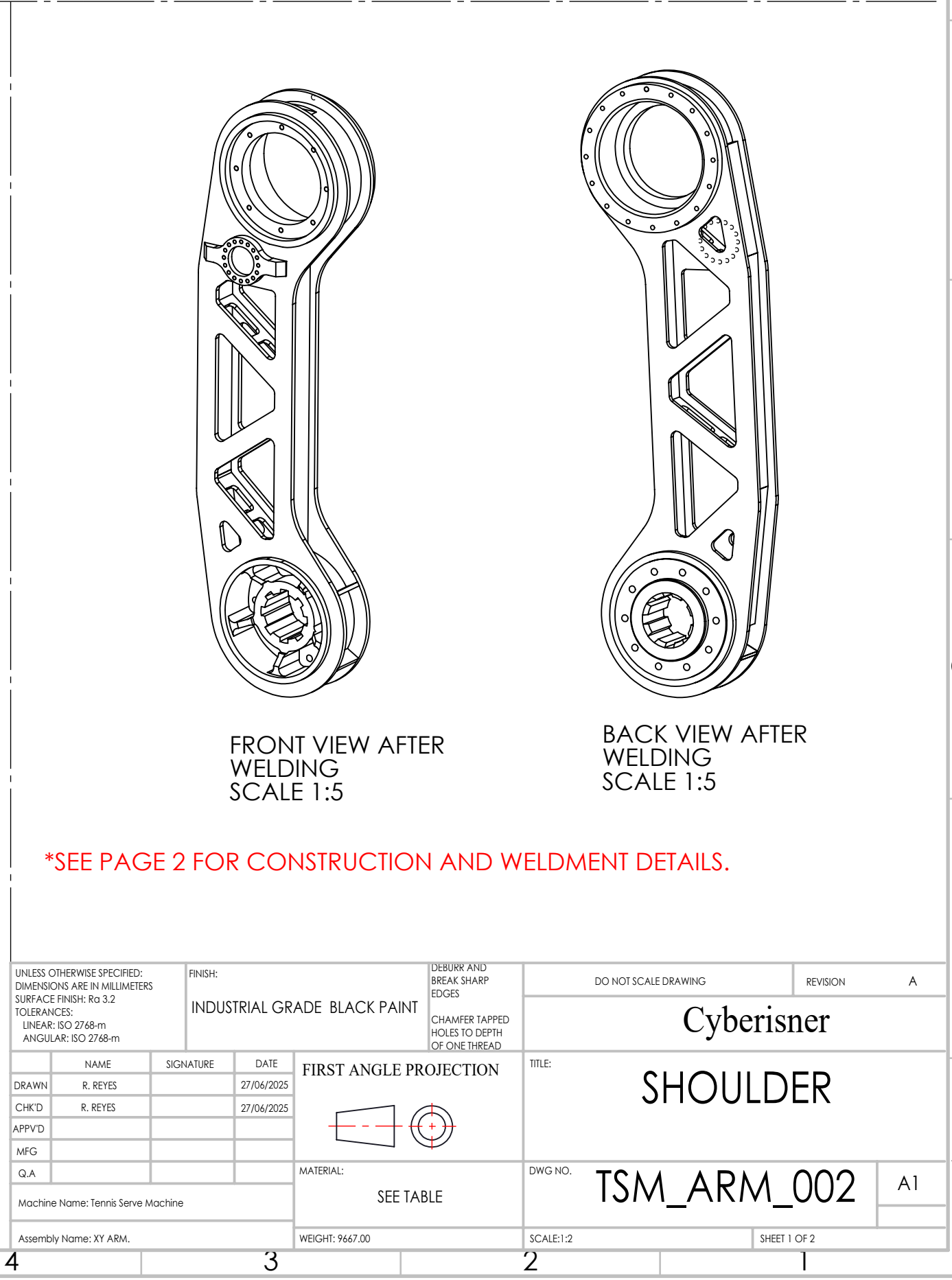
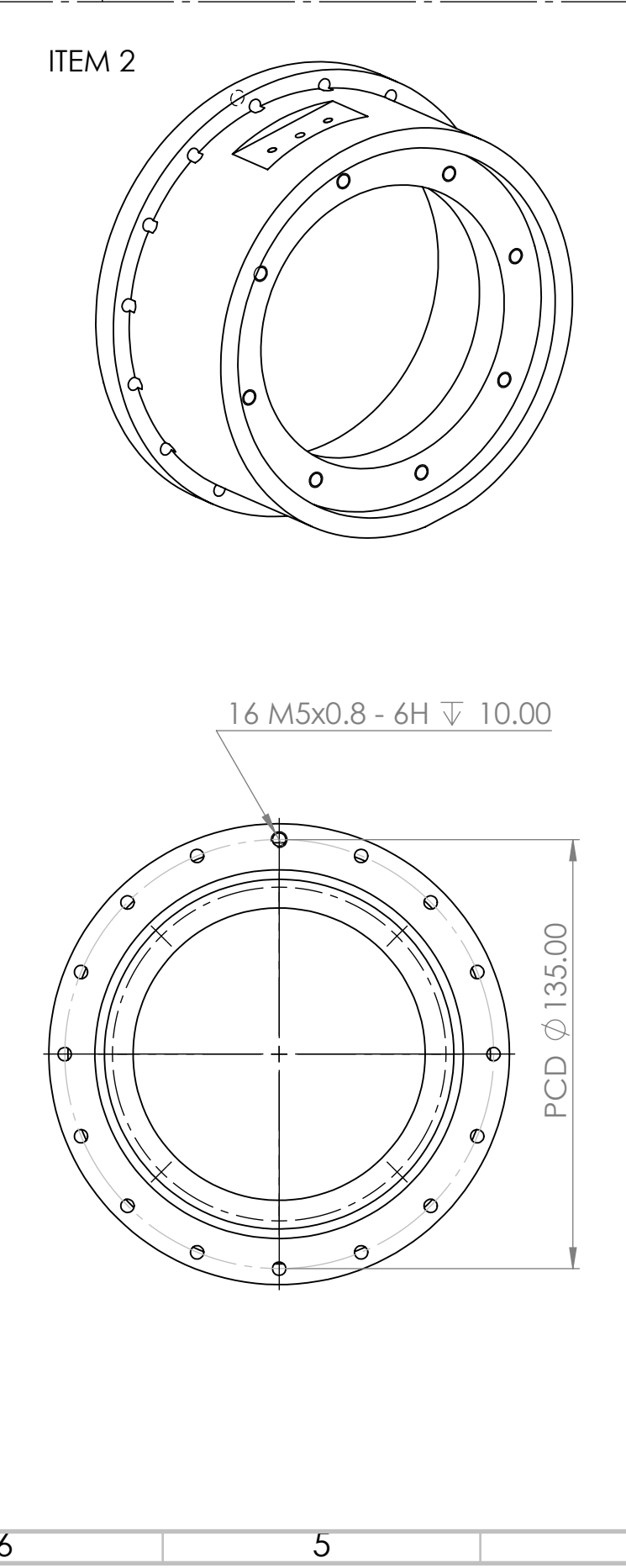
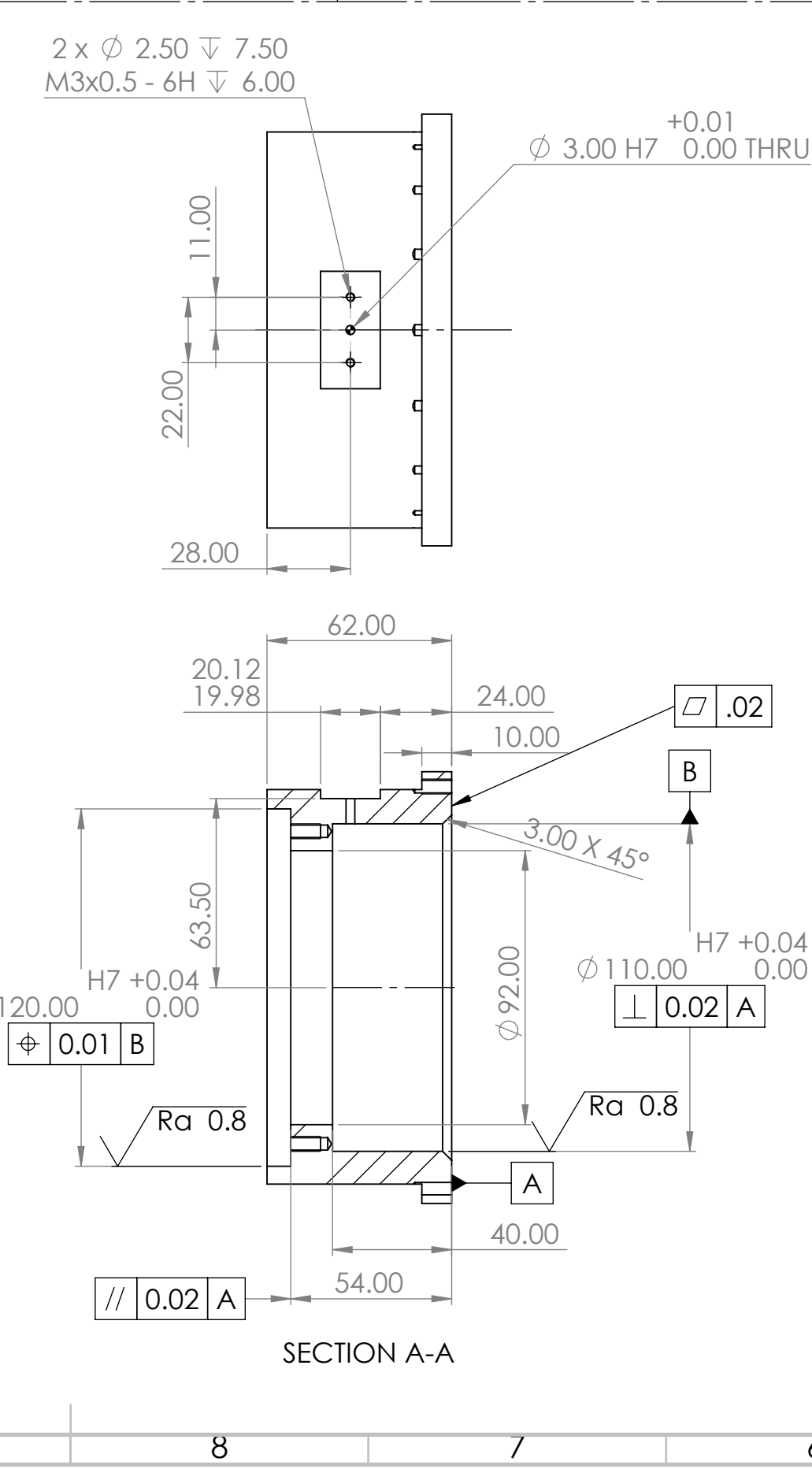
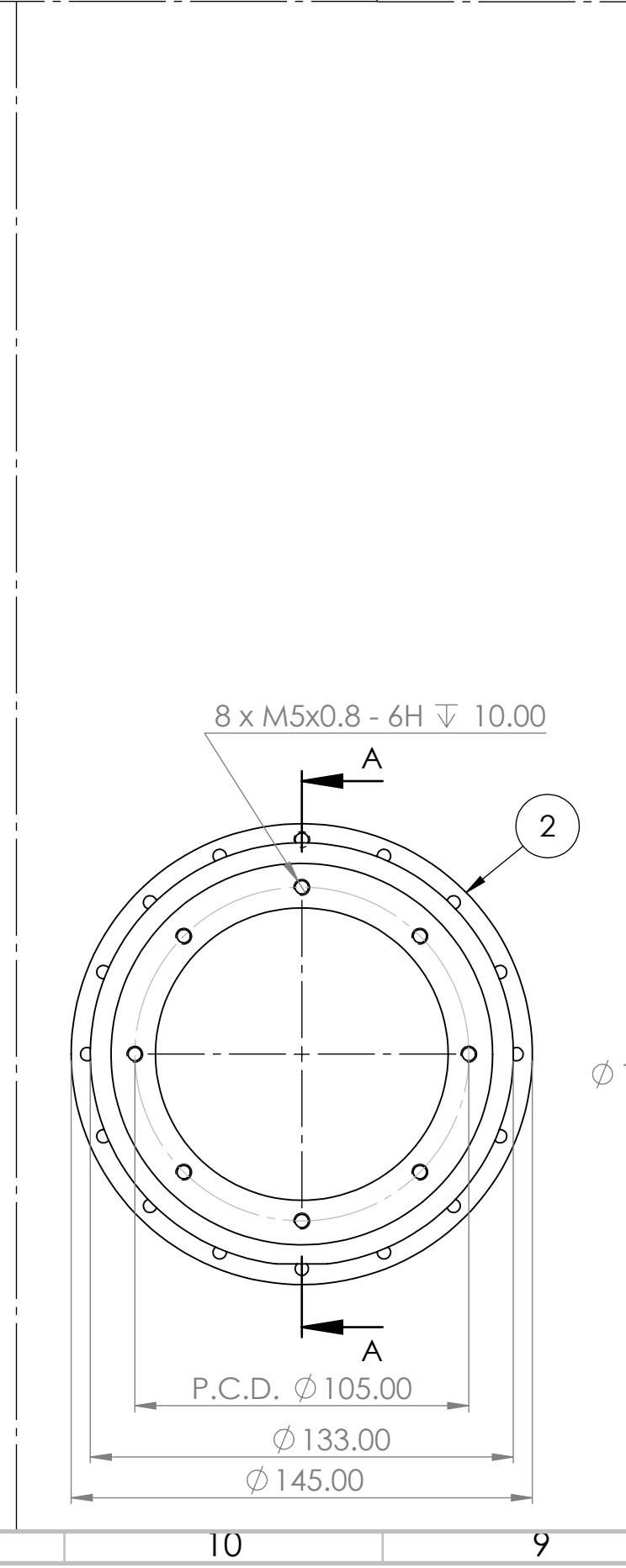
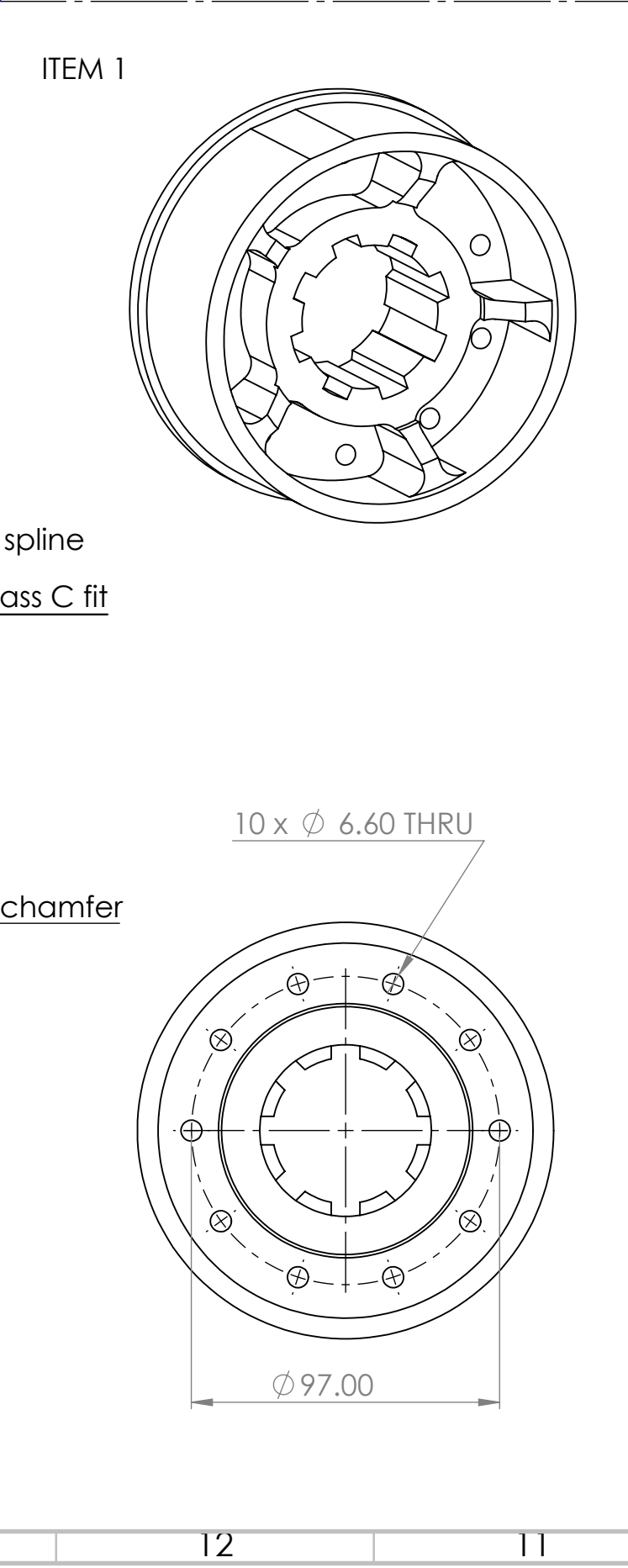
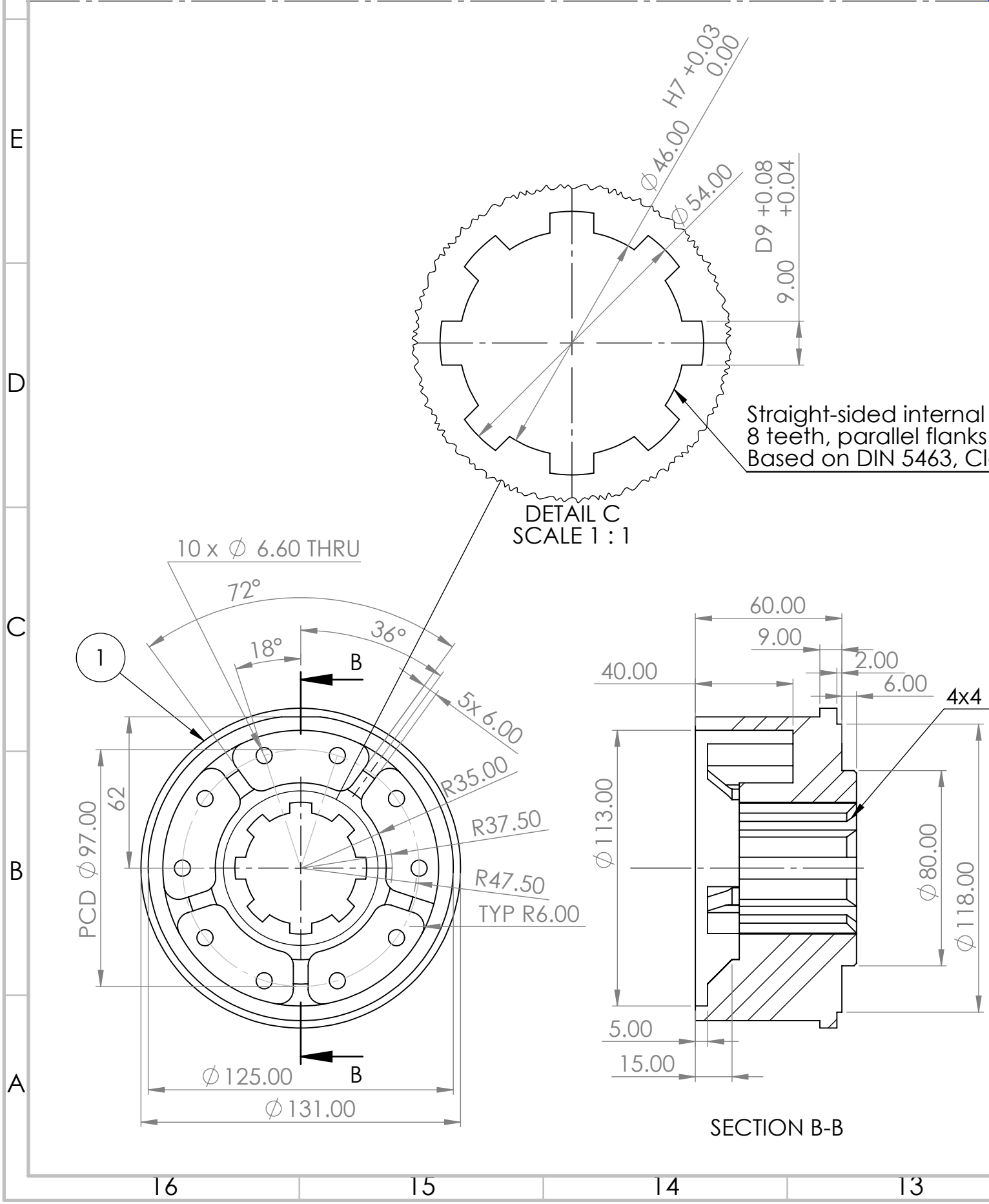
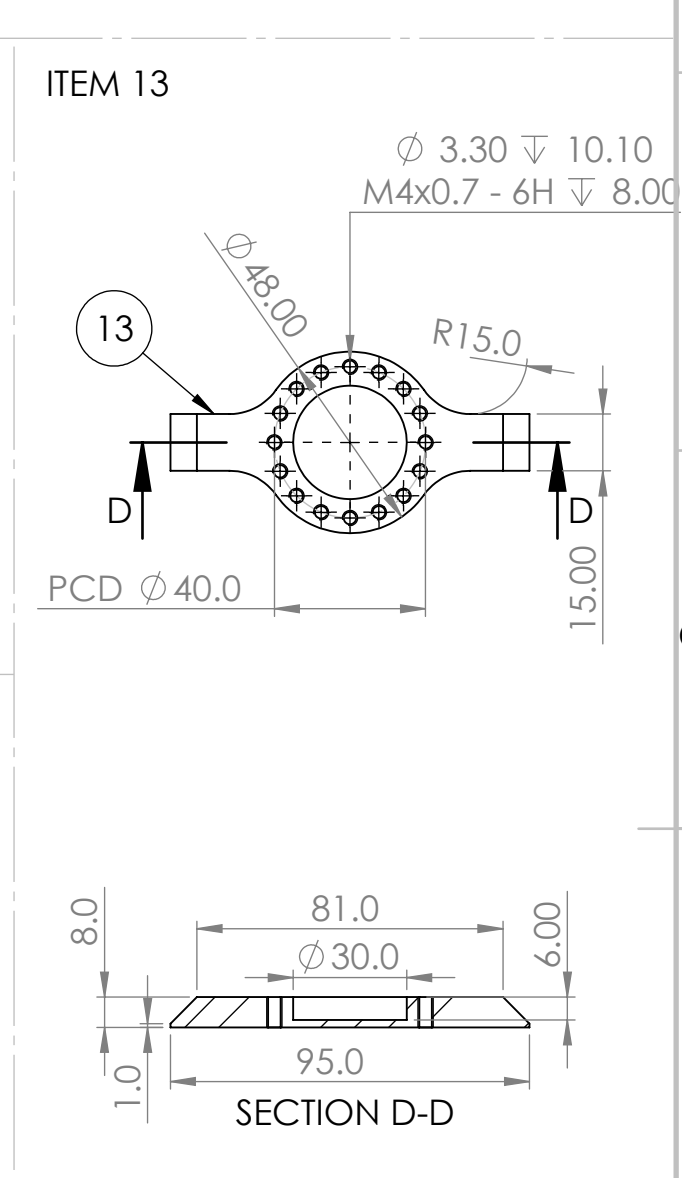
