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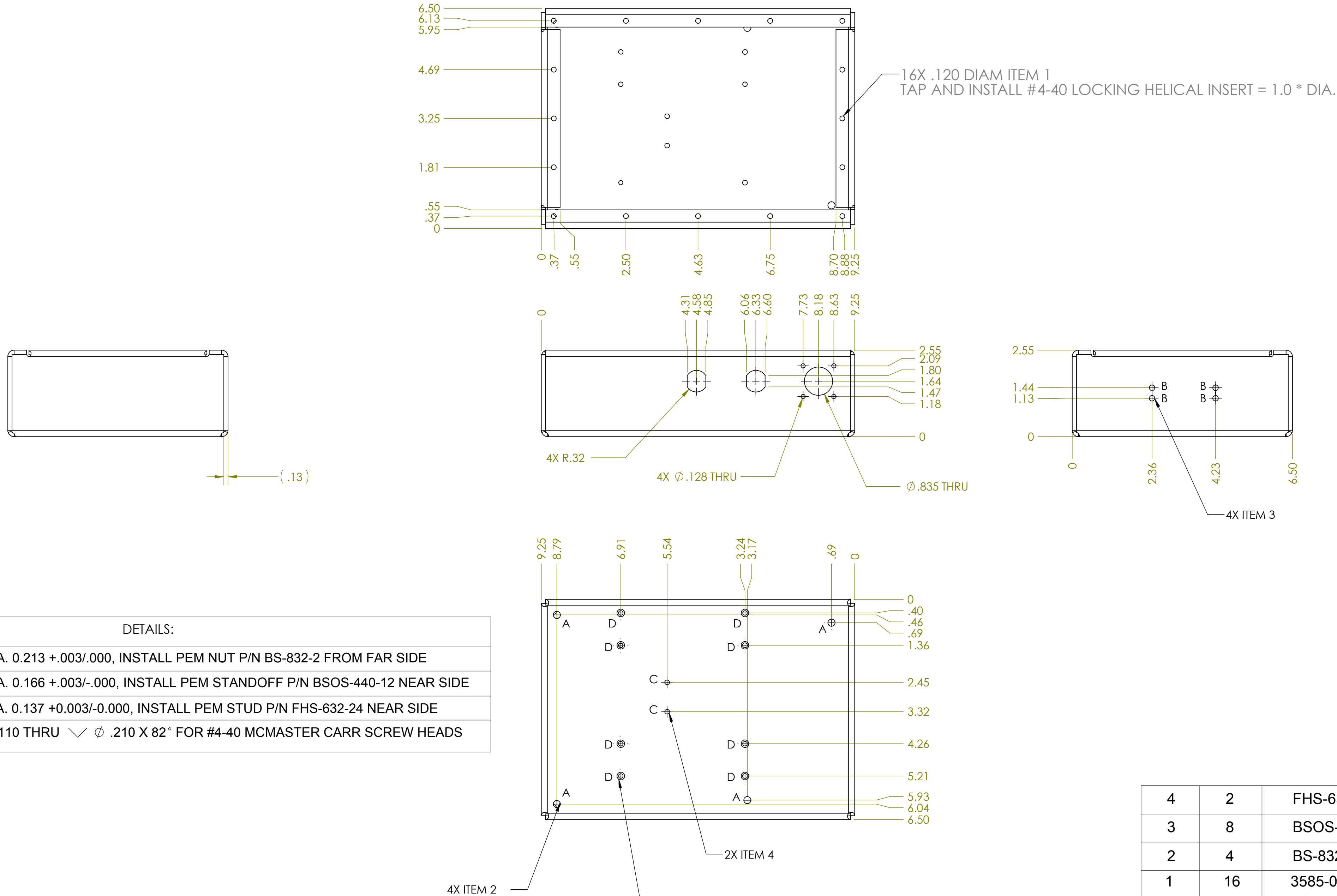
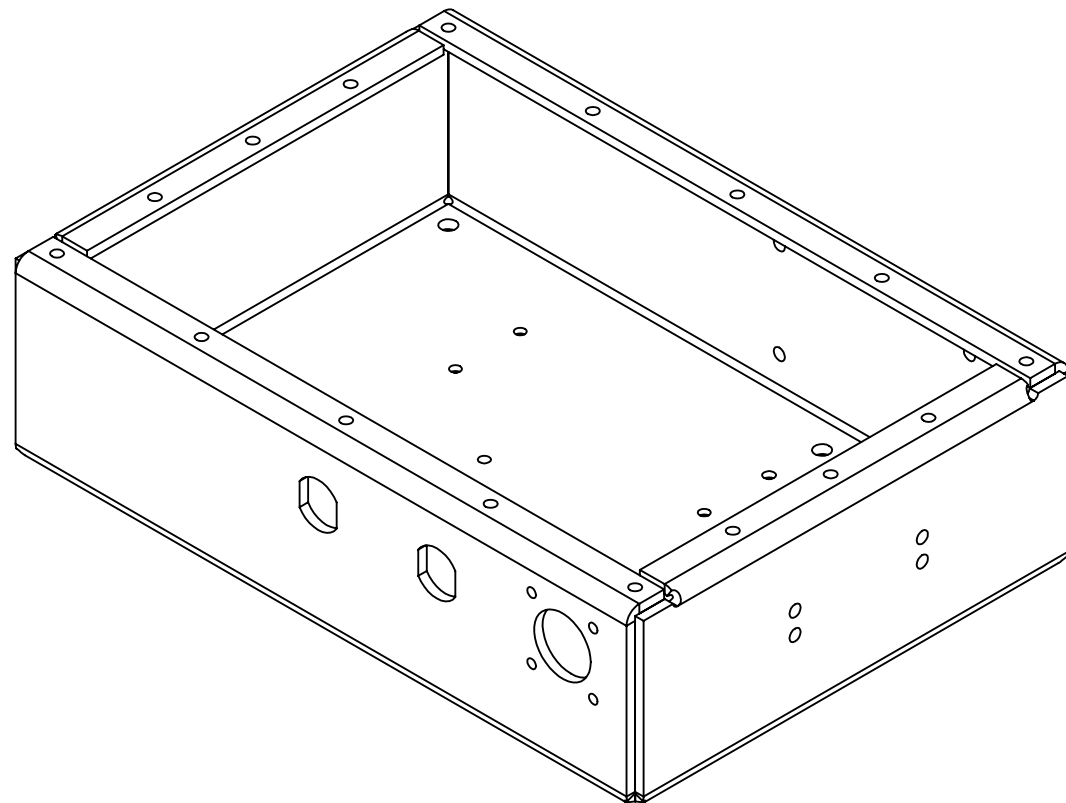
B

