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DWG NO
DC2223006

SH 1

1

NOTES: UNLESS OTHERWISE SPECIFIED

1. DIMENSIONS AND TOLERANCES IAW ASME Y14.5M - 2009.

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 C AND F.

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

NORTHROP GRUMMAN PRIVATE/PROPRIETARY LEVEL I

APPROVED SOURCE(S) OF SUPPLY 8

CAD/CAM DATA FILE	PART NUMBER	NATIVE CAD FILE	VENDOR
DC2223006-1_2.IGS DC2223006-1_2.STP	DC2223006-1	DC2223006_4.ZIP	PROCURE ONLY FROM SUPPLIER WITH SAP WMSV
DC2223006-2_2.IGS DC2223006-2_2.STP	DC2223006-2		

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

D

C

A

B

DWG NO
DC2223006

SH 1

1

REV
1

ENGINEERING DEVELOPMENT

13-03-11

ON FILE

SH 1, ZN D5, DATA FILE -1 AND -2 WAS REV_1. SH 2, UPDATED ALL VIEWS. SH 3, ZN A3 -1 CONFIG, RMVD BREAKTHRU RQMNT; BOTTOM VIEW, REV FINS SETBACK TO .125 FROM TANGENT OF RADIUS, BOTH ENDS; RMVD 1 FIN RH AND LH FOR CUTTER ACCESS; ADDED MACHINE RADIUS .063 RELIEF TO EDGE OF RAMP PROFILE, BOTH SIDES; ZN C1,2,3, REV R .250 RAMP TRANSITION TO R.188 FOR

2 MACHINING RELIEF, ONE END ONLY. SH 4, SECT C-C AND D-D, REV PROFILE TO POSITION TOL AND ADDED BASIC BOX TO DIMS, BOTH VIEWS. SH 5, -2 CONFIG, ZN A5, RMVD BREAK THRU RQMNT; BOTTOM VIEW, REV FINS SETBACK TO .125 FROM TANGENT OF RADIUS, BOTH ENDS; RMVD 1 FIN RH AND LH FOR CUTTER ACCESS; ADDED MACHINE RADIUS .063 RELIEF TO EDGE OF RAMP PROFILE, BOTH SIDES. SH 6 AND 7 UPDATE ONLY NO CHG. RJO

3 FLAG NOTE 12 UPDATED. SH 3, A4 AND SH 5, A4 HOLE CALLOUT FIXED TO .1875-.1870. CHANGED -2 DATUMS TO A, B, C AND D. UPDATED SECTION D-D REF DATUMS.

4 SH 7, ZONE A8, FLAG NOTE 13 CHANGED TO FLAG NOTE 12 MS

13-03-28

ON FILE

13-07-25

ON FILE

ON FILE

PROTOTYPE RELEASE ONLY
UNCONTROLLED COPY

USER MUST VERIFY CURRENT
REVISION PRIOR TO USE

SEE SEPARATE PARTS LIST

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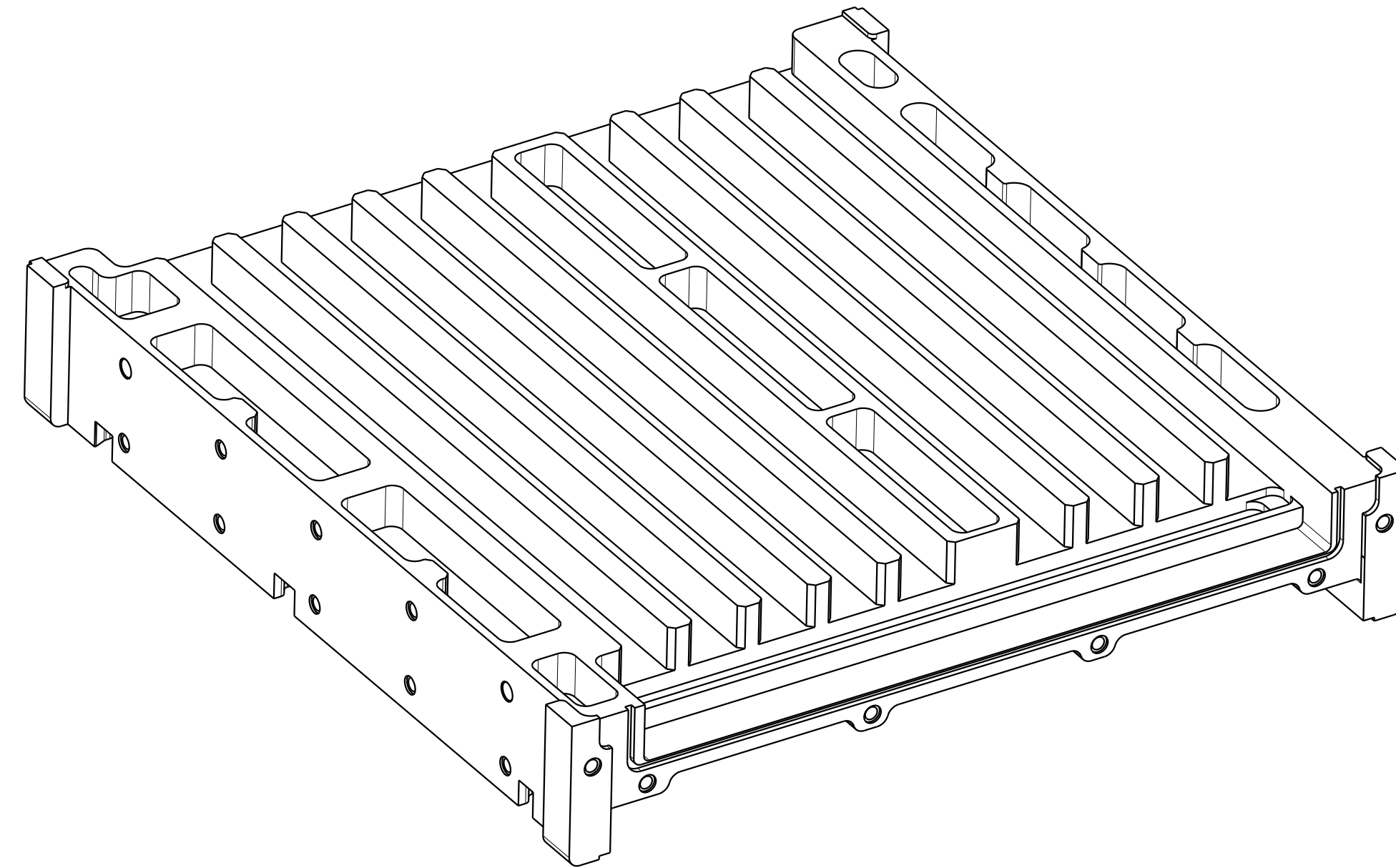
3

