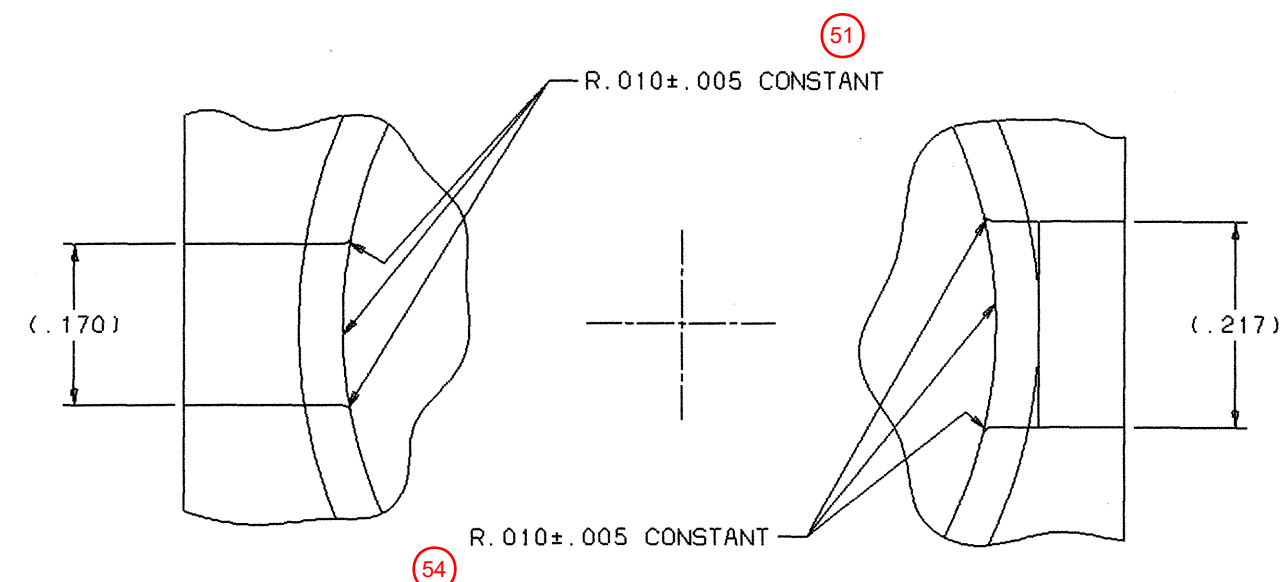
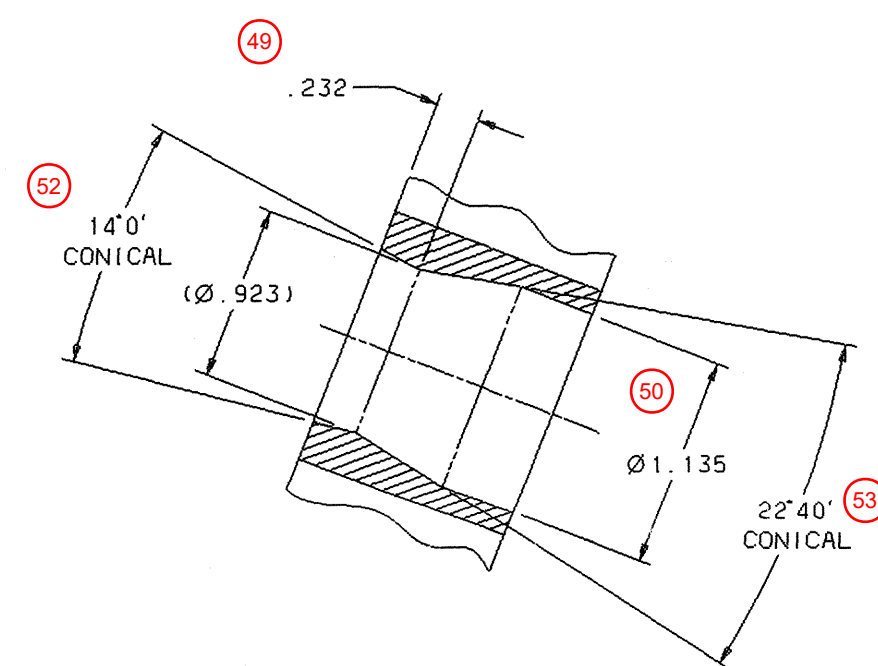


