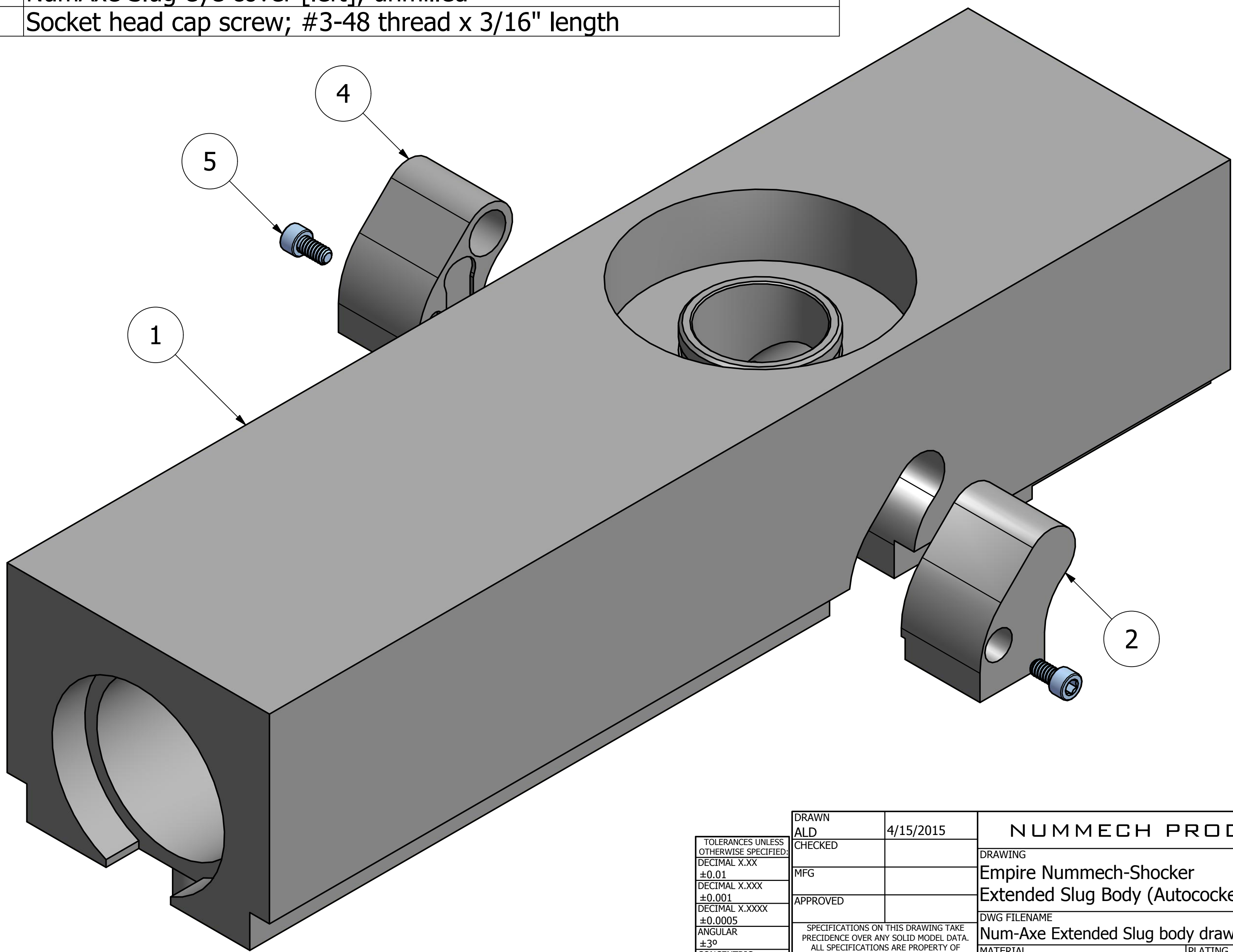


PARTS LIST		
ITEM	QTY	DESCRIPTION
1	1	Axe extended Slug body; unmilled
2	1	NumAxe Slug eye cover [right]; unmilled
3	6	Socket head button cap screw; #6-32 thread x 1/4" length; modified
4	1	NumAxe Slug eye cover [left]; unmilled
5	2	Socket head cap screw; #3-48 thread x 3/16" length



TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMAL X.XX ±0.01 DECIMAL X.XXX ±0.001 DECIMAL X.XXXX ±0.0005 ANGULAR ±3° CONCENTRIC 0.003 T.I.R. SURFACE FINISH √63µin MAX	DRAWN	4/15/2015	NUMMECH PRODUCTS	
	CHECKED		DRAWING	
	MFG		Empire Nummech-Shocker	
	APPROVED		Extended Slug Body (Autococker threaded)	
SPECIFICATIONS ON THIS DRAWING TAKE PRECEDENCE OVER ANY SOLID MODEL DATA. ALL SPECIFICATIONS ARE PROPERTY OF MECHANIZED NUMERICS AND SHALL NOT BE REPRODUCED OR USED AS THE BASIS FOR THE MANUFACTURE OR SALE OF APPARATUS WITHOUT DIRECT CONSENT.		DWG FILENAME: Num-Axe Extended Slug body drawing COMPONENT REV: idw v1.2		
		MATERIAL: ALUMINUM 6061-T6	PLATING: RAW	
		SCALE:	SIZE C	SHEET 1 OF 6