2

1

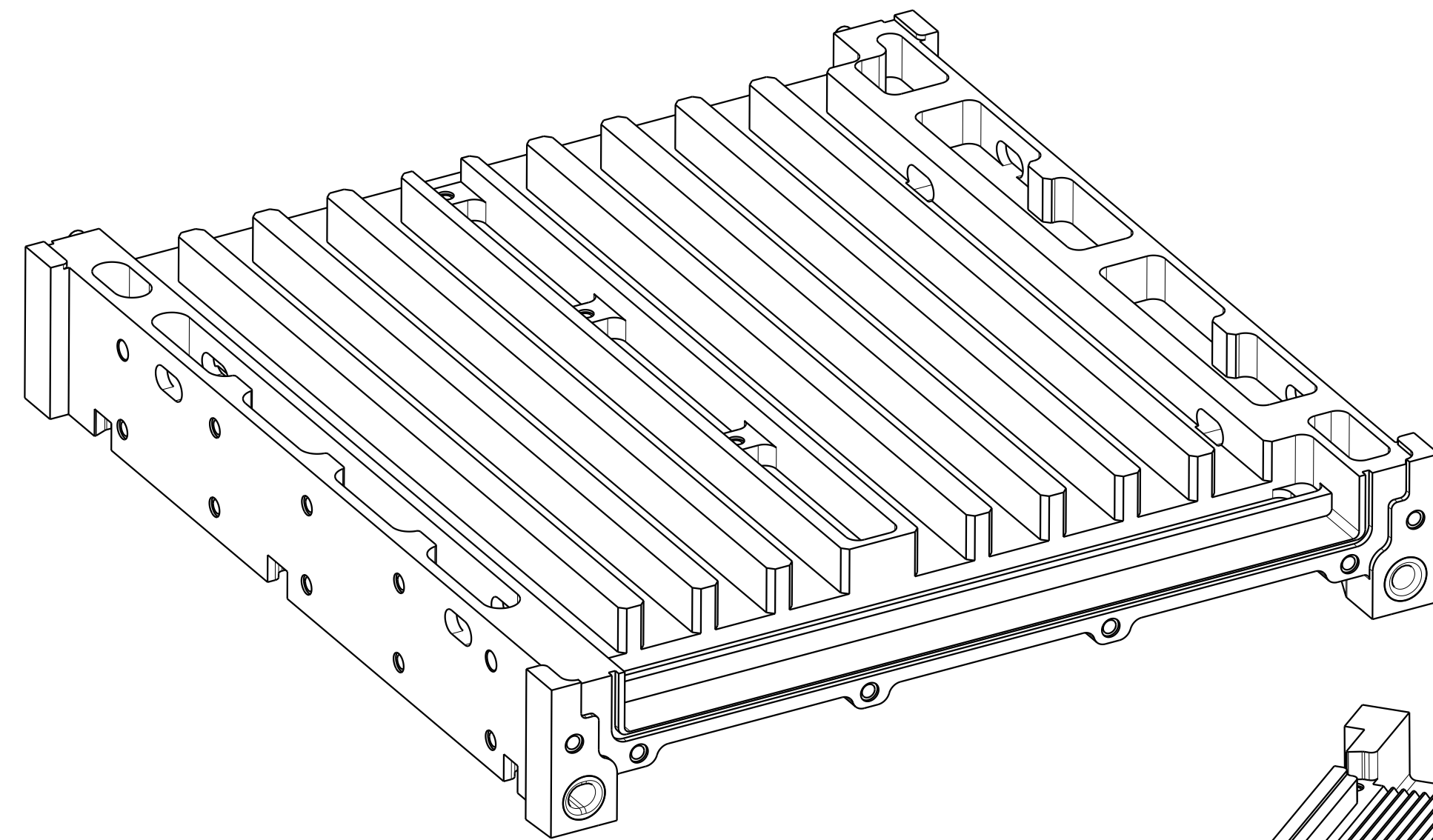
NOTES CONTINUED FROM SH 1

- 11 MEDIUM PRESS FIT. WET INSTALL USING MIL-PRF-81733 SEALANT, TYPE I-1/2. CLASS 1, GRADE A.
- 12 FINISH: APPLY PRIMER COATING, FN 603, TYPE I, CLASS C, IAW MIL-PRF-23377 AND EPOXY TOP COAT, FN 602, 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 INSTALL INSERTS IAW MS33537 AFTER FINISH.
- 15 MARK PART NUMBER AND DASH NUMBER IAW MIL-STD-130 USING INK, FN 601. LOCATE APPROXIMATELY WHERE SHOWN.
16. ABBREVIATIONS NOT IAW ASME Y14.38:
JET: JOINT ENTERPRISE TERMINAL

