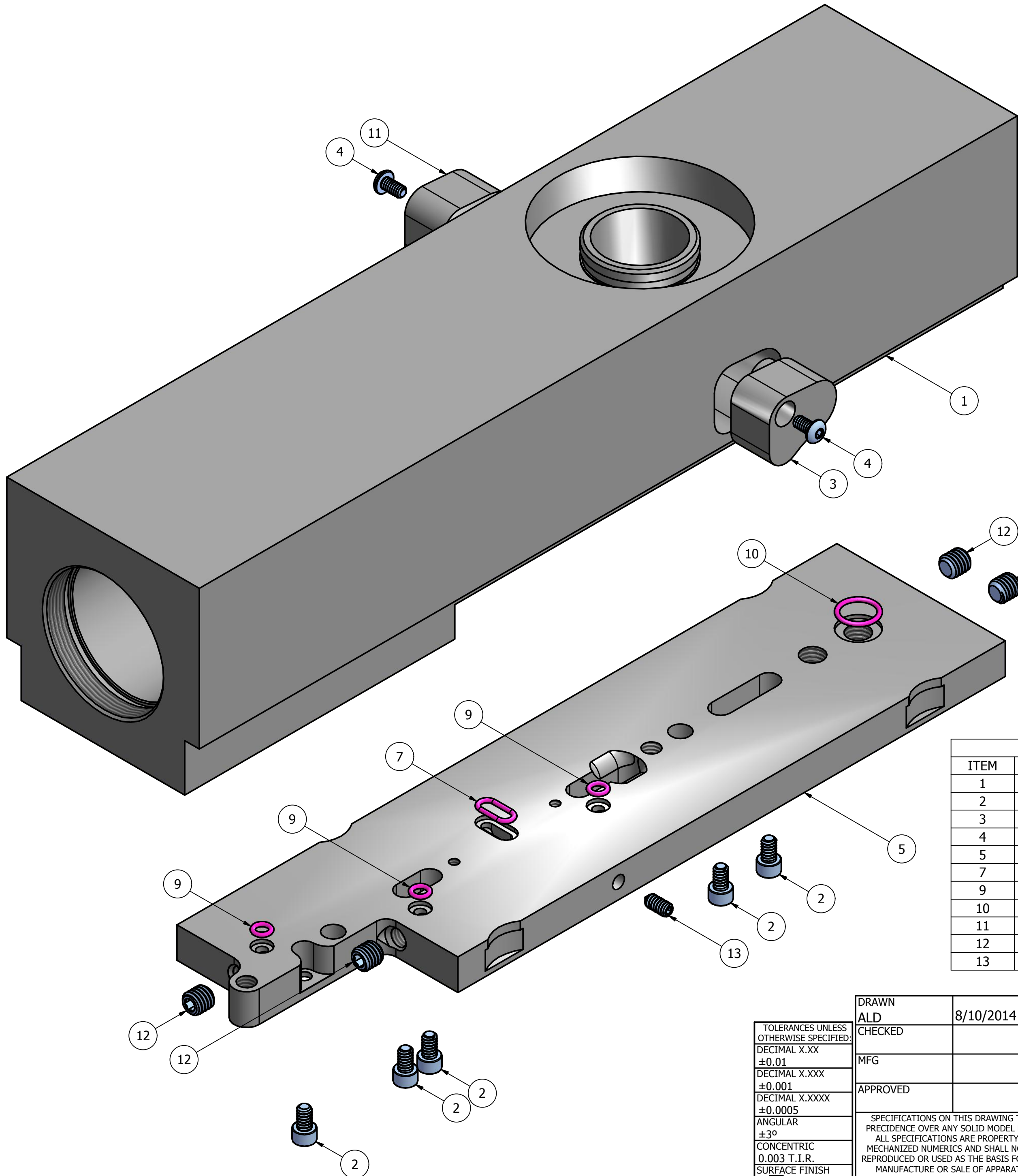


# SLUG BODY & TRANSFER PLATE ASSEMBLY

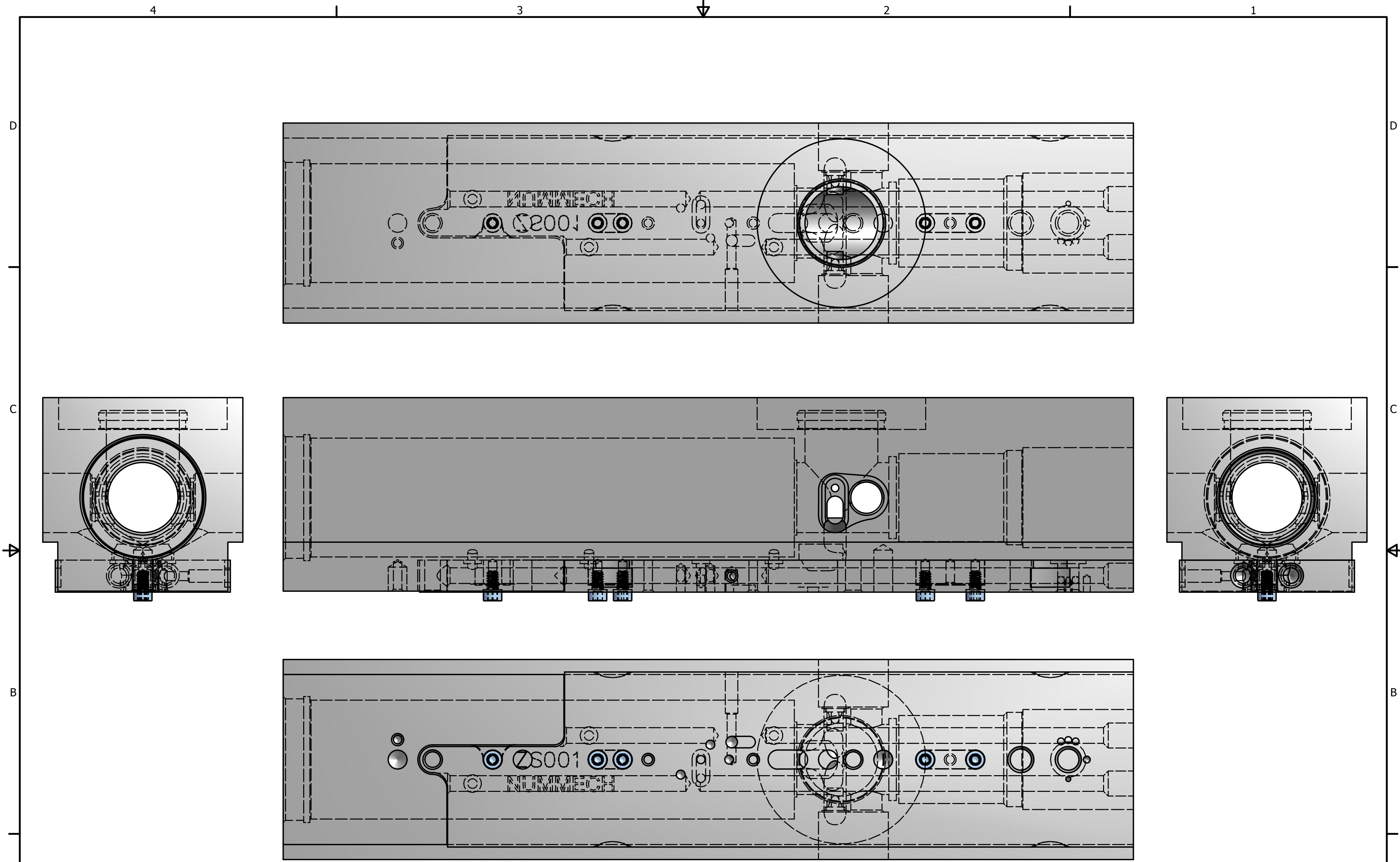


PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1		Shocker standard Slug body; unmilled
2	5		Socket head cap screw; 4-40 x 0.188
3	1		Shocker Slug eye cover [right]; unmilled
4	2		Button socket head cap screw; 3-48 x 0.188
5	1		Shocker Slug transfer plate; unmilled
7	1		O-ring size 1x6-mm ID
9	3		O-ring size 1x2.5-mm ID
10	1		O-ring size 1x7-mm ID
11	1		Shocker Slug eye cover [left]; unmilled
12	4		Set screw; 10-32 x 0.188
13	1		Set screw; 4-40 x 0.25 cone point

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	8/10/2014
CHECKED	
MFG	
APPROVED	
SPECIFICATIONS ON THIS DRAWING TAKE PRECEDENCE OVER ANY SOLID MODEL DATA. ALL SPECIFICATIONS ARE PROPERTY OF NUMMECH PRODUCTS AND SHALL NOT BE REPRODUCED OR USED AS THE BASIS FOR THE MANUFACTURE OR SALE OF APPARATUS WITHOUT DIRECT CONSENT.	

