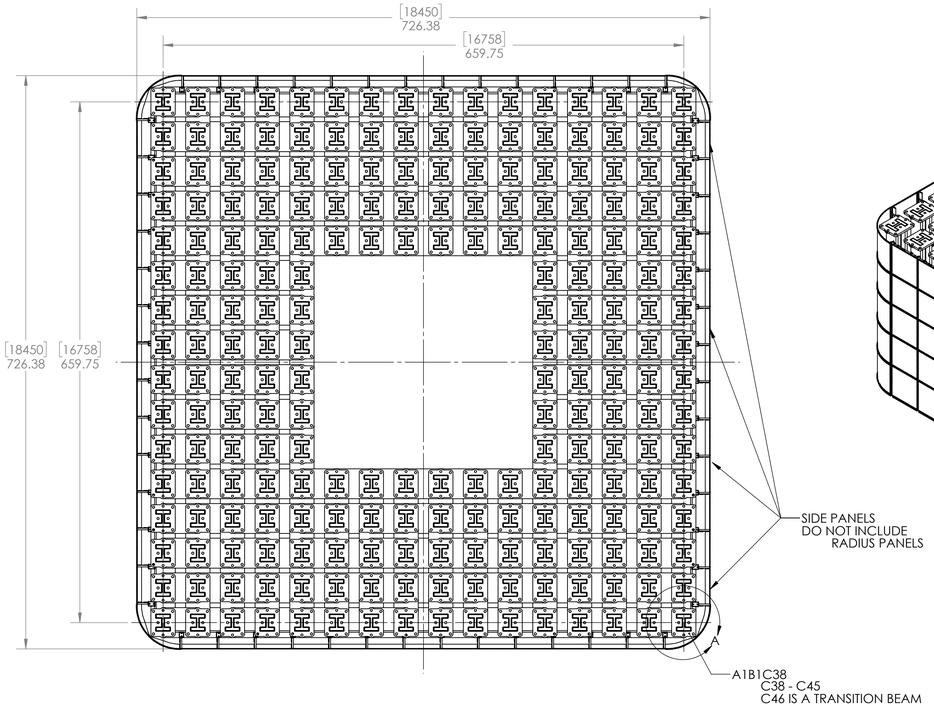
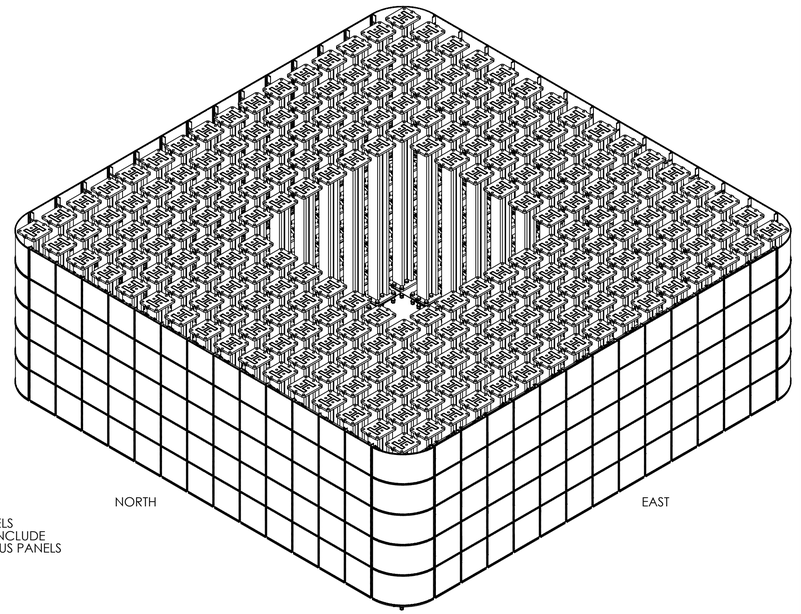
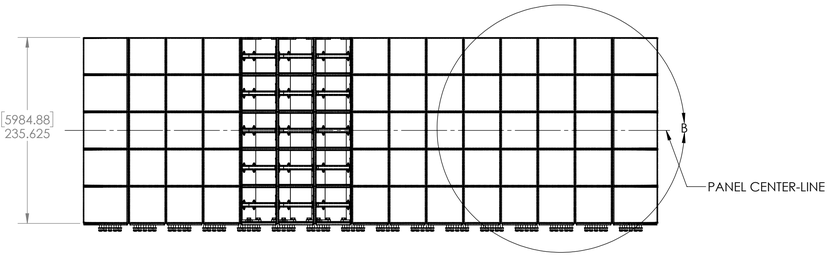
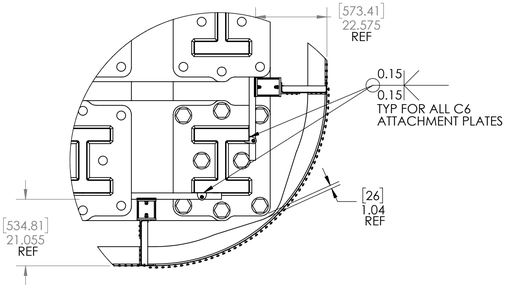
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT	QTY.
1	Panel sq 47.125in 20200513 w550			260
2	Rivet Brazier head for Panel 20200510 w550			26640
3	Rib 31 20210118 w550			280
4	L2x2x0.125 3 20210118 w550			280
5	L2x2x0.125 3 20210118 w550			280
6	Plate Pnl sup 2 20210118 w550			280
7	Rivet Brazier 2t +0.0625 20210107 w550			1680
8	Rivet Brazier t+0.313+0.0625 20210104 w550			1680
9	LS6x3.5x0.312 2 20210118 w550			280
10	W6x9 1 20210118 w550			140
11	Plate pnl sup 3 20210118 w550			560
12	Shim Plate 30 1 pnl 20210120 w550			280
13	Shim Plate 30 2 pnl 20210120 w550			280
14	Shim Plate 30 3 pnl 20210120 w550			280
15	Shim Plate 30 4 pnl 20210120 w550			280
16	Plate pnl was 1 20210120 w550			280
17	91286A377			1120
18	98180A150			4640
19	93827A249			2320
20	93839A825			3520
21	Rib 32 20210118 w550			260
22	Rivet Brazier 3t 20200514 w550			1680
23	W6x9 1 20210118 w550			140
24	Rib Radius 3 20200515 w550			20
25	Rib Radius 30 20210120 w550			20
26	W14x550 1 20210129			220
27	Plate w14x550 20210524			440
28	bolt 2.75in HD 1 20210524			1760
29	nut 2.75in HD 1 20210524			1760
30	wash 2.75in HD 1 20210524			3520
31	nut 2.75in HD 1 half 20210524			1760
32	C6x10.5 2 20210312 w550			300
33	Plate bolt hold 1 20210312 w550			600
34	Plate bolt hold 2 20210315 w550			600
35	Plate C6bk 1 20210315 w550			1200
36	Thread rod madetoOrd 0.5x12 - 20tpi w550			600
37	Plate connect 1 20210524 w550			198
38	Plate connect 2 20210524 w550			198
39	Shim Plate conct 1 20210524 w550			4
40	Shim Plate conct 1 20210524 w550			80

