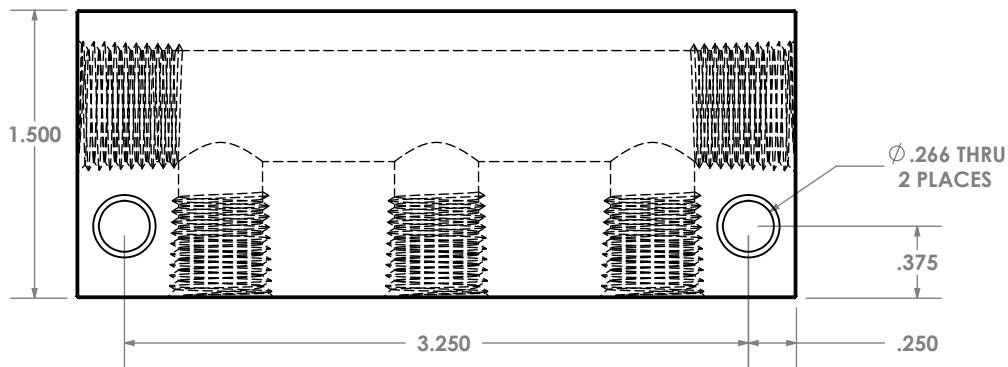


MB STURGIS INCOMING INSPECTION REQUIREMENT:
 MINIMUM ACCEPTED QUALITY LEVEL (AQL) FOR THIS PART
 SHALL BE 1.0 AT GENERAL INSPECTION LEVEL I

ADDITIONAL VENDOR REQUIREMENT:
 FIRST ARTICLE SAMPLE FOR EACH ORDER
 MUST BE APPROVED BY MB STURGIS
 PRIOR TO PRODUCTION.

Rev	Date	Properties

NOTE: END CUTS SHALL BE CUT CLEAN AND SMOOTH



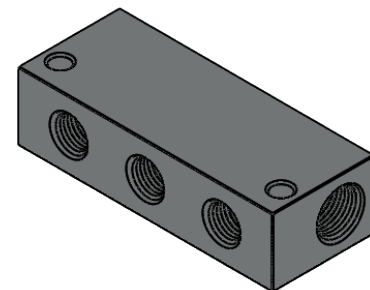
VENDOR DOCUMENTATION CHECKLIST:
 (REQUIRED FOR EACH SHIPMENT)

____ PART QA INSPECTION LOG
 ____ MATERIAL CERTIFICATIONS

INCOMING INSPECTION LOG:
 (REQUIRED FOR EACH SHIPMENT)

____ DATE
 ____ SHIPMENT QUANTITY
 ____ SAMPLE SIZE
 ____ DIMENSIONAL CHECK
 ____ NOTES CHECK

COMMENTS: _____

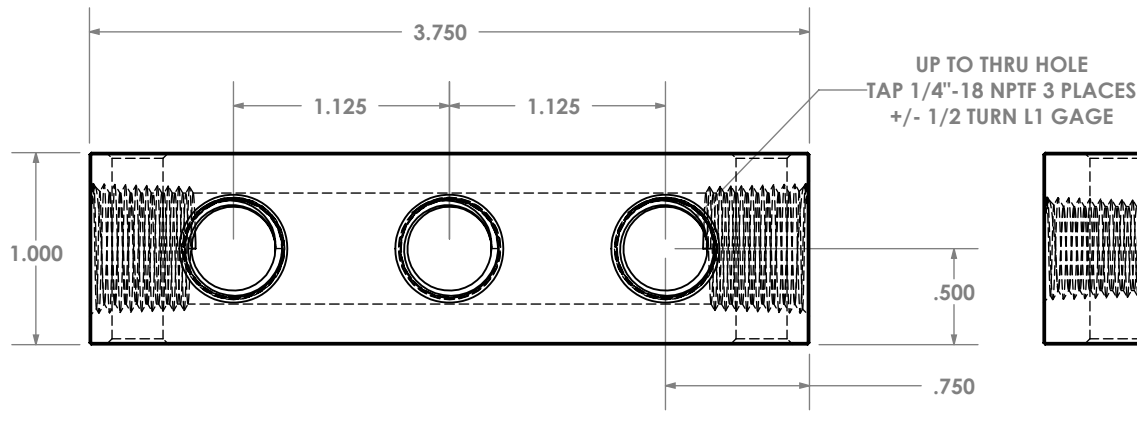


CHAMFER ALL HOLES MIN 0.030

ALL THREADS SHALL BE NPTF PER ANSI B1.20.3

**+/- 1/2 turn using L1 Gage
 AND
 MXT shall not go past flush
 with end of part using 6-step gage**

NOTE: DEBURR ALL SHARP EDGES (0.010 MIN)



**TAP 3/8\"-18 NPTF FROM BOTH SIDES
 +/- 1/2 TURN L1 GAGE**

Purchasing Requirements(new PO):

Supplier(s) is required to provide the following at the beginning of every purchase order:

1. Material certification from the material supplier.
2. Certificate of Conformance from the part supplier to include:
 - Dimensional data & Cpk for a 6 piece sample (Asterisk dimensions only)
 - Pass/Fail data for thread gage check

Purchasing Requirements(shipment):

Supplier(s) is required to provide the following at the beginning of every shipment:

Material certification from the material supplier.

- Notes:**
1. Shall be clean and free of dirt, chips and oil.
 2. Burrs not to exceed .002".
 3. Must pass Ammonia Vapor Test per ASTM B85M-95,PH-9.8-10.
 4. Shall be packaged to protect against damage in shipment.
 5. Sealing, threads and exposed surfaces shall be free of chatter.
 6. Parts shall be packaged to protect against moisture and corrosion.

Approximate Volume = 4.1118 Cubic Inches
 Approximate Weight = .4011 Pounds

NOTE: FINISHED PART SHALL BE CLEAR ANODIZED TO PASS 96 HOUR SALT SPRAY TEST(ASTM B117.)



This drawing and the information it contains are proprietary and confidential. Disclosure or copying requires the written approval of:

MB Sturgis, Inc.
 11722 Northline Industrial
 Maryland Heights, MO 63043
 (314) 291-6665

Unless Otherwise Specified
 .X +/- .015
 .XX +/- .010
 .XXX +/- .005

Angles +/- 1 Deg
 Concentricity +/- .010
 Break Sharp Edges .005 R/Chamfer
 All Dimensions Are In Inches

Quality Assurance Provisions Sampling Plan ANSI Z1.4
 Attribute +.005 >+/- .005 <+/- .005 Go Ring No GO Ring Surface
 AQL 1.0, S-2 2.5, S-2 .65 2.5, S-4 6.5, S-4 2.5, S-4

Material: **6061-T65 ALUMINUM**

Drawn By: **DAG**

Date: **05-21-2019**

Checked By: **DAG**

Date: **05-21-2019**

Title: **5 WAY MANIFOLD
 3X1/4NPT BY 2X3/8NPT**

Scale: **1:1**

Part Number: **402315**

Rev: **A00**

UNCONTROLLED DOCUMENT IF PRINTED
 MASTER COPY ON MB STURGIS SERVER