



NOTES

1. Material: 2002398- Reduced Clicker Head (typically 4140 alloy steel).
2.  Weld in 5/32" hex key from top. Recess key to leave sufficient room for weld. Ensure weld does not protrude above noted surface. It's acceptable to post-grind weld flush as necessary.
3.  Shorten hex key to specified length.
4. After welding re-harden part to strengthen hex key (it may have softened due to welding temperature).
 1. Heat to 1550 F
 2. Quench in oil
 3. Immediately after quenching (ideally while still warm) temper at 500 F.
5. Cleanliness: Part shall be delivered visibly clean, to the normal unaided eye, of all particulate matter and non-particulate film matter.
6. Torque a 10-32 SHC screw to 50 in*lb and verify hex key did not yield.
7. Interfacing Parts: 10-32 SHC Screw in CSD Back Plate, CCM 50I Sturtevant Richmond torque wrench.

REVISIONS						
Rev	Changes			Date	By	Chk
	Description	Sht	Zone			
-	Initial Revision	-	-	21Aug12	RH	FA
A	Shortened hex length.	1	F7	24May17	RH	RW
	Allowed post-grinding of weld to make flush.	1	A1			
	Added post-welding heat-treatment to ensure hex key strength.	1	A2			