4

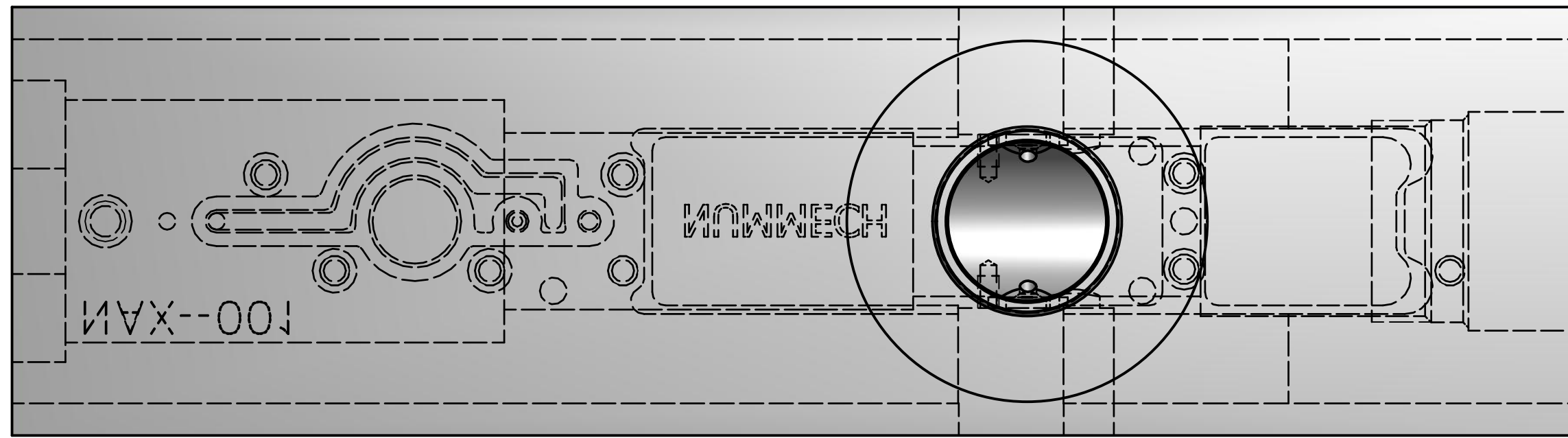
3

2

1

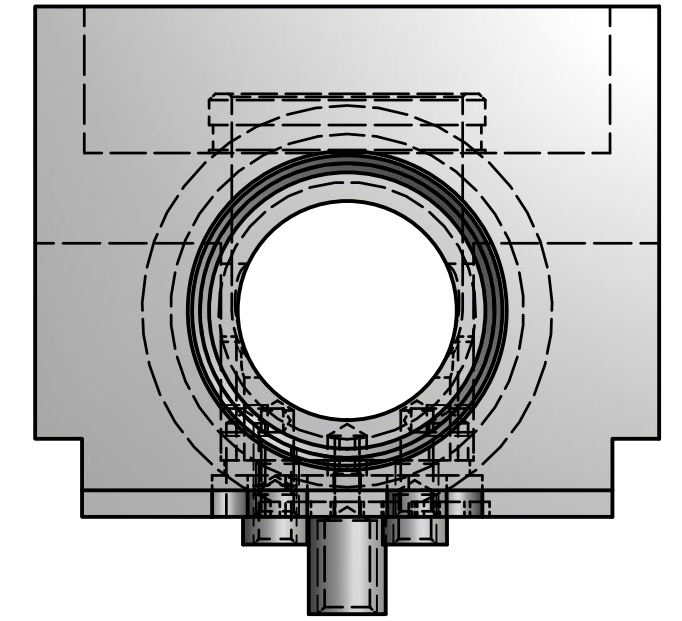
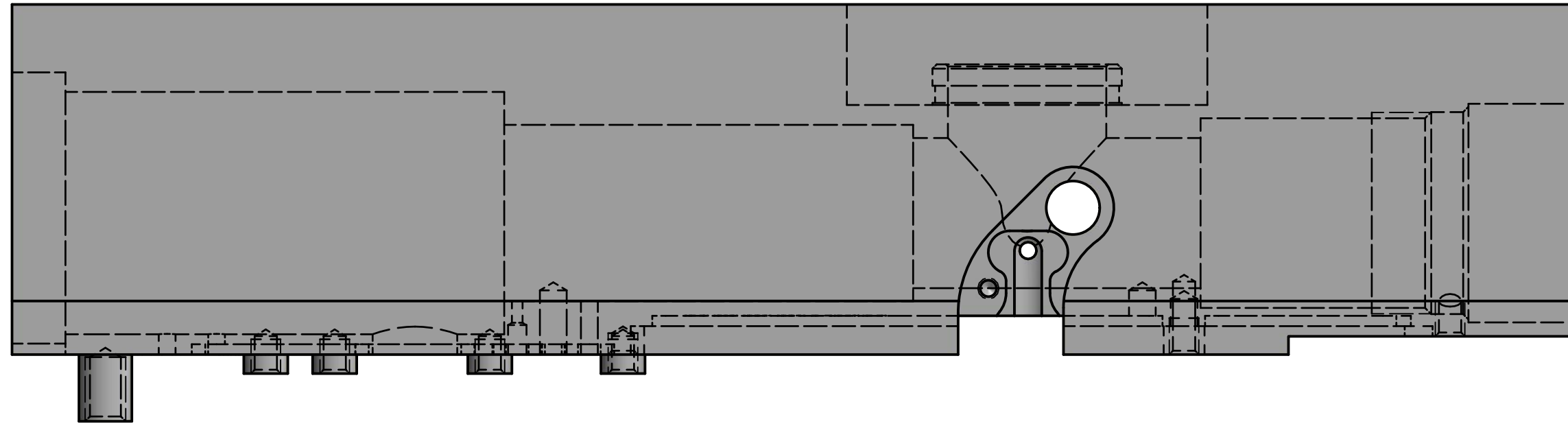
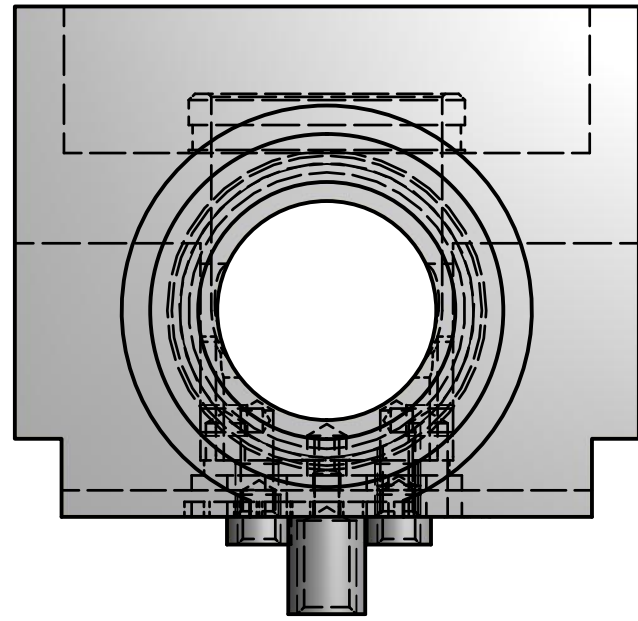
D