**-2 ASSEMBLY**

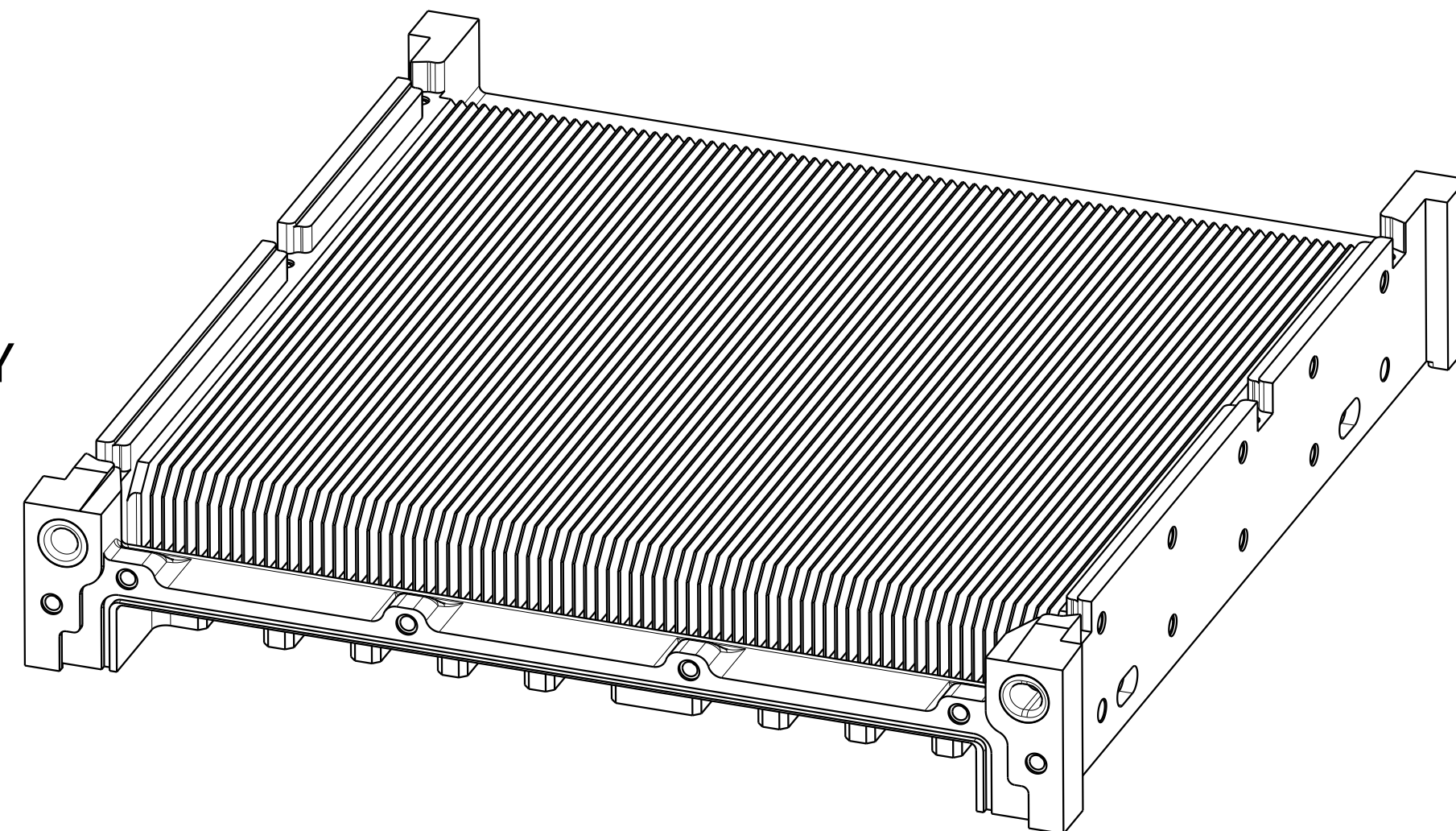
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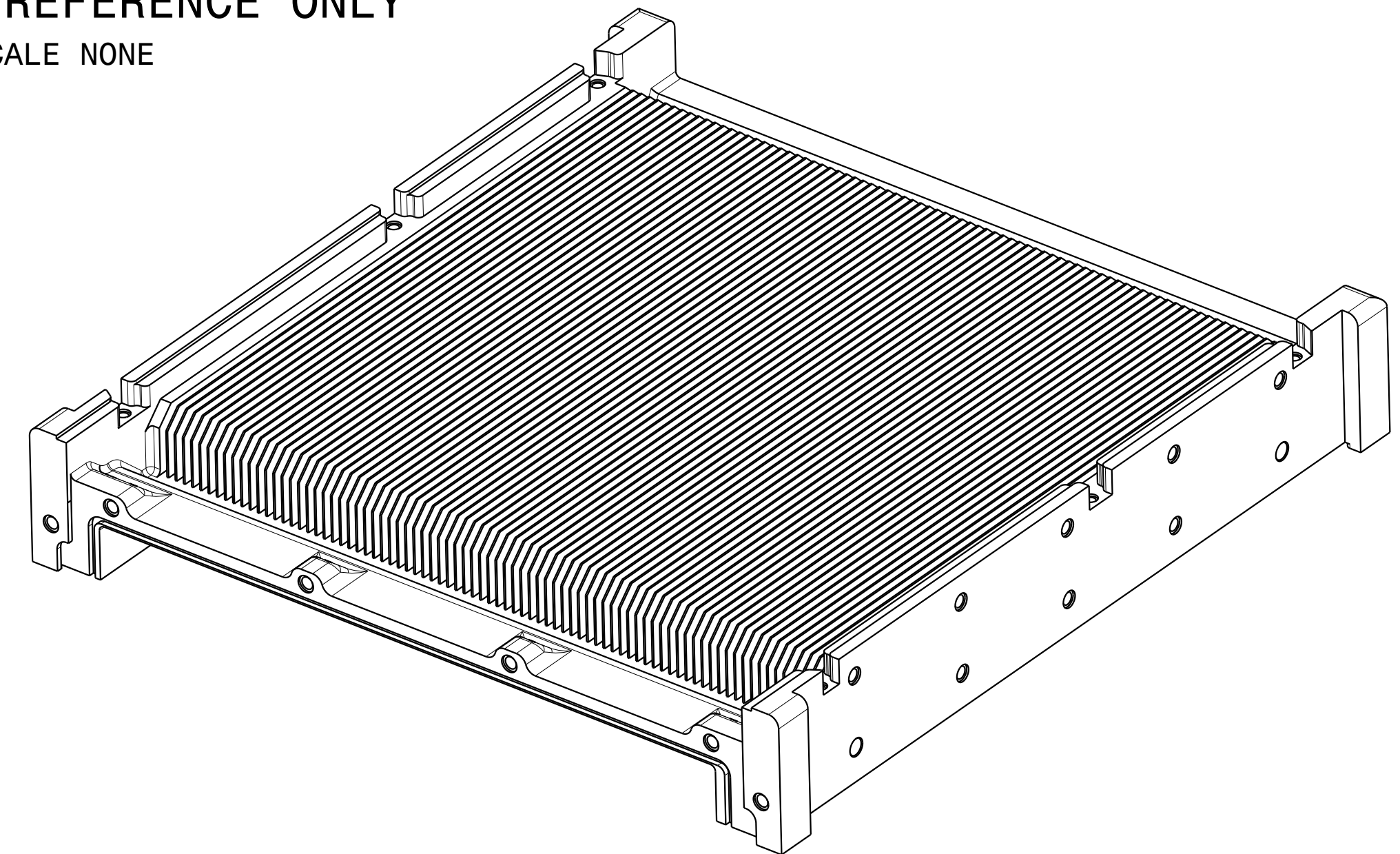
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**-1 ASSEMBLY**