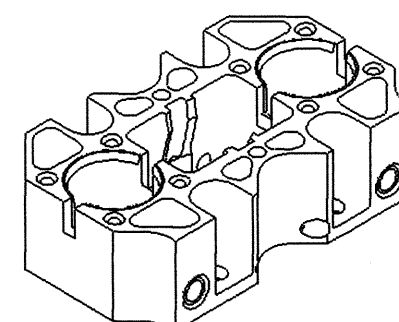
-1 SHOWN
-2 SAME AS -1 EXCEPT AS SHOWN ON SH3



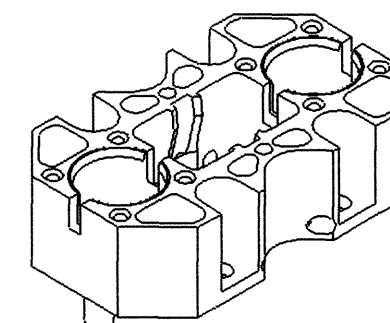
VIEW H
SCALE: 10/1
2 PLACES



SECTION C-C
2 PLACES



ISOMETRIC VIEW
SCALE: NONE
FOR REFERENCE ONLY
-2 SHOWN



ISOMETRIC VIEW
SCALE: NONE
FOR REFERENCE ONLY
-1 SHOWN

PRODUCT DATA
MANAGEMENT OFFICE

MAR 01 2010

VERIFY REVISION STATUS
BLDG. M4 RELEASED COPY

NOTES: UNLESS OTHERWISE SPECIFIED

1. PART IDENTIFICATION MARKING PER PR12-6-0900.
2. FABRICATE PER M120701.
3. HEAT TREAT -12 TO H1000 PER PR11-7-14 PRIOR TO 4.
4. PASSIVATE -12 PER PR2-9-1 PRIOR TO 7.
5. SOLUTION HEAT TREAT AND AGE -11 AND -13 PER PR11-1-3 PRIOR TO 7.
6. CLEAN -11 AND -13 FOLLOWING 5 AND PRIOR TO 7 AS FOLLOWS:
1. IF EDM IS USED, CLEAN EDM RECAST LAYER PER PR2-17-04 PRIOR TO MACHINING FEATURES WITH A TOTAL TOLERANCE LESS THEN .010.
2. CLEAN ENTIRE PART PER PR2-17-01.
7. APPLY GREEN LOCKTITE PER PR4-20-1 EVENLY AROUND OUTSIDE OF -12 SLEEVE OR INSIDE OF 1.0830 Ø BORE. PRESS SLEEVE INTO BODY. BODY TEMP MAY BE ELEVATED TO 300° F MAX AND SLEEVE TEMP MAY BE REDUCED TO -250° F MIN TO AID PRESSING OPERATION. WIPE OFF EXCESS LOCKTITE USING TT-1-735 ISOPROPYL ALCOHOL.
8. MACHINE AFTER PERFORMING 7.
9. DRY FILM LUBE ALL SURFACES EXCEPT THOSE NOTED IN 14 PER PR6-20-1-1, EXCEPT DO NOT ANODIZE THE PART. DRY FILM SHALL BE PER C600541-1.
10. DELETED.

