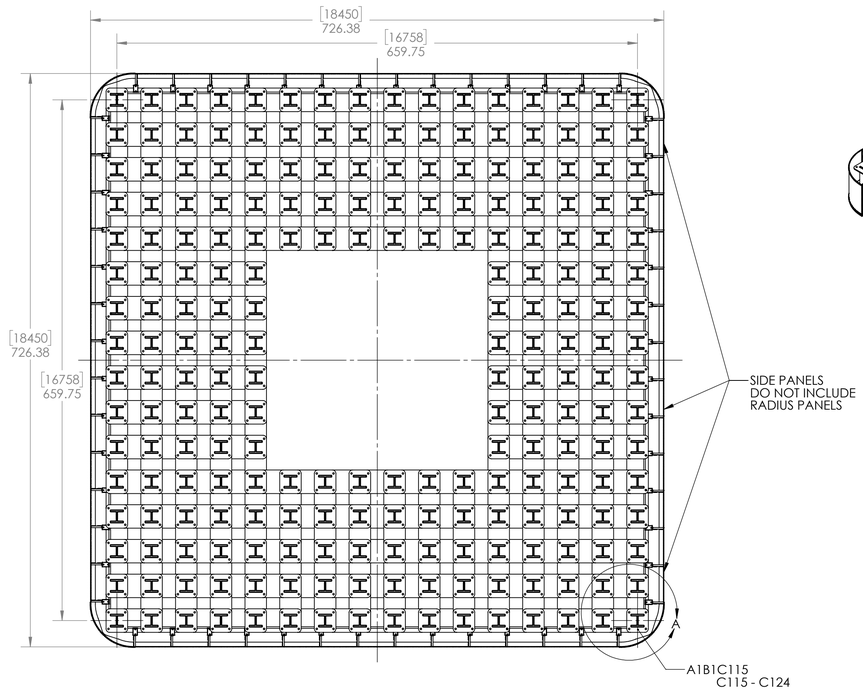
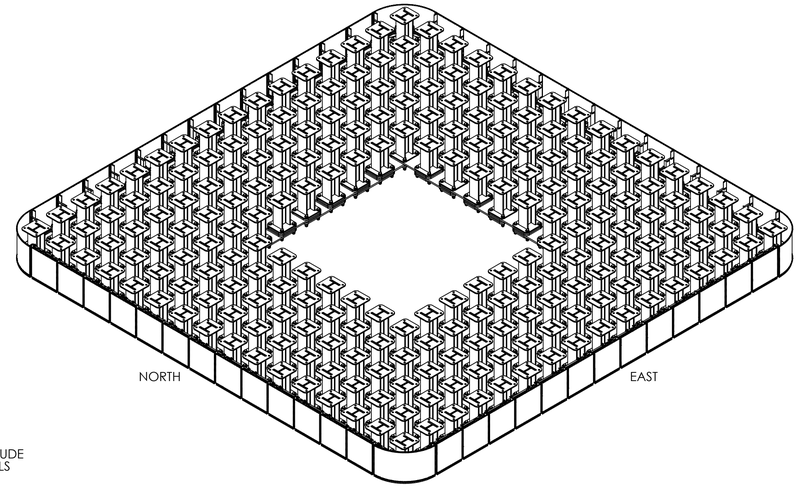
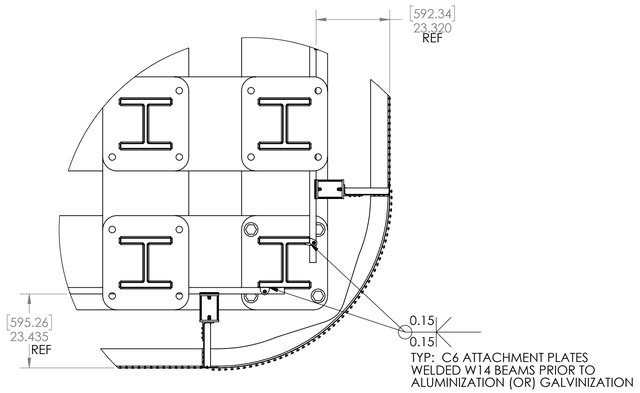
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT	QTY.
1	W14x193 1 20210528 s1			220
2	Plate w14x193 20210528 s1			440
3	bolt 2in 4tpi 15.5in DH3 1 20210528 w193 s1			880
4	nut 2in 4tpi HD 1 20210527 w193 s1			880
5	wash 2in HD 1 20210528 w193 s1			1760
6	nut 2in 4tpi HD 1 half 20210528 w193 s1			880
7	Plate connect 1 20210527 w193 s1			198
8	Plate connect 2 20210527 w193 s1			198
9	Shim Plate conct 1 20210527 w193 s1			4
10	Shim Plate conct 1 20210527 w193 s1			80
11	Panel sq 47.125in 20200513 w550 w455 w370 w283 w193			52
12	Rivet Brazier head for Panel 20200510 w550 w455 w370 w283 w193			5328
13	Rib 31 20210118 w550 w455 w370 w283 w193			56
14	L2x2x0.125 3 20210118 w550 w455 w370 w283 w193			56
15	L2x2x0.125 3 20210118 w550 w455 w370 w283 w193			56
16	Plate Pnl sup 2 20210118 w550 w455 w370 w283 w193			56
17	Rivet Brazier 2t +0.0625 20210107 w550 w455 w370 w283 w193			336
18	Rivet Brazier t+0.313+0.0625 20210104 w550 w455 w370 w283 w193			336
19	LS6x3.5x0.312 2 20210118 w550 w455 w370 w283 w193			56
20	W6x9 1 20210118 w193			28
21	Plate pnl sup 3 20210118 w550 w455 w370 w283 w193			112
22	Shim Plate 30 1 pnl 20210120 w550 w455 w370 w283 w193			56
23	Shim Plate 30 2 pnl 20210120 w550 w455 w370 w283 w193			56
24	Shim Plate 30 3 pnl 20210120 w550 w455 w370 w283 w193			56
25	Shim Plate 30 4 pnl 20210120 w550 w455 w370 w283 w193			56
26	Plate pnl was 1 20210120 w550 w455 w370 w283 w193			56
27	91286A377			224
28	98180A150			928
29	93827A249			464
30	93839A825			704
31	Rib 32 20210118 w550 w455 w370 w283 w193			52
32	Rivet Brazier 3t 20200514 w550 w455 w370 w283 w193			336
33	W6x9 1 20210118 w193			28
34	Rib Radius 3 20200515 w550 w455 w370 w283 w193			4
35	Rib Radius 30 20210120 w550 w455 w370 w283 w193			4
36	C6x10.5 2 20210312 w455 w370 w283 w193			60
37	Plate bolt hold 1 20210312 w455 w370 w283 w193			120
38	Plate bolt hold 2 20210315 w455 w370 w283 w193			120
39	Plate C6bk 1 20210315 w455 w370 w283 w193			180
40	Thread rod madetoOrd 0.5x12 - 20tpi w550 w455 w370 w283 w193			120