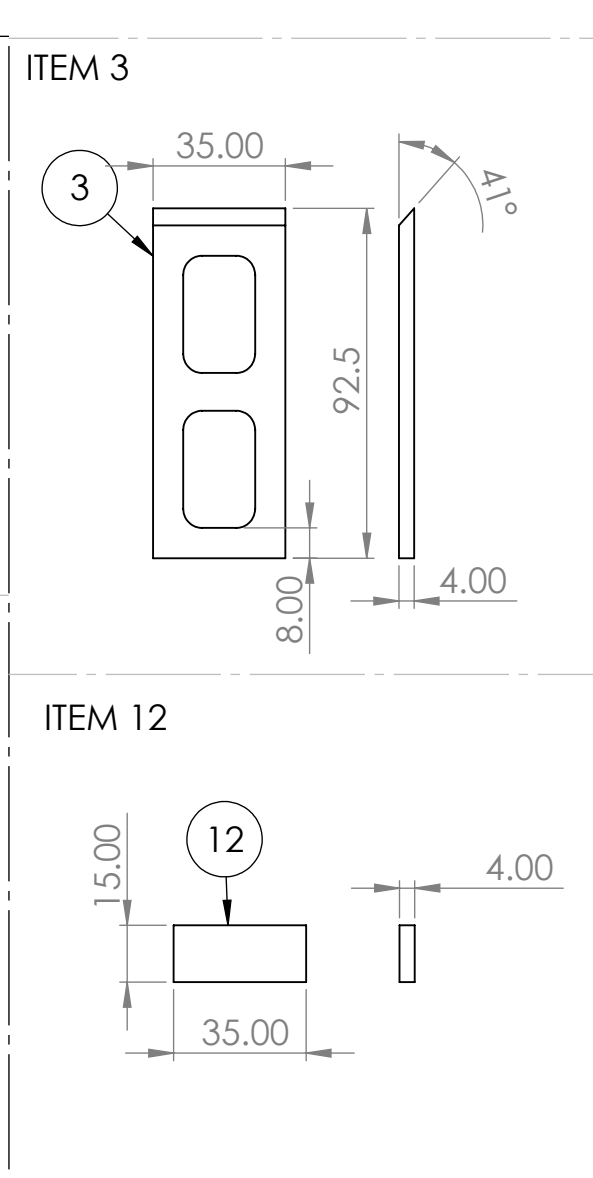
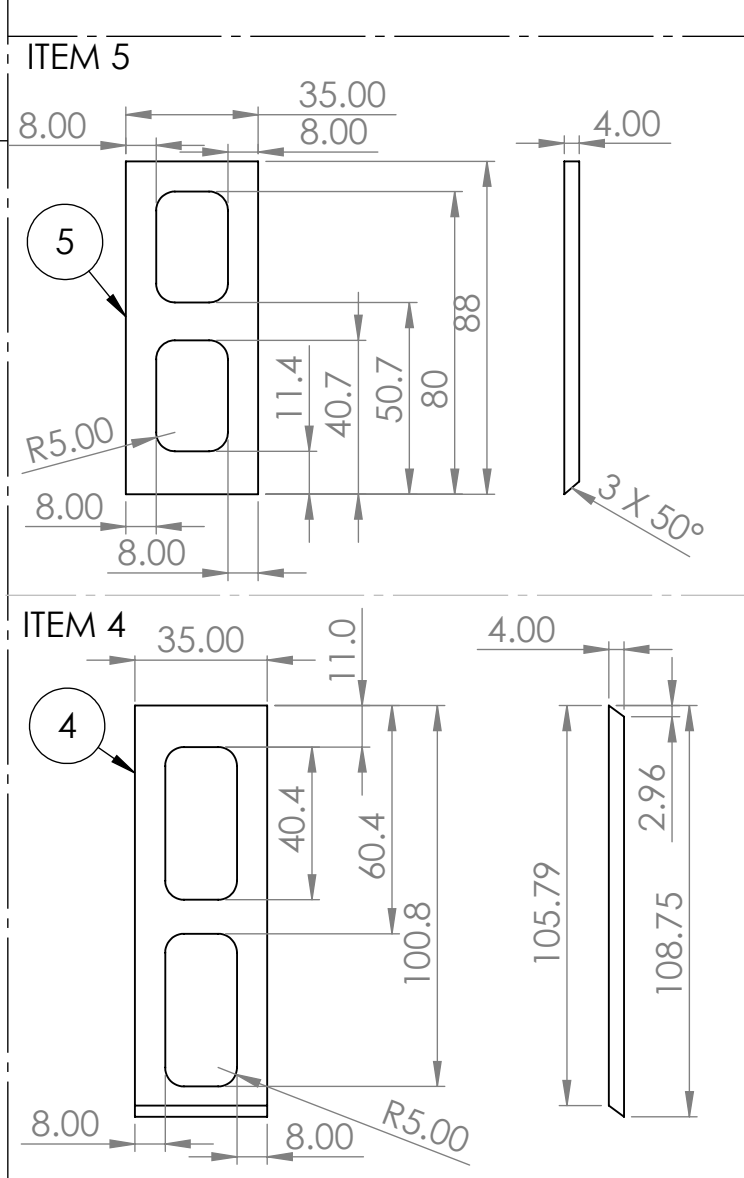


WELD TABLE				
ITEM NO.	QTY.	description	MATERIAL	SPECIAL NOTES
1	1	LOWER CYLINDER	C45	FINAL MACHINING OF PRECISION BORES AND TOLERANCE-CRITICAL SURFACES MUST BE DONE AFTER WELDING TO PREVENT WARPING OR DISTORTION DUE TO HEAT
