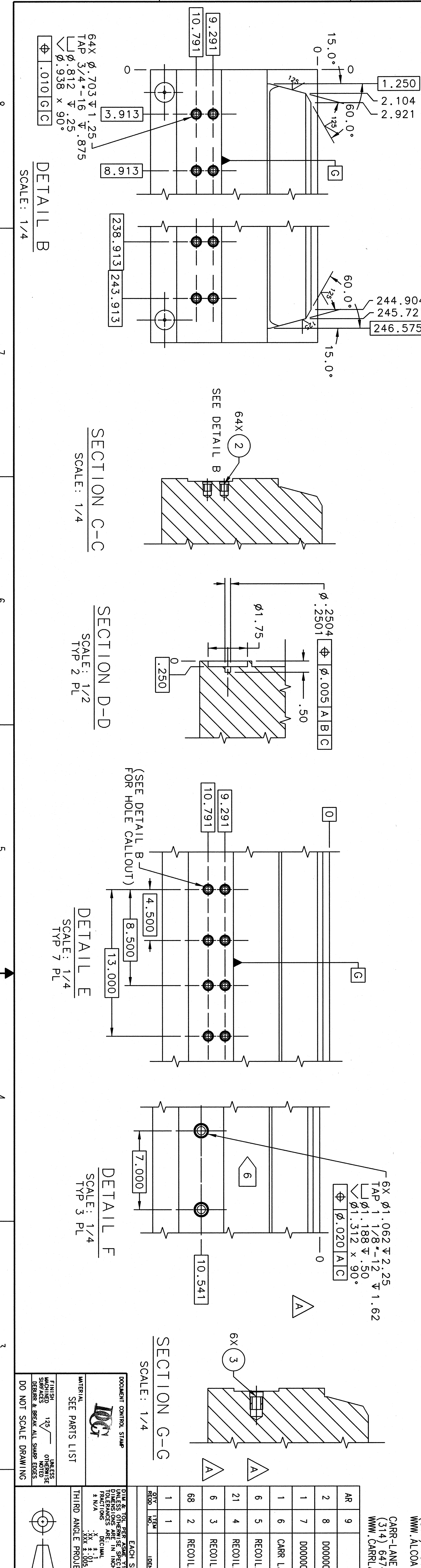
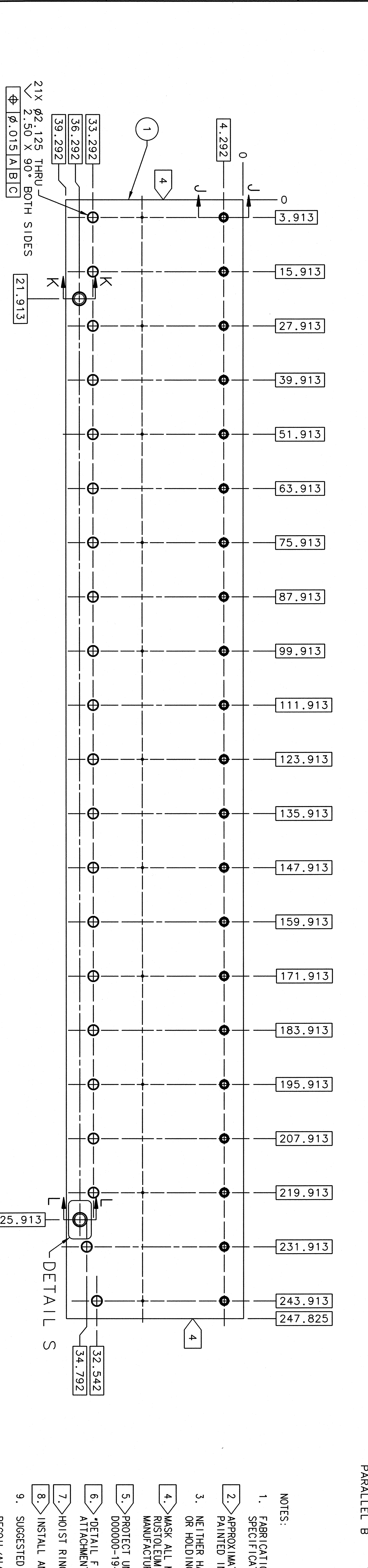
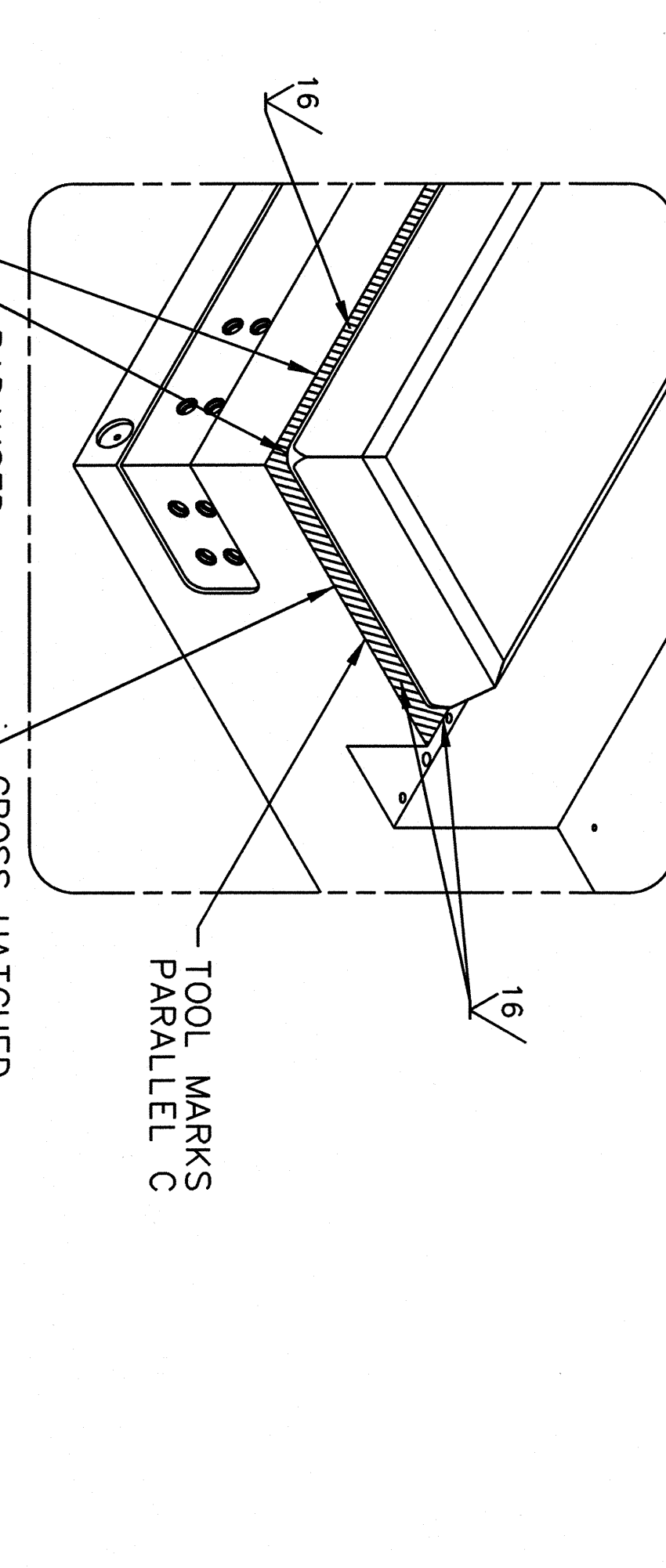
