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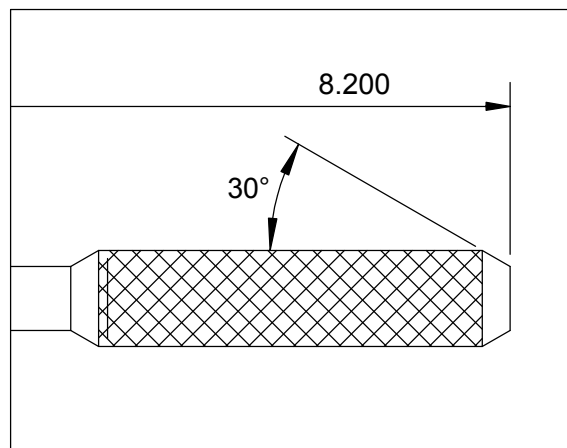
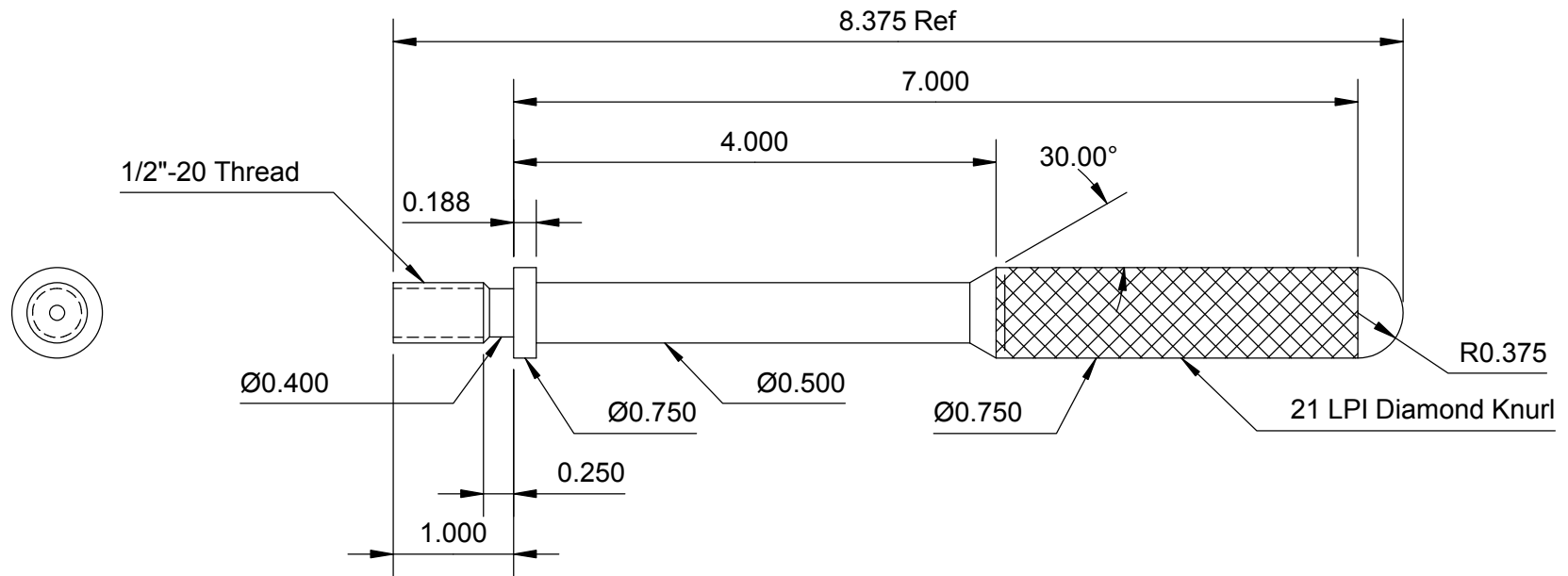
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Tenderizing Hammer

