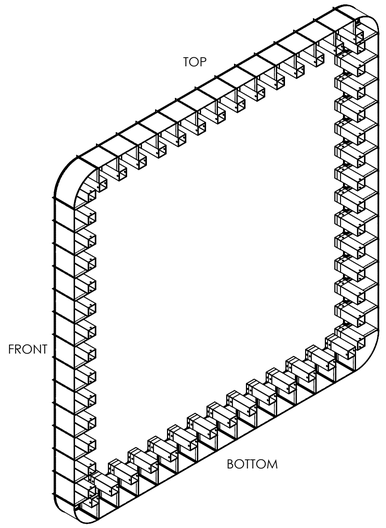
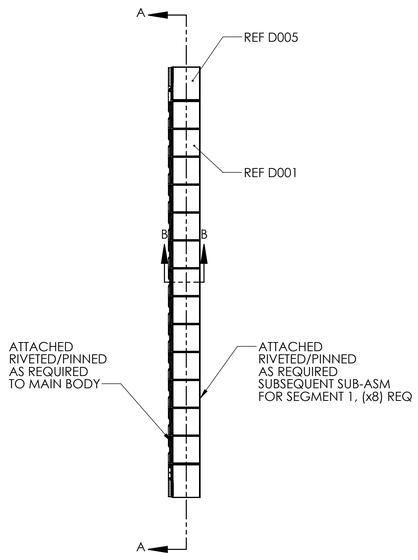
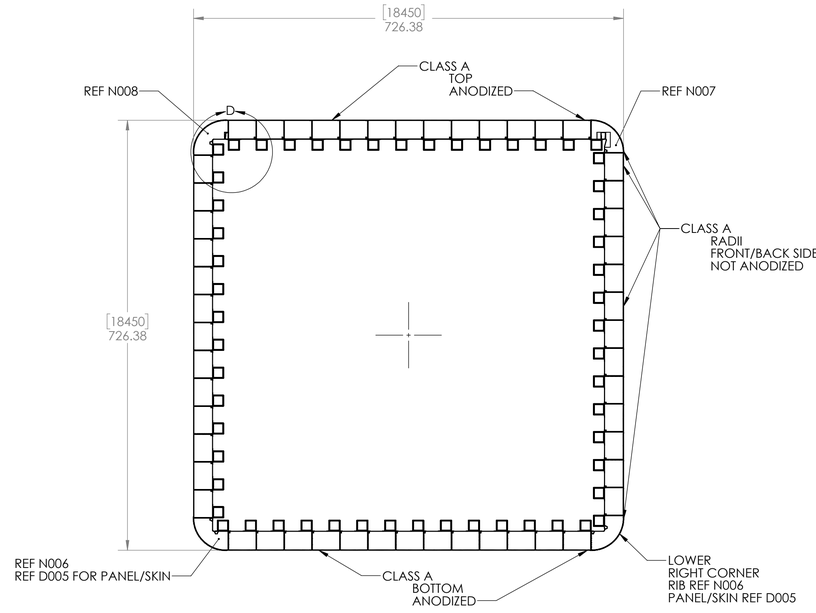
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT	QTY.
1	Panel sq 47.125in 20200513			52
2	Rivet Brazier 2t 20200514			4888
3	Rib 8 20200530			56
4	Coilbeam ii 20200531			56
5	Coil Conct Base i 20200531			56
6	Coil Connect ii 20200531			56
7	Coil Connect brace 20200601			56
8	Rivet Brazier 2t 0.125in 20200604			1568
9	Rib 9 20200530			39
10	Rivet Brazier 4t 20200514			2240
11	Bracket Crossrib ii 20200610			52
12	Rib Radius 3 20200515			4
13	Rivet Brazier head for Panel 20200510			544
14	Rib Radius 11 Copy 20210108			2
15	Rib Radius 14 Copy 20210108			1
16	Coilbeam attach Ledge i Copy 20210108			1
17	Rib 11 20200607			13
18	Rib Radius 15 Copy 20210108			1
19	Coilbeam attach Ledge ii Copy 202010108			1

