

Outer Tie Bar nut (or Main nut)

24 needed

Use 4140 steel forging blanks Rc 30/32

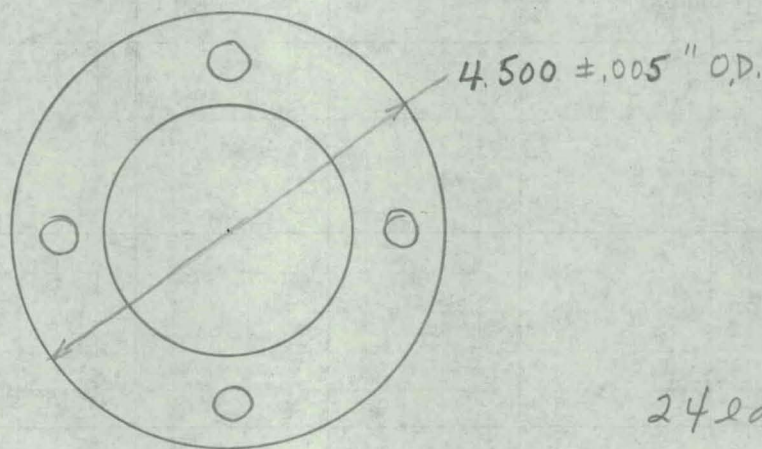
Nut is $4.500 \pm .005$ " O.D. X $2.750 \pm .005$ " long

Internal thread is 12 T.P.I. to match tie bars

4 equispaced wrenching holes on $3\frac{5}{8}$ " diam. centers of $\frac{3}{8}$ " diam are drilled to a depth of $\frac{1}{2}$ " on top side of nut.

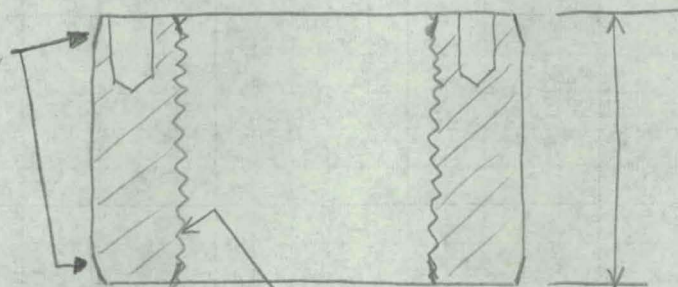
200 Ton
Cubic Press

H. J. Hall
12 Jan 1966



24 each

light chamfer
each end



12 T.P.I.
to match the bars

40004003

CONFIDENTIAL
THIS DOCUMENT IS SUBJECT TO COURT ORDER

Tie Bars 200 ton cubic press 12 needed

use stressproof $2\frac{3}{4}$ " diam bars, as drawn X 44"L.
Standard tolerance is $2.750'' \begin{smallmatrix} +.000 \\ -.006 \end{smallmatrix}$ Dia as drawn at mill.

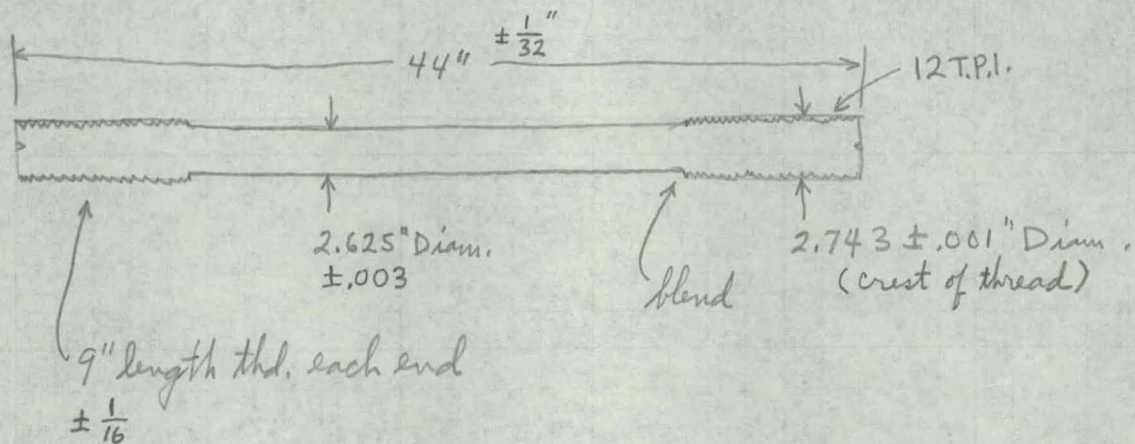
Make threaded ends $2.743 \pm .001''$ diam (crest of thread)

use 12 T.P.I. for 9" length each end.

Thread depth is .05112", Flat at external thread crest is .01042,

Diam of bar between threaded ends = $2.625'' \pm .003$

Length of tie bar = $44'' \pm \frac{1}{32}''$



12 each

H. J. Hall
12 Jan 1966

40004004

CONFIDENTIAL
THIS DOCUMENT IS SUBJECT TO COURT ORDER

Inner Tie-Bar Nut

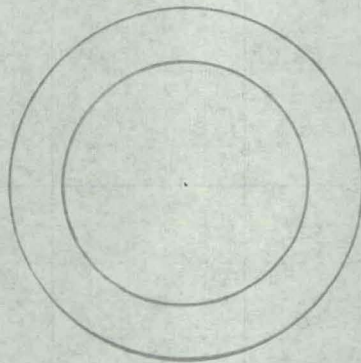
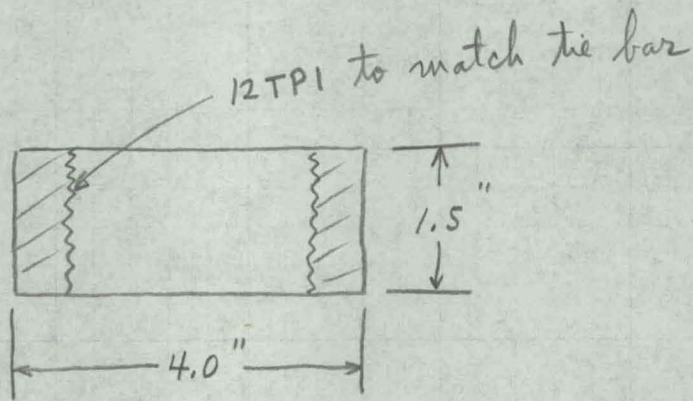
24 needed ✓

use mild steel

nut is $4.000 \pm .010$ " O.D. x $1.500 \pm .010$ " L. with
12T.P.I. thread to match tie bars.

No wrenching holes are needed, nut will
be adjusted with a stilson wrench

200 ton
Cubic Press
H.J. Hall
12 Jan 1966



40004605

CONFIDENTIAL
THIS DOCUMENT IS SUBJECT TO COURT ORDER