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DWG NO
DC2223013

SH 1

1

NOTES: UNLESS OTHERWISE SPECIFIED

1. THIS DRAWING SHALL BE INTERPRETED IAW ASME Y14.100-2017.

2. MATERIAL: SEE SEPARATE PARTS LIST.

3. PART TO BE MANUFACTURED USING THIS DRAWING AND SPECIFIED CAD/CAM DATA FILE. PART IS MODELED AT NOMINAL SIZE.

4. ALL FEATURE SIZES, TOLERANCES AND LOCATIONS SHALL BE IAW THIS DRAWING AND THE CAD/CAM DATA FILE. DIMENSIONAL VALUES OF GEOMETRY DERIVED FROM THE CAD/CAM DATA FILE REPRESENT A BASIC DIMENSION UPON WHICH A TOLERANCE IS APPLIED. UNLESS OTHERWISE SPECIFIED ON THE DRAWING, THE FOLLOWING TOLERANCES SHALL APPLY:
A) PROFILE TOLERANCE FOR ALL UNSPECIFIED SURFACES TO BE:
B) POSITIONAL TOLERANCE FOR ALL UNSPECIFIED HOLES AND COUNTERSINKS TO BE:
5. ALL DISPLAYED DIMENSIONS ARE CRITICAL TO FUNCTION.

6. DIMENSIONS AND TOLERANCES SHOWN ON THIS DRAWING TAKE PRECEDENCE OVER SUPPLIED CAD/CAM DATA FILE.

7. INSPECTION REQUIREMENTS
A) USE THIS DRAWING AND APPLICABLE CAD/CAM DATA FILE TO INSPECT PART.
B) MINIMUM INSPECTION REQUIREMENTS:
1) ALL DIMENSIONS AND TOLERANCES SHOWN ON THIS DRAWING.
2) QUALITY OF FINISH IAW APPLICABLE FINISH SPECIFICATION.
3) ALL TAPPED HOLES SHALL BE GAGED PRIOR TO INSERT INSTALLATION.
4) AFTER FINISH, ALL BLIND TAPPED HOLES SHALL BE INSPECTED FOR DEBRIS.
C) INSPECTION CONDITION: PART MAY BE CONSTRAINED ALONG DATUM A.

8 IDENTIFICATION OF THE APPROVED SOURCE(S) OF SUPPLY IS NOT TO BE CONSTRUED AS A GUARANTEE OF PRESENT OR CONTINUED AVAILABILITY AS A SOURCE OF SUPPLY FOR THE ITEM DESCRIBED ON THIS DRAWING.

9. DIMENSIONS APPLY AFTER FINISHING AND PLATING.

10 FINISH: CHEM FILM IAW MIL-DTL-5541, CL 3. ALL SURFACES AND HOLES.

NOTES CONTINUED ON SH 2

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APPROVED SOURCE(S) OF SUPPLY 8

CAD/CAM DATA FILE	PART NUMBER	NATIVE CAD FILE	VENDOR
DC2223013-1_1.IGS DC2223013-1_1.STP	DC2223013-1	DC2223013_1.ZIP	PROCURE ONLY FROM MBPD APPROVED SUPPLIER LIST
DC2223013-2_1.IGS DC2223013-2_1.STP	DC2223013-2	DC2223013_2.ZIP	PROCURE ONLY FROM MBPD APPROVED SUPPLIER LIST
DC2223013-3_1.IGS DC2223013-3_1.STP	DC2223013-3	DC2223013_3.ZIP	PROCURE ONLY FROM MBPD APPROVED SUPPLIER LIST

UNSPECIFIED FEATURE CONTROL

FILLET RADII	R.01 ±.005	MODELED AS SHARP
BREAK SHARP EDGES	.005 - .015	MODELED AS SHARP
HOLE TOLERANCES	PER DRAWING TITLE BLOCK	MODELED AS NOMINAL
CHAMFERS AND C'SINK INCLUDED ANGLES	±1°	MODELED AS NOMINAL
DEPTH OF BLIND HOLES AND C'BORES	±.005	MODELED AS NOMINAL
THREADED HOLES	CLASS 3B THREAD	MODELED AT MAJOR DIA

REVISIONS

REV	DESCRIPTION	DATE	APPROVED
1	ENGINEERING DEVELOPMENT	20130319	ON FILE
2	-2 CONFIGURATION ADDED TO SH 5. ADDED FLAG NOTE 18. UPDATED FLAG NOTE 11. MS	20181211	ON FILE
3	-3 CONFIGURATION ADDED WHICH DOES NOT INCLUDE -1 BUSHINGS. MS		ON FILE

PROTOTYPE RELEASE ONLY
UNCONTROLLED COPY
USER MUST VERIFY CURRENT
REVISION PRIOR TO USE

CRITICAL TO FUNCTION DRAWING

ONLY CRITICAL FEATURES ARE DEFINED ON THIS DRAWING. THIS SIMPLIFIED DRAWING AND APPLICABLE CAD/CAM DATA FILE MUST BE USED FOR COMPLETE PART DEFINITION AND FINAL ACCEPTANCE.

SEE SEPARATE PARTS LIST

QTY	REQD	PER ASSY	CAGE CODE	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPEC	REF DES	FIND NO	
UNLESS OTHERWISE SPECIFIED			PARTS LIST							
1. DIMENSIONS ARE IN INCHES.			TOLERANCES			DO NOT SCALE DRAWING				
2. SURFACE TEXTURE SHALL BE 64			ON ALL HOLE DIAMETERS			CONTRACT NO.				
3. DIMENSIONS APPLY AFTER PLATING OR CONVERSION COATING.			UNDER .0140 ±.0020 -.0005			.501 THRU .750 ±.008 -.001			ORIG R.O'ROURKE 13-03-09	
4. REMOVE BURRS AND SHARP EDGES.			.014 THRU .125 ±.004 -.001			.751 THRU 1.000 ±.010 -.001			CHECKER	
5. PARENTHETICAL DATA IS FOR REFERENCE ONLY.			.126 THRU .250 ±.005 -.001			1.001 THRU 2.000 ±.012 -.001			RDE	
6. ALL SHEETS ARE THE SAME REVISION STATUS.			.251 THRU .500 ±.008 -.001						MFG	
			ON DECIMAL DIMENSIONS:			ON ANGULAR DIMENSIONS:			QA	
			.XXX ± .010			MACHINED ±0°30'			PCMO	
			.XX ± .03			LOCATING ±0°30'			EDMC	
			.X ± .1			FORMED ±2°			THIRD ANGLE PROJECTION	
			CHAMFERS ±5°			HEAT TREAT				
JET			D2223012			FINISH 10 12 13			SCALE 1 / 1	
USED ON			CI NO. NEXT ASSY APPLICATION						SHEET 1 OF 5	

