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de HAVILLAND

CAGE CODE 71867

CSP STANDARD

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SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	EDWARDS	WASHER, SADDLE	CSP 306
CHECKED	EDWARDS		
STRESSED			SHEET: 1
APPROVED	EDWARDS		

REVISION TABLE UPDATED, SHEET "1" HAS BEEN RAISED AT ISSUE "AL"
INDEX TABLE REVISED CSP306-130 ADDED.

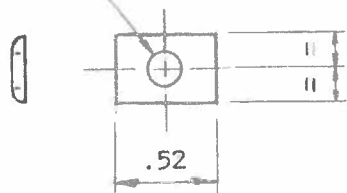
APPROVED: 30 SEP 1970 REV: AF - 17 APR 2012 REV: AG - 23 APR 2013 REV: AH - 10 JAN 2014 REV: AJ - 4 JUN 2015 REV: AK - 21 OCT 2015 REV: AL - 25 JAN 2018



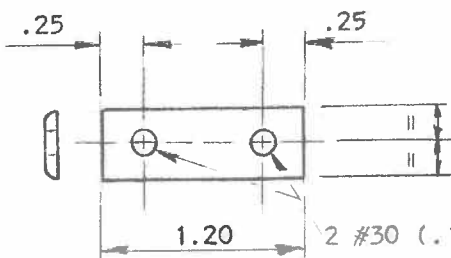
STANDARDS SHEET

#9 (.196 dia.) Hole

Make From CV 350
Finish C1 or A1

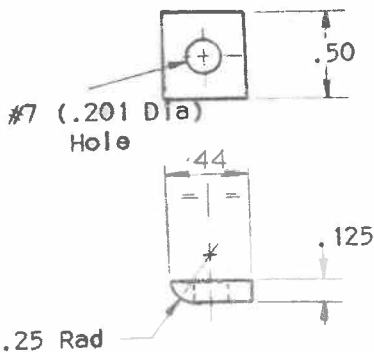


-1



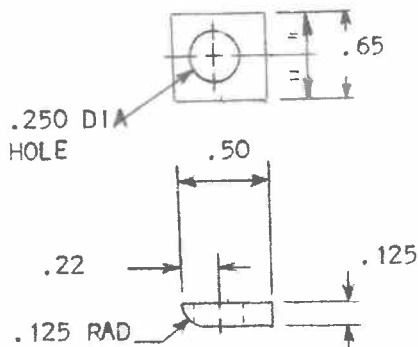
Make From CV 350
Finish C1 or A1
Interchangeable With C4W1943-27

-2



.125 Alclad 2024-T3
QQ-A-250/5
Finish C1 or A1

-3



.125 Alclad 2024-T3
QQ-A-250/5
Finish C1 or A1

-4

DRAWN	SCHRATNER
CHECKED	
STRESSED	
APPROVED	

CLASSIFICATION

STANDARD

WASHER-SADDLE

CSP 306

30 SEPT 70

PAGE 1 CHANGED TO PAGE 1A M.R. 30 SEPT 70

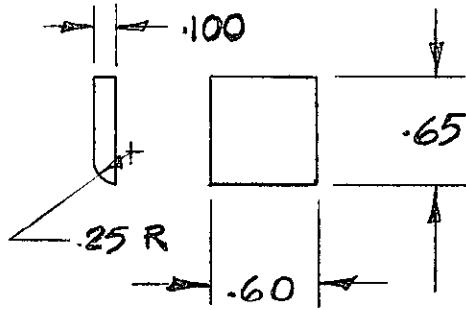
(D)

(C) FINISH ON 123 WAS 1 44 28"

(E) -4 ADDED JAN 77 D.L.

(A) -3 ADDED NOV 70 S.S.

