TEMPER ARE CONFIDENTIAL AND ARE NOT TO BE REPRODUCED, USED OR COPIED IN WHOLE OR IN PART OR DISCLOSED TO OTHERS EXCEPT AS AUTHORIZED BY SAMSON ROLL FORM PRODUCTS PH 847-965-6700 FAX 847-965-8950 6101 W OAKTON ST. SKOKIE, IL 60077 -TOLERANCES- NOT INDICATED XXX ±.010 XX ±.030 X ±.060 DRAWN BY: L.S.B. 7-25-11 DATE: L.S.B. 7-25-11 DATE: ANGLE ANGLE -TOLERANCES- NOT INDICATED XXX ±.010 XX ±.060 DRAWN BY: L.S.B. 7-25-11 DATE: ANGLE ANGLE STRAIGHTNESS.015''/FOOT DO NOT SCALE SCALE: 1:1 DRAWING # DRAWING # STRAIGHTNESS.015''/FOOT SHEET #						/1510N		
SEE PS FOR WATERIAL TYPE AND TINSH 1/2 1/2 SEE PS FOR WATERIAL TYPE AND TINSH FOR LEWER MURICIPAL SEE PURCHASE OPDER LEMENT DUMENSON (TCT), SEE PURCHASE OPDER LEMENT DUMENSON TO COTOD 102 C PURCHASE OPDER LEMENT DUMENSON TO COTOD 102 C PURCHASE OPDER LEMENT AND AND AND ST NOT THE COCEPTOR OF GUT ENDS WHICH MAY RAY DURE RECEIVEDING THIS AMOUNT PROFILE DUMENSIONS TO BE MEASURED 2" OR GREATER FROM CUT ENDS MATERIAL CALLS CONTENTS AND AND AND AND TO TEMPER ATT. PER MYFT TO CHERRE ON FOLLOW FORUSES THE AND			L REV	,			DATE	BY
SEE PO FOR MATERIAL TYPE AND FINISH FOR LENGTH DMENSION ("''), SEE PURCHASE ORDER. LENGTH TOLERANCELESS THAN 100": ±1/16" LESS THAN 120": ±1/8", 120" OR OREATER: ± 1/4" MAXIMUM BURR NOT TO EXCEED 10% OF MATU. THICKNESS WITH THE 'EXCEPTION OF CUT ENDS, WHICH MAY HAVE BURR EXCEEDING THIS AMOUNT. FINISHED PART MAY EXHIBIT TYPICAL ROLL FORMED END CUT DISTORTION. PROFILE DIMENSIONS TO BE MEASURED 2" OR GREATER FROM CUT ENDS. MATERIAL GAUGE 20 MATERIAL GAUGE 20 MATUR THE RATION AND ITS CONTENTS MATERIAL GAUGE 20 MATERIAL FINISH TEMPER THE BERNING AND ITS CONTENTS NOT THER M/FT. THE SHARNON AND ITS CONTENTS TOLERANCESS- THE SHARN AND ITS CONTENTS MATERIAL GAUGE 20 MATERIAL SAMSON ROLL FORM FRODUCTS AFE CONTRENT LA AND RUSCIDED IN STATEMENT AND RUSCIDED IN MATERIAL TORM FRODUCTS TITLE SAMSON ROLL FORM FRODUCTS TITLE ANGLE TOLERANCESS- THE 4000 MOL TOTO TO TO TO TO TO TO TOTO TO TOTO TO					DESSIN		Drite	
PROFILE DIMENSIONS TO BE MEASURED 2" OR GREATER FROM CUT ENDS. MATERIAL GAUGE 20 WIDTH FINISH COATING THIS DRAWING AND ITS CONTENTS ARE CONFIDENTIAL AND ARE NOT TO BE REPRODUCED, USED OR COPIED IN WHOLE OR IN PART OR DISCLOSED IN WHOLE OR IN PART OR DISCLOSED TO OTHERS EXCEPT AS AUTHORIZED BY SAMSON ROLL FORM PRODUCTS SAMSON ROLL FORMED PRODUCTS FAX 847-965-6700 6101 w OAKTON ST. SKOKIE, IL 60077 TTOLERANCES- NOT INDICATED XXX ± 0.00 X ± 0.060 DRAWN BY: L.S.B. 7-25-11 DATE: ANGLE ANGLE TRACTIONAL ±1/32 CHECKED BY: DATE: A SIZE A CUSTOMER A	FOR LENGTH DIN LENGTH TOLERAN MAXIMUM BURR WHICH MAY HAV	MENSION (''L' NCE:LESS THA NOT TO EXC E BURR EXC	1/2 AND FINISH), SEE PURCHA AN 60'': ±1/16 EED 10% OF M EEDING THIS AN	'' LESS TH 1AT'L THICH 10UNT.	L L 1/2 R. AN 120'': ±1/8'', KNESS WITH THE E		TER: ± 1/4'' UT ENDS,	
COATING THIS DRAWING AND ITS CONTENTS ARE CONFIDENTIAL AND ARE NOT TO BE REPRODUCED, USED OR COPIED IN WHOLE OR IN PART OR DISCLOSED TO OTHERS EXCEPT AS AUTHORIZED BY SAMSON ROLL FORM PRODUCTS SAMSON ROLL FORMED PRODUCTS PH 847-965-6700 FAX 847-965-8950 6101 w OAKTON ST. SKOKIE, IL 60077 TOLERANCES- NOT INDICATED XXX ±.010 XX ±.030 X ±.060 DRAWN BY: L.S.B. 7-25-11 DATE: A CHECKED BY: DATE: A SIZE A			MEASURED 2''	OR GREAT	ER FROM CUT ENI	DS.		
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BY SAMSON ROLL FORM PRODUCTS TITLE -TOLERANCES- NOT INDICATED .XXX ±.010 .XX ±.030 X ±.060 FRACTIONAL ±1/32 ANGLES ±1° BY SAMSON ROLL FORM PRODUCTS TITLE DATE: ANGLE SIZE CUSTOMER A	WT. PER M/FT.		HOLE OR IN PART OR	DISCLOSED	PH 847-965-6 FAX 847-965-89	700 61 950 61	01 W OAKTON S KOKIE, IL 60077	Τ.
NOT INDICATED .XXX ±.010 .XX ±.030 .X ±.060 FRACTIONAL ±1/32 ANGLES ±1°		BY	SAMSON ROLL FORM	PRODUCTS -			, .2 00077	
FRACTIONAL ±1/32	NOT INDICATED	L.S	S.B. 7-25-11					
angles ±1" straightness.015"/foot DO NOT SCALE SCALE: 1:1 DRAWING # S-1844 SHEET # REV. twist 1°/foot This drawing 1:1	FRACTIONAL $\pm 1/32$	CHECKED BY:		DATE:				
	ANGLES ±1° STRAIGHTNESS.015''/FOOT TWIST 1°/FOOT	DO NOT SCALE THIS DRAWING	SCALE: 1:1	DRAWING #	; S-1844	SHEET #		REV.