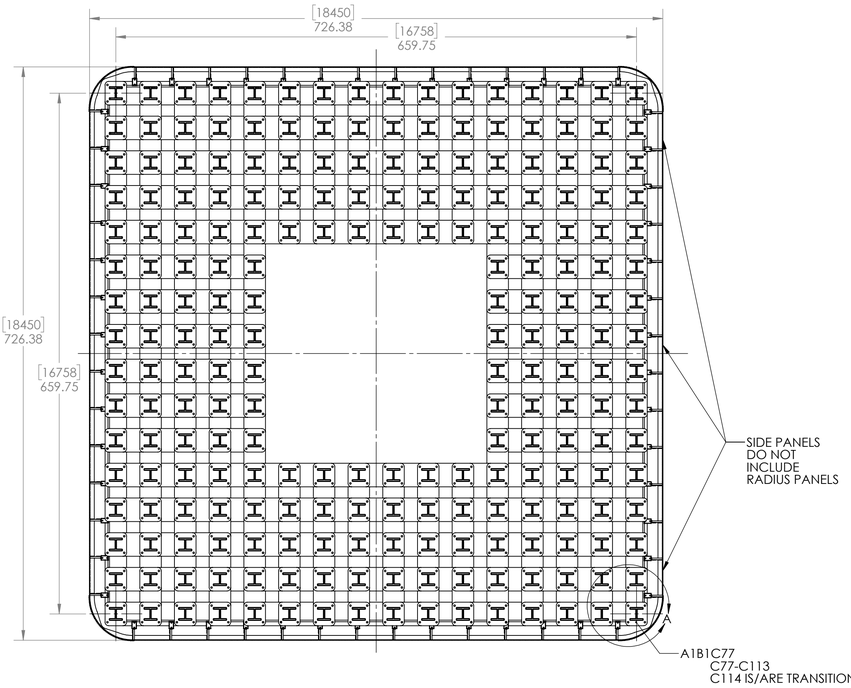
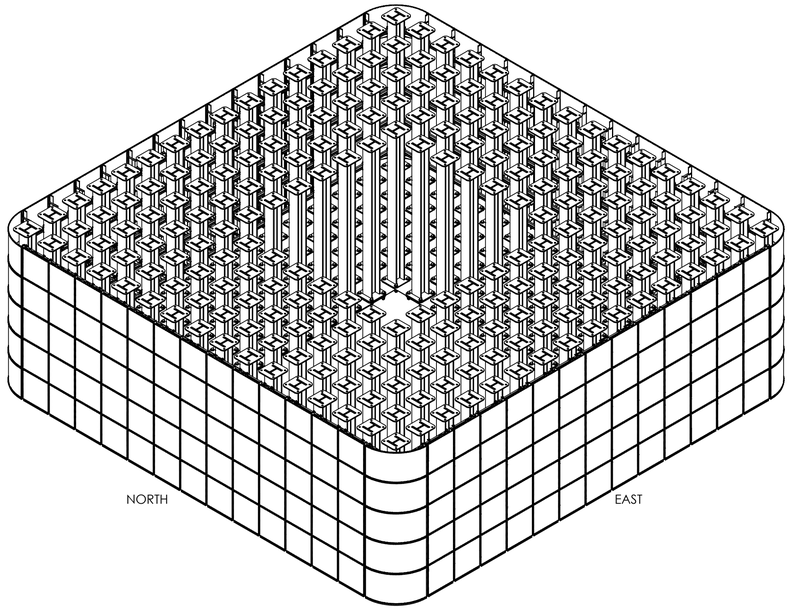
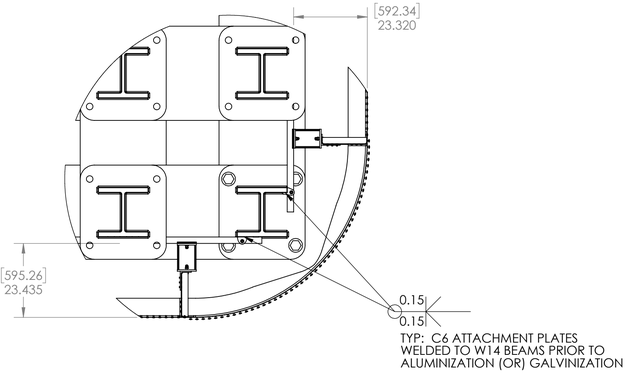
| ITEM NO. | PART NUMBER | DESCRIPTION | WEIGHT | QTY. |
|---|---|---|---|---|
| 1 | Panel sq 47.125in 20200513 w550 w455 w370 w283 w193 | | | 260 |
| 2 | Rivet Brazier head for Panel 20200510 w550 w455 w370 w283 w193 | | | 26640 |
| 3 | Rib 31 20210118 w550 w455 w370 w283 w193 | | | 280 |
| 4 | L2x2x0.125 3 20210118 w550 w455 w370 w283 w193 | | | 280 |
| 5 | L2x2x0.125 3 20210118 w550 w455 w370 w283 w193 | | | 280 |
| 6 | Plate Pnl sup 2 20210118 w550 w455 w370 w283 w193 | | | 280 |
| 7 | Rivet Brazier 2t +0.0625 20210107 w550 w455 w370 w283 w193 | | | 1680 |
| 8 | Rivet Brazier t+0.313+0.0625 20210104 w550 w455 w370 w283 w193 | | | 1680 |
| 9 | LS6x3.5x0.312 2 20210118 w550 w455 w370 w283 w193 | | | 280 |
| 10 | W6x9 1 20210118 w193 | | | 140 |
| 11 | Plate pnl sup 3 20210118 w550 w455 w370 w283 w193 | | | 560 |
| 12 | Shim Plate 30 1 pnl 20210120 w550 w455 w370 w283 w193 | | | 280 |
| 13 | Shim Plate 30 2 pnl 20210120 w550 w455 w370 w283 w193 | | | 280 |
| 14 | Shim Plate 30 3 pnl 20210120 w550 w455 w370 w283 w193 | | | 280 |
| 15 | Shim Plate 30 4 pnl 20210120 w550 w455 w370 w283 w193 | | | 280 |
| 16 | Plate pnl was 1 20210120 w550 w455 w370 w283 w193 | | | 280 |
| 17 | 91286A377 | | | 1120 |
| 18 | 98180A150 | | | 4640 |
| 19 | 93827A249 | | | 2320 |
| 20 | 93839A825 | | | 3520 |
| 21 | Rib 32 20210118 w550 w455 w370 w283 w193 | | | 260 |
| 22 | Rivet Brazier 3t 20200514 w550 w455 w370 w283 w193 | | | 1680 |
| 23 | W6x9 1 20210118 w193 | | | 140 |
| 24 | Rib Radius 3 20200515 w550 w455 w370 w283 w193 | | | 20 |
| 25 | Rib Radius 30 20210120 w550 w455 w370 w283 w193 | | | 20 |
| 26 | W14x193 1 20210528 | | | 220 |
| 27 | Plate w14x193 20210528 | | | 440 |
| 28 | bolt 2in 4tpi 10in DH3 1 20210528 w193 | | | 880 |
| 29 | nut 2in 4tpi HD 1 20210527 w193 | | | 880 |
| 30 | wash 2in HD 1 20210528 w193 | | | 1760 |
| 31 | nut 2in 4tpi HD 1 half 20210528 w193 | | | 880 |
| 32 | C6x10.5 2 20210312 w455 w370 w283 w193 | | | 300 |
| 33 | Plate bolt hold 1 20210312 w455 w370 w283 w193 | | | 600 |
| 34 | Plate bolt hold 2 20210315 w455 w370 w283 w193 | | | 600 |
| 35 | Plate C6bk 1 20210315 w455 w370 w283 w193 | | | 900 |
| 36 | Thread rod madetoOrd 0.5x12 - 20tpi w550 w455 w370 w283 w193 | | | 600 |
| 37 | Plate connect 1 20210527 w193 | | | 198 |
| 38 | Plate connect 2 20210527 w193 | | | 198 |
| 39 | Shim Plate conct 1 20210527 w193 | | | 4 |
| 40 | Shim Plate conct 1 20210527 w193 | | | 80 |

