

Outer Tie Bar nut (or Main Nut)

24 needed

Use 4140 steel forging blanks Rc 30/32

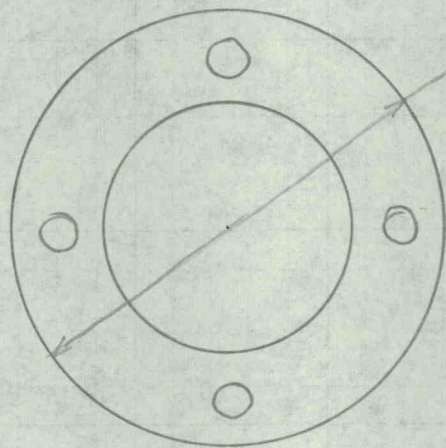
Nut is  $4.500 \pm .005$ " O.D. X  $2.750 \pm .005$ " long

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

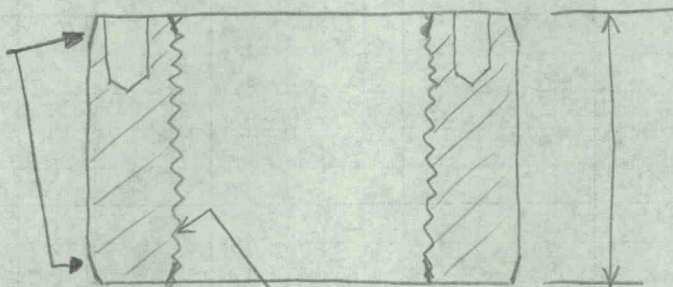
H. J. Hall  
12 Jan 1966



$4.500 \pm .005$ " O.D.

24 each

light chamfer  
each end



$2.750 \pm .005$ " Long

12 T.P.I.  
to match the bars

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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.

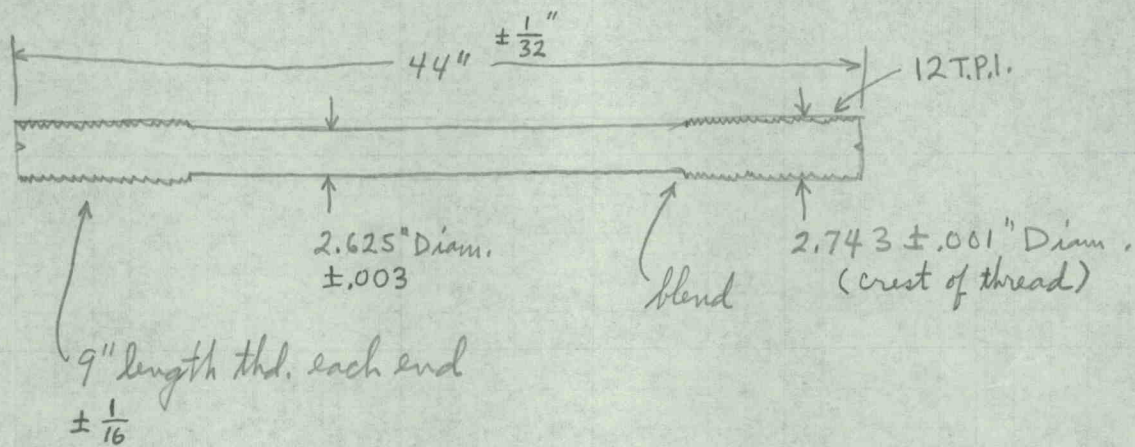
Make threaded ends  $2.743 \pm .001''$  diam (crest of thread)

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

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Inner Tie-Bar Nut

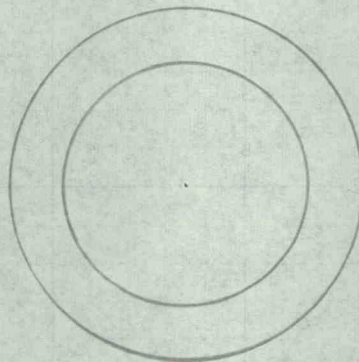
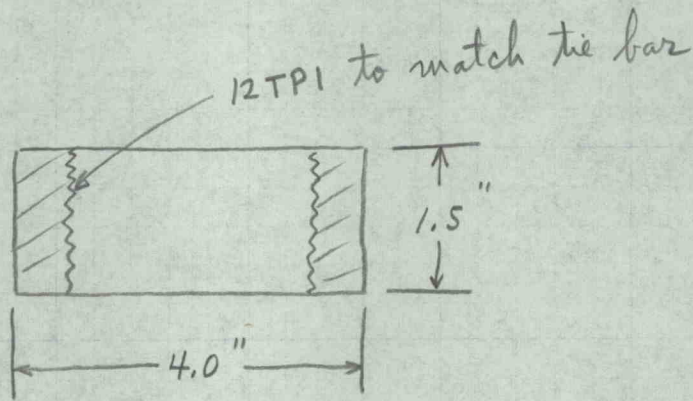
24 needed ✓

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



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