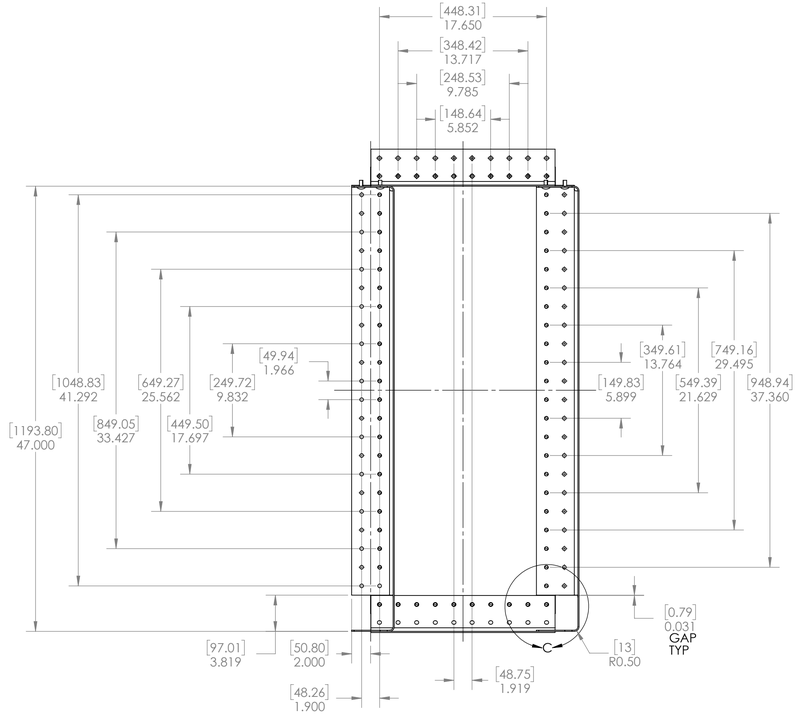
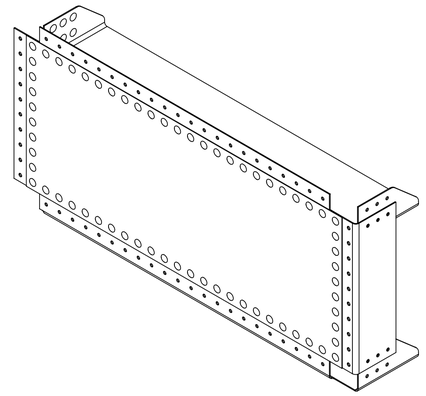
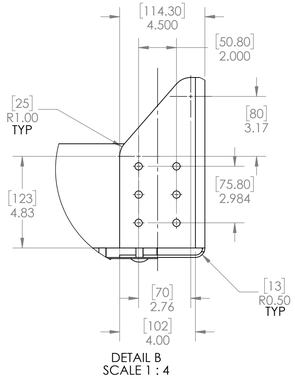
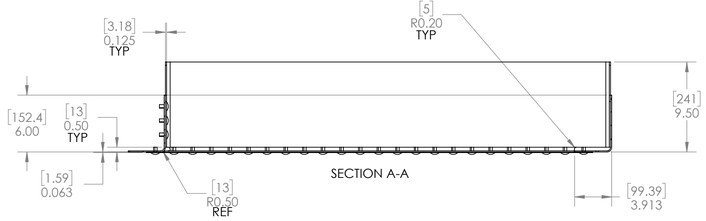
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT	QTY.
1	Panel sq 19.503in 20210112 R1 std8 B			1
2	Rivet Brazier head for Panel 20200510 R1 std8 B			64
3	Rib 16 20210104 R1 std8 B	19[IN] SIDE RIB		2
4	Rib 32 20210118 w550 w455 w370 w283 w193 Arm 1 cpy	46[IN] TOP/BOT RIB		2
5	Rivet Brazier 3t 20200514 w550 w455 w370 w283 w193 Arm 1 cpy			12



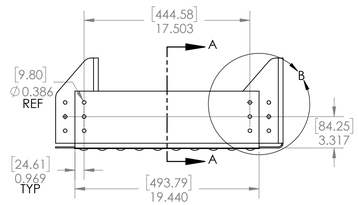


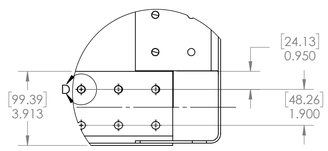


DETAIL B
SCALE 1 : 4

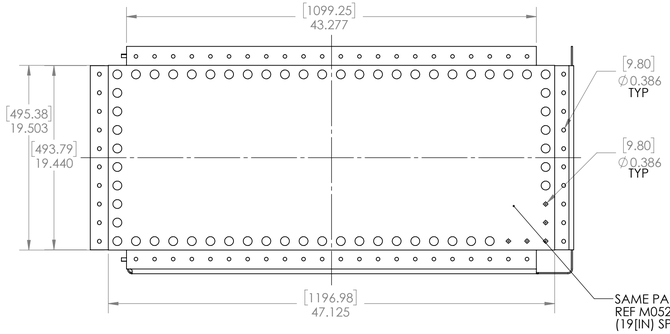


SECTION A-A

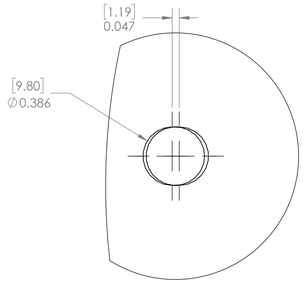




DETAIL C
SCALE 1 : 4



SAME PANEL USED IN M052
REF M052 FOR SIDE-HOLE
(19[IN] SPACING/S



TYP - SLOT/HOLES MATING TO PANEL
ON SIDE-RIBS ONLY

DETAIL D
SCALE 2 : 1

NOTE/S:
NO SHARP EDGES/CORNERS
ALL AL, EXCEPT FOR W6 BEAM ASM (BEAM, SHIM/S AND BOLTS)
T6061-T6 FOR CLASS A PLATE
AL ALLOY FOR OTHER
W6 BEAM, Sy 42[KSI]
PLATE/S, SHIM/S AISI 1045 OR Sy 42[KSI]
BOLT/S ASM G8
OXIDIATION PROTECTION
ALUMINIZATION TYPE II (PREF)
GALV, G100 (OPTION)
CLASS A, REF J001
CAD 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] [0.4234[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/PER ASSEMBLED

UNLESS OTHERWISE SPECIFIED:
TOLERANCES:
DIMENSIONS TAKEN AT 59[F]
DIMENSIONS TAKEN AT 15[C]
FRACTIONAL±0.13[1/5]
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 COEFFICENT (CTE)
dL(ENG) = (DIM)*(CTE[1/R])*(TEMP-59)
dL(SI) = (DIM)*(CTE[1/K])*(TEMP-15)
***TOLERANCES DO NOT CHANGE

CREO DESIGNS, ENG DPT

TITLE: GLORIOUS CROSS
INT - PANEL/SKIN P19
PR359, ASM - 7

SIZE	DWG. NO.	REV
D	M - 051	1

SCALE: 1:8 SHEET 1 OF 1