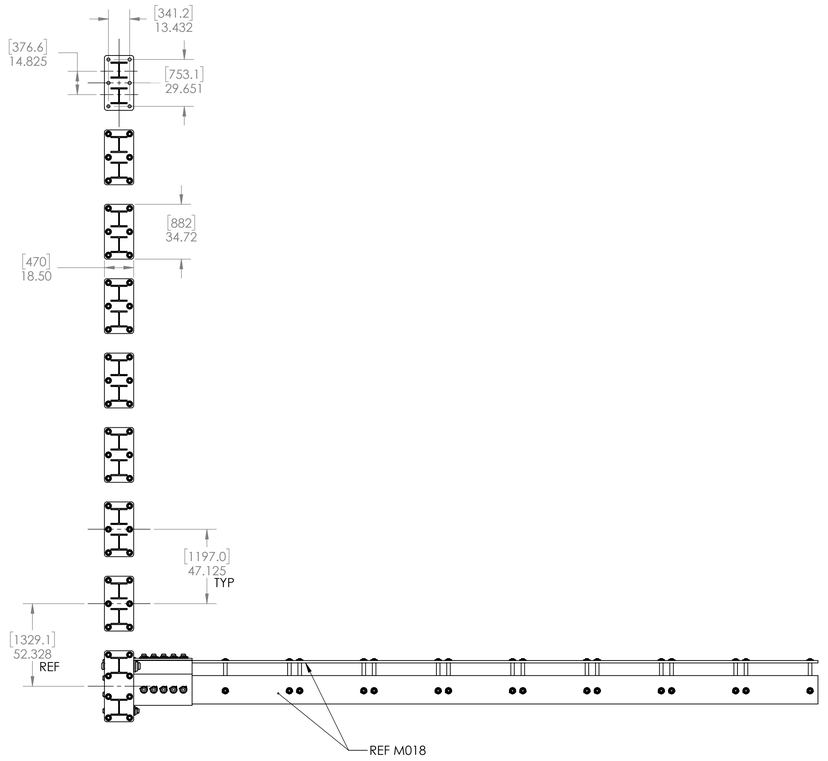
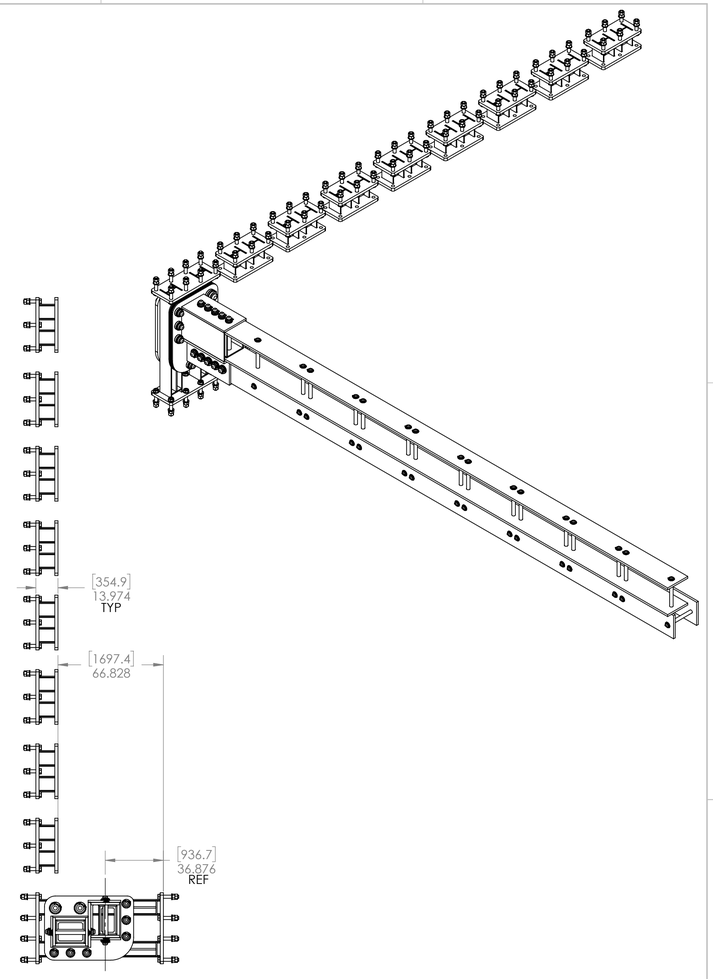
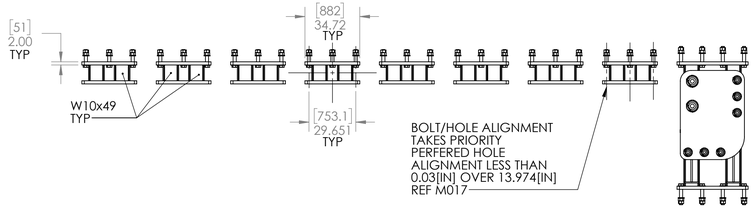
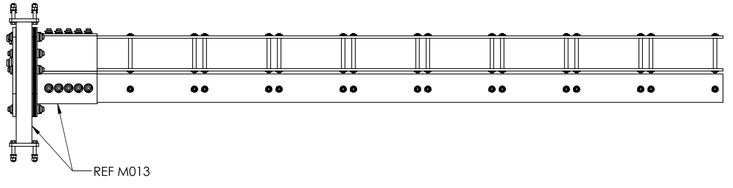
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT	QTY.
1	Plate Lower left corn 2 20200928 LowL1			1
2	Connect beam i 20200619 LowL1			4
3	Rod connect 11 20200909 LowL1			32
4	Clevis key 1a 20200904 LowL1			64
5	Bent pin 2 20200904 LowL1			64
6	98450A774			100
7	Clevis wash 1a 20200904 LowL1			64
8	Clevis block 1 20200907 LowL1			64
9	Plate arm main coup 1 20200919 LowL1			1
10	Plate arm main coup 3 20200919 LowL1			2
11	Plate arm main coup 4 20200919 LowL1			4
12	Plate arm main coup 2 20200919 LowL1			3
13	Plate arm main coup 11 20200928 LowL1			1
14	Plate arm main coup 12 20200928 LowL1			1
15	Plate arm main coup 13 20200928 LowL1			1
16	Plate arm main coup 14 20200928 LowL1			2
17	Rod connect 14 20200910 LowL1			5
18	Clevis key 2 20200910 LowL1			20
19	Clevis wash 2 20200910 LowL1			15
20	Bent pin key 2 20200910 LowL1			32
21	Clevis block 2 20200910 LowL1			20
22	Rod connect 18 20200928 LowL1			5
23	Clevis wash 7 20200928 LowL1			15
24	Shim arm main coup 4a 20200929 LowL1			1
25	Shim arm main coup 4b 20200929 LowL1			2
26	Shim arm main coup 4c 20200929 LowL1			1
27	Shim arm main coup 4d 20200929 LowL1			1
28	Shim arm main coup 4e 20200929 LowL1			1
29	Shim arm main coup 4f 20200929 LowL1			1
30	Brace sup plate W10x49 14 20200929 LowL1			1
31	Rod connect 15 20200915 LowL1			6
32	Clevis key 3 20200915 LowL1			12
33	Clevis block 3 20200915 LowL1			12
34	Clevis wash 3 20200915 LowL1			12
35	Clevis wash 5 20200920 LowL1			6
36	Rod connect 16 20200915 LowL1			2
37	Clevis key 4 20200915 LowL1			4
38	Clevis wash 4 20200915 LowL1			4
39	Bent pin key 4 20200915 LowL1			4
40	Clevis block 4 20200915 LowL1			4
41	Clevis wash 6 20200925 LowL1			2
42	W10x49 arm conect 15 20200929 LowL1			1
43	Brace rib W10x49 10 20200919 LowL1			16
44	Brace rib W10x49 10 2 20210615 LowL1			2
45	W10x49 arm conect 16 20200929 LowL1			1
46	Brace rib W10x49 10 3 20210615 LowL1			2
47	Brace plate W10x49 13 20200927 LowL1			2
48	7.8in grab 12in long			16
49	Plate washer i 20200728 LowL1			128
50	93827A301			128
51	W10x49 arm 20 20201109 LowL1			16
52	Brace plate W10x49 10 20200919 LowL1			16
53	91268A982			48

