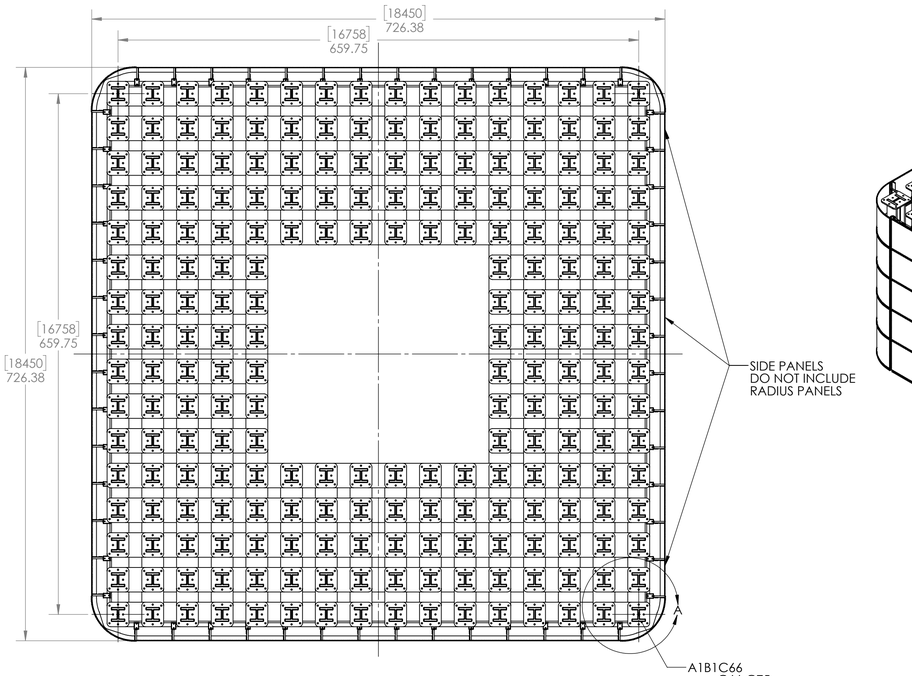
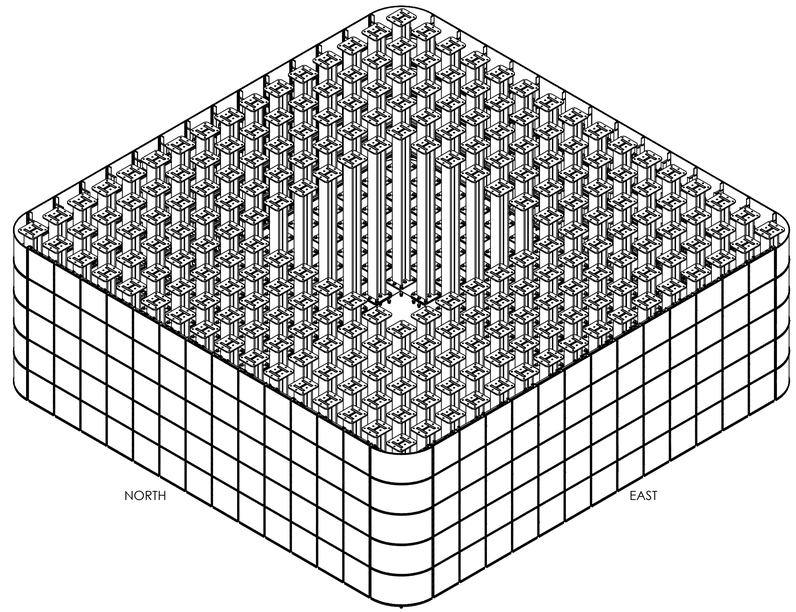
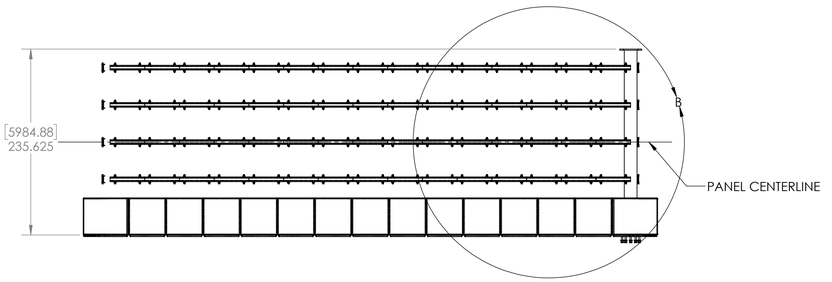
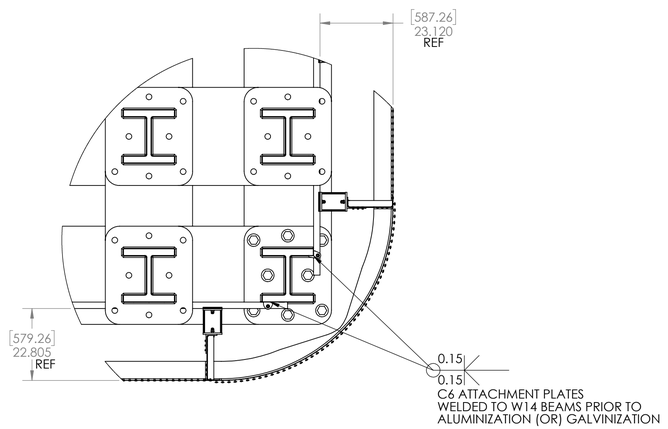
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT	QTY.
1	Panel sq 47.125in 20200513 w550 w455 w370 w283			260
2	Rivet Brazier head for Panel 20200510 w550 w455 w370 w283			26640
3	Rib 31 20210118 w550 w455 w370 w283			280
4	L2x2x0.125 3 20210118 w550 w455 w370 w283			280
5	L2x2x0.125 3 20210118 w550 w455 w370 w283			280
6	Plate Pnl sup 2 20210118 w550 w455 w370 w283			280
7	Rivet Brazier 2t +0.0625 20210107 w550 w455 w370 w283			1680
8	Rivet Brazier t+0.313+0.0625 20210104 w550 w455 w370 w283			1680
9	LS6x3.5x0.312 2 20210118 w550 w455 w370 w283			280
10	W6x9 1 20210118 w283			140
11	Plate pnl sup 3 20210118 w550 w455 w370 w283			560
12	Shim Plate 30 1 pnl 20210120 w550 w455 w370 w283			280
13	Shim Plate 30 2 pnl 20210120 w550 w455 w370 w283			280
14	Shim Plate 30 3 pnl 20210120 w550 w455 w370 w283			280
15	Shim Plate 30 4 pnl 20210120 w550 w455 w370 w283			280