<b>NUMMECH PRODUCTS</b>		
DRAWING		
Smart Parts Num-Shocker Standard Slug Body (Autococker threaded)		
DWG FILENAME		COMPONENT REV
Standard Slug body drawing.idw		v2.3
MATERIAL	PLATING	
ALUMINUM 6061-T6	RAW	
SCALE	SIZE C	SHEET 1 OF 9

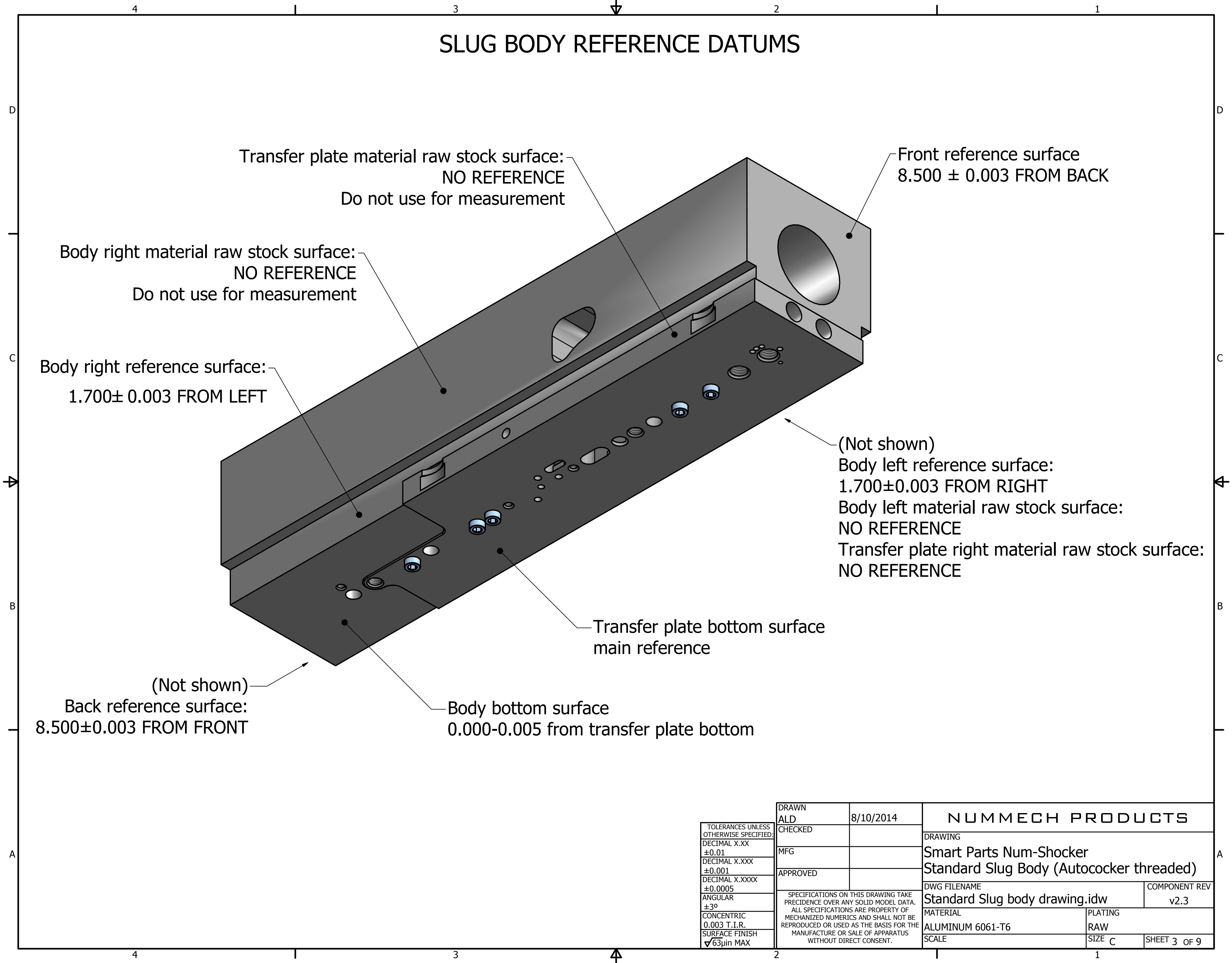


TOLERANCES UNLESS OTHERWISE SPECIFIED:  
 DECIMAL X.XX ±0.01  
 DECIMAL X.XXX ±0.001  
 DECIMAL X.XXXX ±0.0005  
 ANGULAR ±3°  
 CONCENTRIC 0.003 T.I.R.  
 SURFACE FINISH √63µin MAX

DRAWN ALD 8/10/2014  
 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.

<b>NUMMECH PRODUCTS</b>		
DRAWING		
<b>Smart Parts Num-Shocker Standard Slug Body (Autococker threaded)</b>		
DWG FILENAME		COMPONENT REV
Standard Slug body drawing.idw		v2.3
MATERIAL	PLATING	
ALUMINUM 6061-T6	RAW	
SCALE	SIZE C	SHEET 2 OF 9

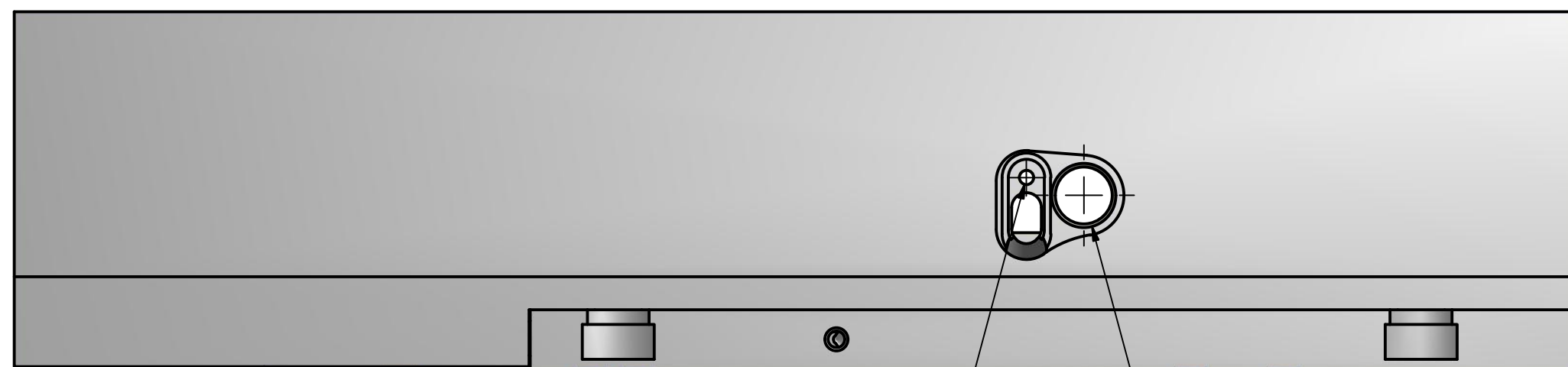
# SLUG BODY REFERENCE DATUMS



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	8/10/2014	NUMMECH PRODUCTS	
	CHECKED		DRAWING	
	MFG		Smart Parts Num-Shocker Standard Slug Body (Autococker threaded)	
	APPROVED		DWG FILENAME	COMPONENT REV
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.			Standard Slug body drawing.idw	v2.3
MATERIAL		ALUMINUM 6061-T6	PLATING	RAW
SCALE		SIZE C	SHEET 3 OF 9	



