



- NOTES;
- M4 x 0.7 THREAD TO BE PRODUCED USING FULL FORM INSERT. THREAD CORE TO BE $\phi 2.979$ MINIMUM. THREAD ROOT TO BE R0.088 MINIMUM.
 - HEAT TREATMENT HARDEN & TEMPER TO 58-61 HRC. AREA 'B' IS REQUIRED IN A BRITTLE CONDITION. COMPONENTS TO BE HELD VERTICALLY DURING THE HEAT TREATMENT PROCESS TO REDUCE DEFORMATION.
 - AFTER HARDENING VAPOUR BLAST COMPONENTS AND PROTECT FROM CORROSION.

SCALE 1:1

SEE DESIGN STANDARD DS336 FOR DEFINITION OF Δ SYMBOL. SEE DESIGN STANDARD DS520 FOR DEFINITION OF R & FP No. UNLESS OTHERWISE STATED: ALL DIMENSIONS IN MILLIMETRES & APPLY BEFORE FINISHING TOL. $\pm 0,25$ ANGLES $\pm 2^\circ$ REMOVE SHARP CORNERS - CHAMFER OR R0,5 MAX. INTERNAL RADI1 0,5 MAX. SURFACE TEXTURE - $\sqrt{Ra 3,2}$ THREADS TO BS 3643 6g/6h. DRAWING PRACTICE TO BS 8888	3rd ANGLE PROJECTION DO NOT SCALE	TITLE <h1>BREAK STEM</h1>		DRAWN BY MARTIN SPIVEY	DRAWN DATE DEC 01	SHEET 1 OF 1	CHECKED MPS
		RENISHAW MATL R CODE R-0041-0000	MATERIAL (ENTER R OR FP CODE TO VIEW EQUIVALENT MATERIAL SPEC USING SUPPLIER PORTAL SITE @ WWW.RENISHAW.COM) SILVER STEEL - BS 1407			SCALE U.O.S. 10:1	DRAWING No. M-2197-0150-03-D

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 GL12 8JR

SHEET	1	TITLE	DRG. No.
CONT. ON NEXT SHT.		BREAK STEM	M-2197-0150

MOD. ISS.	DETAILS OF CHANGE	CIN	SIGN DATE
02 B	FIRST ISSUE.	FIN 882	MPS JAN02
03 A	FIRST USE OF MOD SHEET; UNDERCUT SHOWN AT LOCN B/C3 CHANGED - WAS PARALLEL DIAMETER GROOVE $\varnothing 3 \times 1.5$ LG WITH R 0.2 IN CORNERS.	36901	PNO MAR 02
03 B	IMPROVEMENTS TO THREAD FORM CONTROLS. SHEET 1: LOC'N C5: 'M4 x 0.7' HAS 'SEE NOTE 1' ADDED. LOC'N C2: PARTIAL SECTION VIEW OVERLAYED. SPOT DRILLED IDENTIFICATION FEATURE ADDED. LOC'N D1: NOTE 1: 'M4 x 0.7 THREAD.....' WAS 'HEAT TREATMENT.....'.	40287	DJB MAY 03
03 C	AT LOCN B-C6, $\varnothing 6,9/6,7$ WAS $\varnothing 7,1/6,9$ THIS CHANGE WAS NECESSARY TO ALLOW A REASONABLE CLEAN UP TOLERANCE ON AVAILABLE RAW MATERIAL.	SPIN 14548	SW MAR 05
03 D	BORDER UPDATED.	PC8495	MF MAY 16

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DRAWING MODIFICATION SHEET