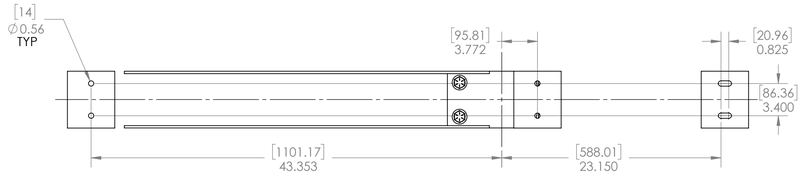
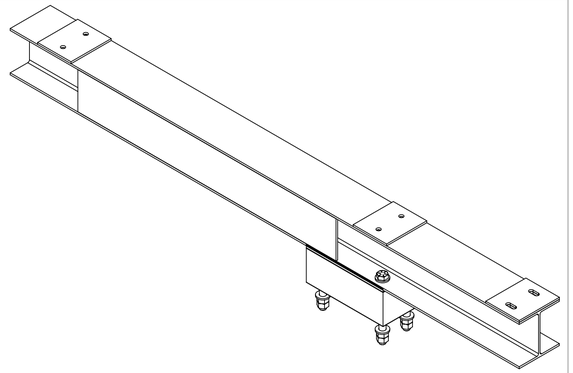
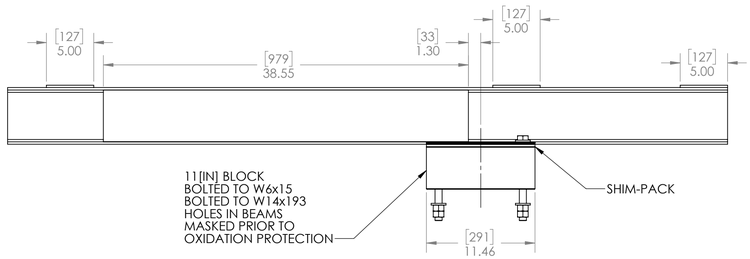
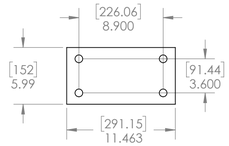
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT	QTY.
1	W6x15 1 20210106 R1			1
2	Plate W6 1 20210106 R1			1
3	Plate W6 2 20210107 R1			2
4	Plate W6 3 20210107 R1			2
5	Plate W6 2 20210107 R1			1
6	Shim Plate W6 1 2021010 R1			1
7	Shim Plate W6 1 2021010 R1			1
8	Shim Plate W6 1 2021010 R1			1
9	Shim Plate W6 1 2021010 R1			1
10	91257A749			4
11	98180A150			8
12	93827A249			8

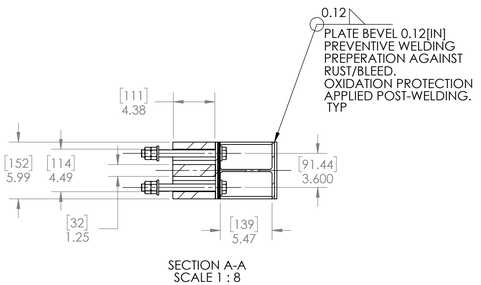




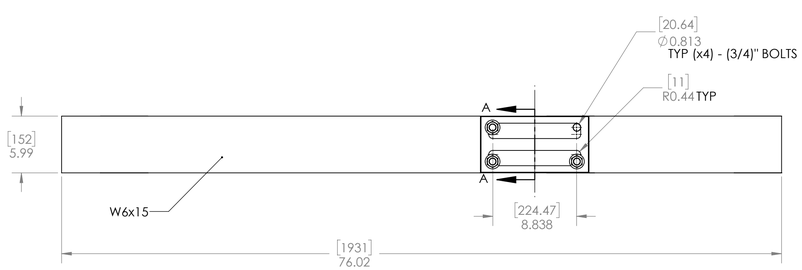


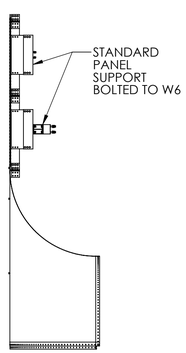


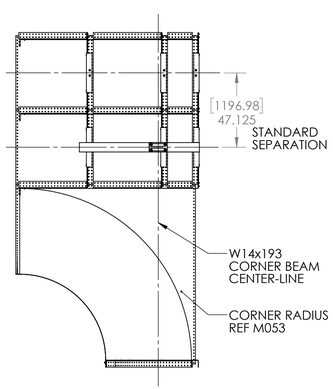
SHIM-PACK
0.25/0.125/0.063/0.031[IN]



SECTION A-A
SCALE 1 : 8







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 = 0.000015159[6 - 59]47.125
dL = 0.0167[in] [0.4234[mm]]

AT 86[F] THE DIMENSION OF THE PART IS 47.125 + 0.0167 =47.1429[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 - W6 PANEL SUPPORT ASM, PR360-371

SIZE	DWG. NO.	REV
D	M - 056	1

SCALE: 1:24 | SHEET 1 OF 1