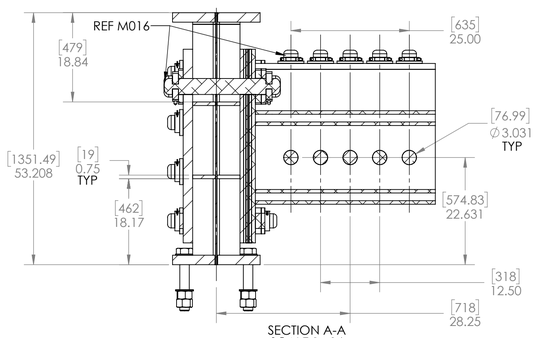
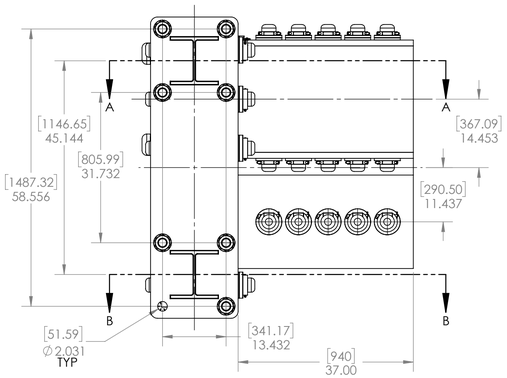
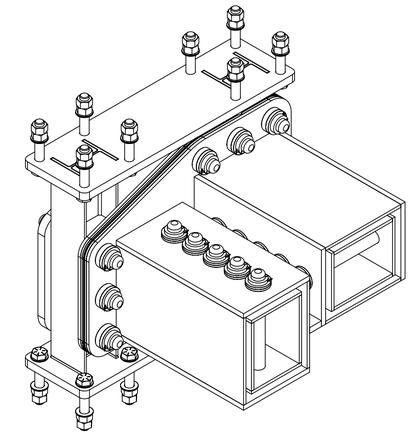
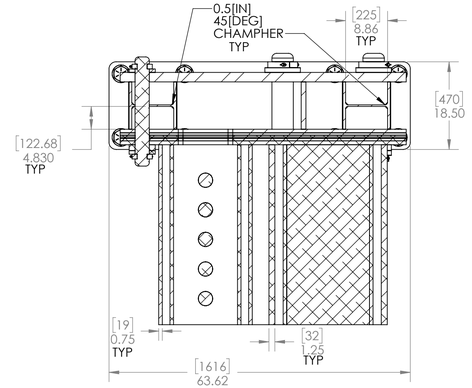
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT	QTY.
1	Plate Upper left corn 2 20200912 UpL1			1
2	Rod connect 15 20200915 UpL1			6
3	Clevis key 3 20200915 UpL1			12
4	Bent pin key 2 20200910 UpL1			32
5	98450A774			36
6	Clevis block 3 20200915 UpL1			12
7	Clevis wash 3 20200915 UpL1			12
8	Clevis wash 5 20200920 UpL1			6
9	Rod connect 16 20200915 UpL1			2
10	Clevis key 4 20200915 UpL1			4
11	Clevis wash 4 20200915 UpL1			4
12	Bent pin key 4 20200915 UpL1			4
13	Clevis block 4 20200915 UpL1			4
14	Clevis wash 6 20200925 UpL1			2
15	W10x49 arm conect 11 20200925 UpL1			1
16	Brace rib W10x49 10 20200919 UpL1			8
17	W10x49 arm conect 12 20200925 UpL1			1
18	Brace sup plate W10x49 11 20200925 UpL1			1
19	Brace sup plate W10x49 12 20200925 UpL1			1
20	Shim arm main coup 2a 20200925 UpL1			1
21	Shim arm main coup 2b 20200925 UpL1			2
22	Shim arm main coup 2c 20200925 UpL1			1
23	Shim arm main coup 2d 20200925 UpL1			1
24	Shim arm main coup 2e 20200925 UpL1			1
25	Shim arm main coup 2f 20200925 UpL1			1
26	Plate arm main coup 3 20200919 UpL1			4
27	Plate arm main coup 4 20200919 UpL1			4
28	Plate arm main coup 1 20200919 UpL1			4
29	Plate arm main coup 2 20200919 UpL1			4
30	Rod connect 14 20200910 UpL1			10
31	Clevis key 2 20200910 UpL1			20
32	Clevis wash 2 20200910 UpL1			30
33	Clevis block 2 20200910 UpL1			20
34	Plate arm main coup 5 20200925 UpL1			1
35	Brace plate W10x49 11 20200925 UpL1			2
36	7.8in grab 12in long			16
37	Plate washer i 20200728 UpL1			32
38	93827A301			32



