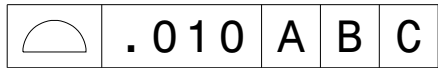


NOTES: UNLESS OTHERWISE SPECIFIED

1. THIS DRAWING SHALL BE INTERPRETED IAW ASME Y14.100-2017 AND ASME Y14.41-2012. ALL DIMENSIONS DERIVED FROM DATASET SHALL BE INTERPRETED AS US CUSTOMARY NOTATION.
2. DATASET PIN DTE2227193-1 SHALL COMPRISE OF THIS DRAWING, ASSOCIATED LISTS, AND MODEL DTE2227193-1_1.STP, MODELED AT MEAN SIZE. BASIC DIMENSIONS NOT DISPLAYED HEREIN AND NECESSARY TO SPECIFIED TOLERANCES SHALL BE OBTAINED BY QUERYING THE MODEL. QUERIED DIMENSIONS SHALL BE ROUNDED TO THREE DECIMAL PLACES.
3. THE GEOMETRIC TOLERANCE OF FEATURES UNSPECIFIED IN THE DRAWING FIELD ARE AS FOLLOWS:

A. SURFACES:



B. HOLES:



4. INSPECTION REQUIREMENTS
- A. USE THIS DRAWING AND ITS ASSOCIATED MODEL 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 GAUGED PRIOR TO INSERT INSTALLATION.
 - 4. AFTER FINISH, ALL BLIND TAPPED HOLES SHALL BE INSPECTED FOR DEBRIS.
 - C. INSPECTION CONDITION: PART SHALL BE CONSTRAINED ALONG DATUM A.