D



C

C

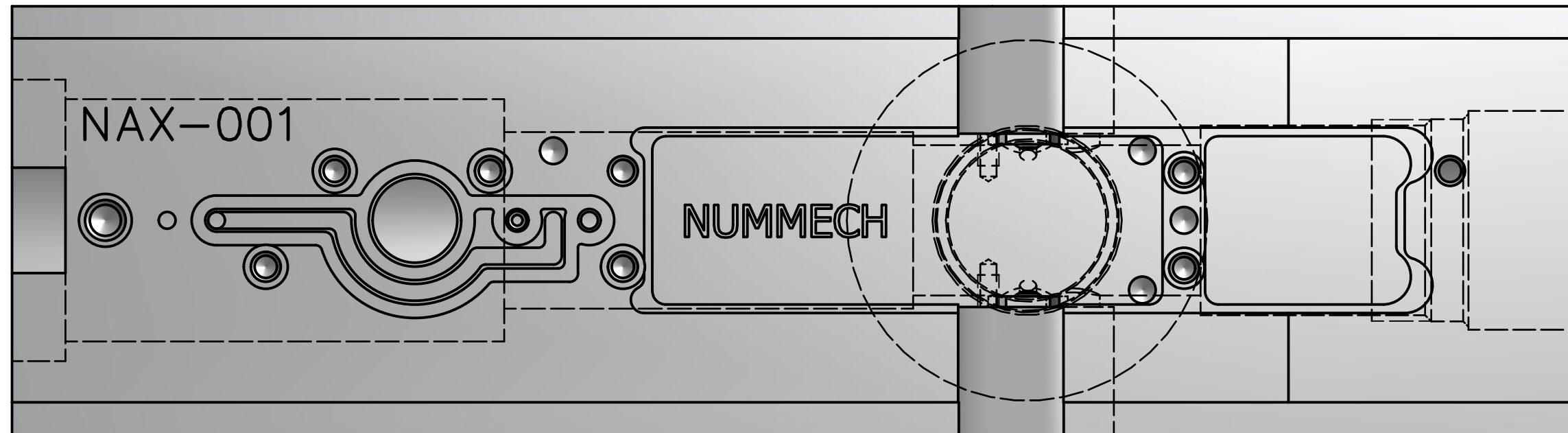


B

B

B

B



A

A

4

3

4

2

1

TOLERANCES UNLESS OTHERWISE SPECIFIED:
 DECIMAL X.XX ±0.01
 DECIMAL X.XXX ±0.001
 DECIMAL X.XXXX ±0.0005
 ANGULAR ±3°
 CONCENTRIC 0.003 T.I.R.
 SURFACE FINISH √63µin MAX

DRAWN ALD	4/15/2015
CHECKED	
MFG	
APPROVED	

SPECIFICATIONS ON THIS DRAWING TAKE PRECEDENCE OVER ANY SOLID MODEL DATA. ALL SPECIFICATIONS ARE PROPERTY OF MECHANIZED NUMERICS AND SHALL NOT BE REPRODUCED OR USED AS THE BASIS FOR THE MANUFACTURE OR SALE OF APPARATUS WITHOUT DIRECT CONSENT.

NUMMECH PRODUCTS	
DRAWING Empire Nummech-Shocker Extended Slug Body (Autococker threaded)	
DWG FILENAME Num-Axe Extended Slug body drawing	COMPONENT REV idw v1.2
MATERIAL ALUMINUM 6061-T6	PLATING RAW
SCALE	SIZE C
SHEET 2 OF 6	