SECTION A-A
SCALE 1 : 16



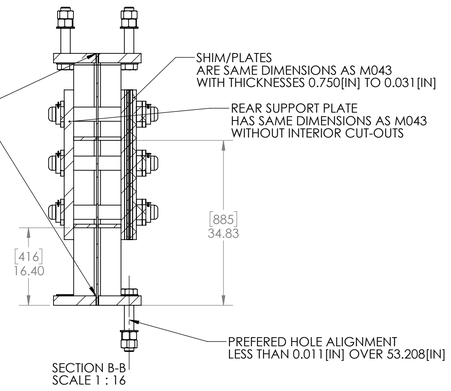




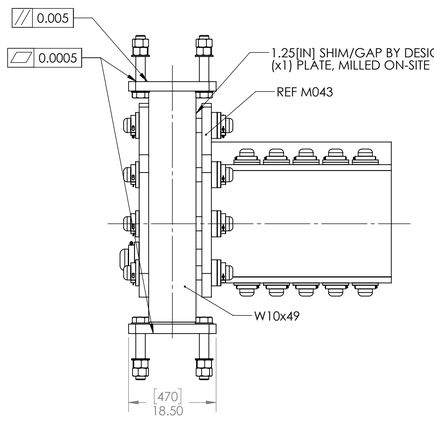
SECTION C-C
SCALE 1 : 16

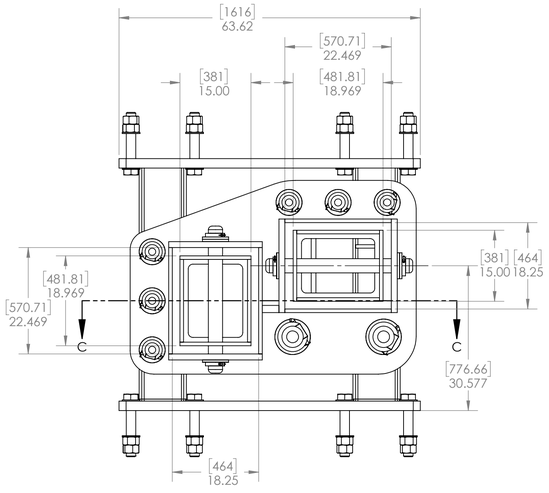
WELD/S:
BEVEL (TOTAL) = (THICKNESS (-) 0.3[IN])
WELD = (BEVEL (+)0.3[IN]MIN)
WELD RADIUS 0.2[IN] MIN
ALL-AROUND/BOTH SIDES
ALL PLATE/S
ANTI-RUST PREPERATION
NO BLEEDING
MATING SIDES ARE GROUND
FOR FLATNESS

NOTE:
CENTERING BEAM INTO PLATE
HOLE ALIGNMENT IS TOP PRIORITY
GAP/S FOR ASSEMBLY MAY VARY
OUTSIDE TOLERANCE/SPEC
TO ALIGN THE HOLES.



SECTION B-B
SCALE 1 : 16





NOTE/S:
DEFINITION:
INT = INTERSECTION
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 = 0.000013118(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[DEC]
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)*(CTE1)/(K)*(TEMP-59)
dL(S) = (DIM)*(CTE1)/(K)*(TEMP-15)
***TOLERANCES DO NOT CHANGE

CREO DESIGNS, ENG DPT

TITLE: GLORIOUS CROSS
INT - C139 UPPER LEFT CORNER BASE/BRACE

SIZE	DWG. NO.	REV
D	M - 042	1

SCALE: 1:32 | SHEET 1 OF 1