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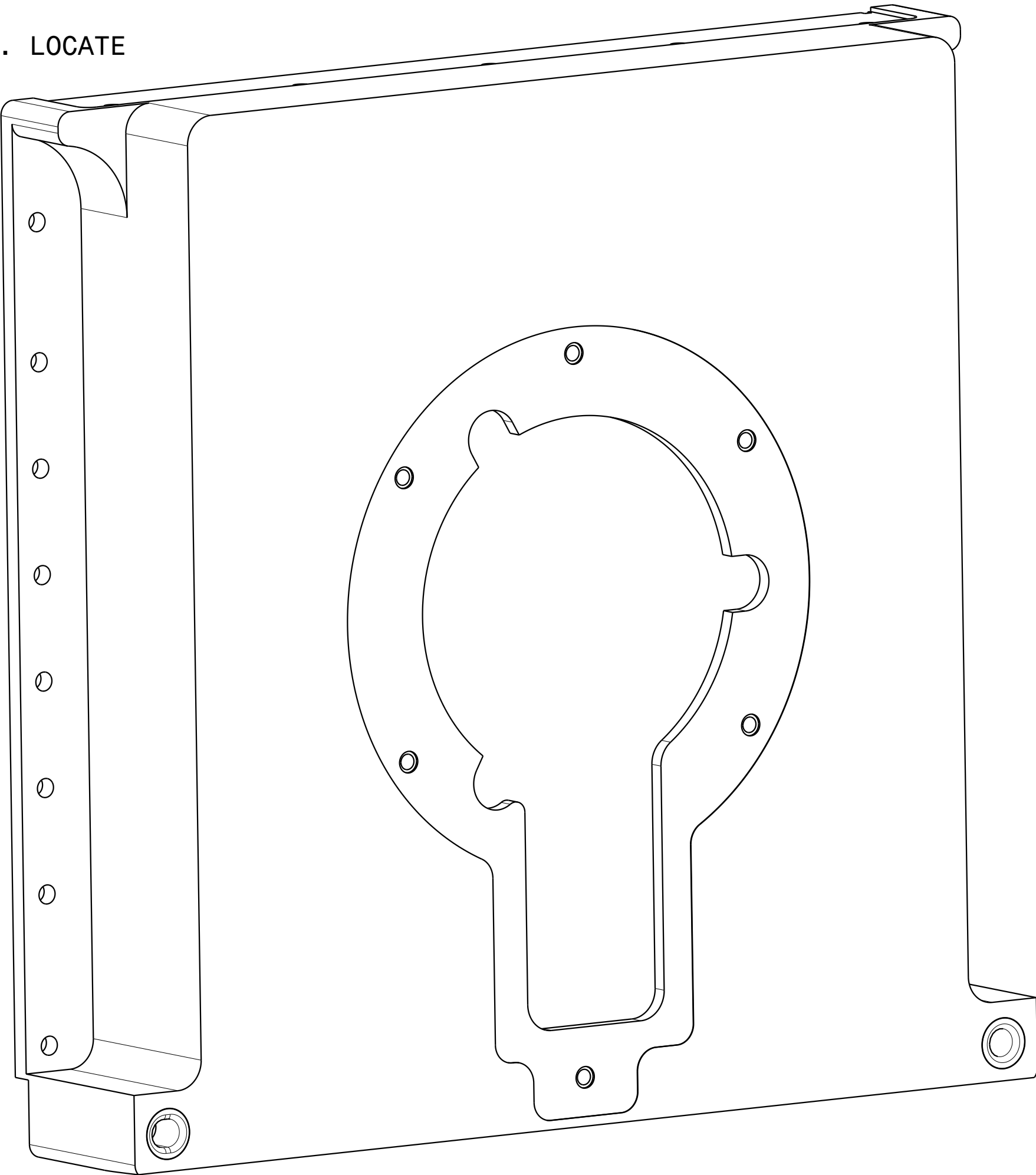
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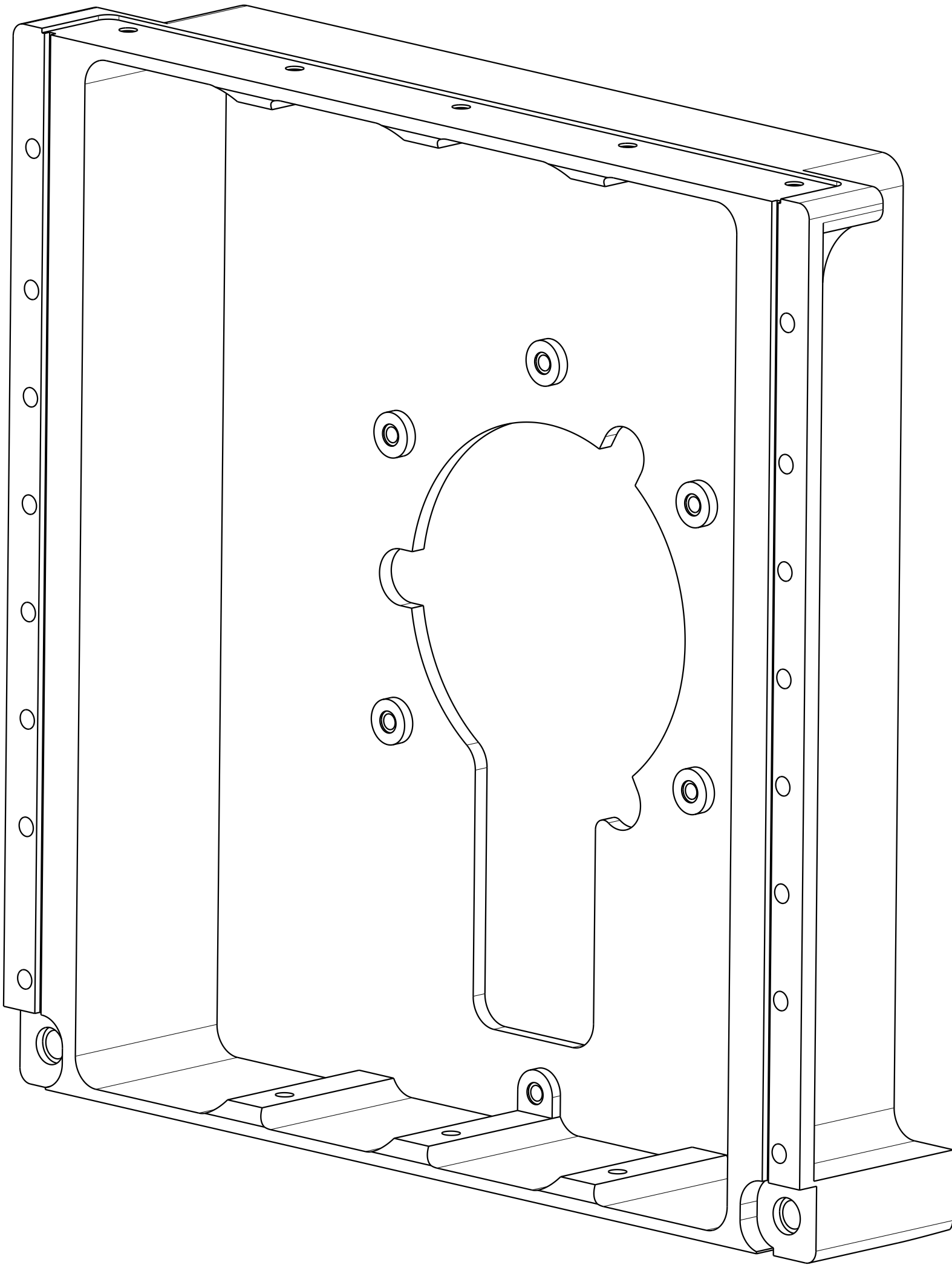
1

