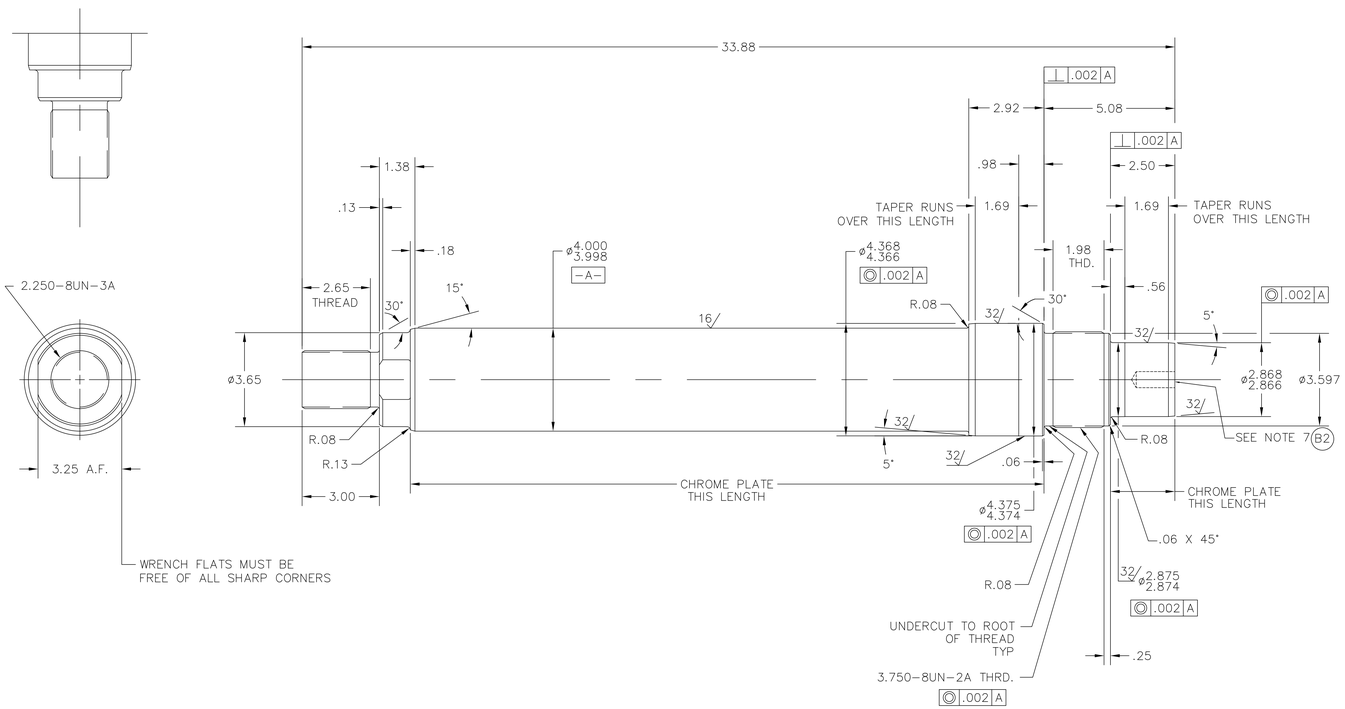
(C2) 4. THIS DRAWING IS USED FOR THE ASSEMBLY/ MANUFACTURE OF KOCSIS CYLINDER 9900013 (NAWC 514762−7 & −8) ONLY. ALL MATERIAL SHALL BE COMMERCIAL GRADE, UNLESS OTHERWISE STATED.

5. MATERIAL SHALL BE IAW ASTM A564, TYPE 630 COND. A.

6. FINISH SHALL BE 125 UNLESS OTHERWISE SPECIFIED.

(B1) 7. OPTIONAL .625−11UNC−1.50 DEEP HOLE IS ALLOWABLE TO AID THE PLATING PROCESS. IT IS NOT A REQUIRED FEATURE.

COMPUTER DRAWING NO MANUAL REVISIONS	CAD PROG: AUTOCAD VER: 2012 FILE NAME: 4950009rCs1		
REVISIONS			
ZONE	REV	DESCRIPTION	DATE	APRV'D
	(B)	CL "R" CHG REPLACES REVISION "A" WITH CHANGE. IN NOTES: (1) ADDED NOTE 7. IN DWG: (2) ADDED HOLE AND CALLOUT. REASON: INCORPORATE 09D0324 & ECP−II−CATS−3115. B.BAKER	8/13/2012	MW
	(C)	CL "R" CHG IN NOTES: (1) WAS AMS−QQ−C−320, CLASS 2, TYPE OPTIONAL, (2) ADDED −8, REASON: INCORPORATE REI 13−5404 & ECP−II−JBD−3662 C. FITZGIBBONS	7/14/2016	MW 4.8.2.1



REPLACES REVISION "A" WITH CHANGE

9900013			1	4950009	PISTON ROD			SEE NOTE 5	
NEXT ASSEMBLY	FIND NO.	CAGE	QTY	PART NUMBER	DESCRIPTION	NOMINAL STOCK SIZE	MATERIAL	SPECIFICATION	UNIT WT. (LBS) ZONE

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ASSOCIATED DOCUMENTS:

THE FOLLOWING SHALL BE IDENTIFIED IN THE AREA SHOWN BY
CAGE CODE
PART NUMBER
CONTRACT NUMBER
SERIAL NUMBER

CLASSIFICATION OF CHARACTERISTICS
CRITICAL (C) TO (C)
MAJOR (M) TO (M)
MINOR − ALL OTHER CHARACTERISTICS

UNLESS OTHERWISE INDICATED:
* INTERPRET DRAWINGS IN ACCORDANCE WITH ASME Y14.100.
* REMOVE BURRS AND BREAK ALL SHARP EDGES .015 MAX.
* ~~TOLERANCES ON DIMENSIONS LOCATING BOLT HOLES AND FINISHED SURFACES SHALL NOT BE CUMULATIVE.~~
* FOR NAWC USE ONLY: STOCK SIZE AND WEIGHT ARE NOMINAL WITHOUT MANUFACTURING ALLOWANCES.
* DIMENSIONS ARE IN INCHES.
*
DECIMAL TOLERANCES: .3 PL± .005 .2 PL± .01 ANGLES± 1°

MARKING METHOD
☐ DO NOT MARK
☐ ENGRAVE
☐ INK STAMP
☐ METAL STAMP
☐ ACID ETCH
☐ LASER ETCH
☐ VIBRO ETCH
☐ SEE NOTE
INCH GOTHIC STYLE LETTERING

DRAWN	LK	2−11−94
CHECKED	M. WITHERS	1/15/2007
MATERIAL		
ANALYZED		
SUPERVISOR		
PROJECT LEADER		
APPROVED FOR RELEASE 4821	D. SCAFURO	1/17/2007

DEPARTMENT OF THE NAVY
NAVAL AIR WARFARE CENTER
AIRCRAFT DIVISION, LAKEHURST, N.J. 08733−5000

TITLE
PISTON ROD

DESIGNED FOR MK 7 JET BLAST DEFLECTOR

SIZE	CAGE CODE	DWG NO.	REV
H	80020	4950009	C

SCALE 1:2 EST WT SHEET 1 OF 1

NAWCADLKE 3900/43A (REV. 06−97)