2	1	UPPER CYLINDER	C45	FINAL MACHINING OF PRECISION BORES AND TOLERANCE-CRITICAL SURFACES MUST BE DONE AFTER WELDING TO PREVENT WARPING OR DISTORTION DUE TO HEAT
3	1	REINFORCEMENT 1	E335	
4	2	REINFORCEMENT 2	E335	
5	1	REINFORCEMENT 3	E335	
6	1	LEFT PANEL1	E335	
7	1	LEFT PANEL 2	E335	
8	1	LEFT PANEL 3	E335	
9	1	BACK PANEL	E335	
10	1	FRONT PANEL	E335	
11	1	RIGHT PANEL	E335	
12	6	CYLINDER RIBS	E335	
13	1	S.A. SUPPORT	E335	

NOTES:
1. PREHEAT C45 PARTS TO 150-250°C BEFORE WELDING. USE LOW-HYDROGEN ELECTRODES COMPATIBLE WITH BOTH MATERIALS.
2. ALLOW CONTROLLED COOLING TO AVOID CRACKING OR HARDENING.
3. FINAL MACHINING OF PRECISION BORES AND TOLERANCE-CRITICAL SURFACES MUST BE DONE AFTER WELDING TO AVOID WARPING.
4. AFTER WELDING AND FINAL MACHINING, APPLY INDUSTRIAL GRADE BLACK PAINT TO ALL EXTERNAL SURFACES EXCEPT PRECISION MACHINED AREAS.