TOTAL WEIGHT W/O OXIDATION PROTECTION = 767,399[LBF]
TOTAL WEIGHT W/ GALVINIZATION AND WELDING = 819,000[LBF]

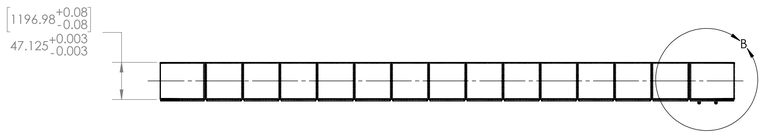


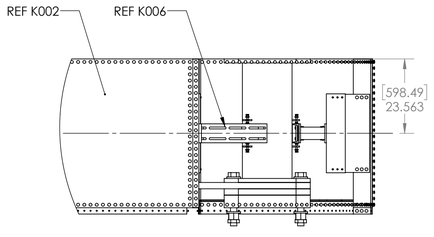


NOTE FOR BOM:
(x10) OF THESE SEGMENT ARE LOCATED
BELOW THE ARM INTERSECTION
ABOVE THE ARM INTERSECTION
ABOVE GROUND LEVEL (APROX)
W14x665 STD COUNT IS 4,620
W14x550 STD COUNT IS 1,980
W14x455 STD COUNT IS 2,200
W14x370 STD COUNT IS 1,980
W14x283 STD COUNT IS 2,420
W14x193 STD COUNT IS 8,360
W14x193-S1 STD COUNT IS 2,200
STD PANELS 25,700
RIVETS FOR STD PANELS 2,682,000



DETAIL A
SCALE 1 : 24





DETAIL B
SCALE 1 : 24

NOTE/S:
NO SHARP EDGES/CORNERS
W14, ASTM 913 G65
W6, Sy 42[KSI]
C6, Sy 36.3[KSI]
PLATE/S AISI 1045 Sy 75[KSI]
OXIDIATION PROTECTION
POST WELDING/ASSEMBLY
ALUMINIZATION TYPE II (PREF)
GALV, ASTM123 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, GALVINIZED 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 (AST/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 Sy 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]	6061-T6 (SI) FT-1 (1000/in)	6061-T6 (SI) PT-6 (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[1/dK - 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

GAUGES/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

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

CREO DESIGNS, ENG DPT

TITLE: GLORIOUS CROSS
W14x193 - S1
NEAR ARM/S

SIZE	DWG. NO.	REV
D	L - 001	1

SCALE: 1:96 SHEET 1 OF 1