WEIGHT OF LOWER LEFT ARM ASM = 18,346[LBF]









NOTE/S:
DEFINITION:
INT = INTERSECTION
AKA: ARM/BEAM PANEL SUPPORT/BRACE - 1
NO SHARP EDGES/CORNERS
W14/W10, ASTM A913 G65, Sy 65[KSI]
W6-BEAMS, Sy 42[KSI] (PERF A572 G42)
C6-BEAMS, Sy 36[KSI]
AL, T6061-T6, Sy 40[KSI] MIN
AL. ALLOY, Sy 40[KSI] MIN
PLATE/S AISI 1045, Sy 75[KSI] (MIN)
ALUMINIZATION TYPE II (PREF)
GALVINIZE ASTM A123 G100 ACCPTABLE
MASKING OF MATING SURFACES
OIL-SHEEN, SAE 50+, PRIOR TO ASM
NO AGGLOMERATION OF OIL
AL/ALLOY TO STEEL INTERFACE, POLYMER FILM OR OTHER
MINIMIZE/NEUTRALIZE IONIC EXHANGE
BOLT/S ASM G8
CLASS B, AS-BUILT
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 = 0.000013159(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[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 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
INT - C126 LOWER LEFT CORNER ARM-BEAM/S

SIZE	DWG. NO.	REV
D	M - 012	1

SCALE: 1:48 SHEET 1 OF 1