

WEDLING INSTRUCTIONS

- PARTS (SHAFT AND BLOCK) TO BE HEATED TO 400°F USING OVEN (ALTERNATIVE METHOD OF HEATING IS TORCH HEAT TO 400°F)
- CHECK TEMPERATURE WITH DIGITAL TEMPERATURE GUN
- REMOVE HEAT AND WELD THE TWO PIECES IMMEDIATELY

WELDING METHOD/MATERIAL

TIG WELD USING ER 80 SB 2 FILL WIRE

****NOTE**

THIS WELDING INSTRUCTIONS IS FOR MATERIAL GRADE 8620 ONLY

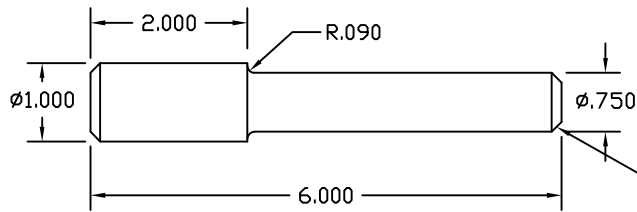
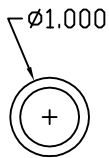
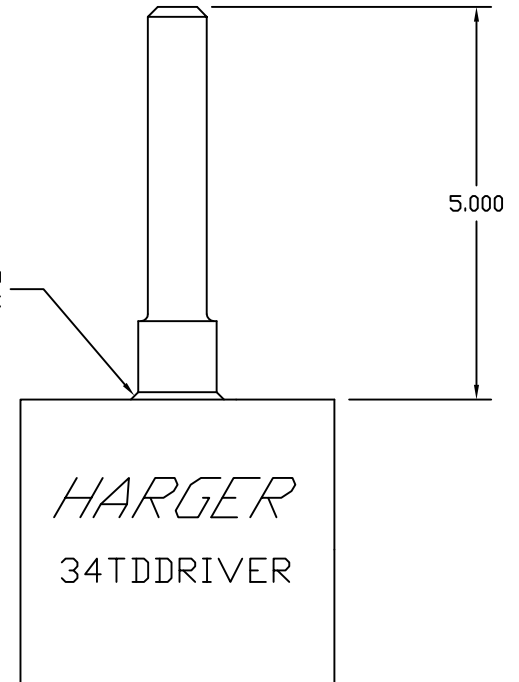
SECTION A-A

BODY

REFER TO WEDLING INSTRUCTIONS

WELD

PROPOSAL REV LEVEL J



ARBOR

1/8 x 45°
TYP 2

*NOTE:
CHAMFER AND FACE ON CNC MACHINE

ASSEMBLY

EST WT 7.65#

APPROVED

AS DRAWN: _____
 AS NOTED: _____
 DATE: _____

THIS DOCUMENT AND THE CONTENTS THEREOF IS THE PROPERTY OF HARGER INC., AND IS FURNISHED TO YOU FOR INFORMATION ONLY. THE INFORMATION CONTAINED HEREIN IS CONFIDENTIAL AND OF A PROPRIETARY NATURE AND MUST NOT BE DISCLOSED TO THIRD PARTIES WITHOUT THE EXPRESS WRITTEN APPROVAL OF HARGER INC.

LET	REVISION	DATE	BY
J	REDUCE ARBOR TO .750	101514	WD
J	ADD WELDING INSTRUCTIONS	101514	WD
I	CHANGE DEPTH 1.5 R	041814	JKH
H	REDESIGN WELD	012014	JKH
TOLERANCES UNLESS NOTED:			
	FRACTIONAL	+/-	1/16
		+/-	.030
		+/-	.010

PART NO. 34TDDRIVER

DRAWN BY: *jkh*
 CHECKED BY: _____



301 ZIEGLER DRIVE
 GRAYSLAKE, IL 60030
 (847) 548-8700

REVISION: IZ
 SCALE: 1/2
 SHEET: 1 OF 1

DATE: 1/20/14