TOTAL WEIGHT W/O OXIDIATION PROTECTION = 1,110,833[LBF]
TOTAL WEIGHT W/ GALVINIZATION AND WELDING = 1,173,000[LBF]

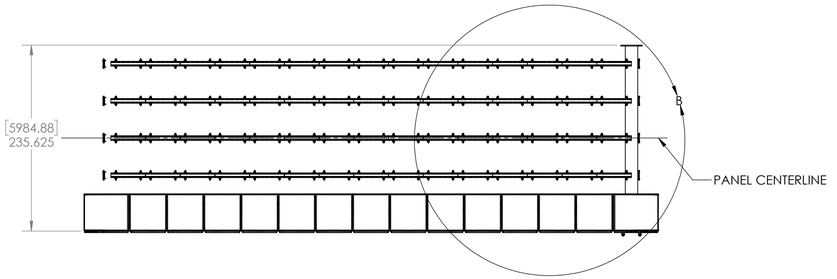


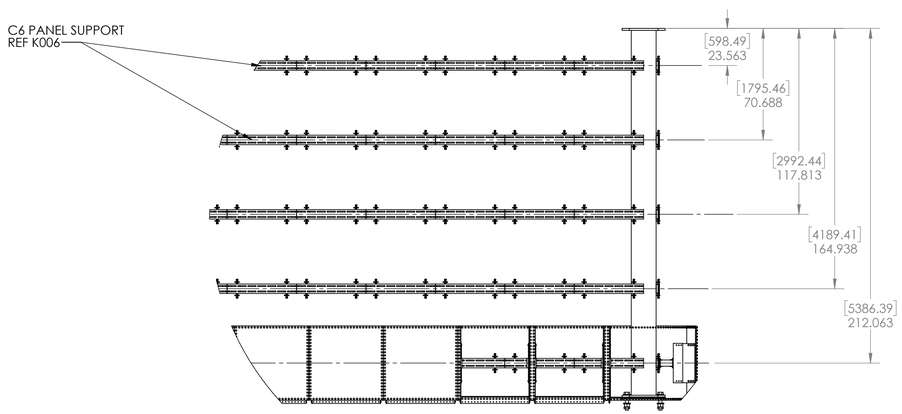




TYP: C6 ATTACHMENT PLATES
WELDED TO W14 BEAMS PRIOR TO
ALUMINIZATION (OR) GALVINIZATION

DETAIL A
SCALE 1 : 24




DETAIL B
SCALE 1 : 48

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]
OXIDATION 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 (EAST/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] | 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 | 8.994 |

EXAMPLE:
LET DIM = 47.125[IN] (T6061-T6)
dL = 0.000013186 - 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[IN]
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
W14x193 STD SEG ASM
FOR MAIN BODY

| SIZE | DWG. NO. | REV |
|---|---|---|
| D | K - 001 | 1 |
| SCALE: 1:96 | | SHEET 1 OF 1 |