5. UNLESS OTHERWISE SPECIFIED, ALL PLATE JOINTS TO BE WELDED WITH 5MM FILLET WELDS. STAGGERED INTERMITTENT 30MM WELD LENGTH WITH 60MM PITCH, ON BOTH SIDES IF ACCESSIBLE.



UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS SURFACE FINISH: Ra 3.2 TOLERANCES: LINEAR: ISO 2768-m ANGULAR: ISO 2768-m				FINISH: INDUSTRIAL GRADE BLACK PAINT		DEBURK AND BREAK SHARP EDGES		DO NOT SCALE DRAWING		REVISION	A
DRAWN R. REYES				SIGNATURE		DATE		FIRST ANGLE PROJECTION		TITLE	
CHD R. REYES				SIGNATURE		DATE		FIRST ANGLE PROJECTION		TITLE	
APPV D				SIGNATURE		DATE		FIRST ANGLE PROJECTION		TITLE	
MFG				SIGNATURE		DATE		FIRST ANGLE PROJECTION		TITLE	
QA				SIGNATURE		DATE		FIRST ANGLE PROJECTION		TITLE	
Machine Name: Tennis Serve Machine				MATERIAL:		SEE TABLE		DWG NO.		TSM_ARM_002	
Assembly Name: XT ARM				WEIGHT: 1667.00		SCALE: 1:2		SHEET 1 OF 2		A1	