NOTES CONTINUED FROM SH 1

- 11
- PRESS FIT CLASS LN2 IAW ASME B4.1-2009. WET INSTALL USING MIL-PRF-81733 SEALANT, TYPE I-1/2. CLASS 1, GRADE A.
- 12
- FINISH: APPLY PRIMER COATING, FN 605, TYPE I, CLASS C, IAW MIL-PRF-23377 AND EPOXY TOP COAT, FN 603, IAW MIL-PRF-22750, WHITE COLOR NO. 17925, IAW FED-STD-595, ON INDICATED SURFACES. PRIMER AND TOPCOAT APPLICATION SHALL FOLLOW MANUFACTURER'S RECOMMENDED PROCEDURES. PRIMER SHALL HAVE A DRY FILM THICKNESS OF .0009 MAX. TOPCOAT SHALL HAVE A DRY FILM THICKNESS OF .0017-.0023.
- 13
- FINISH: THE FOLLOWING SURFACES SHALL BE FREE OF PAINT AND PRIMER INCLUDING OVERSPRAY:
A. SURFACES NOT INDICATED IN NOTE 10.
B. MATING SURFACES.
- 14
- TOP COIL TO BE .08 BELOW SURFACE.
- 15
- INSTALL INSERTS IAW MS33537 AFTER FINISH.
- 16
- MARK PART NUMBER AND DASH NUMBER IAW MIL-STD-130 USING INK, FN 601. LOCATE APPROXIMATELY WHERE SHOWN.
- 17
- ABBREVIATIONS NOT IAW ASME Y14.38:
MBPD: MODEL BASED PRODUCT DEFINITION
JET: JOINT ENTERPRISE TERMINAL
- 18
- PRESS INSTALLED BUSHINGS, FN 502 AND 503, TO BOTTOM OF INSTALLATION LOCATIONS. PRESS NEW BUSHINGS, FN 505 AND 506, INTO LOCATIONS SHOWN.



- 1 SHOWN FOR REFERENCE ONLY
SCALE NONE



- 1 SHOWN FOR REFERENCE ONLY
SCALE NONE

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SIZE	CAGE CODE	DWG NO	REV
D	65409	DC2223013	3
SCALE 1 / 1		SHEET 2	