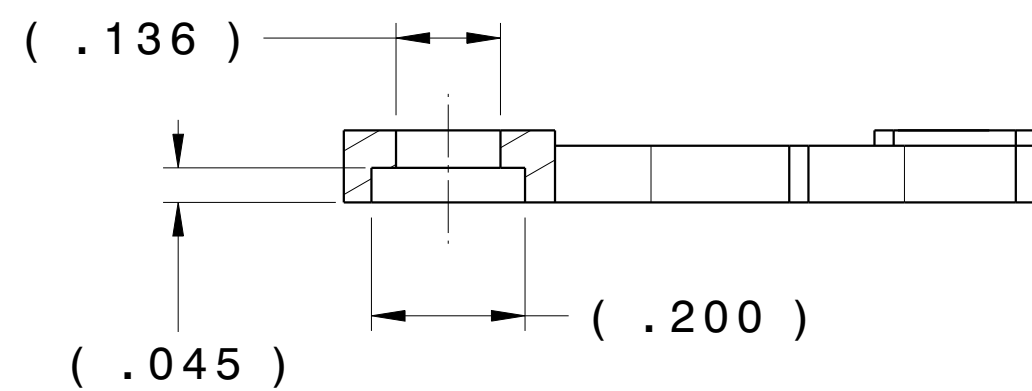
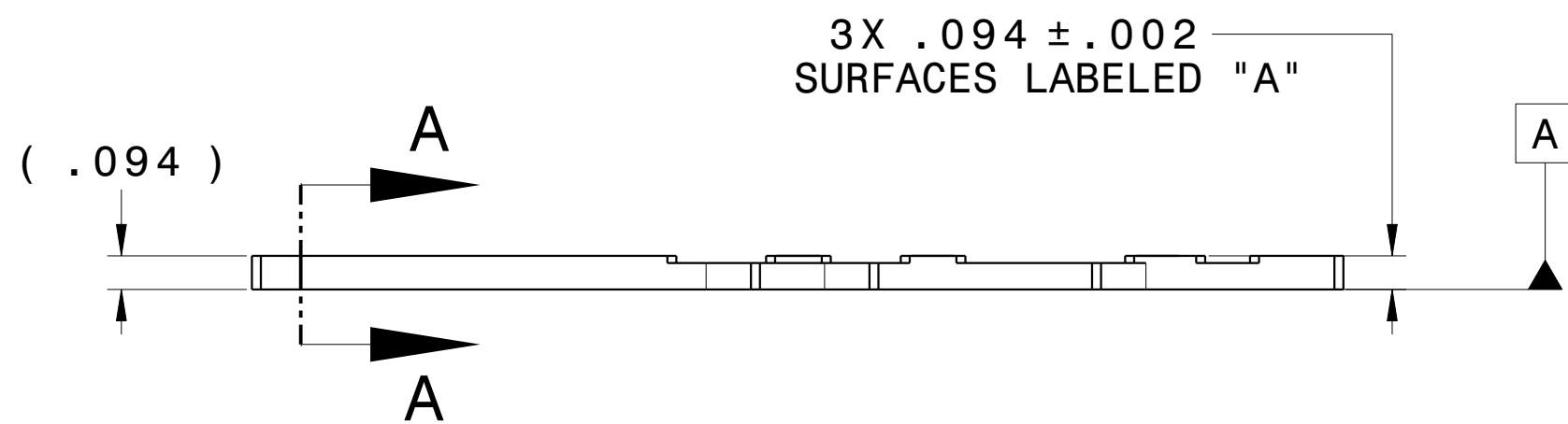
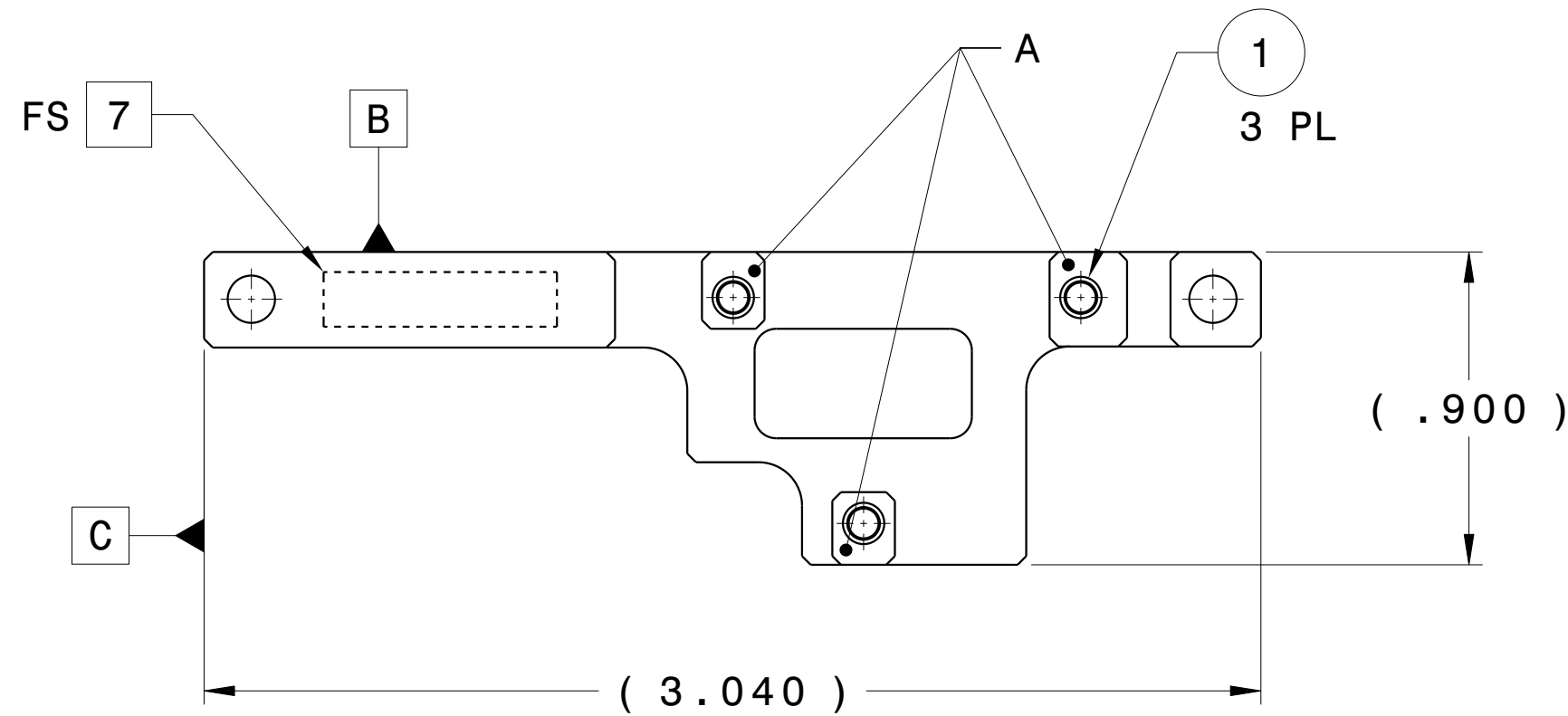
5. MATERIAL: AL ALY 6061-T651 IAW SAE AMS 4027

