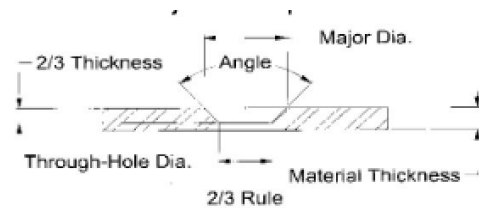


These tolerances apply when customer specifications are not provided (e.g., solid models, physical samples, or underdimensioned prints). EVS may reference these standards when quoted tolerances cannot be met with standard manufacturing methods. While tighter tolerances are achievable through secondary processes (reaming, machining, hard tooling), they will impact cost and lead time. Critical tolerances must be indicated at order placement and will be evaluated by Engineering for manufacturability.

Unless otherwise specified, all dimensions/tolerances apply before finishing.

Description	Tolerance (in)	Tolerance (mm)
Hardware Hole Diameter	+0.003 / -.000	+0.08 / -0.00
Hole Diameter	+/- .005	0.13
Countersink Major Diameter	+/- .010	0.25
Countersink Minor Diameter	+/- .010	0.25

Standard For Turret Formed Countersinks to avoid distortion caused by material displacement



STANDARD DIMENSIONS

Description	Tolerance
Angular	+/- 1 degree
Fractional	+/- 1/64
Bend Relief	.062

LOCATIONAL DIMENSIONS

Description	Tol. (in)	Tol. (mm)
Edge to Bend across 1 or 2 bends	+/- .010	0.25
Edge to Bend across 3 bends	+/- .015	0.38
Edge to Edge across no bends	+/- .005	0.13
Edge to Edge across 1 or 2 bends	+/- .010	0.25
Edge to Edge across 3 bends	+/- .015	0.38
Bend to Bend across 1 or 2 bends	+/- .010	0.25
Bend to Bend across 3 bends	+/- .015	0.38
Feature to feature across 4 bends	+/- .020	0.51
Feature to feature across >4 bends	+/- .020 + .005 ea	0.51 + 0.13 ea
Edge to Hole across no bends	+/- .005	0.13
Hole to bend (same plane)	+/- .010	0.25
Hole to Hole (same plane)	+/- .005	0.13
Part to Part (welded assembly)	(see note)	(see note)

Note: Welded assemblies reviewed by EVS Engineering prior to production.

Solid Model format by order of preference: SolidWorks (.SLDPRT, .SLDASM), Pro-E (.PRT, .ASM), Parasolid, STEP, IGES

EVS DEFAULT PLATING SPECIFICATIONS

Process	Material or other pertinent factors	Specification nomenclature
Clear Zinc	N/A	ASTM B633-98, Class FE/ZN 8, Type III
Yellow Zinc	N/A	ASTM B633-98, Class FE/ZN 8, Type II, Yellow Chromate
Black Zinc	N/A	ASTM B633-98, Class FE/ZN 8, Type II, Black Chromate
Clear Iridite	N/A	MIL-C-5541E, Class 1A, Clear
Yellow Iridite	N/A	MIL-C-5541E, Class 1A
Electrodeposited Nickel	COPPER	QQ-N-290A, Class 1, Grade D
Electrodeposited Nickel	STEEL	QQ-N-290A, Class 1, Grade C
Electroless Nickel	ALUMINUM	MIL-C-26074E, Class 1, Grade A
Electroless Nickel	COPPER	MIL-C-26074E, Class 1, Grade B
Electroless Nickel	STEEL	MIL-C-26074E, Class 1, Grade C
Anodize – Clear	N/A	MIL-A-8625F, Type 2, Class 1
Anodize – Black	N/A	MIL-A-8625F, Type II, Class 2, Black
Anodize – Gold	N/A	MIL-A-8625F, Type II, Class 2, Gold
Anodize – Grey	N/A	MIL-A-8625F, Type II, Class 2, Grey
Tin Plate	<i>BRIGHT DIP must be specified if required</i>	ASTM-B545-97, Class A