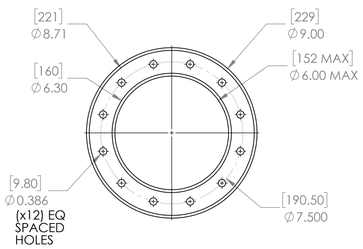
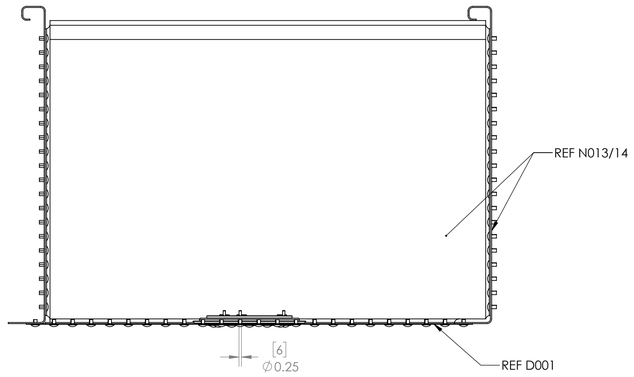
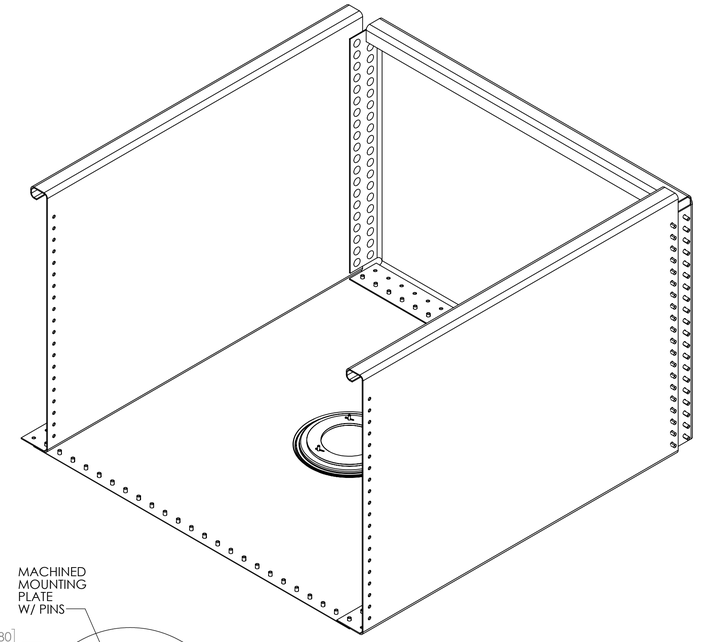
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT	QTY.
1	Panel sq wDrain 47.125in 20200519			1
2	Rivet Brazier head for Panel 20200510			92
3	Rib 1 20200513			2
4	Rib 2 20200514			1
5	Rivet Brazier 3t 20200514			80
6	Drain cover plate 1 20200519			1
7	Drain mounting plate 1 20200519			1
8	Drain screen assmebly 20200519			1
9	Drain mounting plate 2 20200519			1
10	98450A718			3
11	Rivet Brazier Drain 20200520			12

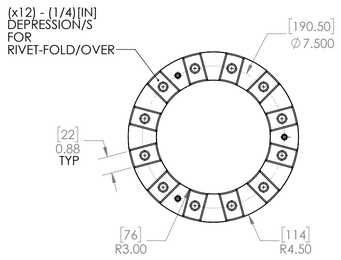
(x3) DRAIN PANELS REQUIRED

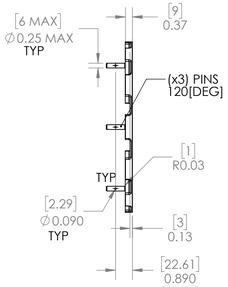


EXTERIOR PANEL/RIVET MOUNT

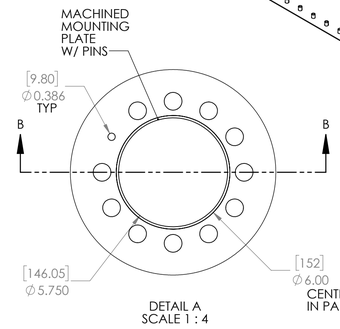




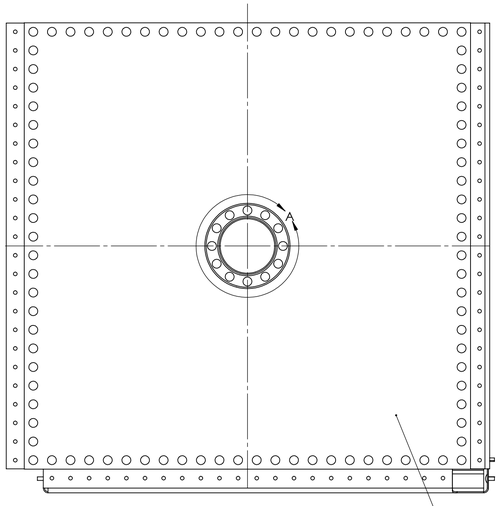


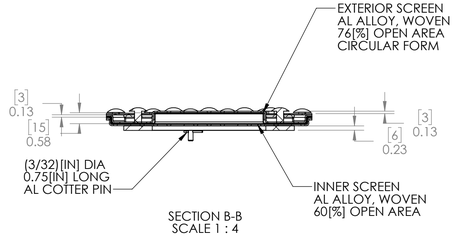


MIN-PANEL/RIVET MOUNT
W/ PINS FOR INTERIOR FLANGE

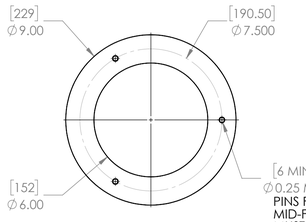


DETAIL A
SCALE 1 : 4

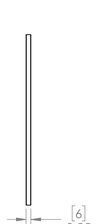




SECTION B-B
SCALE 1 : 4



INTERIOR FLANGE



NOTE/S:
NO SHARP EDGES/CORNERS
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
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: ASSEMBLY TEMP. [F]	EXAMPLE: ASSEMBLY 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 = 0.0000131(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 PREFERED
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[75]
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)*(Ki)*(TEMP-59)
dL(SI) = (DIM)*(CTE)*(Ki)*(TEMP-15)
***TOLERANCES DO NOT CHANGE

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

CREO DESIGNS, ENG DPT

TITLE: GLORIOUS CROSS

ARM - DRAIN PANEL

SIZE	DWG. NO.	REV
D	N - 026	1
SCALE: 1:8		SHEET 1 OF 1