SHOWN FOR REFERENCE ONLY

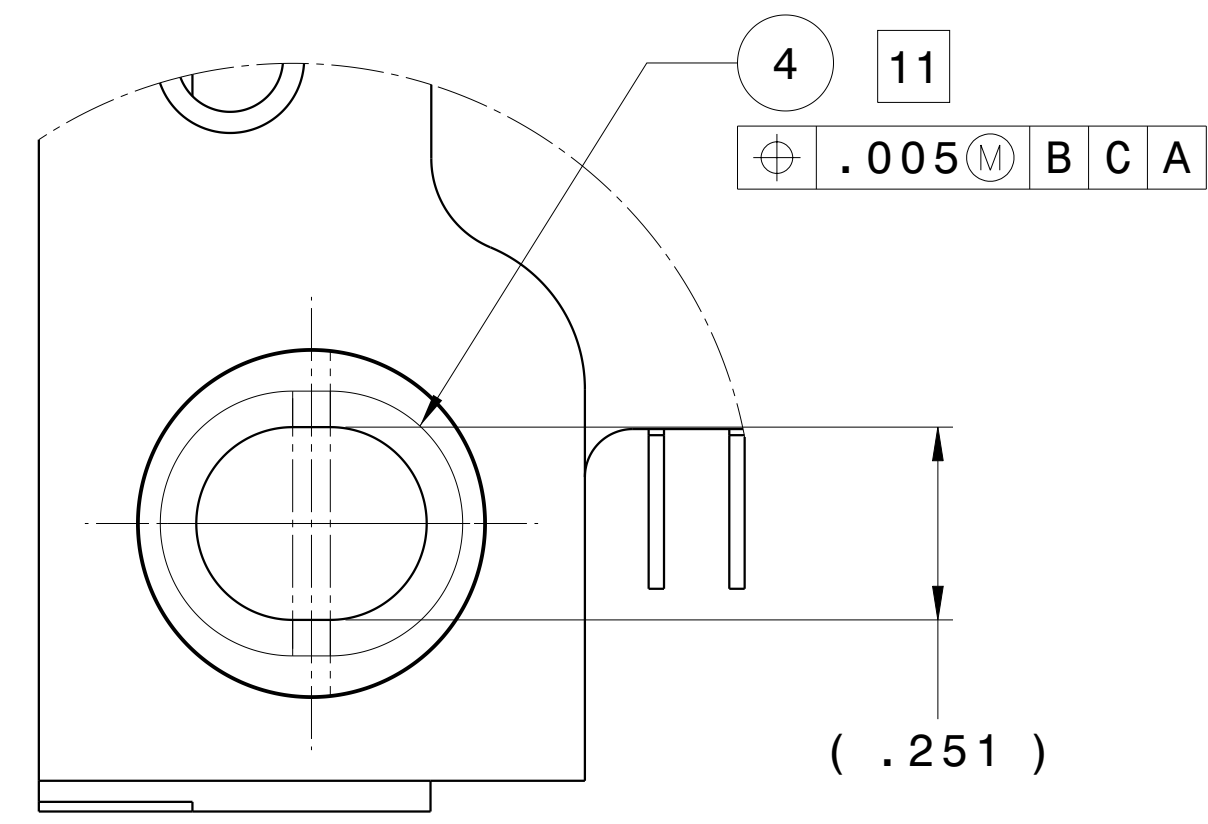
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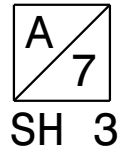
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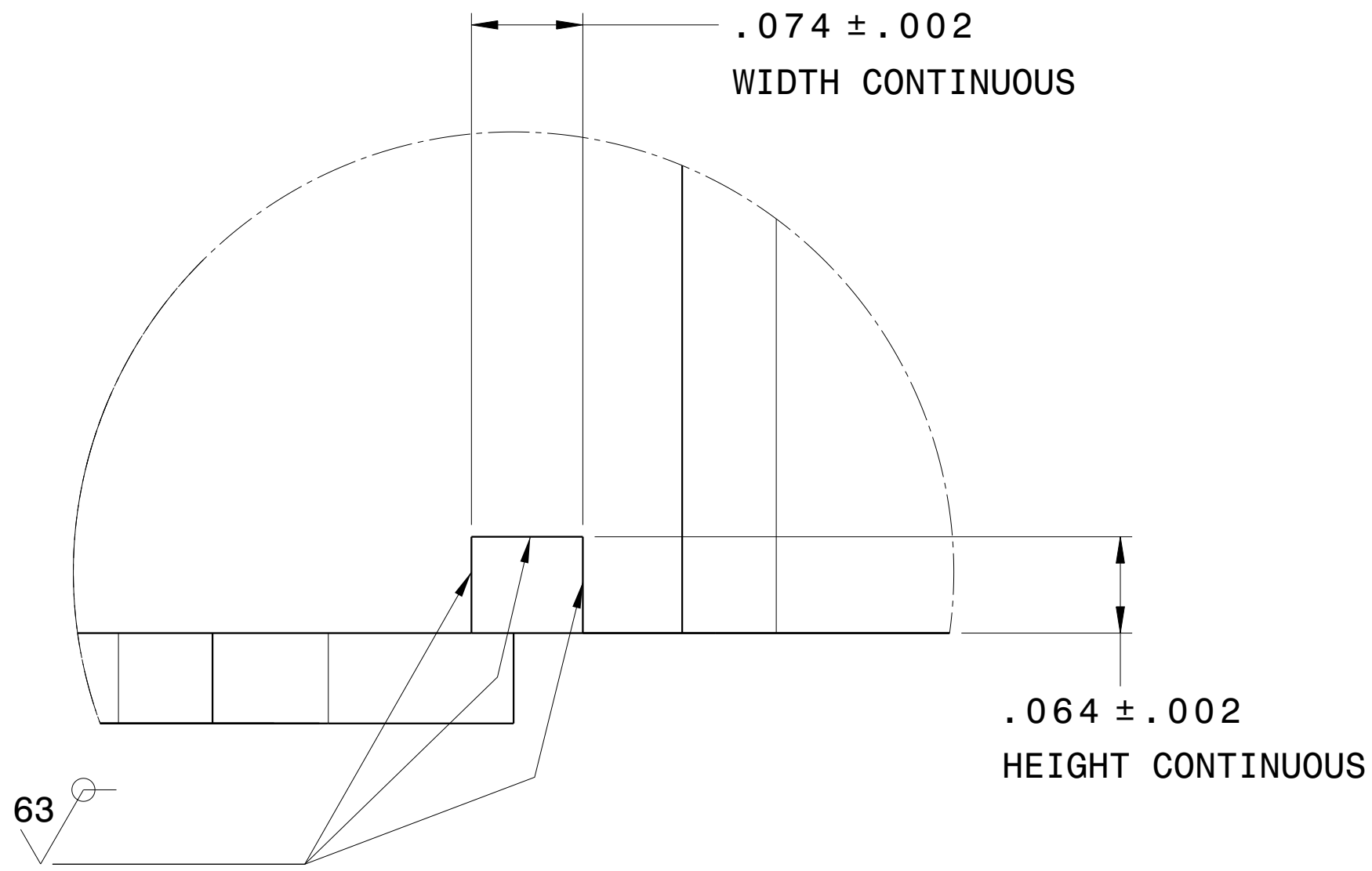
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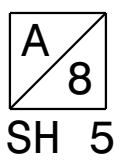
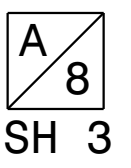
DETAIL A
SCALE 4/1
-1 ONLY



