<table>
<thead>
<tr>
<th>ITEM</th>
<th>QTY</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Clock face</td>
<td>6 x 6 x 1/2 Alum Bar</td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Base</td>
<td>6 x 1 1/2 x 1/2 Alum Bar</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>Clockworks</td>
<td>P/P</td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>Hour Hand</td>
<td>P/P</td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>Minute Hand</td>
<td>P/P</td>
</tr>
<tr>
<td>6</td>
<td>12</td>
<td>SNSS-1/4-20x3/8</td>
<td>SNSS - Socket Head Cap Screw (Inch Thread)</td>
</tr>
<tr>
<td>7</td>
<td>2</td>
<td>SNSS-1/4-28x1 1/4</td>
<td>SNSS - Socket Head Cap Screw (Inch Thread)</td>
</tr>
</tbody>
</table>

Tolerances Unless OTHERWISE SPECIFIED

- FRACTIONAL +/- 1/64
- 2 PLC DEC. +/- .015
- 3 PLC DEC. +/- .005
- ANGLES +/- 5 MIN

**Drawing Information**
- DRAWN: R. Tosch 12/16/2010
- TITLE: Clock Assembly
- DWG NO: MFG102
- SIZE: B
- SCALE: NEW
HASS Mill calculation sheet

1) Drill Bolt Pattern using DRO or Hass Mill
2) Chamfer all holes .030
3) Tap holes using tapping head in drill press
4) Engrave Numbers & image using CNC machine prior to assembly

Check size of cap screws for appropriate depth & diameter

12 x 1/4-20 UNC - 2B

\[ \phi 0.38 \mp 0.20 \]

\[ \phi 0.014B \]

Stamp initials this end

2 3/8 x 2 3/8 x 1/8 clock pocket
Far side
centered about \( \phi \) .31 thru hole

Inspect Hole depth before continuing

\[ \phi 0.21 \mp 1.50 \]

1/4-28 UNF - 2B \( \mp 1.13 \)

\[ 0.010B/AB \]
1) Chamfer all holes .030

Stamp initials this end

2 x 0.08

2 x 0.28 THRU

2 x $\phi$0.41 $\mp$ 0.28

$\phi$0.010

DETAIL A

SCALE 2 : 1

Drawn

R. Tosch 12/16/2010

MFG102

Clock Assembly
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