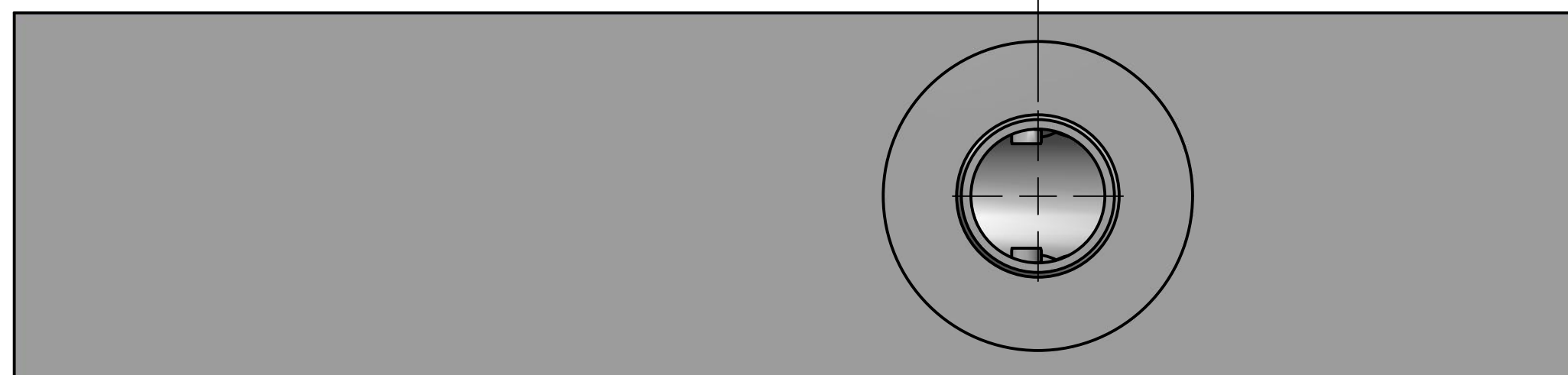
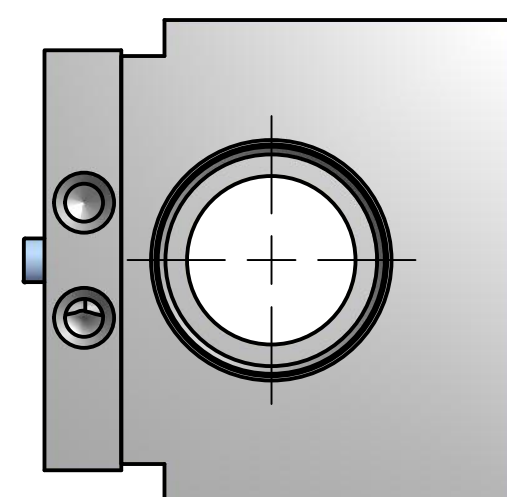
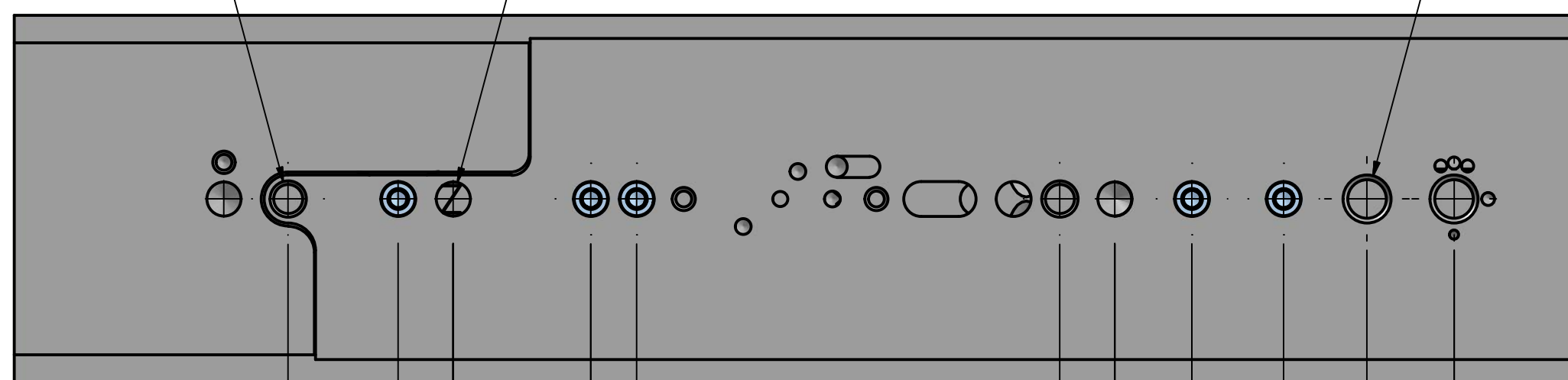
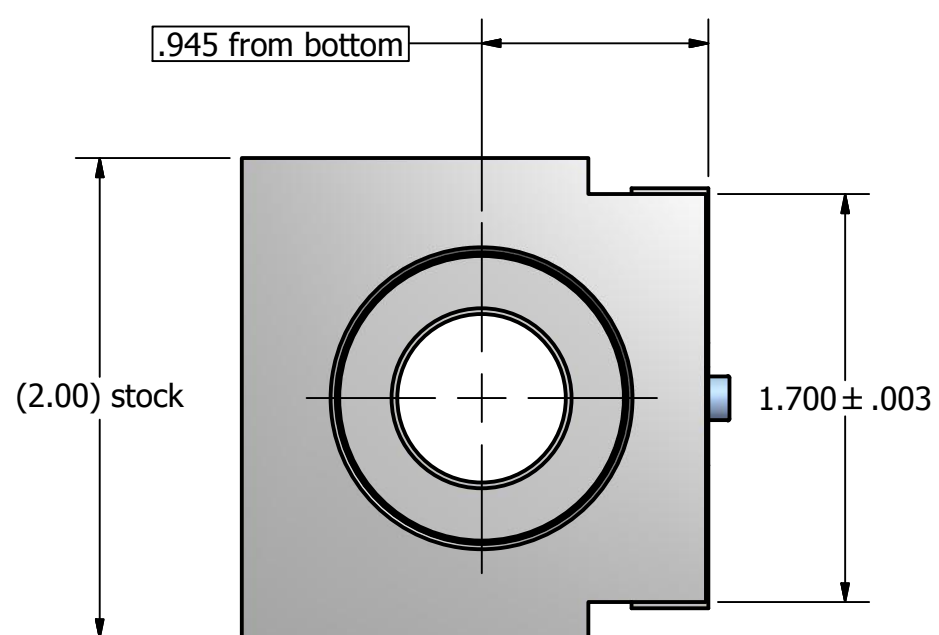
# SLUG BODY MOUNTING DIMENSIONS