C

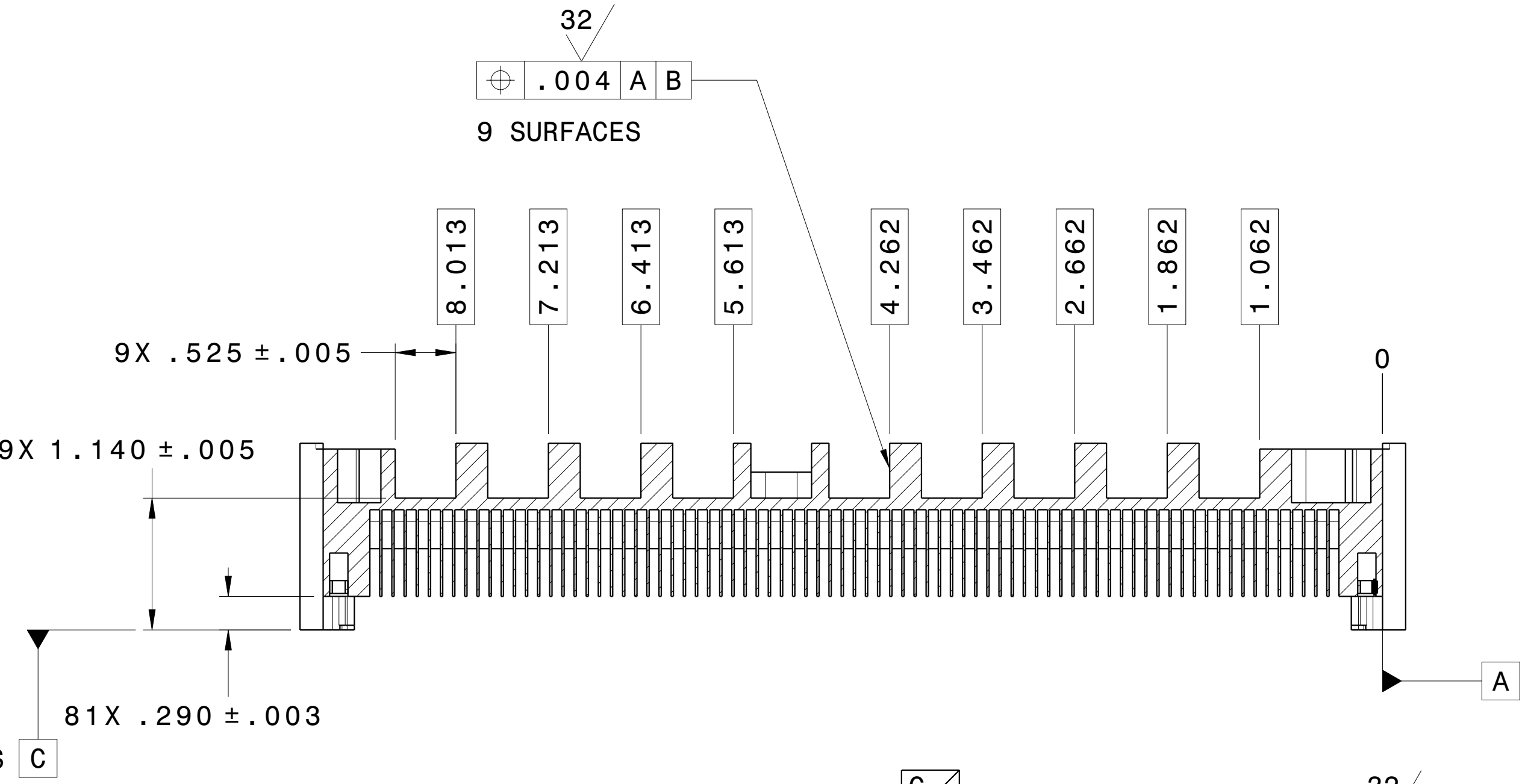


DETAIL B
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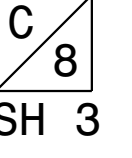


A

2 SURFACES

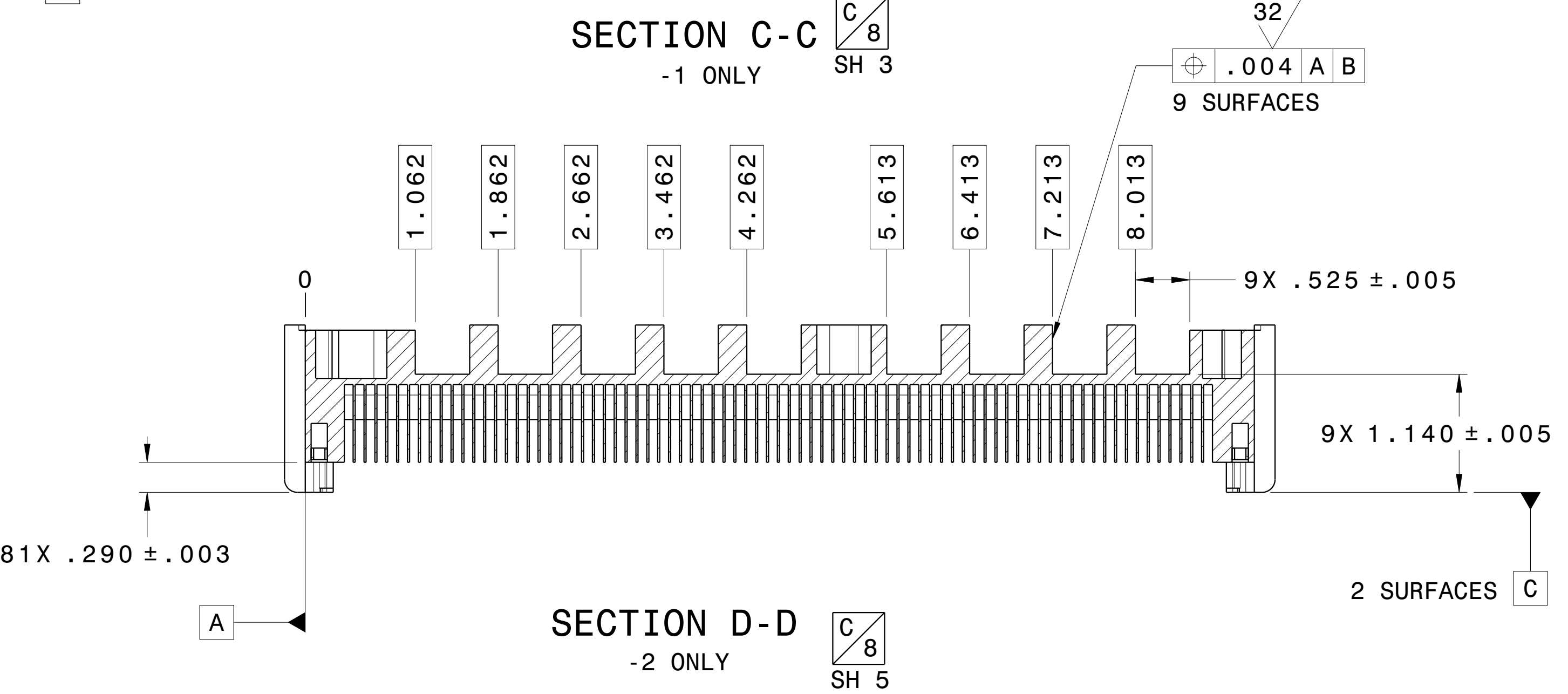


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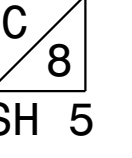


81X .290 ± .003

A



SECTION D-D
-2 ONLY



2 SURFACES

D

C



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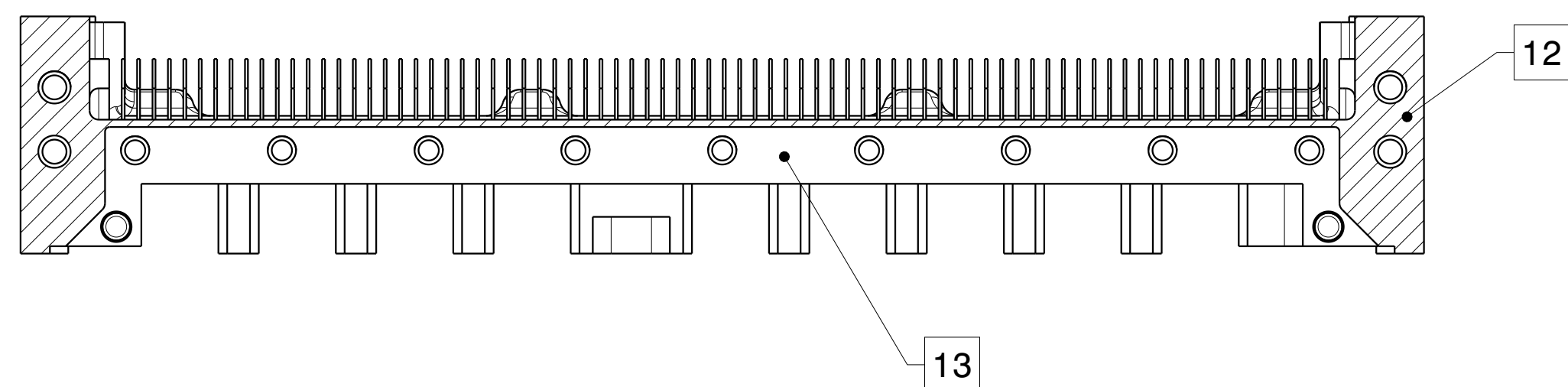
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SH 6