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CATIA

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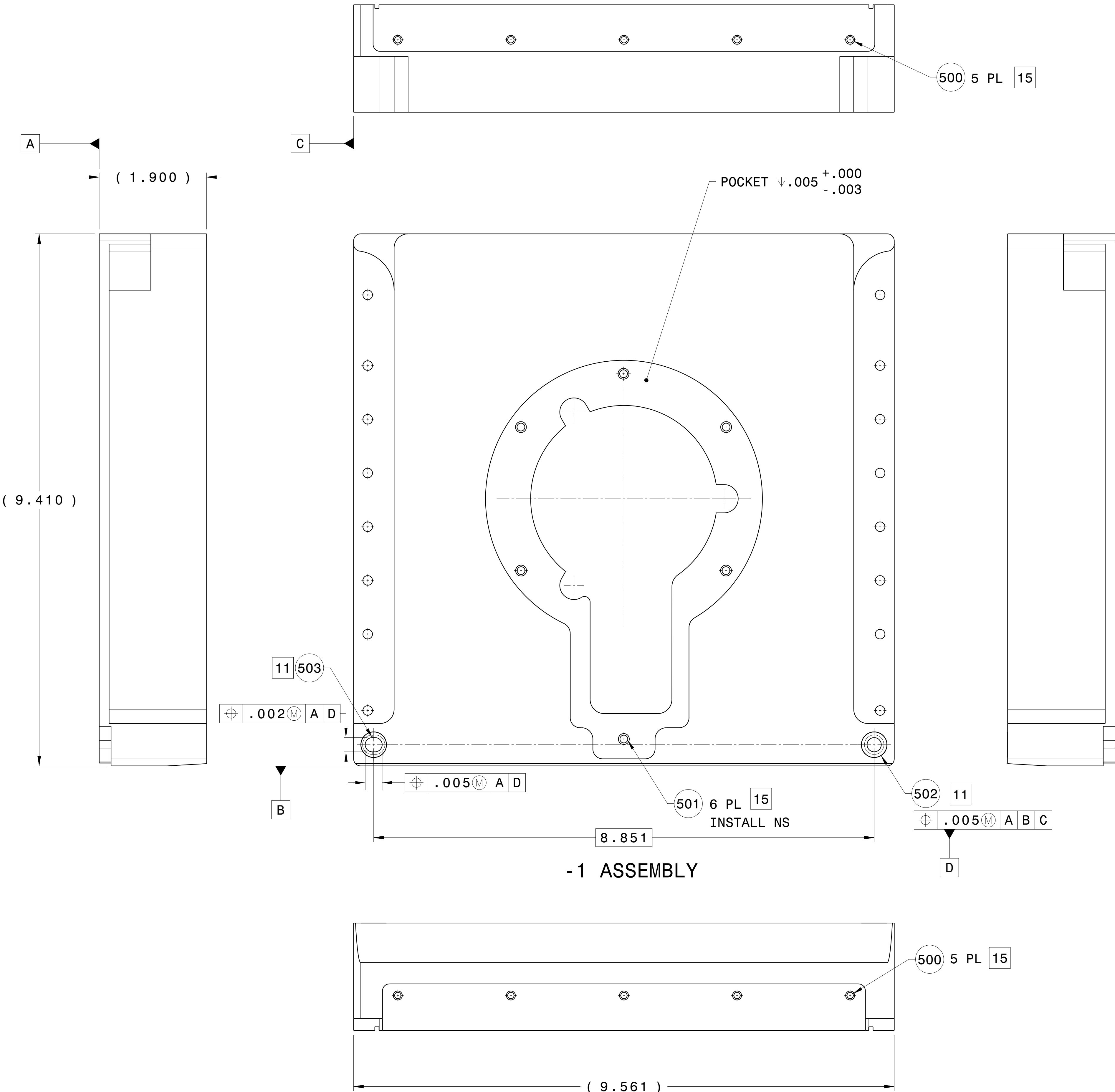
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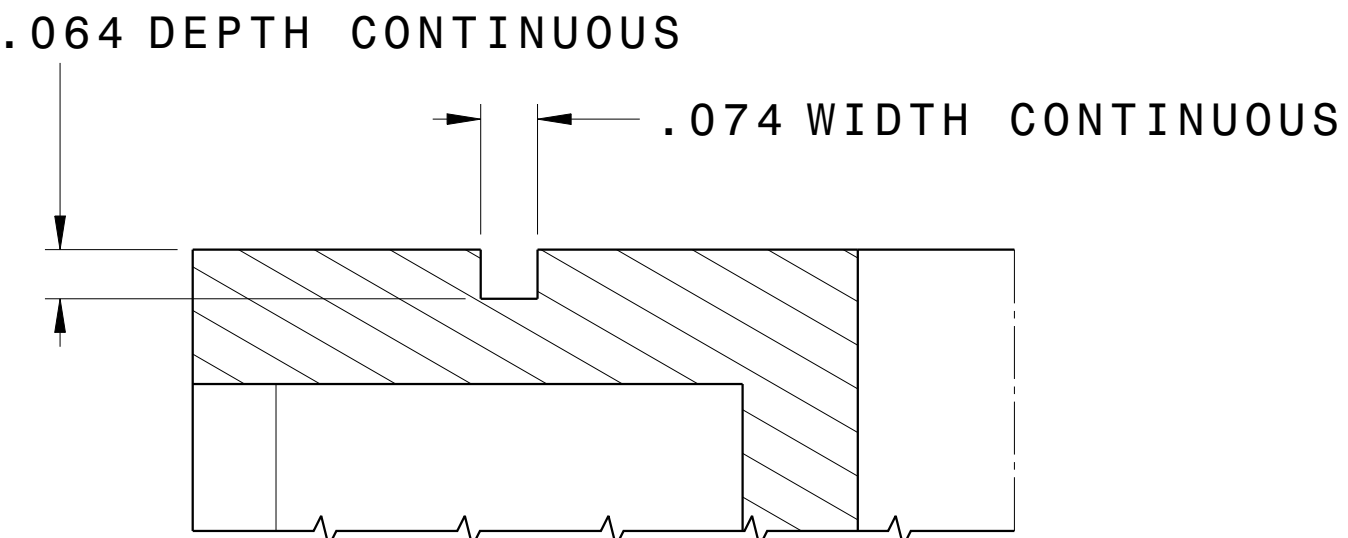
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-1 ASSEMBLY