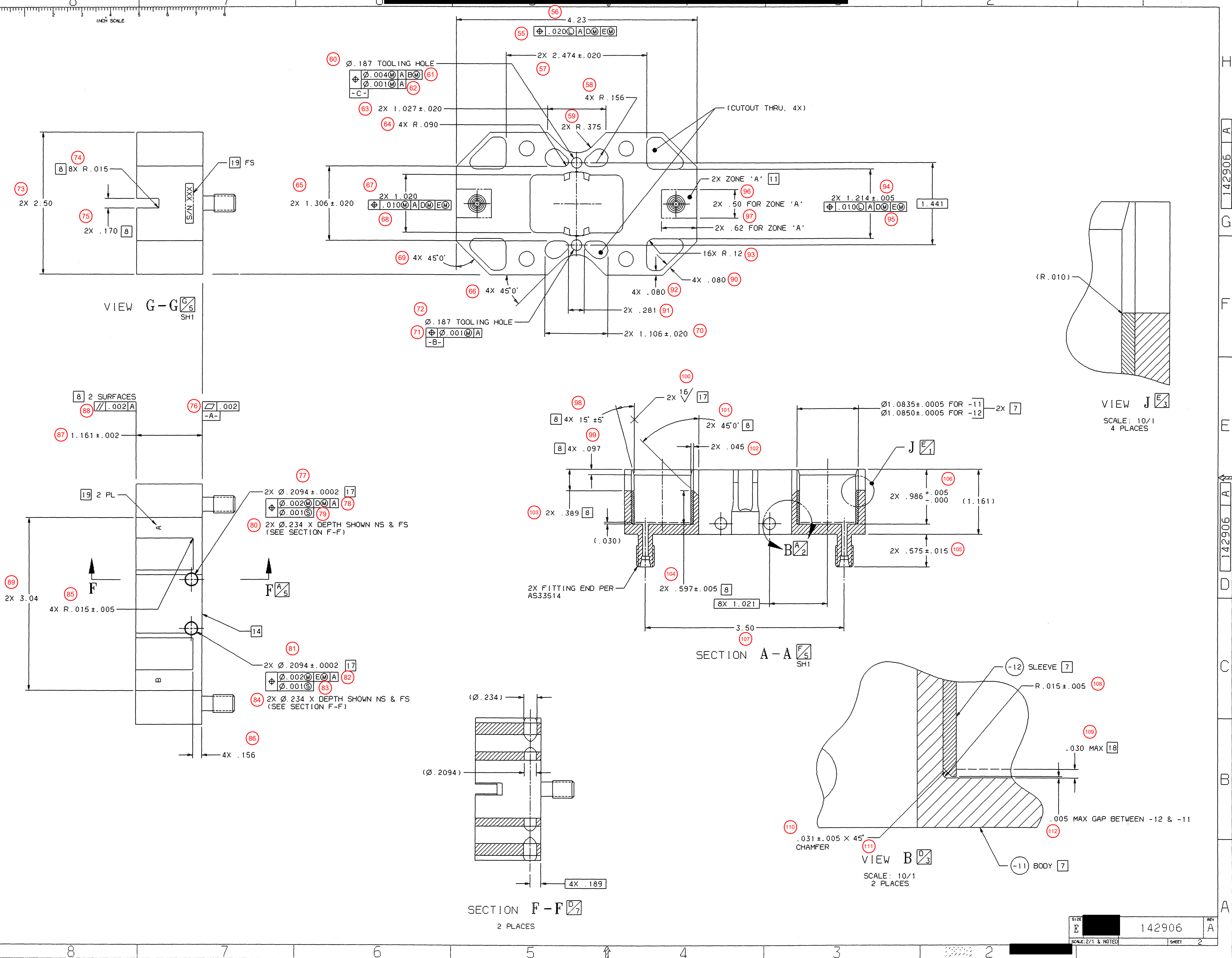
11. .002 FLATNESS REQUIREMENT DOES NOT APPLY OVER ZONE 'A'.
12. SIMILAR TO 137902 AND 139006.
13. FILLET R.015.
14. NO DRY LUBE ON THIS SURFACE.
15. NO USAGE SCHEDULED AT THIS RELEASE.
16. MACHINE AFTER PERFORMING 8.
17. THIS IS A CRITICAL SURFACE FINISH OR DIMENSION AND ACTUAL VALUE SHALL BE RECORDED IN D27261.
18. PERMISSIBLE TO HAVE 8% SURFACE FINISH AND Ø.9900 ±.0005/-0.0010 BORE SIZE IN THIS AREA ONLY.
19. MARK DETAIL WITH MANUFACTURING SERIAL NUMBER AND BORE IDENTIFICATION LETTERS PER PR12-6-1000. LOCATE APPROXIMATELY AS SHOWN.
20. FINAL Ø.9900±.0005 DIMENSION SHALL BE ACHIEVED BY HONING INTERNAL BORE DIAMETER BY A MINIMUM OF .001.