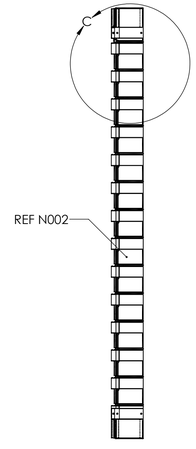
TOTAL WEIGHT OF (x8) SUB-ASM = 125,334[LBF]



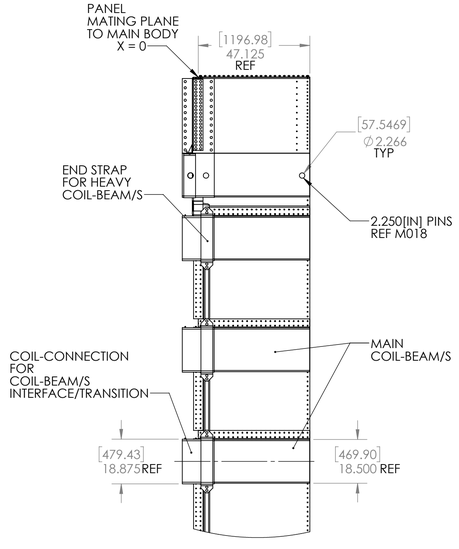




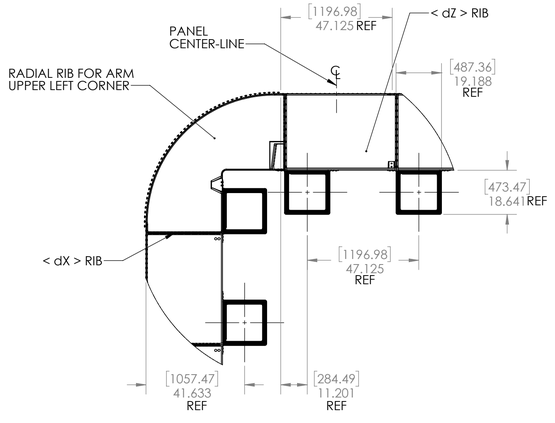
SECTION A-A



SECTION B-B



DETAIL C
SCALE 1 : 32



DETAIL D
SCALE 1 : 32

NOTE/S:
NO SHARP EDGES/CORNERS
(x8) SUB- ASM COMPLETE FIRST SEGMENT, TOTAL LENGTH = 377.000[IN]
Xcg = 181[IN]
Ycg = 0[IN]
Zcg = -1[IN]
FORM/SHAPE OF CLASS B PARTS ARE IDEALIZED
ACTUAL TOOLING DRAFT MAY VARY OUTSIDE OF PRINT/TOLERANCE
RIVET/MATING SEGMENTS/ZONES SEPARATION/S TO BE LESS THAN 0.045[IN]
WHERE THE AXIS OF THE RIVET/SARE COLINEAR, THE RIVET-HOLE/S ARE IN-LINE
NO GAP/S ALLOWED AFTER RIVETING
(x8) SEGMENTS FORM FIRST SEGMENT ASSEMBLY
FIRST SEGMENT ASSEMBLY IS ATTACHED TO BRACE/BEAMS, REF M0XX
AL, T6061-T6, Sy 40[KSI] MIN
AL, ALLOY, Sy 40[KSI] MIN
CLASS B, AS-BUILT
CLASS A, REF A001, D001
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 = 0.000013(86 - 59)47.125
dL = 0.0167[IN] (0.423[mm])

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

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

UNLESS OTHERWISE SPECIFIED:
TOLERANCES:
DIMENSIONS TAKEN AT 59[F]
DIMENSIONS TAKEN AT 15[C]
FRACTIONAL ±0.13[N]
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

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

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

CREO DESIGNS, ENG DPT

TITLE: GLORIOUS CROSS
ARM - FIRST SEGMENT
PANEL ARRAY

SIZE	DWG. NO.	REV
D	N - 001	1
SCALE: 1:128		SHEET 1 OF 1