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DWG NO DC2223013

SH 4

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NORTHROP GRUMMAN PRIVATE/PROPRIETARY LEVEL I

D

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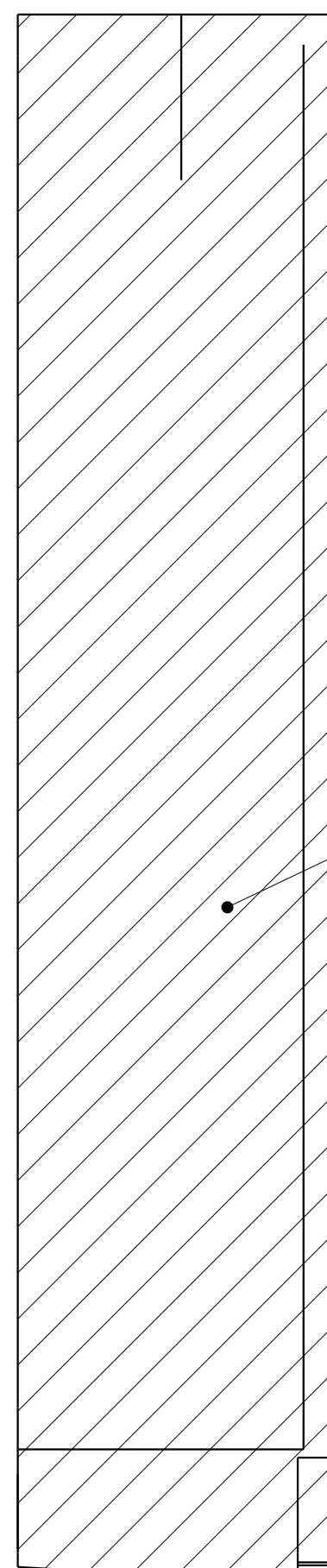