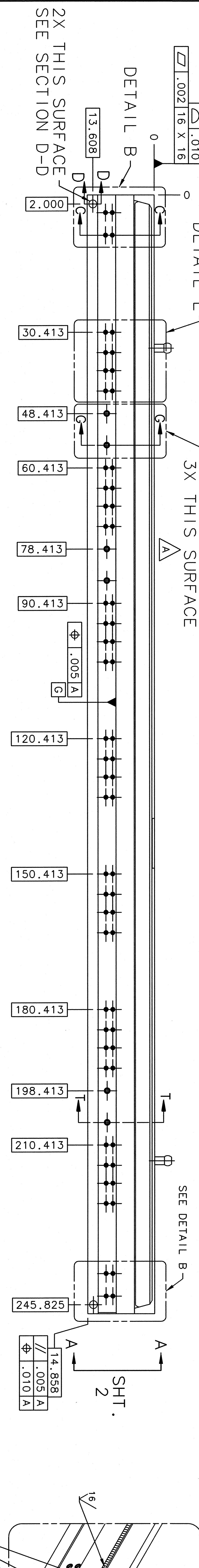
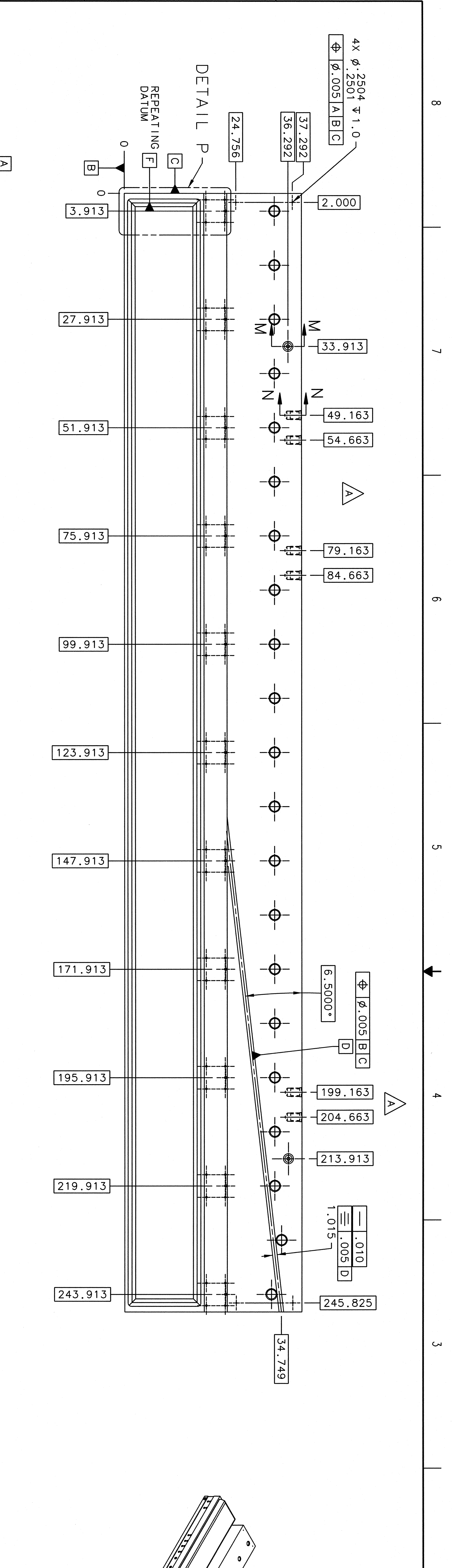