SLUG BODY REFERENCE DATUMS

D

D

C

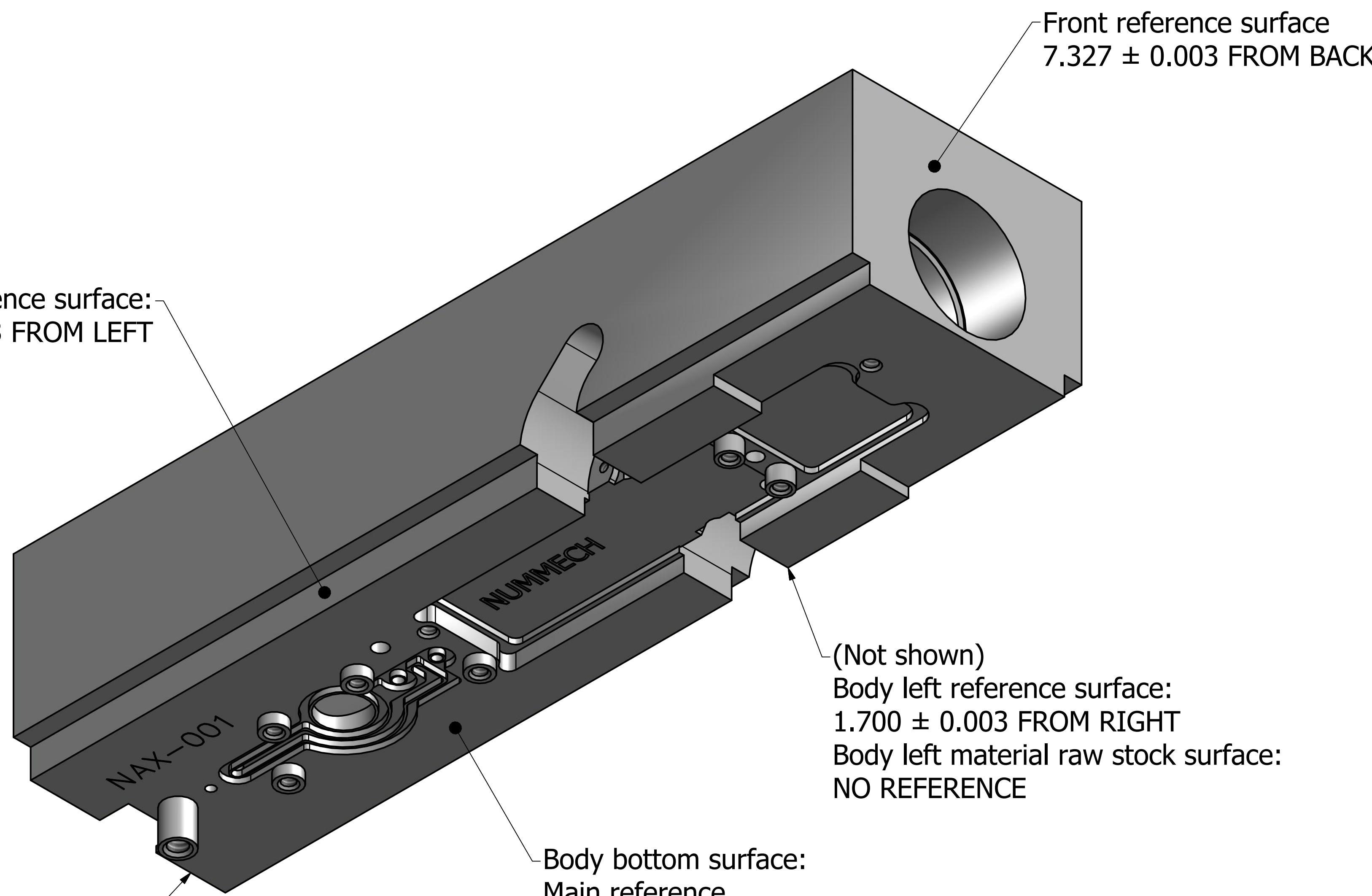
C

B

B

A

A



Body right reference surface:
1.700 ± 0.003 FROM LEFT

Front reference surface
7.327 ± 0.003 FROM BACK

(Not shown)
Body left reference surface:
1.700 ± 0.003 FROM RIGHT
Body left material raw stock surface:
NO REFERENCE

Body bottom surface:
Main reference

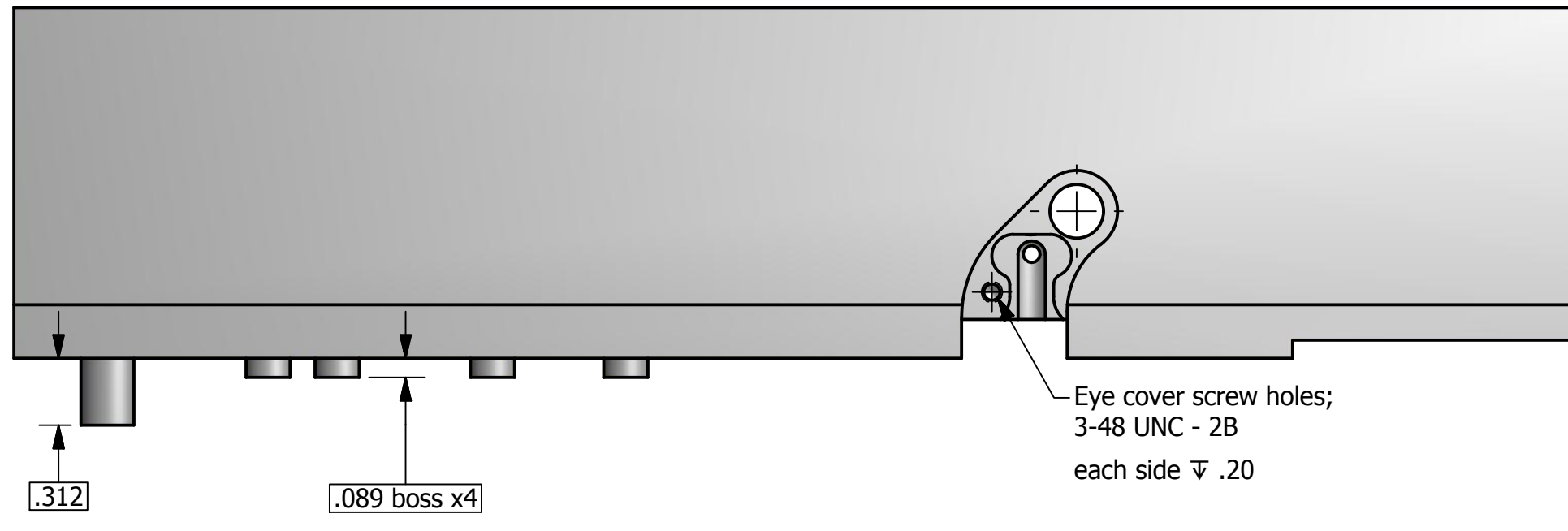
(Not shown)
Back reference surface:
7.327 ± 0.003 FROM FRONT

TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMAL X.XX ±0.01 DECIMAL X.XXX ±0.001 DECIMAL X.XXXX ±0.0005 ANGULAR ±3° CONCENTRIC 0.003 T.I.R. SURFACE FINISH √63µin MAX	DRAWN	4/15/2015	NUMMECH PRODUCTS	
	CHECKED		DRAWING	
	MFG		Empire Nummech-Shocker	
	APPROVED		Extended Slug Body (Autococker threaded)	
SPECIFICATIONS ON THIS DRAWING TAKE PRECEDENCE OVER ANY SOLID MODEL DATA. ALL SPECIFICATIONS ARE PROPERTY OF MECHANIZED NUMERICS AND SHALL NOT BE REPRODUCED OR USED AS THE BASIS FOR THE MANUFACTURE OR SALE OF APPARATUS WITHOUT DIRECT CONSENT.		DWG FILENAME: Num-Axe Extended Slug body drawing		COMPONENT REV: idw v1.2
		MATERIAL: ALUMINUM 6061-T6	PLATING: RAW	
		SCALE:	SIZE: C	SHEET 3 OF 6

SLUG BODY MOUNTING DIMENSIONS

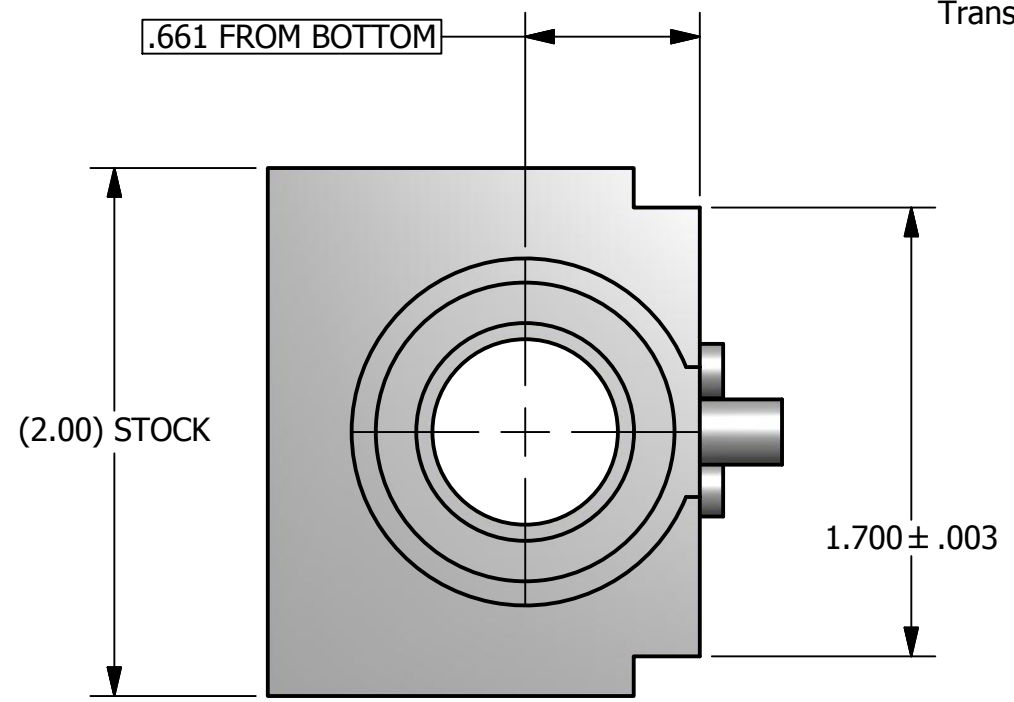
D

D



C

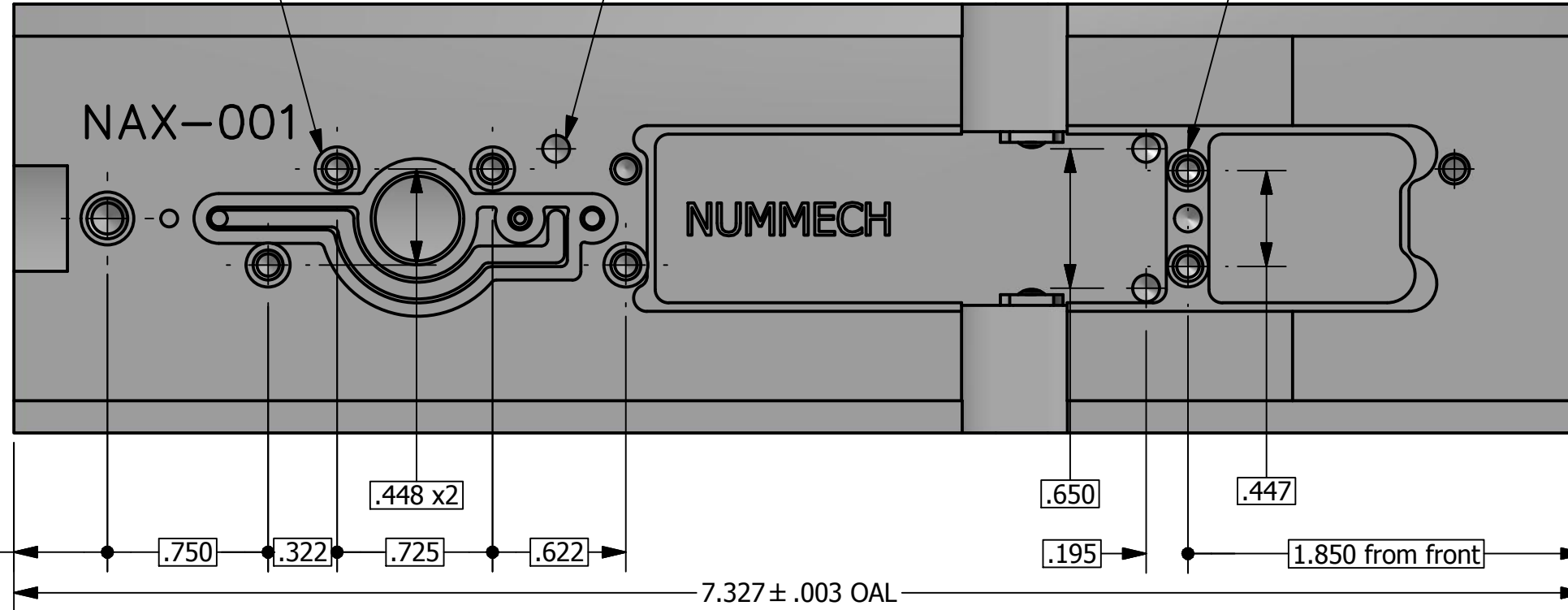
C



Transfer plate back screw holes; 6-32 UNC - 2B hole x4 √.160 from boss

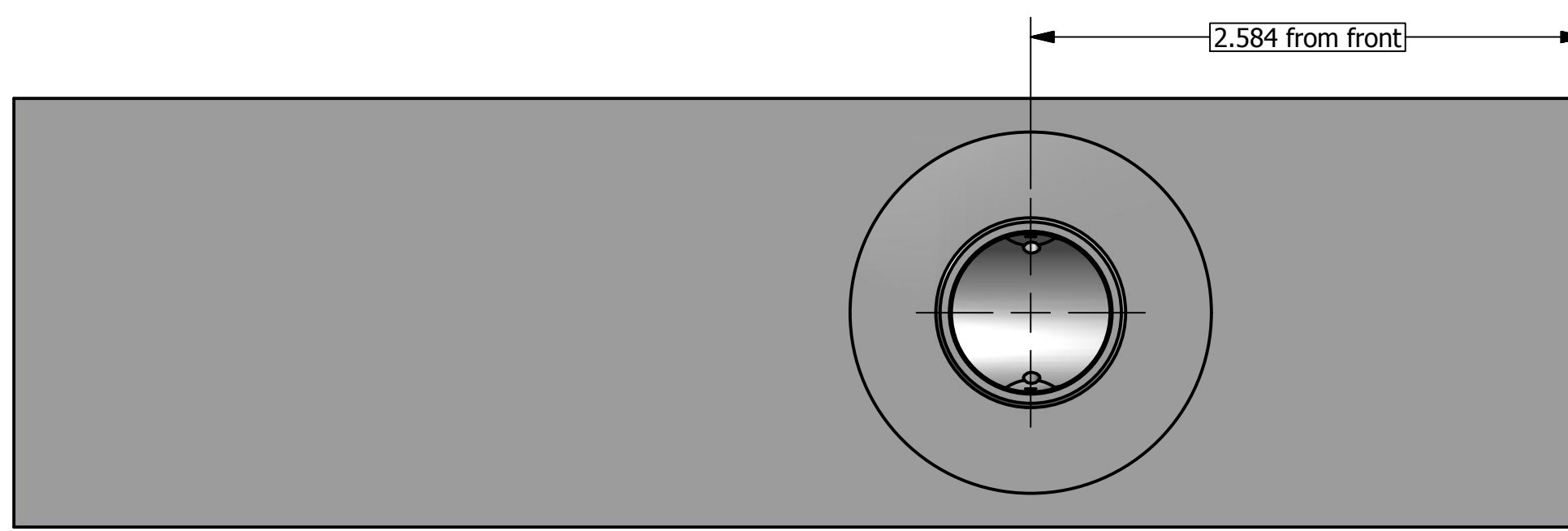
Body alignment pins; Ø.125 √.300 from bottom pinhole x3