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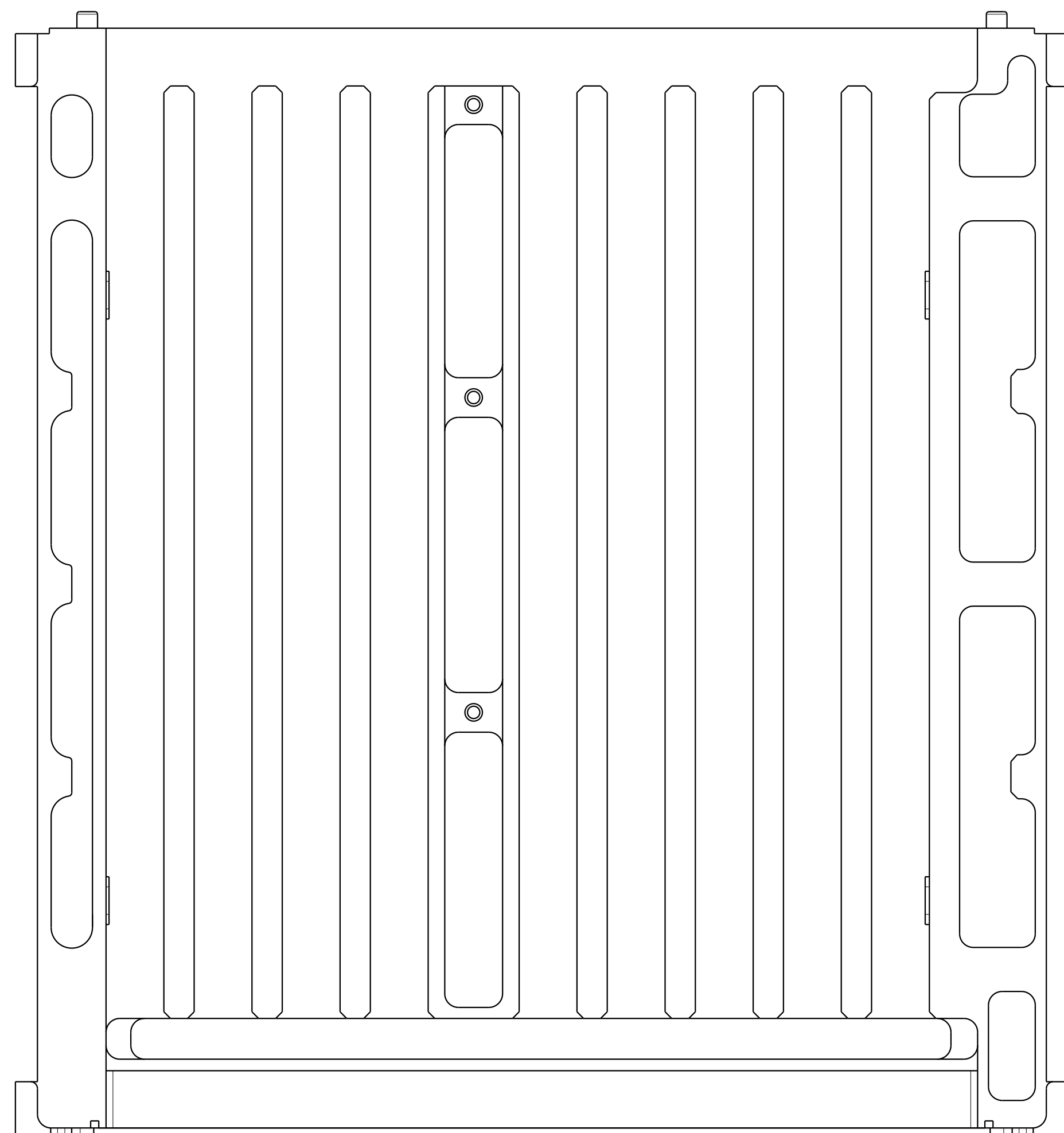
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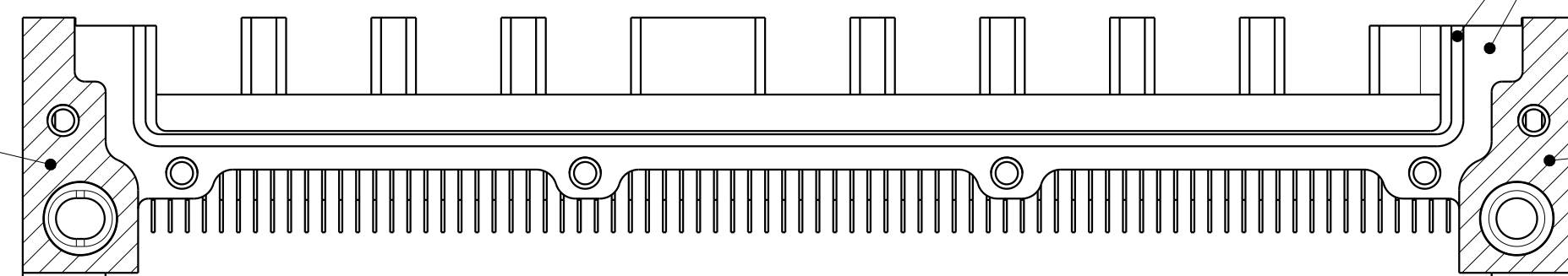