LAST SECTION OR VIEW LETTER USED: J

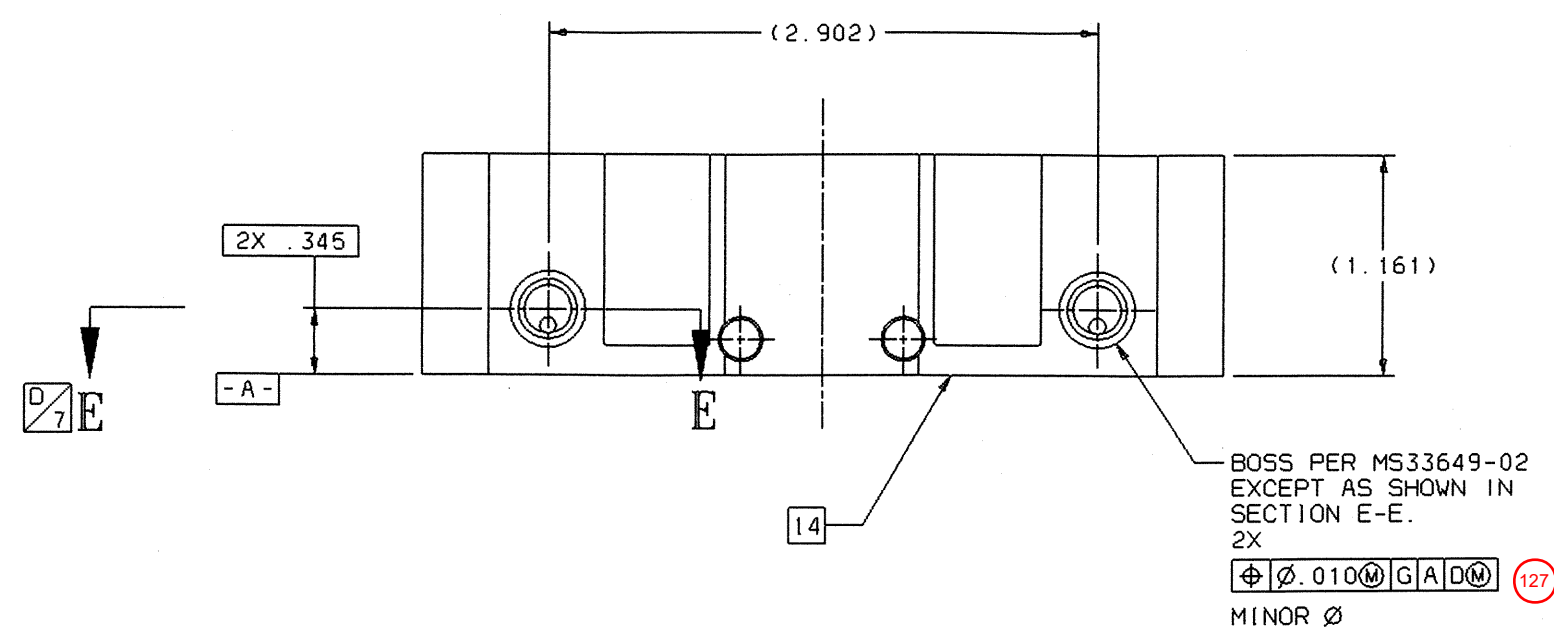