16	Plate pnl was 1 20210120 w550 w455 w370 w283			280
17	91286A377			1120
18	98180A150			4640
19	93827A249			2320
20	93839A825			3520
21	Rib 32 20210118 w550 w455 w370 w283			260
22	Rivet Brazier 3t 20200514 w550 w455 w370 w283			1680
23	W6x9 1 20210118 w283			140
24	Rib Radius 3 20200515 w550 w455 w370 w283			20
25	Rib Radius 30 20210120 w550 w455 w370 w283			20
26	W14x283 1 20210527			220
27	Plate w14x283 20210527			440
28	bolt 1.75in 4tpi 13.0 HD 1 20210527 w283			1760
29	nut 1.75in 4tpi HD 1 20210527 w283			1760
30	wash 1.75in HD 1 20210527 w283			3520
31	nut 1.75in 4tpi HD 1 half 20210527 w283			1760
32	C6x10.5 2 20210312 w455 w370 w283			300
33	Plate bolt hold 1 20210312 w455 w370 w283			600
34	Plate bolt hold 2 20210315 w455 w370 w283			600
35	Plate C6bk 1 20210315 w455 w370 w283			900
36	Thread rod madetoOrd 0.5x12 - 20tpi w550 w455 w370 w283			600
37	Plate connect 1 20210527 w283			198
38	Plate connect 2 20210527 w283			198
39	Shim Plate conct 1 20210527 w283			4
40	Shim Plate conct 1 20210527 w283			80

