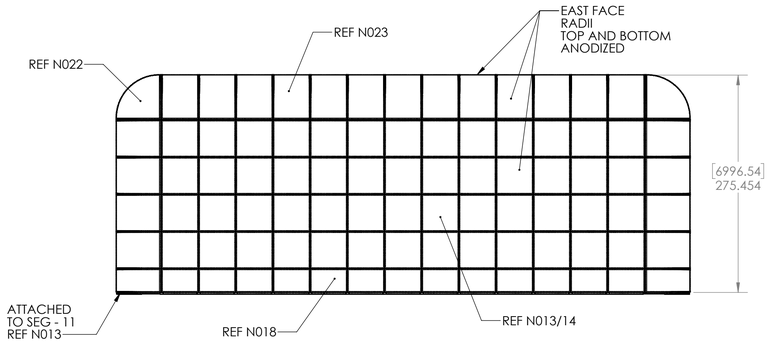
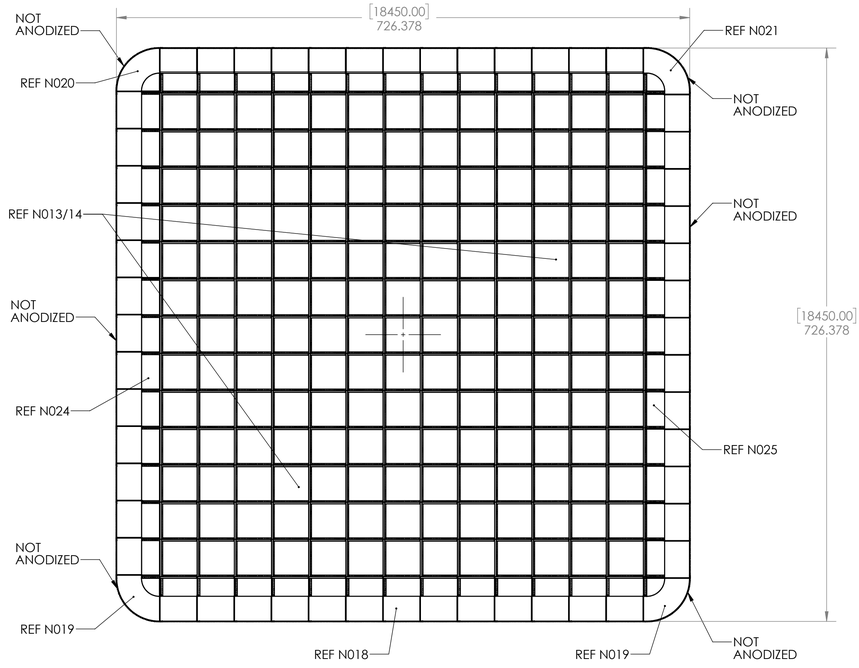
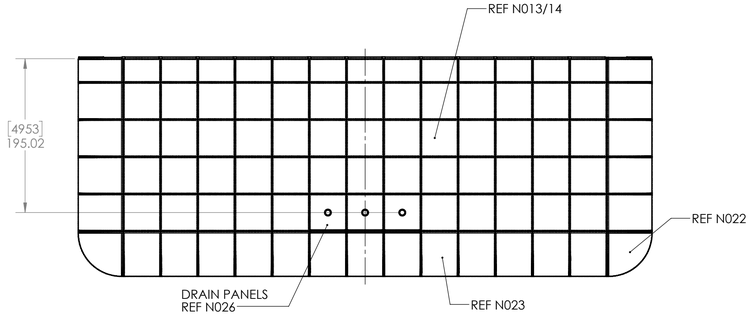
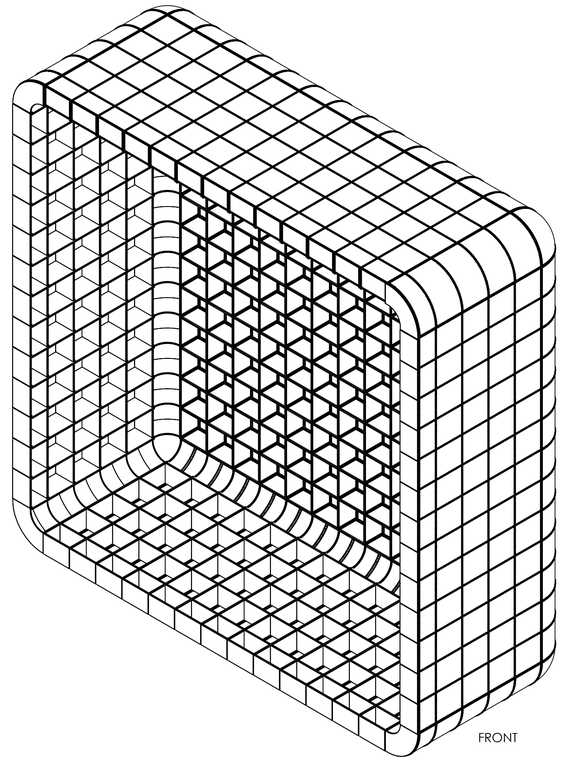
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT	QTY.
1	Panel sq wDrain 47.125in 20200519			3
2	Rivet Brazier head for Panel 20200510			49040
3	Rib 1 20200513			406
4	Rib 2 20200514			626
5	Rivet Brazier 3t 20200514			29400
6	Drain cover plate 1 20200519			3
7	Drain mounting plate 1 20200519			3
8	Drain screen assmebly 20200519			3
9	Drain mounting plate 2 20200519			3
10	98450A718			3
11	Rivet Brazier Drain 20200520			3
12	Panel sq 47.125in 20200513			374
13	Rib Radius 3 20200515			69
14	Rib Radius 4 20200515			12
15	Rib Radius 5 20200515			41
16	Rib Radius 9 20200522			6
17	Rib Radius 10 20200522			6
18	Rib Radius Corner 1 20200516			4
19	Rib Radius 7 20200516			14
20	Rib Radius 8 20200516			14
21	Panel rect 30in 20200518			52
22	Rib 7 30in 20200518			55
23	Panel Radius 3 30in 20200518			4

TOTAL WEIGHT OF 12TH SEG = 37,824[LBF]









NOTE/S:
NO SHARP EDGES/CORNERS
12TH SEGMENT - ENDCAP
TOTAL LENGTH = 275.454[IN]
Xcg = 182[IN]
Ycg = -1[IN]
Zcg = 1[IN]
ENTIRE ARM: 1 THRU 12TH SEGMENTS
TOTAL LENGTH = 4,422.454[IN]
Xcg = 1607.5[IN]
Ycg = 0.0[IN]
Zcg = -0.7[IN]
ENTIRE ARM FROM BODY MID-PLANE: 1 THRU 12TH SEGMENTS
TOTAL LENGTH = 4,842.520[IN] (123000[MM])
TOTAL WEIGHT = 868,087[LBF] (NO OTHER LOADING/S)
Xcg = 2027.6[IN]
Ycg = 0.0[IN]
Zcg = -0.7[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
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 = 0.0000131(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 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

	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/R])*(TEMP-59)
dL(SI) = (DIM)*(CTE[1/K])*(TEMP-15)
***TOLERANCES DO NOT CHANGE

CREO DESIGNS, ENG DPT

TITLE: GLORIOUS CROSS

ARM - 12TH SEGMENT ENDCAP ASM

SIZE	DWG. NO.	REV
D	N - 027	1

SCALE: 1:96 | SHEET 1 OF 1