-1 ASSEMBLY
PAINT PATTERN

12

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12



12 BOTH SIDES

13
BOTH SIDES

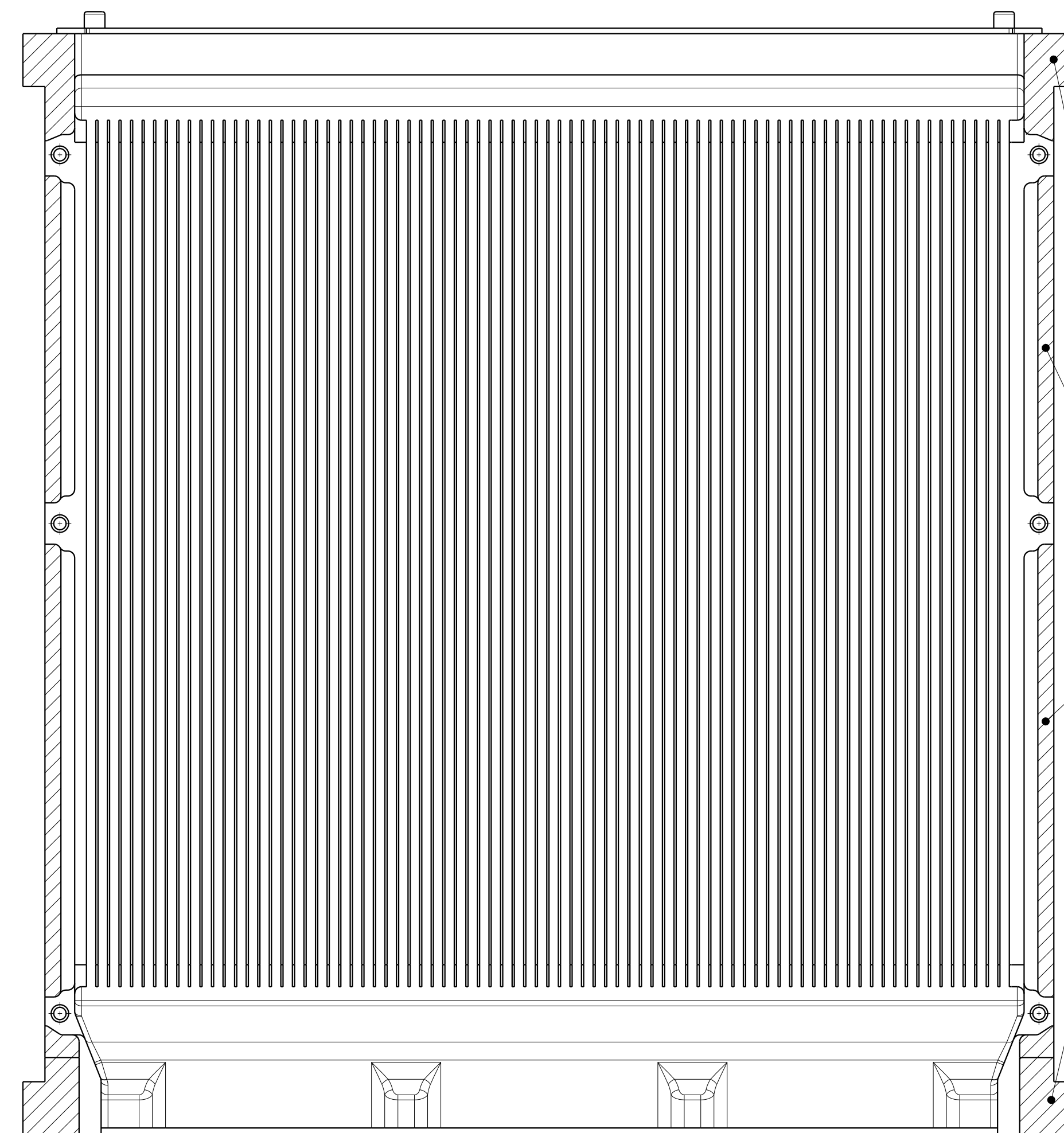
12 BOTH SIDES

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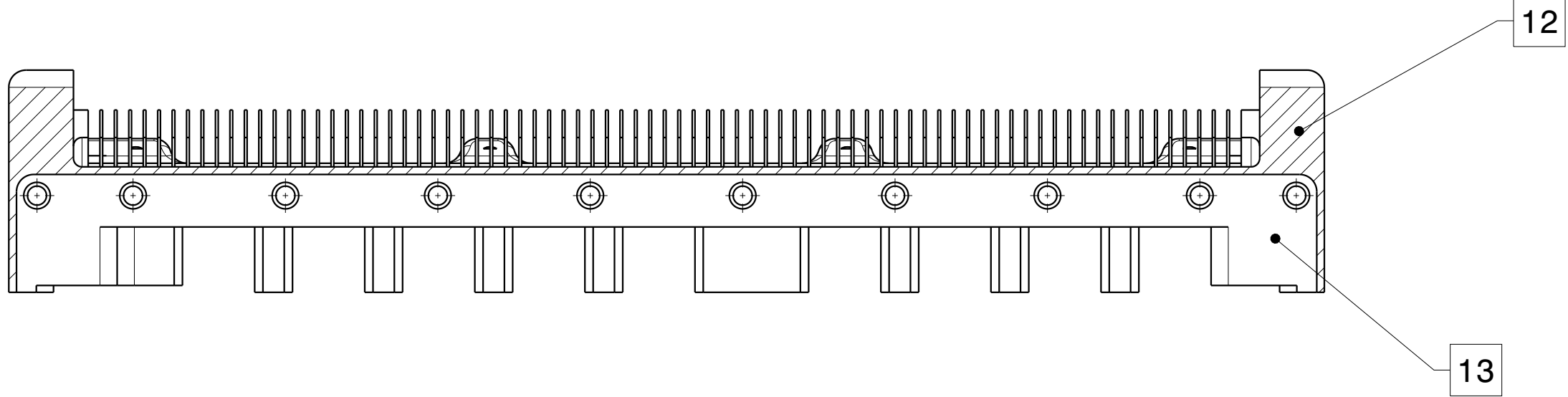