ZONE	REV	DESCRIPTION	DATE	APPROVED
2-28	A	ADDED FOR ADDITIONAL 1/8-12 TAPPED HOLES AND ADDED TWO ADDITIONAL 1/8-12 TAPPED HOLES AND ADDED FOUR ADDITIONAL 1/8-12 TAPPED HOLES AND REVISED DIMENSIONS FOR PARTS 5, 6, 7, 8, REVISED DWT OF ITEM 5, W/S 2. REVISED DWT OF ITEM 5, W/S 2. D. RATH 09/07/11	12 OCT 11	[Signature]
1-28	A	REVISION FOR PARTS 5, 6, 7, 8, REVISED DWT OF ITEM 5, W/S 4, REVISED DWT OF ITEM 5, W/S 2.	12 OCT 11	[Signature]
1-28	A	REVISION FOR PARTS 5, 6, 7, 8, REVISED DWT OF ITEM 5, W/S 4, REVISED DWT OF ITEM 5, W/S 2.	12 OCT 11	[Signature]



SECTION C-C SCALE: 1/4

SECTION D-D TYP 2 PL SCALE: 1/2

DETAIL E TYP 7 PL SCALE: 1/4

DETAIL F TYP 5 PL SCALE: 1/4

SECTION G-G SCALE: 1/4

SECTION H-H SCALE: 1/4

64X Ø.703 T 1.25 TAP 3/4-16 X 2.25 Ø.812 T .25 Ø.938 X 90°

21X Ø2.125 THRU 2.50 X 90° BOTH SIDES

6X Ø1.062 T 2.25 TAP 1 1/8-12 X 1.62 Ø1.188 T .50 Ø1.312 X 90° Ø.020 A C

6X Ø1.062 T 2.25 TAP 1 1/8-12 X 1.62 Ø1.188 T .50 Ø1.312 X 90° Ø.020 A C

- NOTES:
- FABRICATION/MATERIAL SPEC IN ACCORDANCE WITH THIS DRAWING AND SPECIFICATION D00000-19-00-S003.
  - APPROXIMATE WEIGHT = 36040 LBS. WEIGHT & PART NUMBER OF MAGNET TO BE PAINTED IN 2 HIGH CHARACTERS IN APPROXIMATE LOCATION SHOWN. COLOR RED. NEITHER HANDLING NOR MACHINING OPERATIONS SHALL USE MAGNETS FOR LIFTING OR HOLDING DOWN AFTER FINAL ANNEALING PROCESS.
  - MASK ALL MACHINED HOLES AND FINISH IDENTIFIED OUTER SURFACES WITH RUSTOLEUM PRIMER & RUSTOLEUM #866402 (MARLIN BLUE) PAINT PER MANUFACTURERS INSTRUCTIONS.
  - PROTECT UNPAINTED SURFACES PER SECTION 2.1.6 IN SPECIFICATION D00000-19-00-S003.
  - DETAIL F \* (2 PLACES) IS AN ATTACHMENT LOCATION FOR LIFTING PLATE ATTACHMENT. SEE SECTION "T-T".
  - HOLE RING ATTACHMENT POINT.
  - INSTALL AND BOND AFTWARDS WITH WICKING LOCTITE #290.
  - SUGGESTED SOURCES OR JLAB APPROVED ALTERNATE:
    - RECOIL/ALCOA (317) 704-8864 WWW.ALCOA.COM
    - CARR-LANE MFG. CO. (317) 415-6200 WWW.CARR-LANE.COM

AR	9	LOCTITE #290	8
2	8	D00000-19-00-2001 TAPPER TOOLING BALL	
1	7	D00000-19-00-2000 SEMI-HARD SLOT INSERT	
1	6	CARR LANE L-176-48 DRILL LINER BUSHING 2.25 ID X 2.75 OD X 3.0 LG	
6	5	RECOIL/ALCOA 73242 1.50-6 KEYSERT	9
21	4	RECOIL/ALCOA 73202 1.25-7 KEYSERT	9
6	3	RECOIL/ALCOA 73122 .75-10 KEYSERT	9
68	2	RECOIL/ALCOA 73082 .50-13 KEYSERT	9
1	1	LOWER MAGNET ROLL	1.2