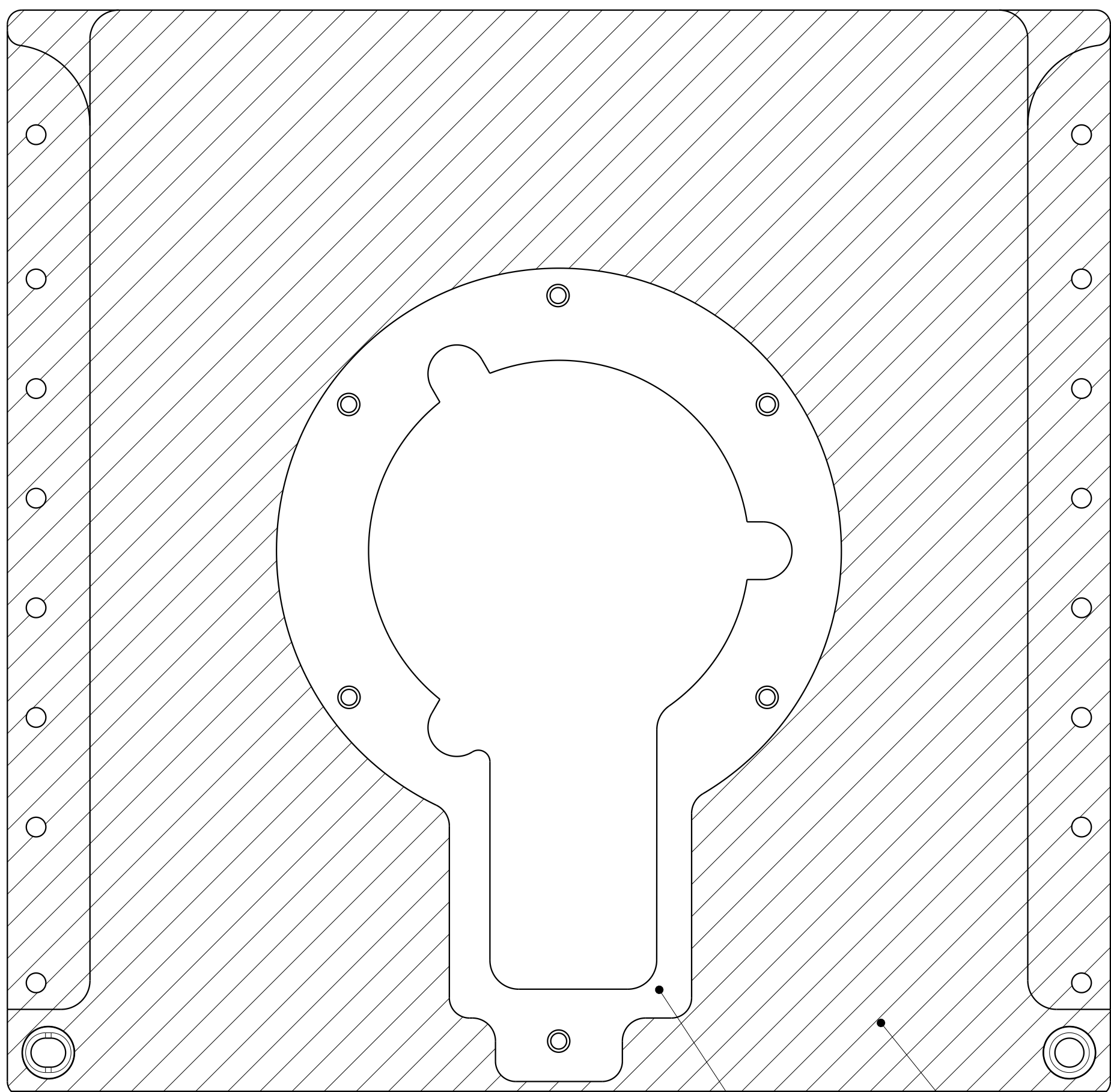
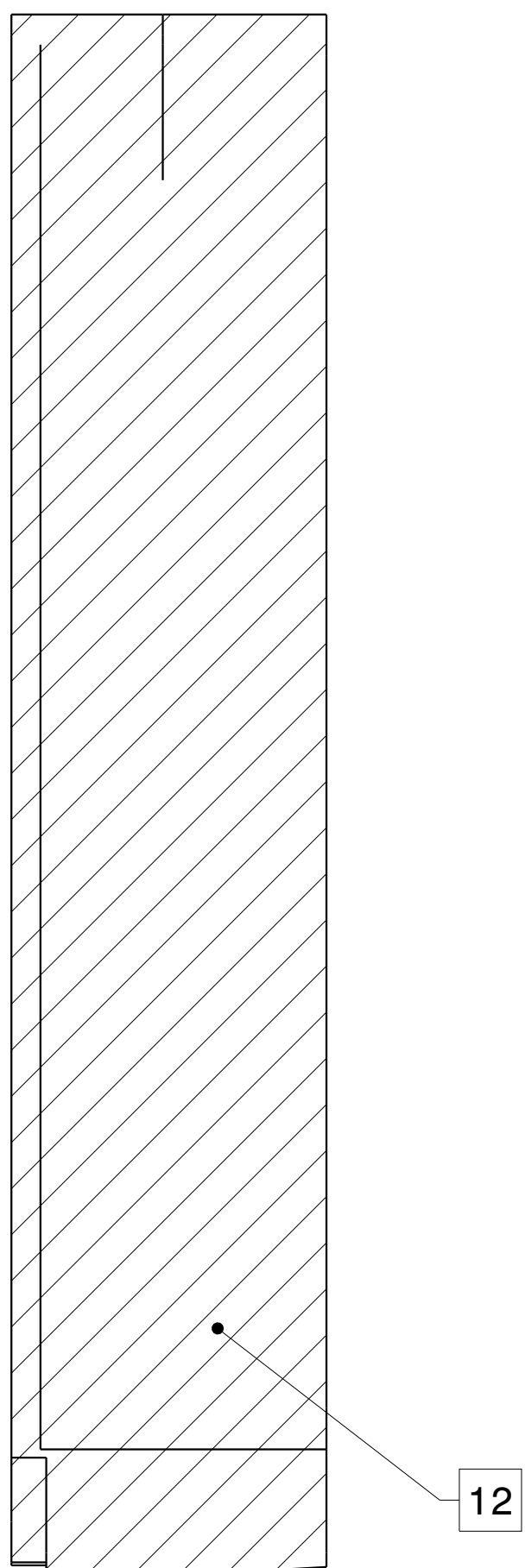
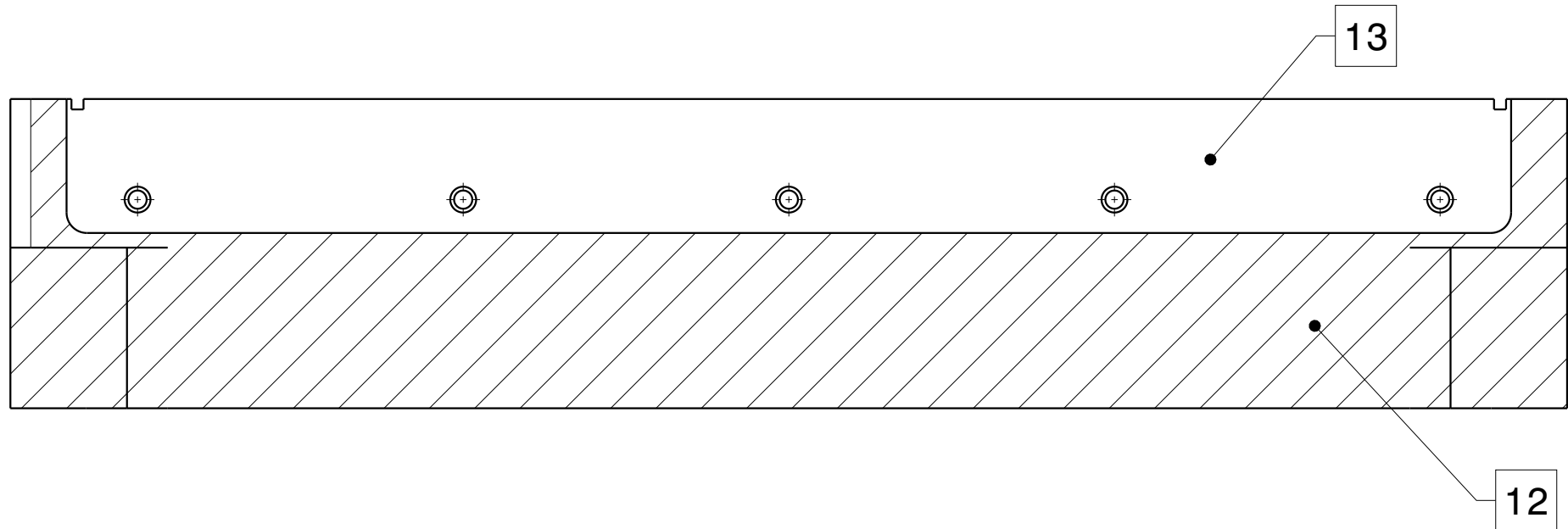
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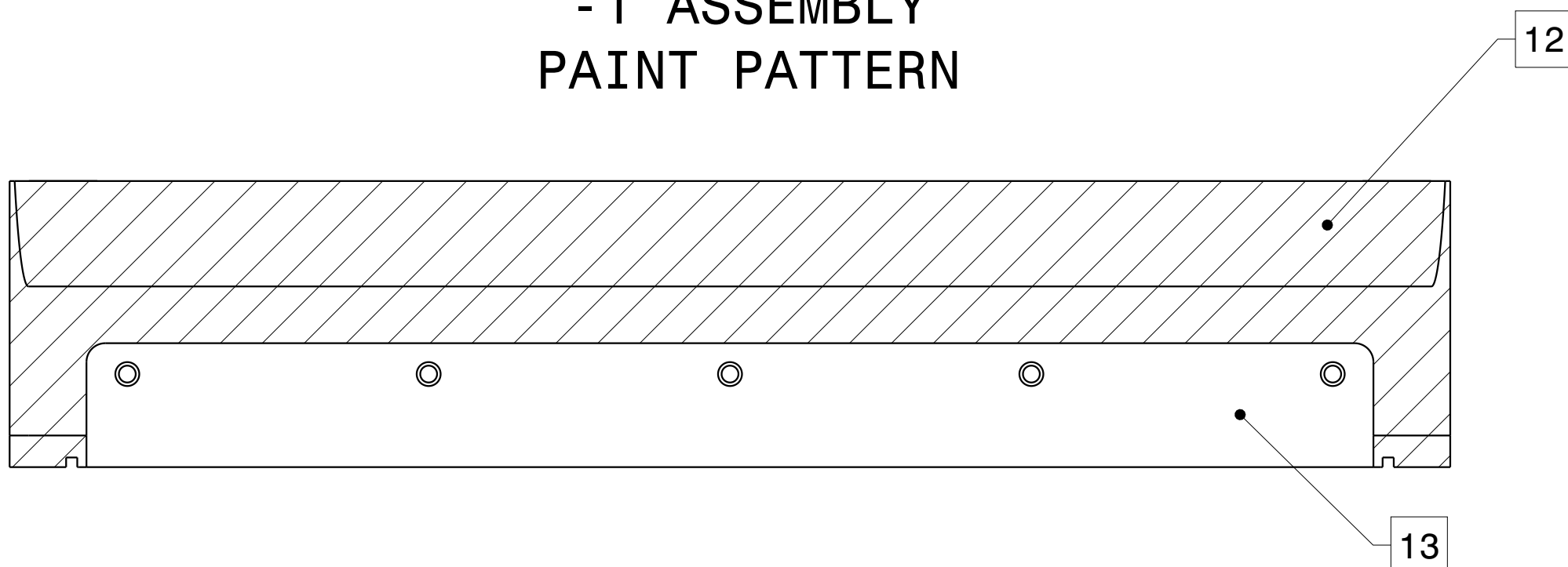
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-1 ASSEMBLY
PAINT PATTERN



