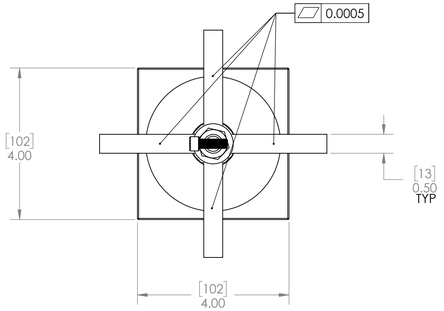
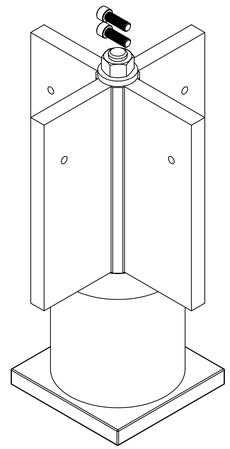
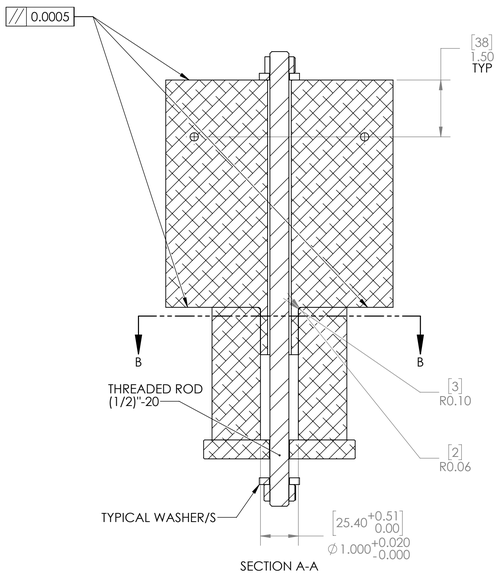
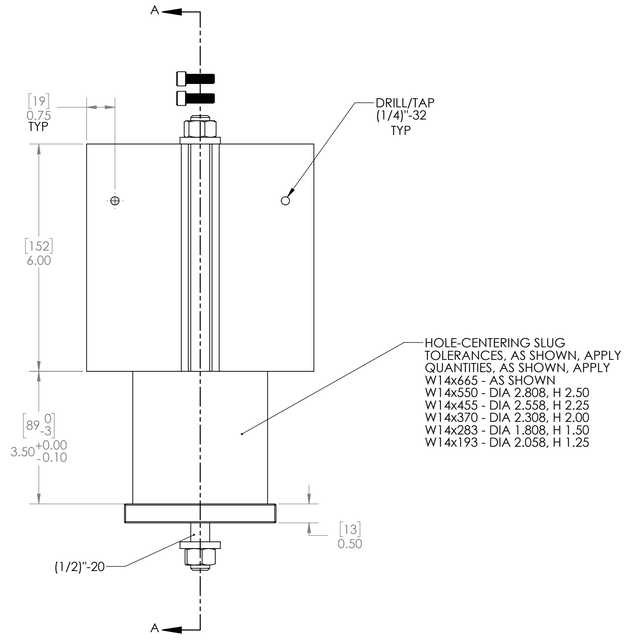
ITEM NO.	PART NUMBER	DESCRIPTION	WEIGHT [LBF]	QTY.
1	Level Align 1 20210427 S1	HOLE-CENTERING FOR LEVELING GUIDE FIXTURE	8.1	1
2	Level Align 2 20210427 S1	HOLE-CENTERING SLUG DIAMETER CHANGES PER BEAM-PLATE		1
3	Level Align 3 20210427 S1			1
4	Thred rod ASM 1 0.5x12in 20tpi 20210315 S1	OXIDIZED STEEL		1
	6516K287			1
	93827A249			2
	98180A150			2
5	90044A204	SOCKET HEAD SCREW 0.25[IN] 0.75[IN]-32[TPI]		2

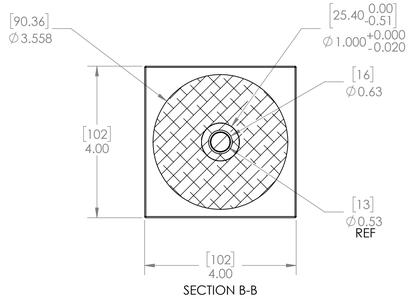
(x256) RECOMMENDED
(x84) MINIMUM

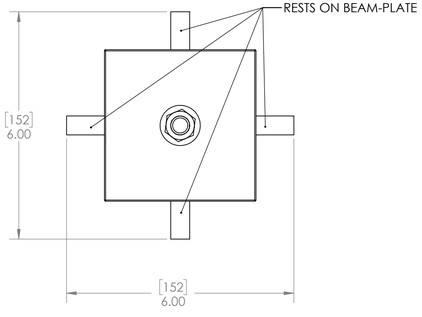












NOTES:
MATERIAL: ALUMINUM ALLOY, T6061-T6 PREFERED
NO SHARP EDGES, DULLED TO MINIMUM (1/128)"
NORMAL HANDELING AND PLACEMENT
CANNOT ALTER FIXTURE. DROP FROM 3[FT] WITHOUT ALTERING FLATNESS AND PARELLELISM.
ALL WELDS ARE AT THE DESCRETION OF THE SUPPLIER.
SHOULD TOLERANCES BE TOO TIGHT
SUPPLIER TO STATE & QUOTE PER THEIR TIGHTEST
SCREWS/RODS/WASHERS/NUTS ARE OXIDIZED (PREFERED) OR GALVINISED STEEL

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 = 0.000013 [(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[5%]
ANGULAR: 0.3[30'0]
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
HOLE-CENTERING FIXTURE 1

SIZE	DWG. NO.	REV
D	B - 006	1

SCALE: 1:2 | SHEET 1 OF 1