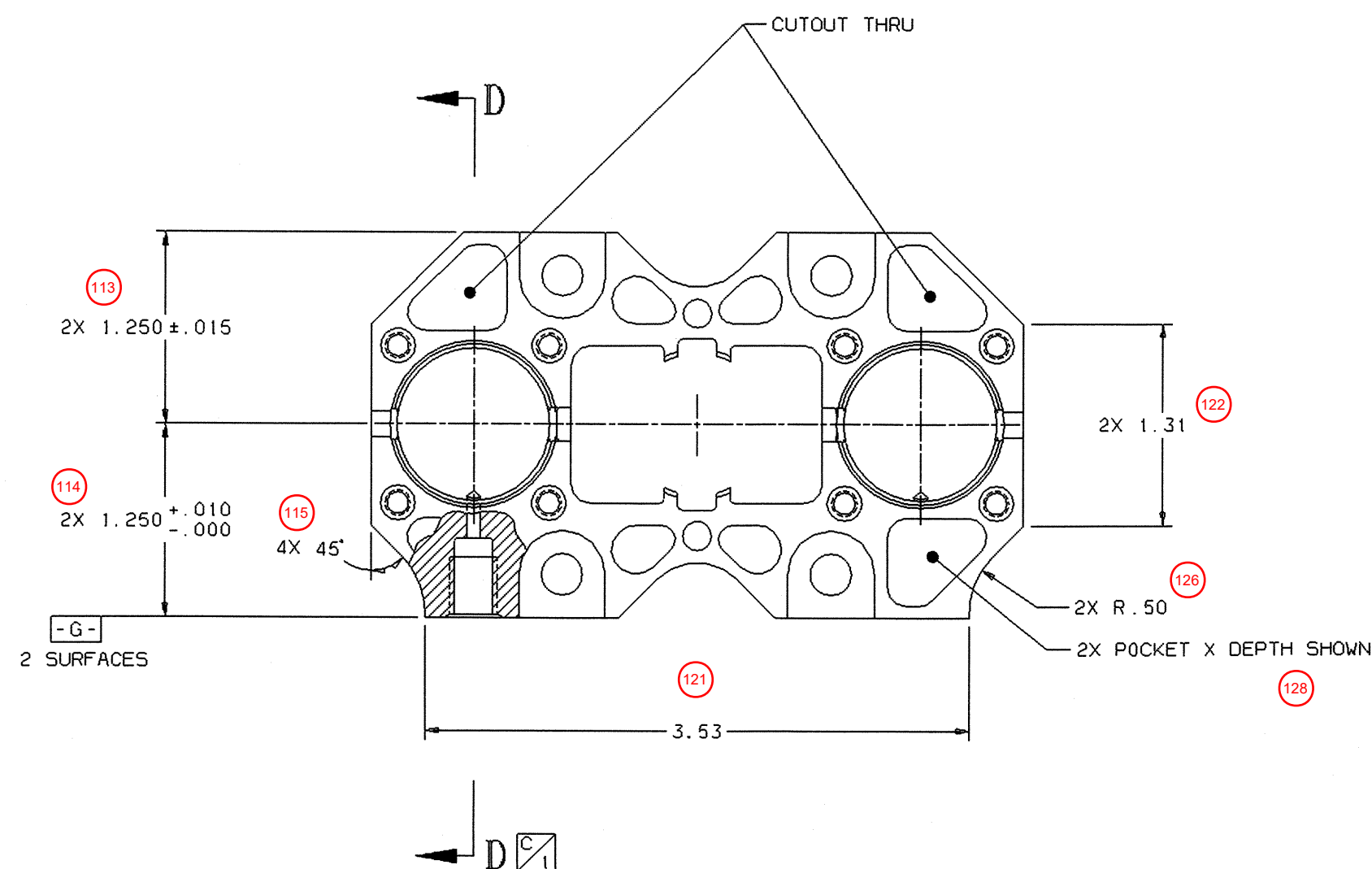
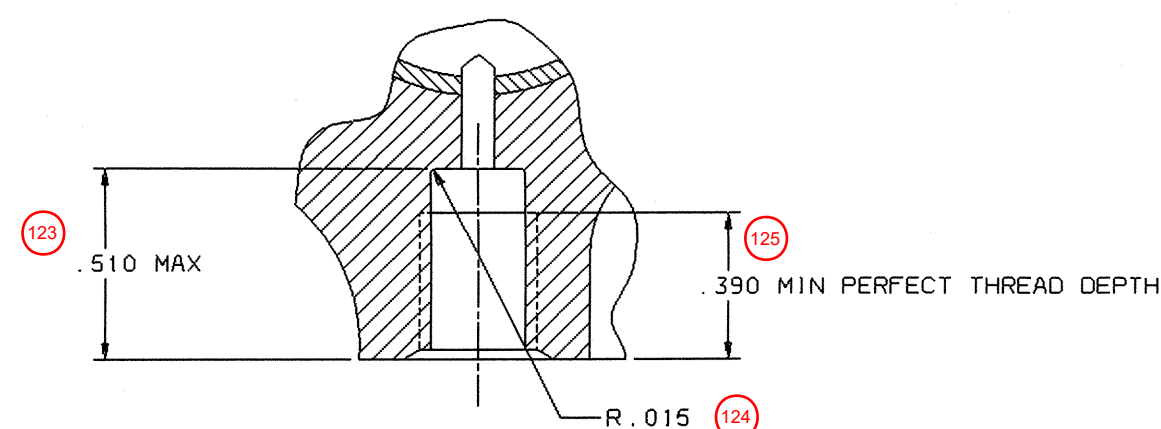
CRITICAL DIMENSION PART