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SIZE	CAGE CODE	DWG NO	REV
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SCALE	1 / 1	SHEET	4

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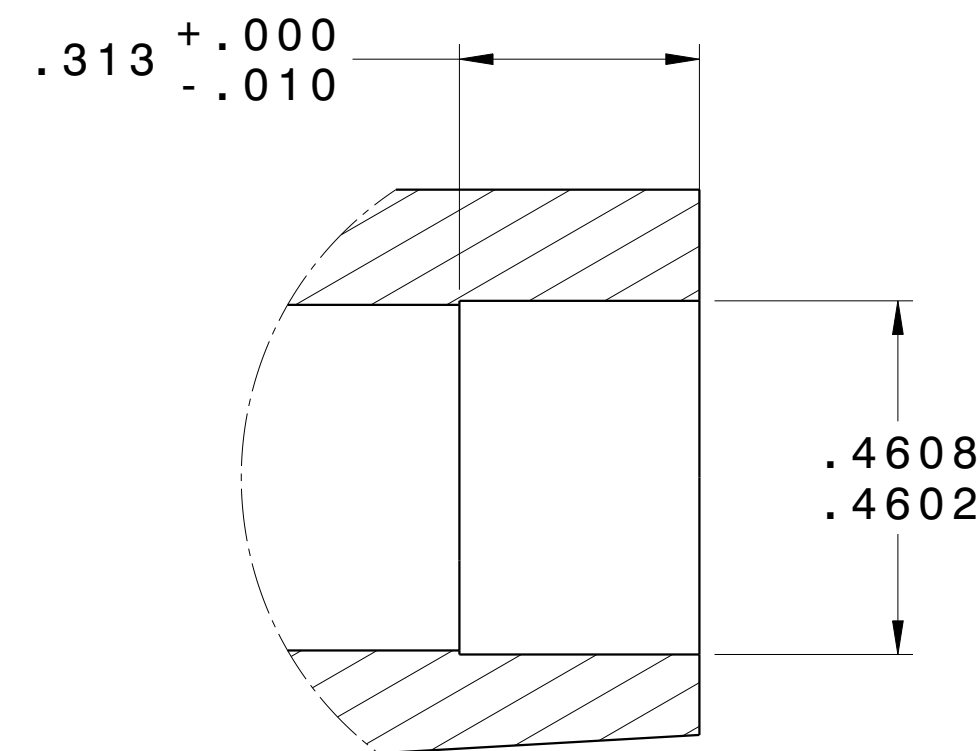
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DWG NO DC2223013

