NOTES:
1. MATERIAL: BAR, 1018 STEEL OR EQ., Ø2.75 x 55.00 LG.
2. HEAT TREAT: NONE
3. SURFACE TREATMENT: AEROCOTE OR EQ.
4. INTERNAL BORE MAY BE DRILLED FROM BOTH ENDS. A SMALL STEP AT THE INTERSECTION OF THE HOLES IS ACCEPTABLE IF SMOOTHED TO BE FREE OF SHARP EDGES.
5. WEIGHT: 69.44 LBS.

RE-APPLY AEROCOTE (OR EQUIVALENT) AFTER INCREASING DEPTH OF LEFT END BORE (TO 11.50") AND INSTALLING SET SCREWS AT BOTH ENDS.

TAP DEPTH IS APPROXIMATE AS SHOWN. DO NOT BREAK THRUST TO BORE WITH TAP. GRIND SET SCREW SHANKER AS REQUIRED TO MAINTAIN 0.22/0.24 PROJECTION FROM O.D. OF SINKER BAR.

PICTORIAL 1-D-5
SPECIAL SINKER BAR
N.T.S.

DETAIL 1-D-2
REF. 1-B-1 & 1-B-6

SECTION 1-B-4
REF. 1-B-8

END VIEW 1-B-8
SPECIAL SINKER BAR

DRILL #3 (0.213") TO BORE TAP 1/4-28 UNC-2B x 0.27 DP. 7°

SECTIONS 1-B-4

SEE DETAIL 1-D-2

INTEGRATED OCEAN DRILLING PROGRAM
TEXAS A&M UNIVERSITY
COLLEGE STATION, TX 77845