Frame screw holes;  
10-32 UNF - 2B  
hole x2 ∇ thru to body

Body alignment pins;  
Ø.188 ∇ thru to body  
pinhole x2

Vertical adapter screw holes;  
1/4-28 UNF - 2B  
hole x2 ∇ thru to body

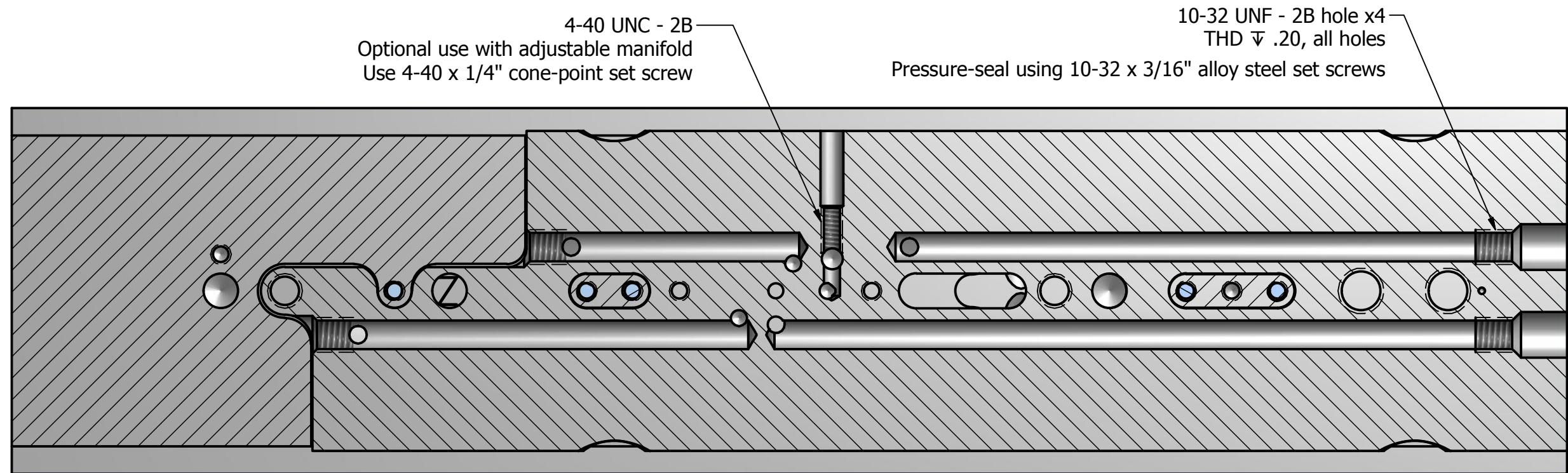
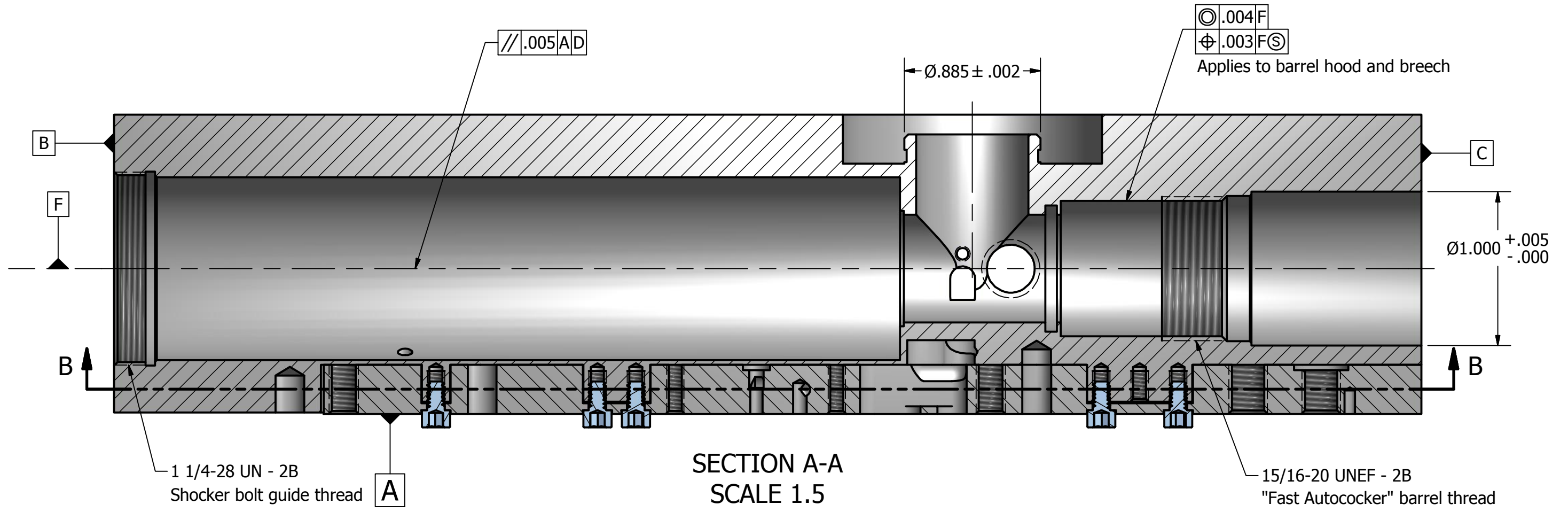
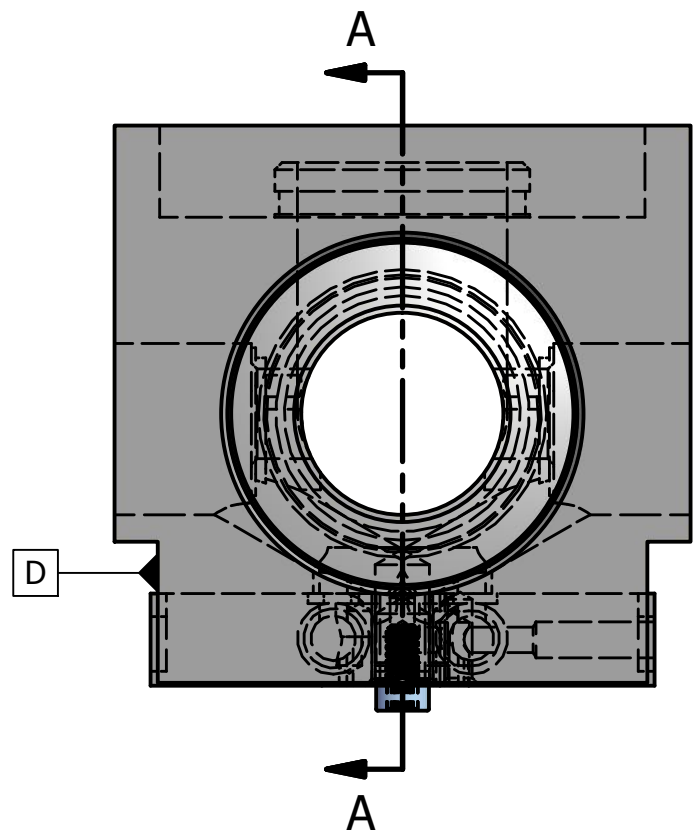


TOLERANCES UNLESS OTHERWISE SPECIFIED:
DECIMAL X.XX ±0.01
DECIMAL X.XXX ±0.001
DECIMAL X.XXXX ±0.0005
ANGULAR ±3°
CONCENTRIC 0.003 T.I.R.
SURFACE FINISH √63µin MAX

DRAWN ALD	8/10/2014
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 Smart Parts Num-Shocker Standard Slug Body (Autococker threaded)		
DWG FILENAME Standard Slug body drawing.idw	COMPONENT REV v2.3	
MATERIAL ALUMINUM 6061-T6	PLATING RAW	
SCALE	SIZE C	SHEET 4 OF 9