Transfer plate front screw holes; 6-32 UNC - 2B hole x2 √.34 from bottom of body



B

B



A

A

<p>TOLERANCES UNLESS OTHERWISE SPECIFIED:</p> <p>DECIMAL X.XX ±0.01</p> <p>DECIMAL X.XXX ±0.001</p> <p>DECIMAL X.XXXX ±0.0005</p> <p>ANGULAR ±3°</p> <p>CONCENTRIC 0.003 T.I.R.</p> <p>SURFACE FINISH √63µin MAX</p>	<p>DRAWN ALD</p>	<p>4/15/2015</p>	<p>NUMMECH PRODUCTS</p>	
	<p>CHECKED</p>		<p>DRAWING</p>	
	<p>MFG</p>		<p>Empire Nummech-Shocker</p>	
	<p>APPROVED</p>		<p>Extended Slug Body (Autococker threaded)</p>	
	<p>SPECIFICATIONS ON THIS DRAWING TAKE PRECEDENCE OVER ANY SOLID MODEL DATA. ALL SPECIFICATIONS ARE PROPERTY OF MECHANIZED NUMERICS AND SHALL NOT BE REPRODUCED OR USED AS THE BASIS FOR THE MANUFACTURE OR SALE OF APPARATUS WITHOUT DIRECT CONSENT.</p>		<p>DWG FILENAME</p>	<p>COMPONENT REV</p>
			<p>Num-Axe Extended Slug body drawing</p>	<p>idw v1.2</p>
			<p>MATERIAL</p>	<p>PLATING</p>
			<p>ALUMINUM 6061-T6</p>	<p>RAW</p>
			<p>SCALE</p>	<p>SIZE C</p>
				<p>SHEET 4 OF 6</p>