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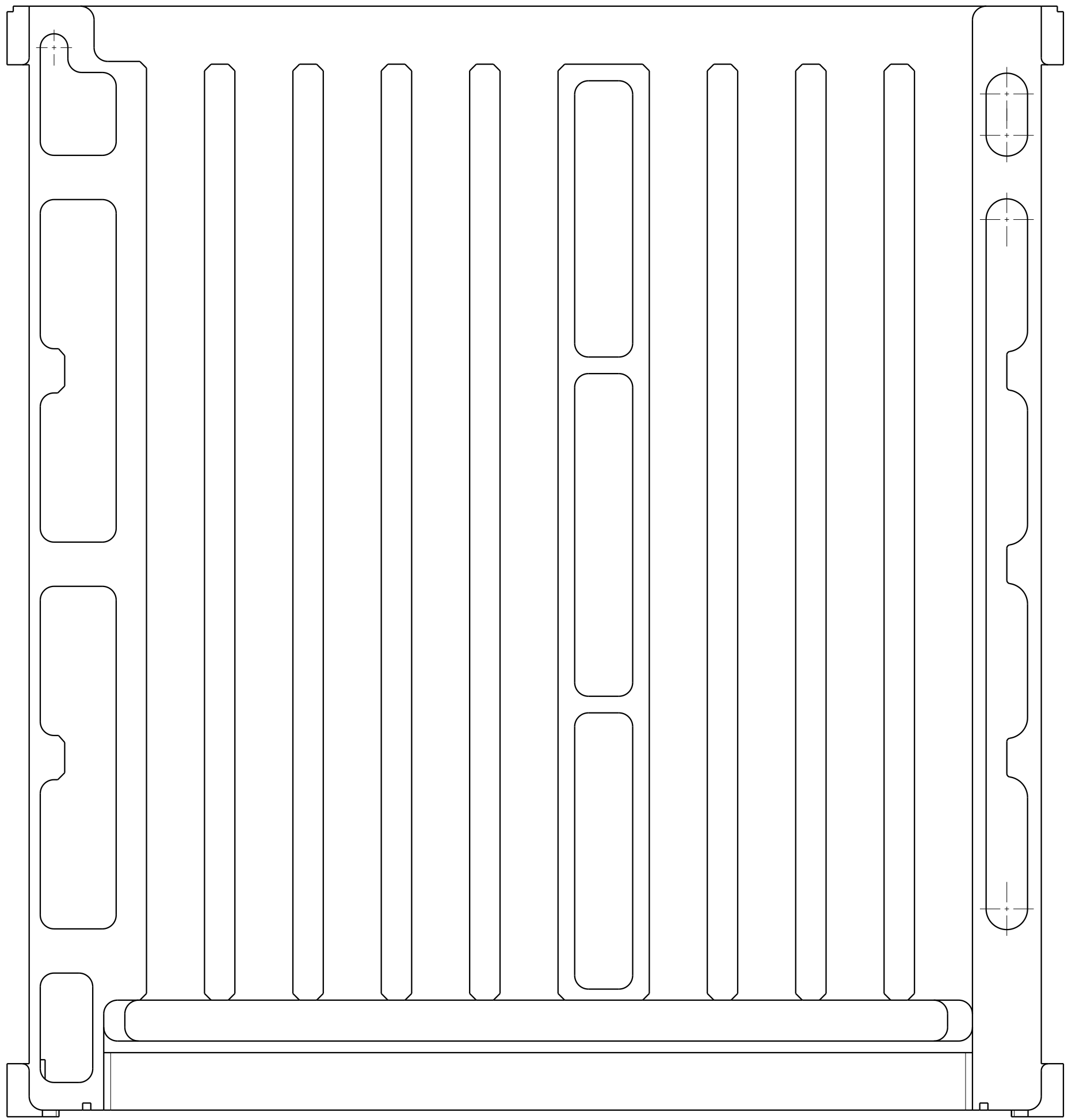
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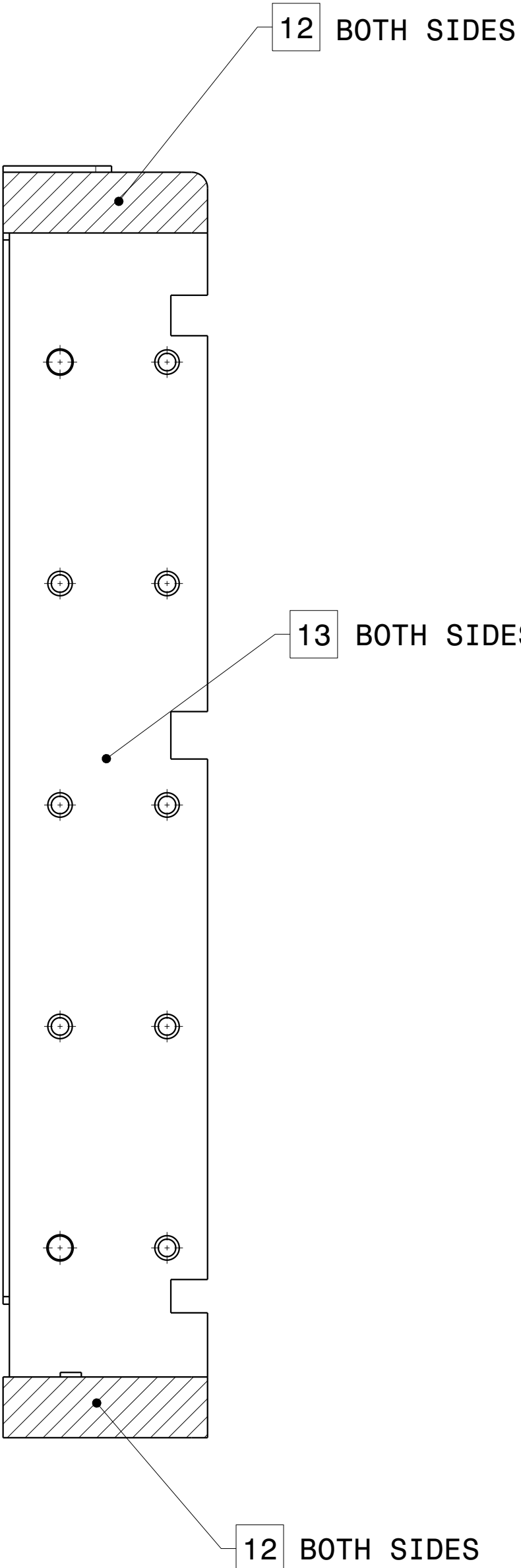
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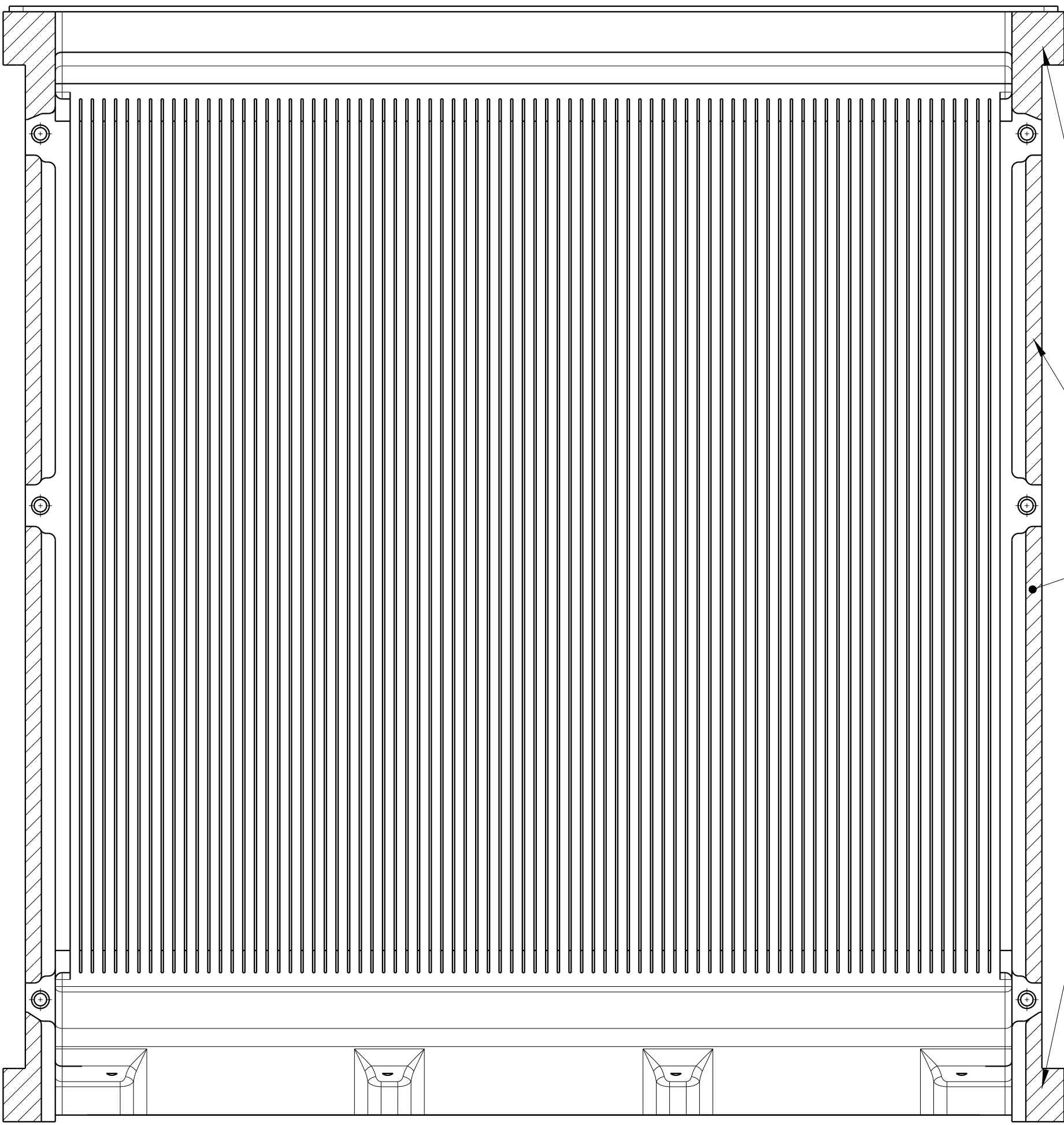


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-2 ASSEMBLY
PAINT PATTERN