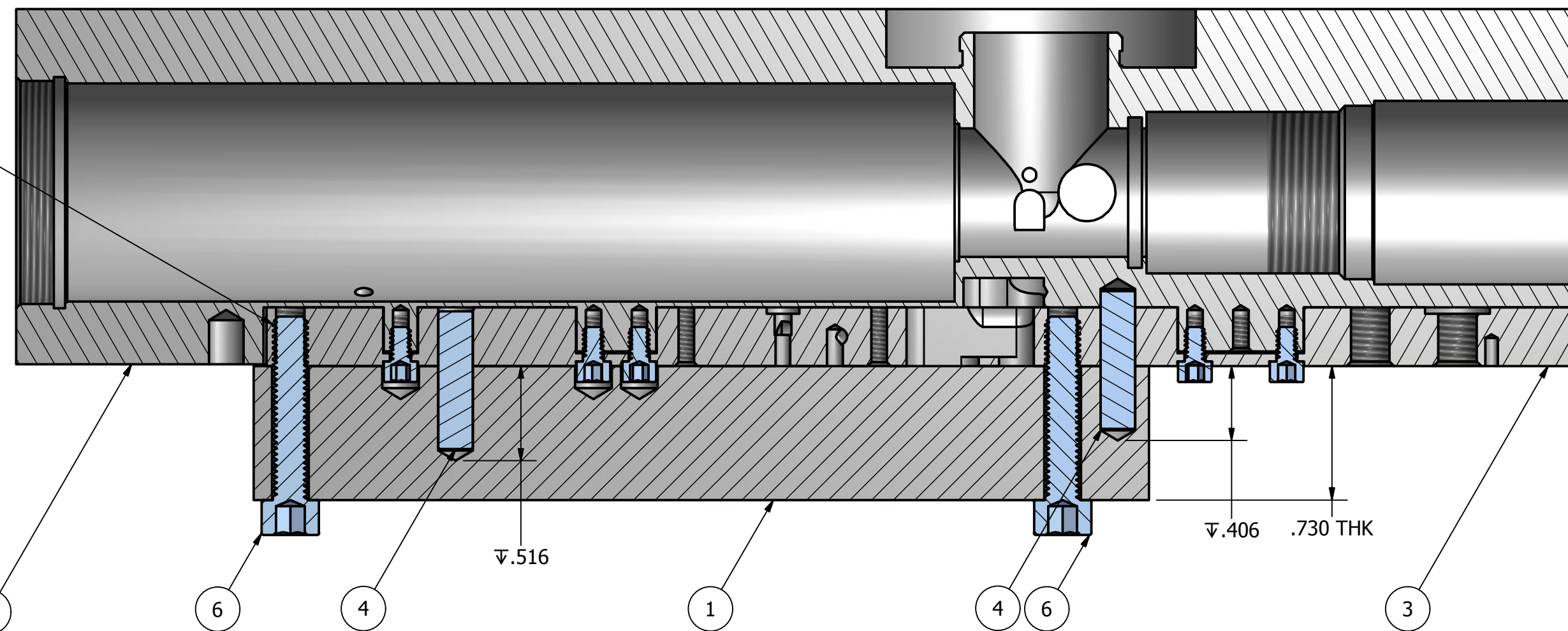
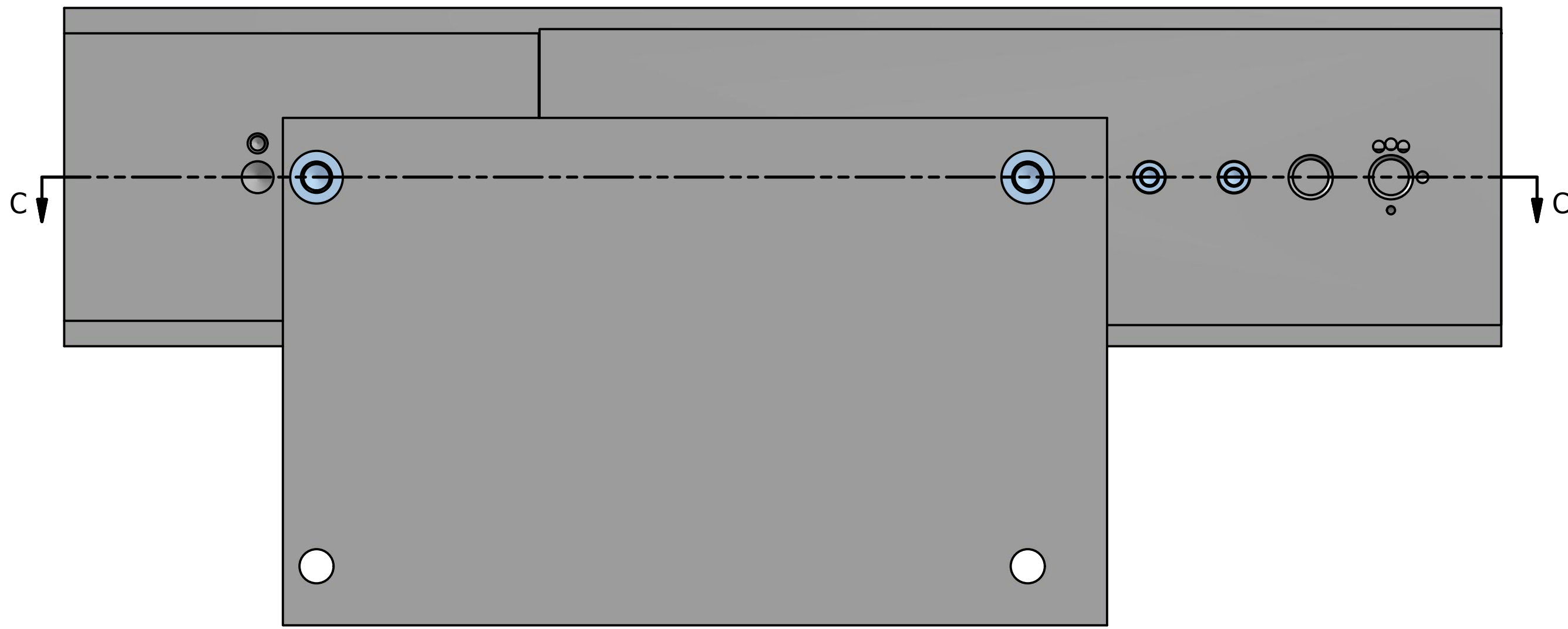
# SLUG BODY INTERNAL SECTIONS



**SECTION B-B**  
SCALE 1.5  
.165 from bottom of transfer plate

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 $\sqrt{63} \mu\text{in MAX}$	DRAWN ALD CHECKED	8/10/2014	<b>NUMMECH PRODUCTS</b>	
	MFG		DRAWING <b>Smart Parts Num-Shocker Standard Slug Body (Autococker threaded)</b>	
	APPROVED		DWG FILENAME <b>Standard Slug body drawing.idw</b>	COMPONENT REV v2.3
	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 <b>ALUMINUM 6061-T6</b>	PLATING <b>RAW</b>	SIZE C
			SCALE	SHEET 5 OF 9

# SLUG BODY SAMPLE MILLING FIXTURE



SECTION C-C  
SCALE 1.5

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1		Slug body upright fixture
2	1		Shocker standard Slug body; unmilled
3	1		Shocker Slug transfer plate; unmilled
4	2		Dowel pin; 3/16 dia x 0.75 long
5	5		Socket head cap screw; 4-40 x 0.188
6	2		Socket head cap screw; 10-32 x 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