4

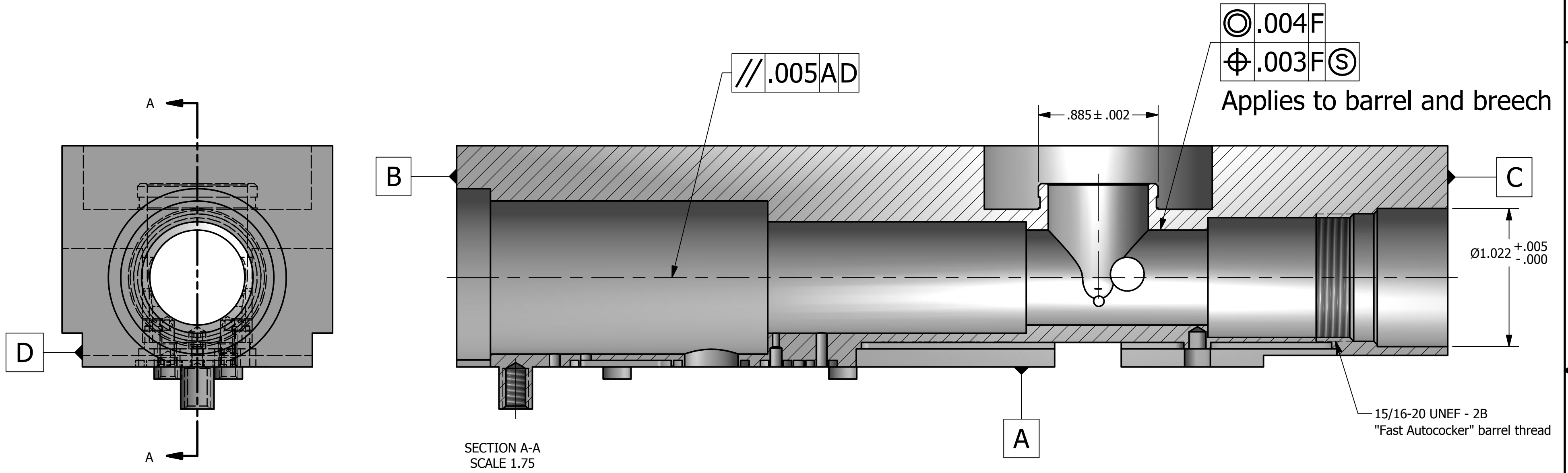
3

4

2

1

SLUG BODY INTERNAL SECTIONS



SECTION A-A
SCALE 1.75

◎ .004 F
⊕ .003 F ◎

Applies to barrel and breech

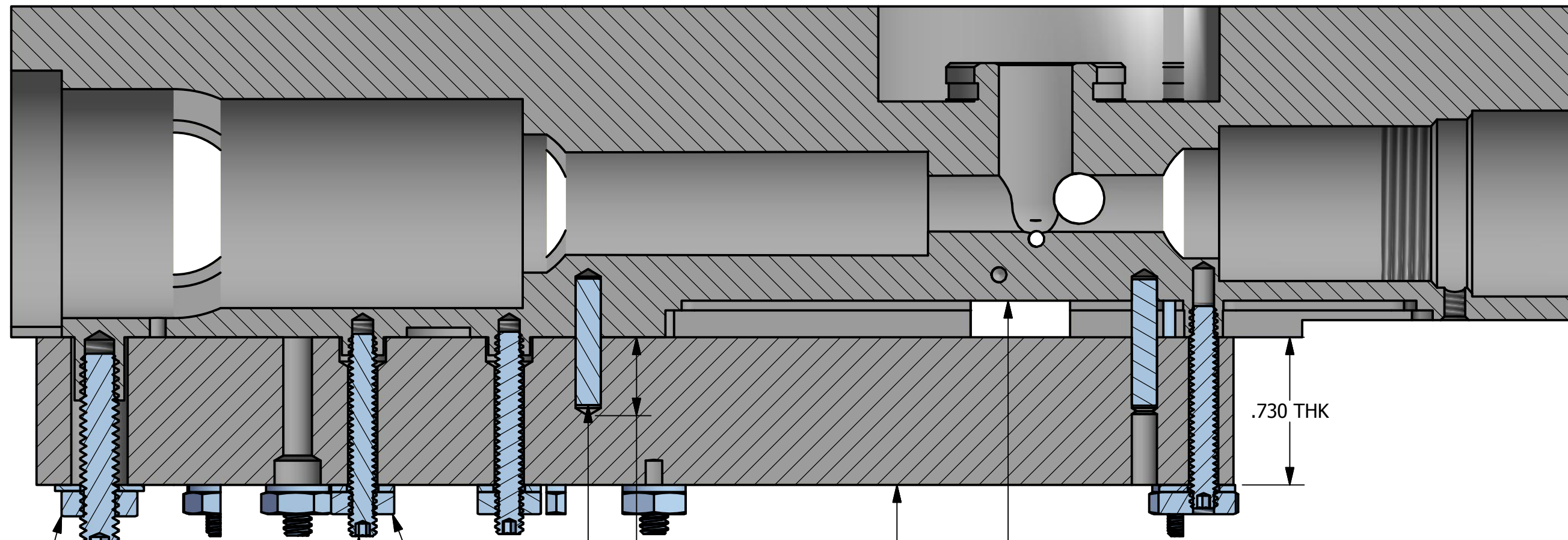
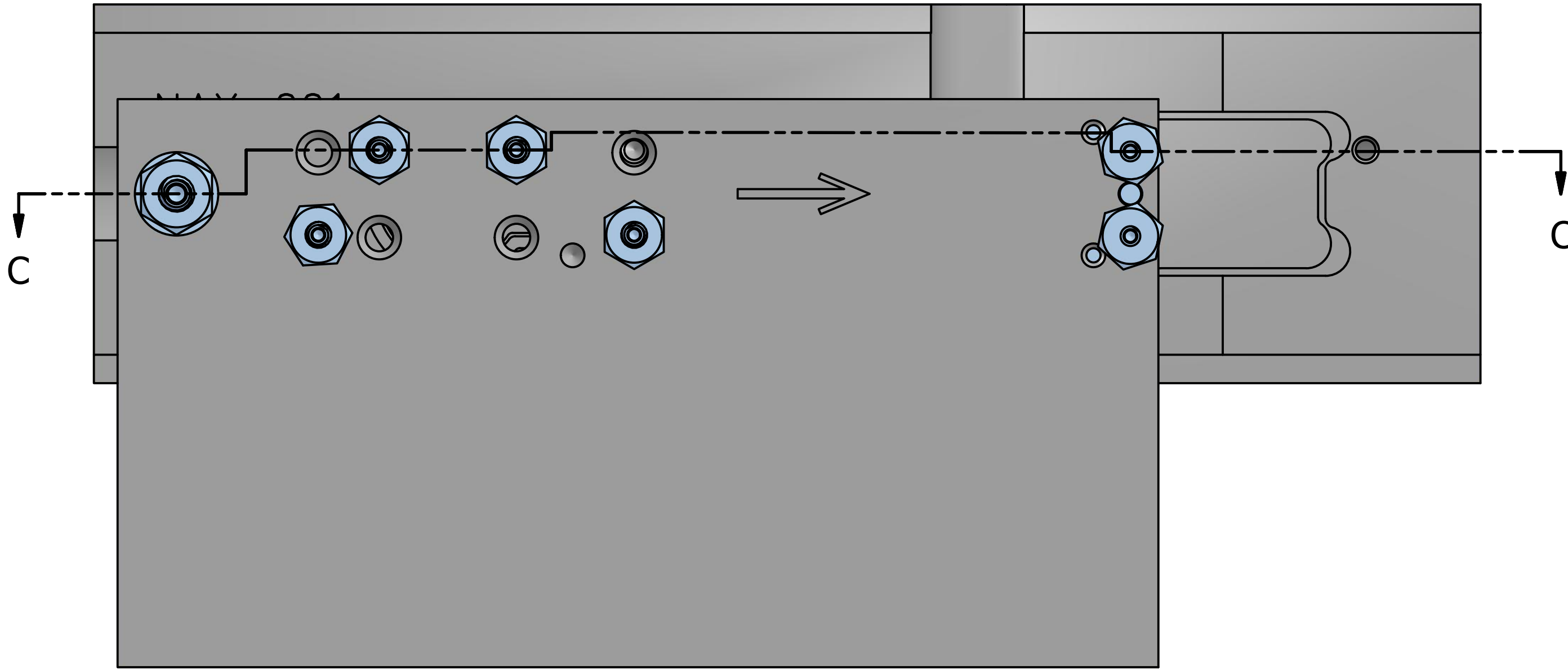
.885 ± .002

