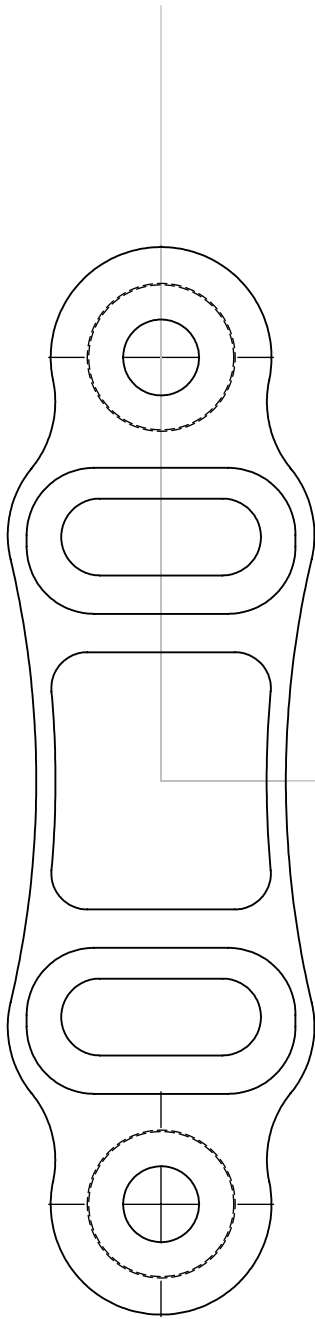


4

3

2

1



POINT TO POINT LOCATIONS FOR "PECK" MACHINING STRATEGY.
USE 1/4" 3F CENTER CUTTING ENDMILL WITH AT LEAST 1/2" LOC.

NOTE* LOCATIONS AREFOR 1/4 OF PROFILE.
SETUP ON CENTER AND SUBSTITUTE X FOR X MINUS FOR OPPOSITE SIDES.
REPEAT FOR Y AXIS.
CONFIGURED FOR A .05" STEPOVER ON TOOL.

EXPECT MINOR HAND FITTING ONCE COMPLETED.

X.2 Y0.
X.2006 Y.05
X.2042 Y.1499
X.2076 Y.1998
X.217 Y.2994
X.2231 Y.349
X.2302 Y.3985
X.2383 Y.4478
X.2472 Y.497
X.2569 Y.5461
X.268 Y.5948
X.275 Y.6442
X.2653 Y.693
X.2403 Y.7361
X.2112 Y.7768
X.1874 Y.8207
X.1695 Y.8674
X.1572 Y.9158
X.1512 Y.9654
X.1523 Y1.0153
X.1585 Y1.065
X.1622 Y1.1147
X.1507 Y1.1632
X.1253 Y1.206
X.0881 Y1.2391
X0. Y1.265

PROPRIETARY AND CONFIDENTIAL
THE INFORMATION CONTAINED IN THIS
DRAWING IS THE SOLE PROPERTY OF
LONGLES, INC. ANY
REPRODUCTION IN PART OR AS A WHOLE
WITHOUT THE WRITTEN PERMISSION OF
LONGRIFLES, INC. IS PROHIBITED.

TOLERANCING: INCHES		NAME	DATE	LONGRIFLES, INC. TITLE: 3.9 ULTACH CHEEK BASE INSTALL MACHINING		
ANGULAR: +/- .5° LINEAR AND RADIUS: .01" = +/- .005" .001" = +/- .001" .0001" = +/- .0005"	DRAWN	C. DIXON	2.7.17			
	CHECKED					
INTERPRET GEOMETRIC TOLERANCING PER:				SIZE DWG. NO. REV B		
MATERIAL		COMMENTS:				
FINISH						
DO NOT SCALE DRAWING						
				SCALE: 1:1		SHEET 1 OF 1