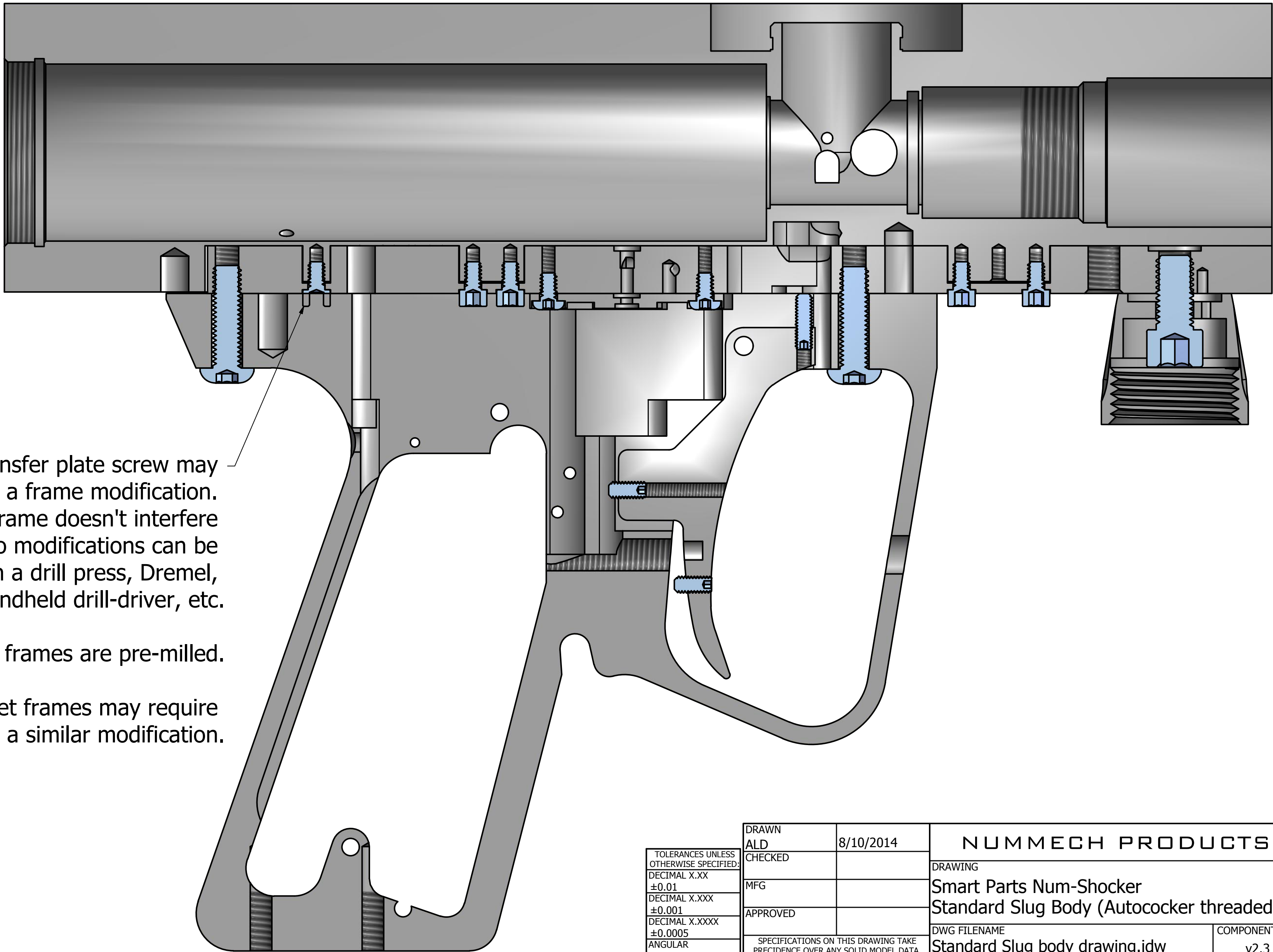
DRAWN	ALD	8/10/2014
CHECKED		
MFG		
APPROVED		

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

NUMMECH PRODUCTS		
DRAWING		
Smart Parts Num-Shocker Standard Slug Body (Autococker threaded)		
DWG FILENAME	COMPONENT REV	
Standard Slug body drawing.idw	v2.3	
MATERIAL	PLATING	
ALUMINUM 6061-T6	RAW	
SCALE	SIZE C	SHEET 6 OF 9