Ø1.022 +.005
-.000

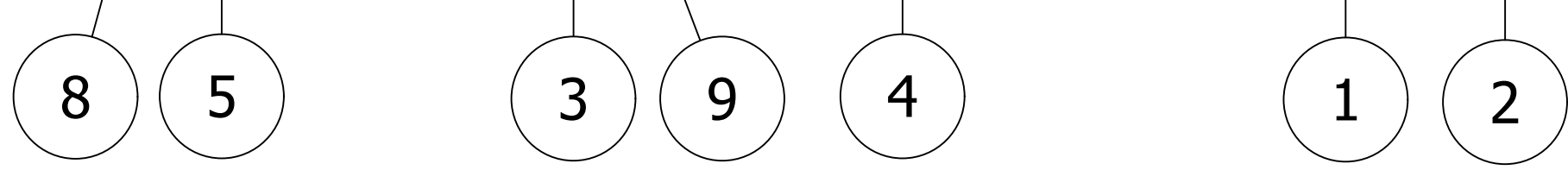
15/16-20 UNEF - 2B
"Fast Autococker" barrel thread

<p>TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMAL X.XX ±0.01 DECIMAL X.XXX ±0.001 DECIMAL X.XXXX ±0.0005 ANGULAR ±3° CONCENTRIC 0.003 T.I.R. SURFACE FINISH √63µin MAX</p>	DRAWN ALD	4/15/2015	NUMMECH PRODUCTS	
	CHECKED		DRAWING Empire Nummech-Shocker Extended Slug Body (Autococker threaded)	
	MFG		DWG FILENAME Num-Axe Extended Slug body drawing idw v1.2	
	APPROVED		COMPONENT REV idw v1.2	
SPECIFICATIONS ON THIS DRAWING TAKE PRECEDENCE OVER ANY SOLID MODEL DATA. ALL SPECIFICATIONS ARE PROPERTY OF MECHANIZED NUMERICS AND SHALL NOT BE REPRODUCED OR USED AS THE BASIS FOR THE MANUFACTURE OR SALE OF APPARATUS WITHOUT DIRECT CONSENT.			MATERIAL ALUMINUM 6061-T6	PLATING RAW
			SCALE	SIZE C SHEET 5 OF 6

SLUG BODY SAMPLE MILLING FIXTURE



ITEM	QTY	DESCRIPTION
1	1	Axe body milling fixture
2	1	Axe extended Slug body; unmilled
3	6	Set screw; #6-32 thread x 1" length
4	4	Dowel pin; 1/8" dia x 5/8" length
5	1	Set screw; #10-24 thread x 1" length
6	6	Metal washer; size #6
7	1	Metal washer; #10
8	1	Hex nut; #10-24
9	6	Hex nut; #6-32



DRAWN ALD		4/15/2015	NUMMECH PRODUCTS	
CHECKED			DRAWING	
MFG			Empire Nummech-Shocker	
APPROVED			Extended Slug Body (Autococker threaded)	
TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMAL X.XX ±0.01 DECIMAL X.XXX ±0.001 DECIMAL X.XXXX ±0.0005 ANGULAR ±3° CONCENTRIC 0.003 T.I.R. SURFACE FINISH √63µin MAX		SPECIFICATIONS ON THIS DRAWING TAKE PRECEDENCE OVER ANY SOLID MODEL DATA. ALL SPECIFICATIONS ARE PROPERTY OF MECHANIZED NUMERICS AND SHALL NOT BE REPRODUCED OR USED AS THE BASIS FOR THE MANUFACTURE OR SALE OF APPARATUS WITHOUT DIRECT CONSENT.		COMPONENT REV
		DWG FILENAME		idw v1.2
		MATERIAL		ALUMINUM 6061-T6
		PLATING		RAW
		SCALE		SIZE C SHEET 6 OF 6