- 6 FINISH: ALL DIMENSIONS APPLY AFTER SURFACE FINISHES.
CHEMICAL CONVERSION COAT IAW MIL-DTL-5541, TYPE II, CLASS 3,
COLOR YELLOW PREFERRED BUT NOT A BASIS FOR REJECTION.

- 7 MARK PART AND DASH NUMBER IAW MIL-STD-130 WITH
.12 HIGH CHARACTERS. LOCATE APPROXIMATELY WHERE SHOWN.

NORTHROP GRUMMAN PROPRIETARY LEVEL I

UNSPECIFIED FEATURE CONTROL		
FEATURE TYPE	TOLERANCE	MODEL CONDITION
FILLET RADII	R.005 TO R.015	MODELED AT NOMINAL
BREAK SHARP EDGES	.005 - .015	MODELED AS SHARP
COUNTERSINK INCLUDED ANGLES	±1°	MODELED AT NOMINAL
DEPTH OF BLIND HOLES AND COUNTERBORES	±.010	MODELED AT NOMINAL
CHAMFERS	±.010 X ±5°	MODELED AT NOMINAL
INTERNAL THREADS	IAW SAE AS8879	MODELED AT TAP DRILL DIAMETER



SECTION A-A

SCALE 4 / 1

2 PL

DIGITAL PRODUCT DEFINITION DATA

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED
BY THE CURRENT DESIGN ACTIVITY.

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				3	80205	NAS1130-02L10D	INSERT, HELICAL COIL, SELF-LOCKING - .086-56, .086 LG	-	NAS1130		1												
				-1	DAI	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPEC	REF DES	FIND NO												
QTY REQD PER ASSY												PARTS LIST											
UNLESS OTHERWISE SPECIFIED												DO NOT SCALE DRAWING											
<div>1. DIMENSIONS ARE IN INCHES. 2. SURFACE TEXTURE SHALL BE 3. DIMENSIONS APPLY AFTER PLATING OR CONVERSION COATING. 4. REMOVE BURRS AND SHARP EDGES. 5. PARENTHETICAL DATA IS FOR REFERENCE ONLY. 6. ALL SHEETS ARE THE SAME REVISION STATUS.</div>												CONTRACT NO.											
												TOLERANCES											
												ON ALL HOLE DIAMETERS											
												ORIG											
												CHECKER											
												MFG											
												QA											
												PCMO											
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												THIRD ANGLE PROJECTION											
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- DTE2227192												D 65409											
USED ON CI NO. NEXT ASSY												DTE2227193											
APPLICATION												SHEET 1 OF 1											
FINISH												SCALE NONE											
6												HEAT TREAT											
												SIGNATURES ON FILE											
												NORTHROP GRUMMAN											
												15120 INNOVATION DRIVE, SAN DIEGO, CA 92128											
												CARRIER PLATE - CNIP, CSS LOADER											