5		1	-13	BODY	1.250 THK, 6AL-4V TI-ALY-PLATE, AB-1, COND A (6N0400-0134-268)	MIL-T-9046						
3	4	2	2	-12	SLEEVE	Ø1.250 CRES CUSTOM 455 ROD, COND A (6L0600-1734-520)	AMS 5617					
5		1	-11	BODY	2.000 THK, 6AL-4V TI-ALY-PLATE, AB-1, COND A (6N0400-0134-274)	MIL-T-9046						
		-2	-1	QTY RECD PER ASSY	ONE CODE	PART OR IDENTIFYING NO.	DESCRIPTION OR DESCRIPTION	MATERIAL	SPEC.	REF. DES.	ZONE	ITEM NO.

UNLESS OTHERWISE SPECIFIED												PARTS LIST																																			
NOT SCALE DRAWING. TEMPERATURE PER 000-510-100 DIMENSIONS ARE IN INCHES. SURFACE FINISH SHALL BE PER BURR AND SHARP EDGES. DIMENSIONS APPLY BEFORE PLATING. CONVERSION CHART: DIMENSIONAL DATA IS A REFERENCE ONLY.												TOLERANCES ON ALL HOLE DIAMETERS UNDER .0140 +.0001 -.0005 .014 THRU .125 +.004 -.003 .126 THRU .250 +.005 -.001 .261 THRU .500 +.005 -.001 OVER 2.000 +.015 -.005												THE FOLLOWING GD&S HAVE BEEN ATTACHED TO THIS PRINT												TRW											
R11-7 027261												BODY, TYPE 11-B PRO																																			
20701 PR2-9																																															
R4-20 PR2-17																																															
R12-6 PR11-1																																															
FINISH												9												SIZE												E											
HEAT TREAT												3												SCALE 2:1 & NOTED												142906											
																																				SHEET 211 OF											



INCH SCALE



-2 SAME AS -1 EXCEPT AS SHOWN