# POSSIBLE MODIFICATION TO "SFT" STYLE FRAMES



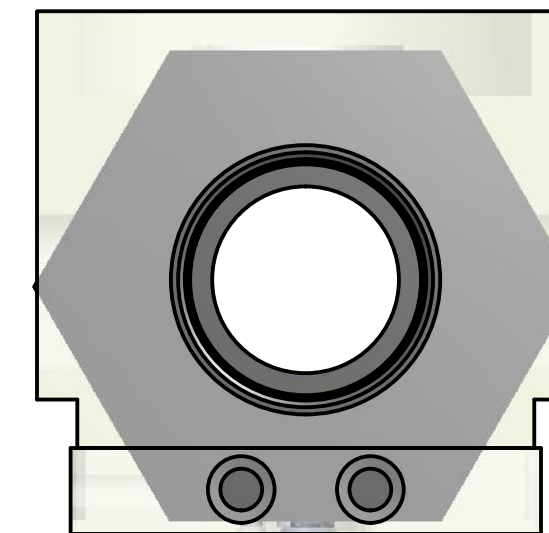
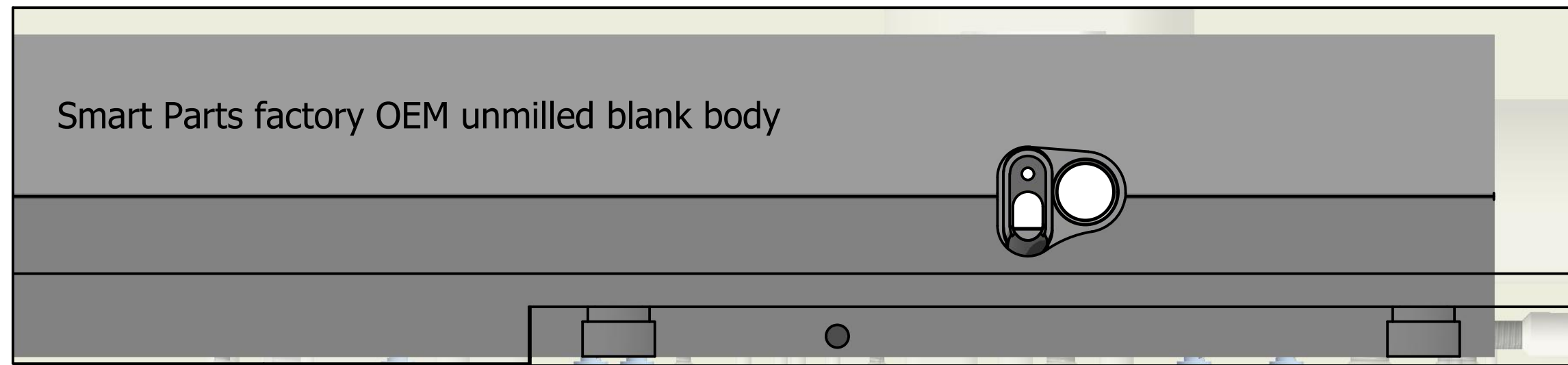
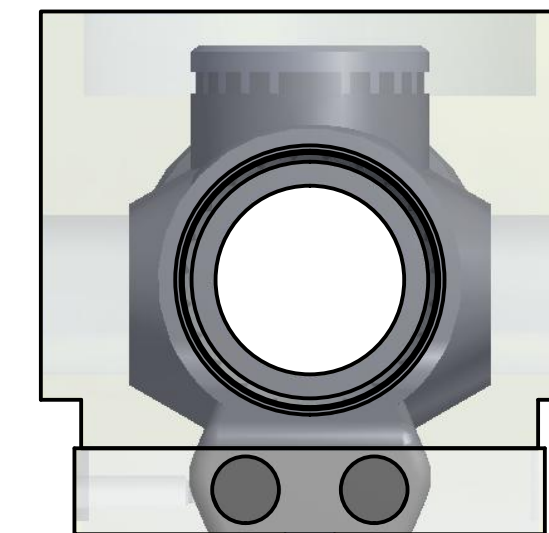
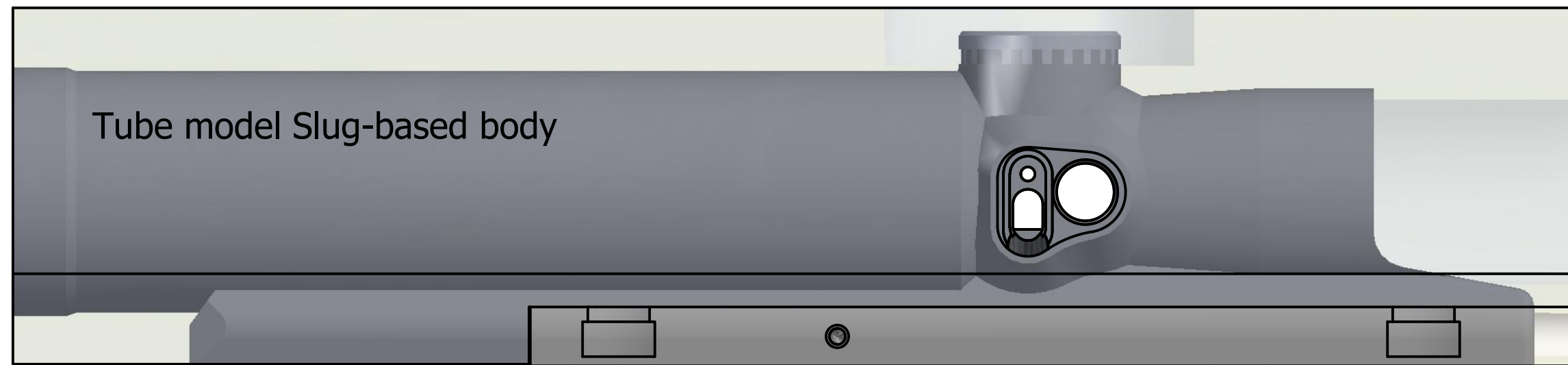
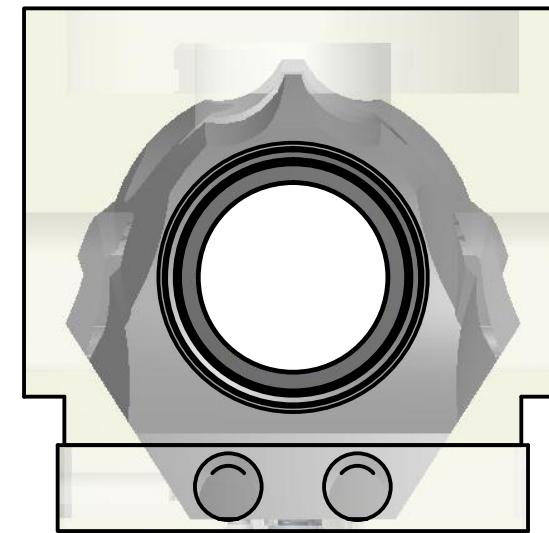
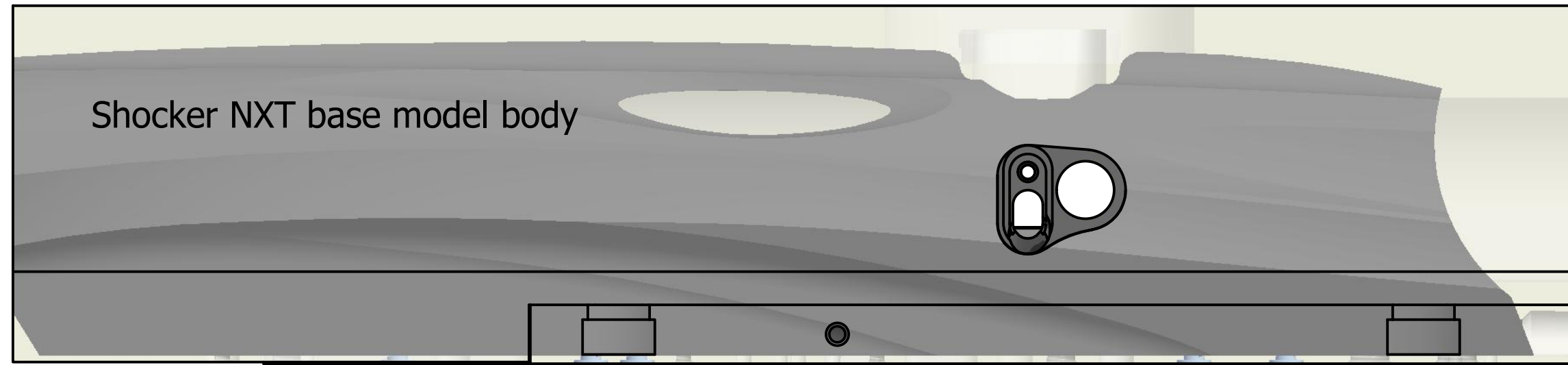
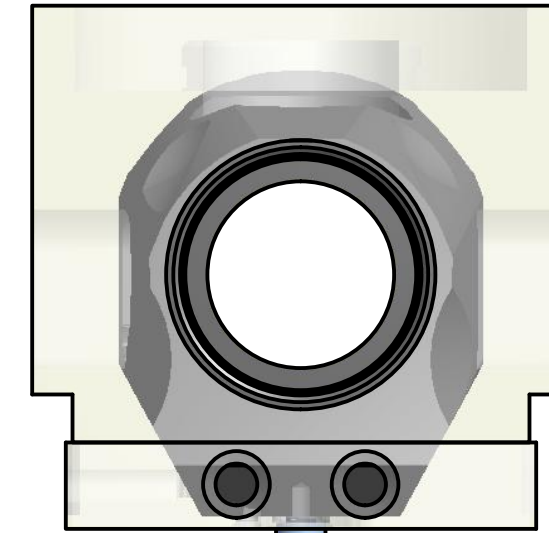
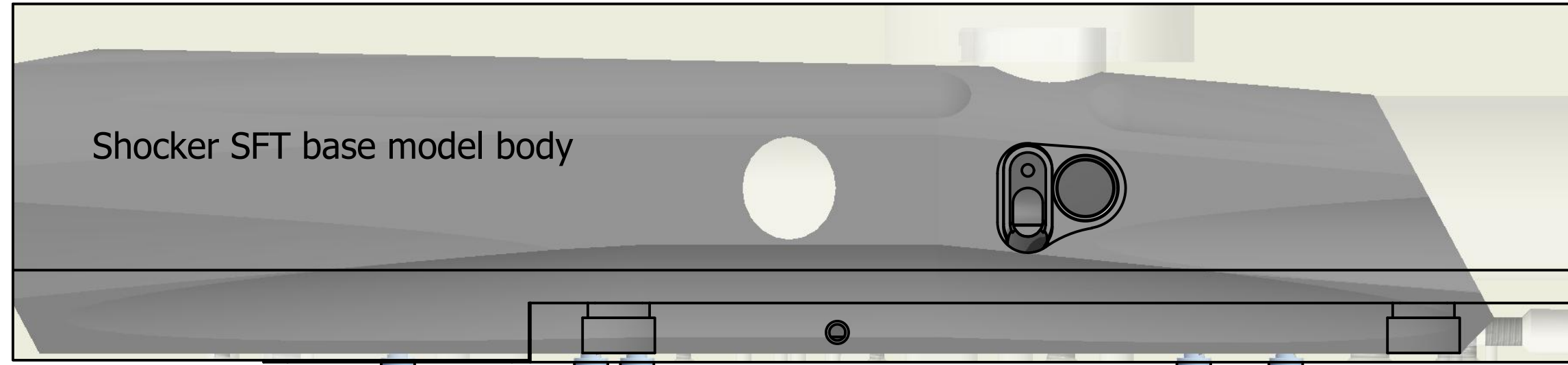
The rear-most transfer plate screw may require a frame modification. This area of the frame doesn't interfere with internals, so modifications can be done at home with a drill press, Dremel, handheld drill-driver, etc.