TOTAL WEIGHT W/O OXIDATION PROTECTION = 2,871,210[LBF]
TOTAL WEIGHT WITH WELDING AND GALVINIZATION = 3,004,000[LBF]

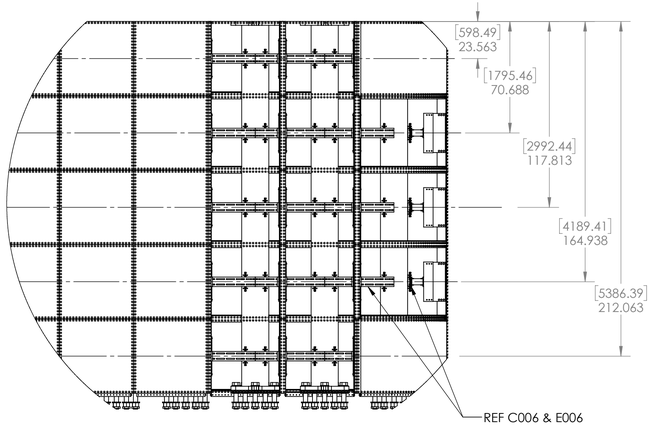








DETAIL A
SCALE 1 : 24



DETAIL B
SCALE 1 : 48

NOTE/S:
NO SHARP EDGES/CORNERS
BEAM/S
- W14, ASTM A913 G65, Sy 65[KSI]
- W6, Sy 42[KSI]
- C6, Sy 36.3[KSI]

PLATES AISI 1045, Sy 75[KSI]
OXIDATION PROTECTION POST WELDING/ASSEMBLY
- ALUMINIZATION TYPE I (PREF)
- GALV, ASTM 123, G100
- MASK-OFF MATING SURFACES
- MASK-OFF BOLT HOLES
- OIL-SHEEN, SAE 50+, PRIOR TO ASM
- NO AGGLOMERATION OF OIL

BOLT/S ASM G8, GALVINIZED OR TYPE II
MATING SURFACE TO BE PROTECTED FOR SHIPPING
- POLY-FILM OR OTHER

PANELS/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 PANELS/SKIN/SHELL ANODIZED
    - RGB (26.4, 48.7, 54.6)
    - VERIFIED IN NATURAL LIGHT
- AL, T6061-T6, Sy 40[KSI]
- RIVETS, AL ALLOY

CLASS B, AS-BUILT
CAD/DATA IS MASTER

EXAMPLE AMBIENT TEMP [F]	EXAMPLE AMBIENT TEMP [C]	T6061-T6 (SI) PTE (0.0001in)	T6061-T6 (SI) PTE (0.0001mm)
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[IN/-59]47.125
dL = 0.0161[IN] (0.4234[mm])

AT 86[F] THE DIMENSION OF THE PART IS 47.125 + 0.0161 =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[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
W14x550 STD SEG ASM FOR MAIN BODY

SIZE	DWG. NO.	REV
D	F - 001	1

SCALE: 1:96 | SHEET 1 OF 1