Revision 0

5370

Sheet 1 of 5



Alternate Handle End Detail

Material: 6061-T6 Aluminum

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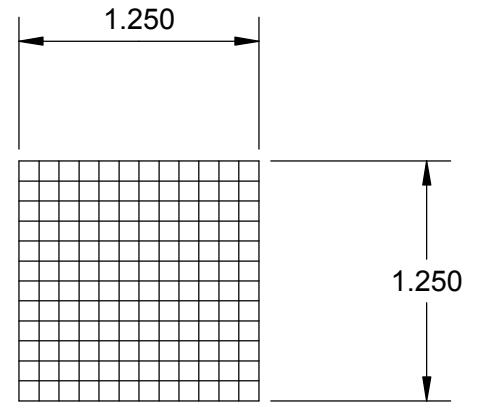
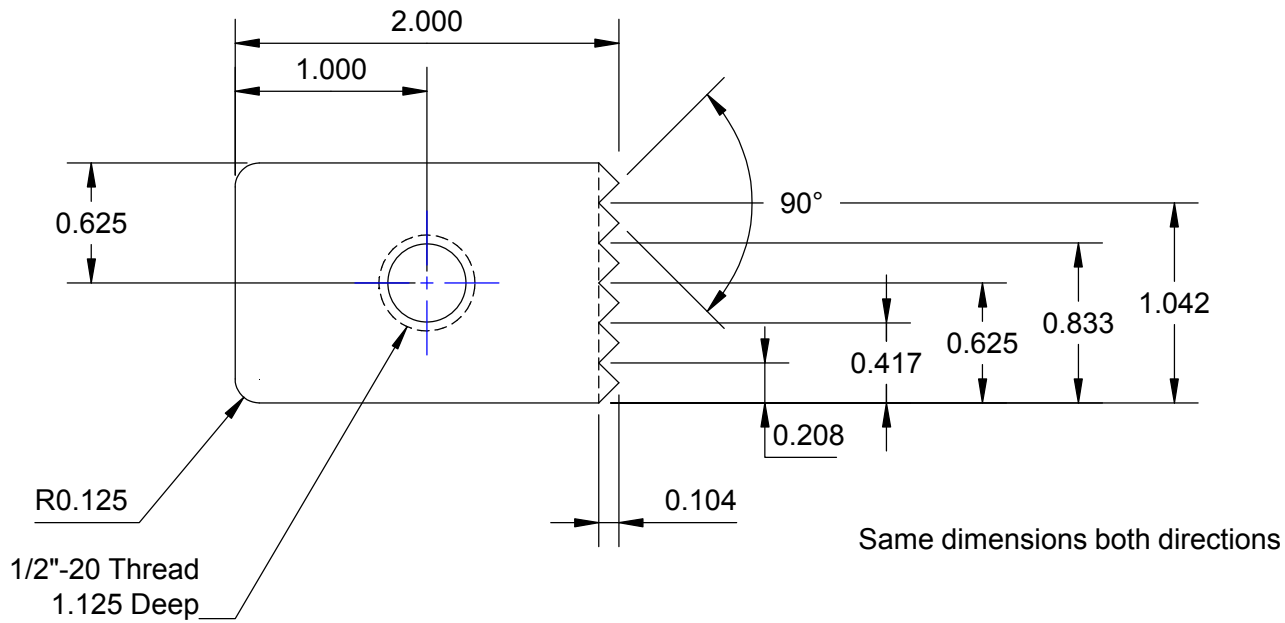
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Handle, Tenderizer

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Material: 6061-T6 Aluminum

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Head, Tenderizer

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Handle

Area	Step	Tools
Threaded End	1. Face end	3/8" shank turning tool
	2. Center drill end	#3 center drill
	3. Turn 0.500" diameter	3/8" shank turning tool
	4. Turn 0.400" diameter	3/8" shank turning tool
	5. Single point thread to 75%	AR Warner threading tool
	6. Use hex die to finish thread	1/2"-13 hex die
Handle Center	7. Chuck grip and support threaded end	
	8. Turn 0.500" diameter	3/8" shank turning tool
	9. Finish 30 degree angle	3/8" shank turning tool
Handle Grip	10. Chuck handle center with grip exposed	
	11. Turn ball end	Ball turning tool
	12. Knurl	Knurling tool

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Handle Process

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Head

Area	Step	Tools
Material	1. Square ends of material	1.25" Diameter indexable end mill
Threaded Hole	2. Clamp on side and locate	Edge finder
	3. Center drill center hole	#3 Center drill
	4. Step drill to 29/64"	¼", 3/8", 29/64" drills
	5. Tap ½"-20 to 1.125 deep	Tap guide, Tap wrench, ½"-20 plug tap
Tenderizer	6. Clamp on end and locate	Edge finder
	7. Machine V-grooves	Drill-Mill, 90 Degree, 3/8" 2 Flute, Cobalt
	8. Rotate 90 degrees in vise and locate	Edge finder
Flat Face	9. Machine V-grooves	Drill-Mill, 90 Degree, 3/8" 2 Flute, Cobalt Maintain Z-height lock during last pass on all grooves
	10. Clamp on V-groove end and locate	Edge Finder
	11. Round 4 corners	0.125" radius corner rounding end mill

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Head Process

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