

DWG. NO. ZP22754

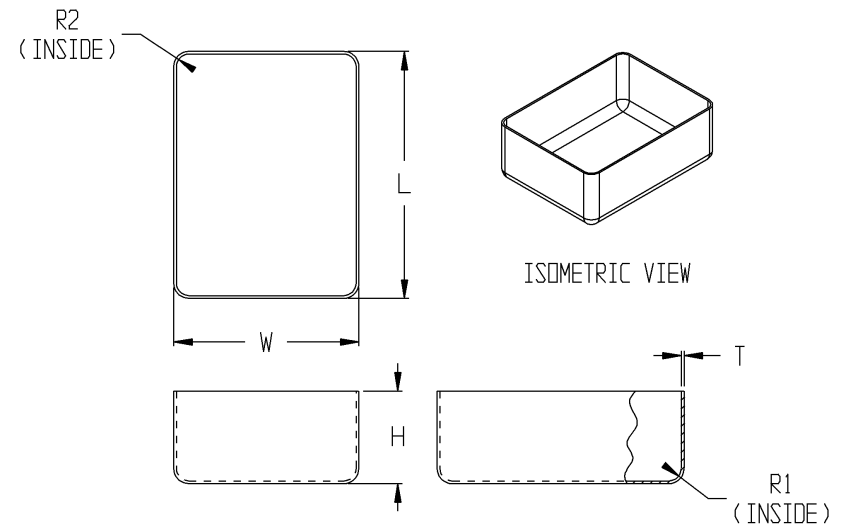
SH 1

REVISIONS

ZONE	REV	DESCRIPTION	DATE	APPROVED
	A	PRODUCTION RELEASE	10/12/05	H. CHOW
	B	1. REMOVED SHTS 2 THRU 13 2. CHANGED P/N HEIGHT TO INCHES	6/2/14	C. READ

NOTES:

- MATERIAL THICKNESS: (T)  
THICKNESS SHOWN IS THE NOMINAL DIMENSION OF THE BLANK BEFORE DRAWING. ACTUAL WALL THICKNESS OF AN AVERAGE ENCLOSURE IS NORMALLY 75% OR MORE OF THE NOMINAL BLANK THICKNESS. (DEPENDENT ON DEPTH OF DRAW, NUMBER OF DRAWS, AND NET BLANK THICKNESS).
- ALTERNATE ALLOYS AND HEAT-TREATING:  
MOST ENCLOSURES CAN BE DRAWN ON STOCK TOOLING USING ANY DRAWABLE ALUMINUM ALLOY. WHEN 6061-0 ALLOY IS DRAWN IT CAN BE HEAT-TREATED TO A -T4 OR -T6 CONDITION (HARDNESS).  
ALLOY CHANGE OPTIONS: AL11 = 1100-0, AL30 = 3003-0, AL60 = 6061-0.
- STANDARD ENCLOSURE TOLERANCES:  
A. OUTSIDE DIM UP TO 6" ±.02  
B. OUTSIDE DIM 6" TO 24" ±.03  
C. OUTSIDE DIM OVER 24" ±.06  
D. RADIUS TOLERANCE ±.03
- BOW TOLERANCES:  
BOWING, OR "OIL-CANNING", MAY OCCUR IN THE BASE OR ANY SIDE OF THE DEEP DRAWN ENCLOSURE PARTICULARLY WHEN MULTIPLE DRAWING OPERATIONS ARE PERFORMED. TOLERANCES FOR THIS BOW CONDITION ARE ADDITIVE TO BASIC DIMENSIONAL TOLERANCES:  
BASIC SIZE \*      MAXIMUM BOW \*\*  
UP TO 6"            0.03"  
OVER 6" TO 12"    0.06"  
OVER 12"           0.12"  
\* THE BOW CONDITION WILL BE CHECKED BY PLACING A STRAIGHT EDGE ACROSS THE TANGENT POINTS OF THE CORNER RADII OF THE SIDE OR BOTTOM OF THE ENCLOSURE, AND MEASURING THE MAXIMUM DEVIATION FROM THE STRAIGHT EDGE TO THE SURFACE OF THE METAL. THIS APPLIES TO EITHER A CONCAVE OR CONVEX CONDITION.  
\*\* THE BASIC SIZE REFERS TO THE ENCLOSURE WIDTH OR LENGTH. THE MAXIMUM ALLOWABLE BOW WILL BE DETERMINED BY THE LARGER OF THE TWO DIMENSIONS FOR ANY GIVEN SIDE, AND BY THE SMALLER OF THE TWO DIMENSIONS FOR THE BOTTOM.
- REMOVE ALL BURRS AND SHARP EDGES.
- ORDERING INFORMATION: ORDER BY PART NUMBER.  
EXAMPLE OF PART NUMBER CALLOUT:



SEE CATALOG FOR DIMENSIONALS

ZT28-54-2.00-AA-T6

- ALLOY CHANGE/HEAT TREAT  $\triangle 2$
- NUTPLATE HOLE PATTERN (SEE CATALOG)
- TRIM HEIGHT IN INCHES (MIN = R1+T; MAX = H/MAXIMUM)
- BASIC ENCLOSURE PART NUMBER (STOCK OR NON-STOCK - SEE CATALOG)

THIS DRAWING IS FOR REFERENCE ONLY, LISTING ALL AVAILABLE PART NUMBERS.  
SEE NOTE 6 FOR PROPER ORDERING INFORMATION.

CURRENCY NOTICE: A HARD COPY OF THIS DOCUMENT MAY NOT BE THE DOCUMENT CURRENTLY IN EFFECT.  
THE CURRENT VERSION IS ALWAYS THE VERSION ON THE ZERO MANUFACTURING, INC. NETWORK.

ALL SHEETS OF DRAWING BEAR THE SAME REV. LTR		ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED		<b>ZERO</b> ZERO MANUFACTURING, INC. North Salt Lake, UT 84054	
APPROVALS		DATE MM/DD/YY		DEEP DRAWN ENCLOSURES (RECTANGULAR & SQUARE)	
DRAWN R.S.H.		7/5/05			
CHECKED H. CHOW		10/12/05			
ISSUED J. MIYA		10/12/05			
MATERIAL SEE CATALOG		FINISH NONE		SIZE/CAGE NO. B 98376	DWG. NO. ZP22754
DD NOT SCALE DRAWING		FILE ZP22754S1.kcd		SCALE 1:1	SHEET 1 OF 1

This document and the drawings and the technical data contained hereon are the property of Zero Mfg. Inc., formerly APW Zero Cases, Zero Enclosures, and Zero Mfg. Co. Reproduction or dissemination in any form except as expressly authorized by the owner is forbidden. The holder agrees to return this document to the owner on demand. Copyright by Zero Mfg. Inc.