SH 5

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NORTHROP GRUMMAN PRIVATE/PROPRIETARY LEVEL I

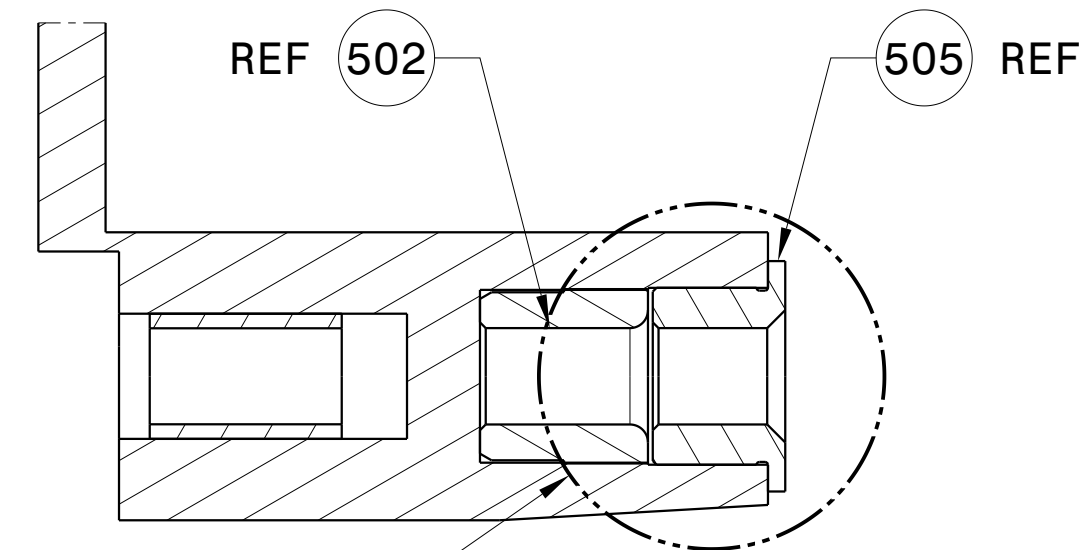


DETAIL C

SCALE: 4/1

2 PLACES

FN 502 AND 505 NOT SHOWN FOR CLARITY FOR -2 ASSEMBLY
FN 505 NOT SHOWN FOR CLARITY FOR -3 ASSEMBLY



SEE DETAIL C

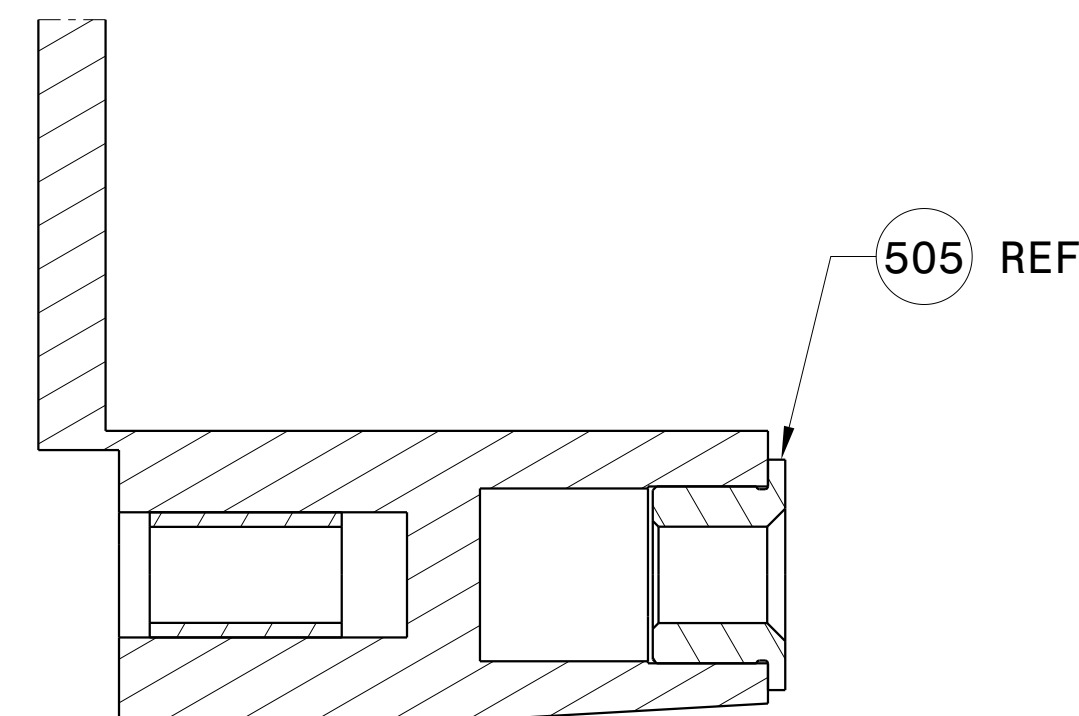
SECTION B-B

18

SCALE: 2/1

2 PLACES

-2 ASSEMBLY ONLY

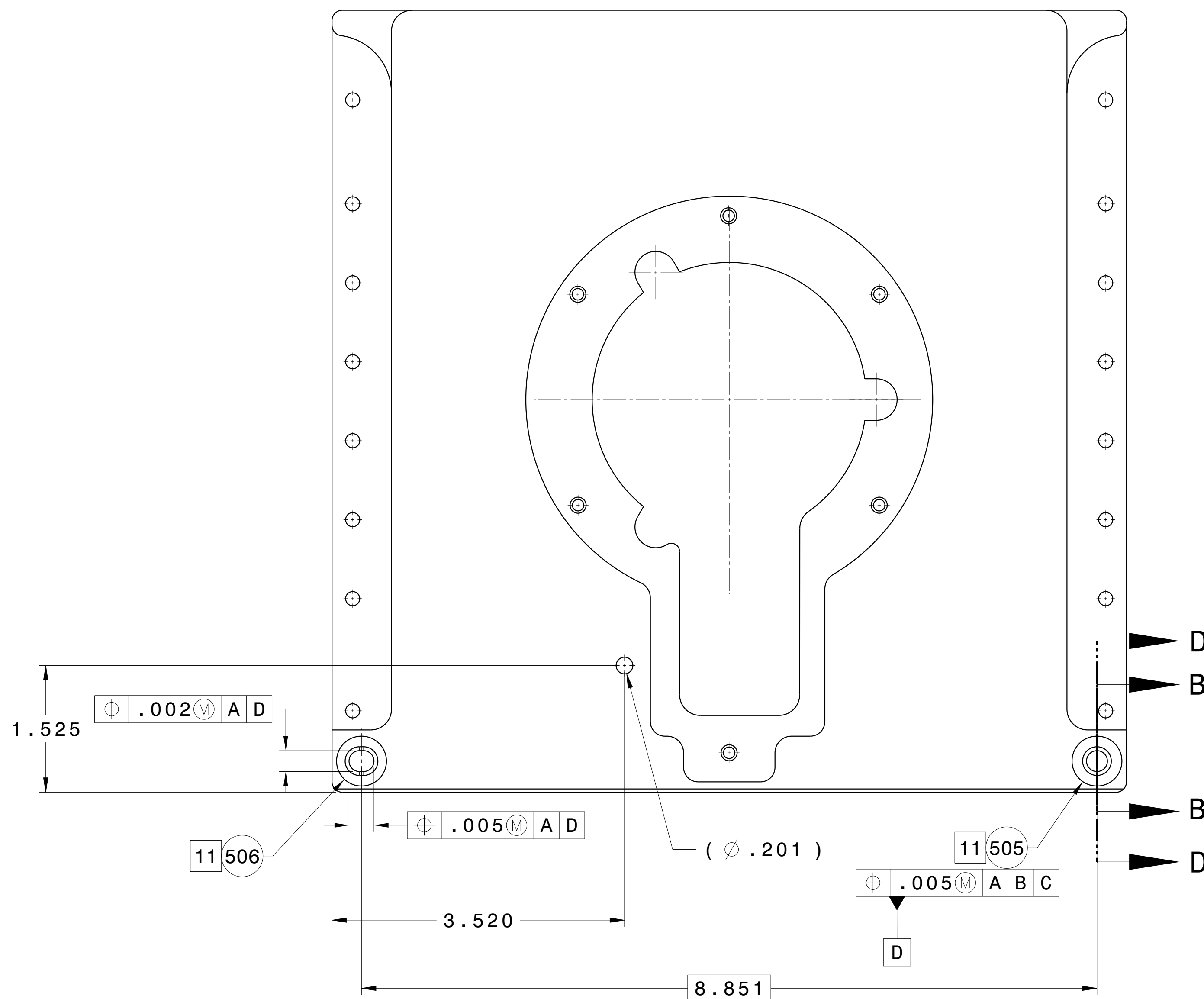


SECTION D-D

SCALE: 2/1

2 PLACES

-3 ASSEMBLY ONLY



-2 ASSEMBLY SAME AS -1 EXCEPT AS SHOWN

-3 ASSEMBLY SAME AS -2 EXCEPT AS SHOWN

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SIZE	CAGE CODE	DWG NO	REV
D	65409	DC2223013	3
SCALE 1 / 1		SHEET 5	

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