NXT frames are pre-milled.

Some aftermarket frames may require a similar modification.

DRAWN ALD		8/10/2014	NUMMECH PRODUCTS	
CHECKED				
MFG			DRAWING Smart Parts Num-Shocker Standard Slug Body (Autococker threaded)	
APPROVED			DWG FILENAME Standard Slug body drawing.idw	COMPONENT REV v2.3
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.		MATERIAL ALUMINUM 6061-T6
		PLATING RAW		SCALE SIZE C
				SHEET 7 OF 9

# UNMILLED SLUG BODY SIZE COMPARISON



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	8/10/2014
CHECKED		
MFG		
APPROVED		

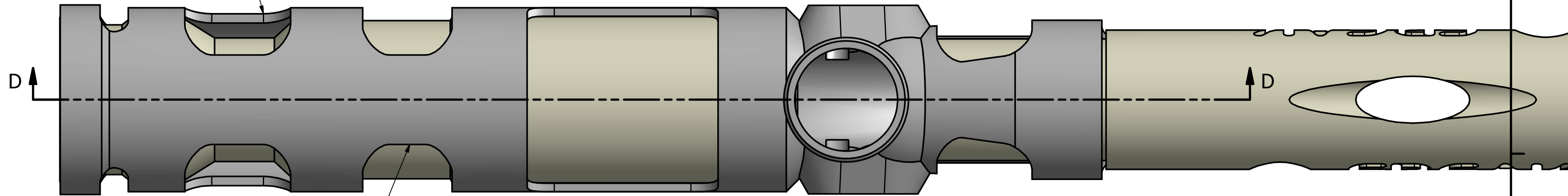
SPECIFICATIONS ON THIS DRAWING TAKE PRECEDENCE OVER ANY SOLID MODEL DATA. ALL SPECIFICATIONS ARE PROPERTY OF MECHANIZED NUMERICS AND SHALL NOT BE REPRODUCED OR USED AS THE BASIS FOR THE MANUFACTURE OR SALE OF APPARATUS WITHOUT DIRECT CONSENT.

NUMMECH PRODUCTS		
DRAWING		
Smart Parts Num-Shocker Standard Slug Body (Autococker threaded)		
DWG FILENAME		COMPONENT REV
Standard Slug body drawing.idw		v2.3
MATERIAL	PLATING	
ALUMINUM 6061-T6	RAW	
SCALE	SIZE C	SHEET 8 OF 9



# BODY WINDOW EXAMPLES

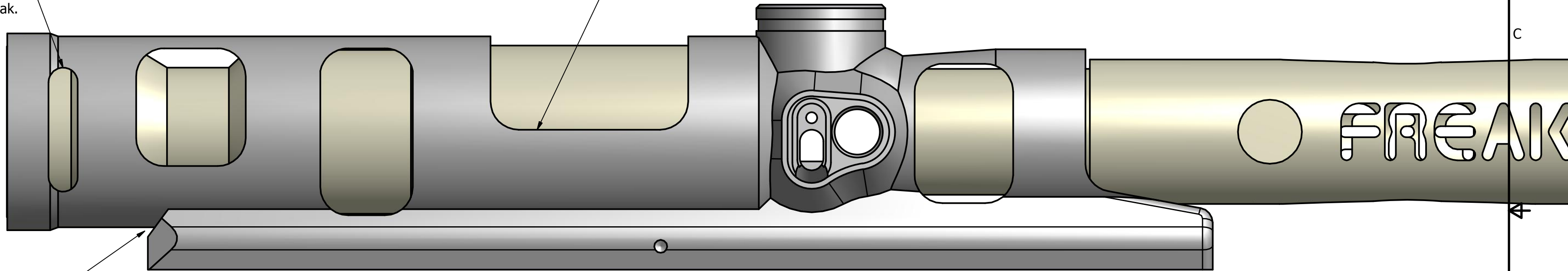
Bolt sleeve reservoir windows aren't recommended because this large space can trap outside debris. However, ultralight bodies can make use of a subtle window in this location.



This window example is supported on top to prevent the body from twisting.

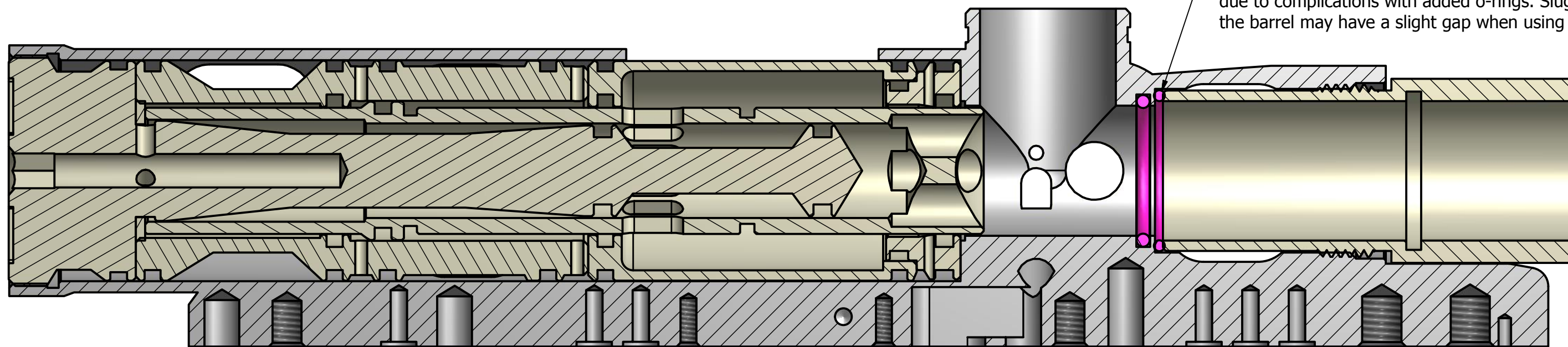
This window example only cuts through the top half of the body. Do not extend the window too low without supporting the top. If the window is too deep, the body will twist itself out of alignment.

Do not remove any of the bolt guide threaded section; the threads will become too weak.



Avoid weakening the body in this area; if a bolt sleeve window is milled then this single spot will support the entire rear of the marker body.

Use of a secondary barrel o-ring may be required if windows are milled around the barrel hood. Smart Parts discouraged private label milling in this location due to complications with added o-rings. Slug bodies aren't designed for it, so the barrel may have a slight gap when using an o-ring.



SECTION D-D  
SCALE 1.75

TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN ALD		8/10/2014		NUMMECH PRODUCTS							
DECIMAL X.XX ±0.01		CHECKED				DRAWING							
DECIMAL X.XXX ±0.001		MFG				Smart Parts Num-Shocker							
DECIMAL X.XXXX ±0.0005		APPROVED				Standard Slug Body (Autococker threaded)							
ANGULAR ±3°		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		COMPONENT REV					
CONCENTRIC 0.003 T.I.R.						Standard Slug body drawing.idw		v2.3					
SURFACE FINISH √63µin MAX						MATERIAL		ALUMINUM 6061-T6		PLATING		RAW	
						SCALE		SIZE C		SHEET 9 OF 9			