A

REVISION HISTORY				
ZONE	REV	DESCRIPTION	APPR	DATE
ALL	3	ECN: XXX CHANGE HOLE SIZE DETAIL D FROM 6-32 TO 4-40 CSINK HOLES. CHANGE ITEM 2 TO BLIND INSERTS.	XXX	XX-XX-XX

NOTES:

1. MATERIAL: ALUMINUM ALLOY 5052 PER ASTM-B209.
2. ALL INSIDE CORNER RADII SHALL BE 0.063 MAX
3. WELD ALL CORNERS AFTER BENDING
4. FINISH: CHEMICAL CONVERSION COAT PER MIL-C-5541E, CLASS 1A, COLOR GOLD.  
INSTALL HARDWARE AND PAINT TOP AND SIDE SURFACES WITH POLANE WHITE. DO NOT PAINT BOTTOM



HOLE#	DETAILS:
A	DRILL DIA. 0.213 +.003/.000, INSTALL PEM NUT P/N BS-832-2 FROM FAR SIDE
B	DRILL DIA. 0.166 +.003/- .000, INSTALL PEM STANDOFF P/N BSOS-440-12 NEAR SIDE
C	DRILL DIA. 0.137 +0.003/-0.000, INSTALL PEM STUD P/N FHS-632-24 NEAR SIDE
D	DRILL $\phi$ .110 THRU $\sphericalangle$ $\phi$ .210 X 82° FOR #4-40 MCMASTER CARR SCREW HEADS

4	2	FHS-632-24	PEM	STUD, FLUSH, #6-32 X 1.50L	EA
3	8	BSOS-440-12	PEM	STANDOFF, BLIND, #4-40 X .375L	EA
2	4	BS-832-2	PEM	NUT, INSERT BLIND, #8-32	EA
1	16	3585-04CN-0112	HELICOIL	INSERT, LOCKING, #4-40 X 1D	EA
ITEM NO.	QTY	PART NO.	SUPPLIER	DESCRIPTION	U/M

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<div>THIRD ANDLE PROJECTION IN ACCORDANCE WITH ASME Y14.5</div> <div>UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR +/- 5 BEND +/- .3 TWO PLACE DECIMAL +/- .01 THREE PLACE DECIMAL +/- .005</div>		ORIG. ENG.SKETCH NO: XX-XX-XX		<div>UAV SOLUTIONS</div> <div>8280 PATUXENT RANGE RD. SUITE E JESSUP, MD 20794 PHONE: 240-456-0195 EMAIL: <a href="mailto:info@uav-solutions.com">info@uav-solutions.com</a></div> <div>TITLE: <b>TRACKER BOX</b></div>	
		INITIALS	DATE		
		DRAFTER: RGB	05-13-11		
		CHECKER: XXX	XX-XX-XX		
NEXT ASSY		USED ON		SIZE: <b>D</b>	DWG NO: <b>06A-0049-00</b>
APPLICATION		WORKMANSHIP PER QOP ISO STD 001-XXXX		CAGE CODE: <b>61F14</b>	SCALE: 1:2
				SHEET 1 OF 1	