TOTAL WEIGHT W/O OXIDATION PROTECTION = 1,531,562[LBF]
TOTAL WEIGHT W/ GALVINIZATION AND WELDING = 1,606,000[LBF]

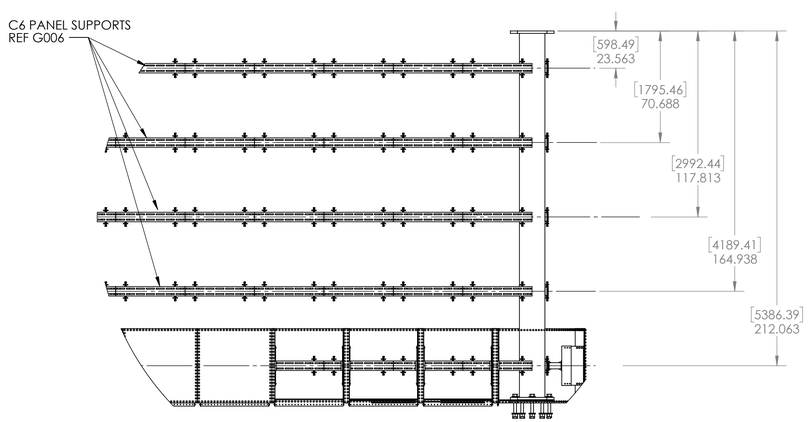








DETAIL A
SCALE 1 : 24



DETAIL B
SCALE 1 : 48

NOTE/S:
NO SHARP EDGES/CORNERS
BEAM/S
- W14, ASTM 913 G65
- W6, Sy 42[KSI]
- C6, Sy 36.3[KSI]

PLATE/S AISI 1045 Sy 75[KSI]
OXIDATION PROTECTION
- POST WELDING/ASSEMBLY
- ALUMINIZATION TYPE II (PREF)
- GALV, ASTM 123 G100 (OPT)
- MASK MATING SURFACES
- MASK BOLT HOLES
- NO MASKING FOR W6 ASM/SHIMS
- OIL-SHEEN, SAE 50+ PRIOR TO ASM
  - APPLY TO BEAR SURFACES ONLY
  - NO AGGLOMERATION

BOLT/S ASM G8, GALVIZED OR TYPE II
MATING SURFACES PROTECTED FOR SHIPPING
- POLY-FILM OR OTHER

PANEL/SKIN/SHELL
- CLASS A, BRUSHED PATTERN, RANDOM, CIRCULAR SWIRL
- MAXIMUM DEPTH 115[MICRO-IN] (0.000115[IN])
- FLATNESS LESS THAN 0.001[IN]
- SIDE/SIDE (EAST/WEST) ANODIZED
  - RGB (26.4, 48.7, 54.6)
  - VERIFIED IN NATURAL LIGHT
- AL T6061-T6, Sy 40[KSI] FOR CLASS A PANEL
- AL ALLOY 40[KSI] MIN FOR OTHER

RIVET/S AL ALLOY
CLASS B, AS-BUILT
CAD/DATA IS MASTER

EXAMPLE AMBIENT TEMP [F]	EXAMPLE AMBIENT TEMP [C]	T6061-T6 dL PER 1000[IN]	T6061-T6 dL PER 1000[mm]
45.00	7.22	-0.183	-4.658
59.00	15.00	0.0	0.0
86.00	30.00	0.354	8.984

EXAMPLE:
LET DIM = 47.125[IN] (T6061-T6)
dL = 0.000013186 - 59)47.125
dL = 0.0167[in] [0.4234[mm]]

AT 86[F] THE DIMENSION OF THE PART IS 47.125 + 0.0167 =47.142[IN]

GALVONIC PROTECTION REQUIRED:
ALUMINIZE TYPE II PREFERRED
GALVINIZE G100 ACCEPTABLE
THERMAL SPRAY AS/FOR ASSEMBLED

UNLESS OTHERWISE SPECIFIED:
TOLERANCES:
DIMENSIONS TAKEN AT 59[F]
DIMENSIONS TAKEN AT 15[C]
FRACTIONAL±0.13[15]
ANGULAR: 0.3[DEG]
TWO PLACE DECIMAL ±0.05[IN]
THREE PLACE DECIMAL ±0.005[IN]
VERIFICATION OF COMPONENTS MUST BE PERFORMED WITH TEMPERATURE COMPENSATION
INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5
PARALLEL PLANES MAX 0.002[IN]
FLATNESS MAX 0.002[IN]
FINISH: AS REQUIRED

GAUGE/S:
DRAWINGS ARE AT 59[F] (15[C]): REFER TO MATERIAL SUPPLIER FOR THERMAL EXPANSION COEFFICIENT (CTE)
dL[ENG] = (DIM)*(CTE[1/R])*(TEMP-59)
dL[SI] = (DIM)*(CTE[1/K])*(TEMP-15)
***TOLERANCES DO NOT CHANGE

	NAME	DATE
DRAWN		
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

CREO DESIGNS, ENG DPT

TITLE: GLORIOUS CROSS
W14x283 STD SEG ASM
FOR MAIN BODY

SIZE	DWG. NO.	REV
D	J - 001	1
SCALE: 1:96		SHEET 1 OF 1