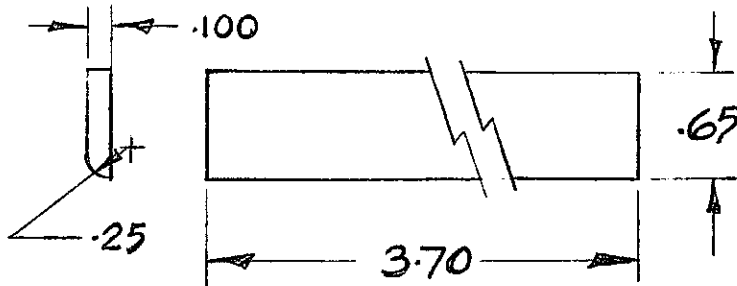
STANDARDS SHEET



MATERIAL: .100 2024 T3
QQ-A-250/5

FINISH: C1 + F19

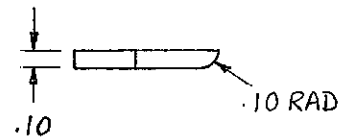
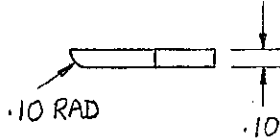
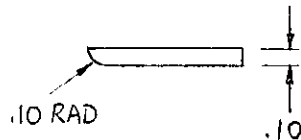
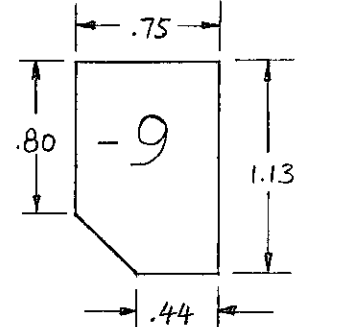
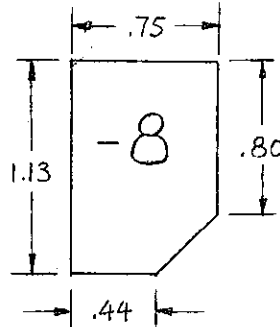
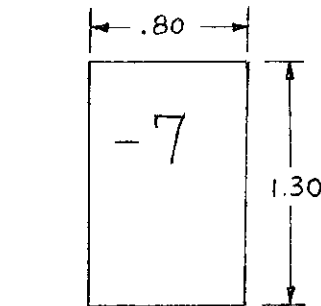
-5



MATERIAL: .100 2024 T3
QQ-A-250/5

FINISH: C1 + F19

-6



MATERIAL: .100 THICK 2024 QQ-A-250/5 T3
FINISH: C1 + F19

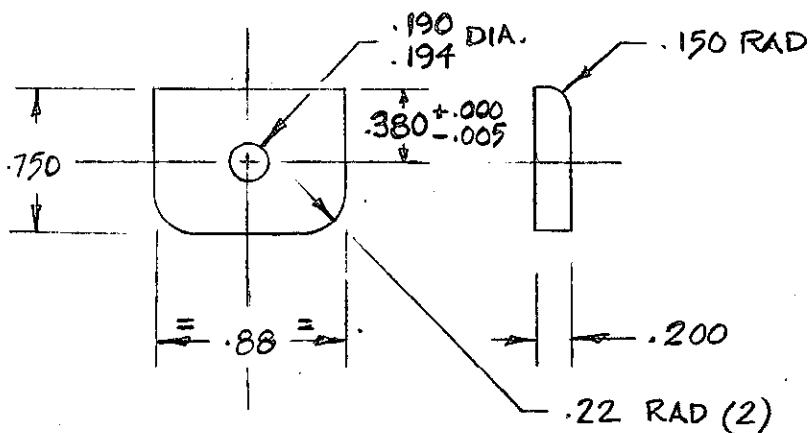
DRAWN	KROMKAMP	CLASSIFICATION	STANDARD
CHECKED	AK	WASHER - SADDLE	CSP 306
STRESSED	WLB		
APPROVED	SEMPER		

28 JUN 79

① -7, -8, -9 ADDED
PLAN 3.4.81



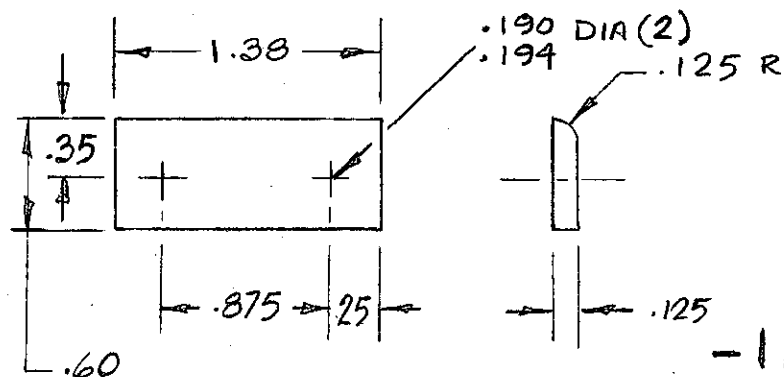
STANDARDS SHEET



MATERIAL: 7075 T6
QQ-A-250/13

FINISH: A1 + F19

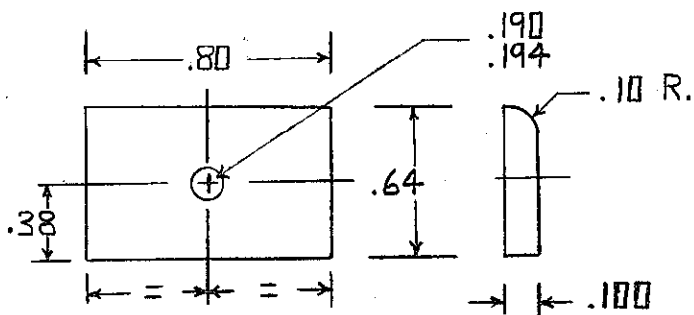
-10



MATERIAL: .125 2024-T3
QQ-A-250/5

FINISH: A1 + F19

-11



MATERIAL: .100 THK. 2024-T3
QQ-A-250/5

FINISH: A1 + F19

-12

DRAWN	KROMKAMP	CLASSIFICATION	STANDARD
CHECKED	FLANNERY	WASHER - SADDLE	CSP 306
STRESSED	6/1/62		
APPROVED	SCHWARTZ		

STDS M.P. 7 OCT 81

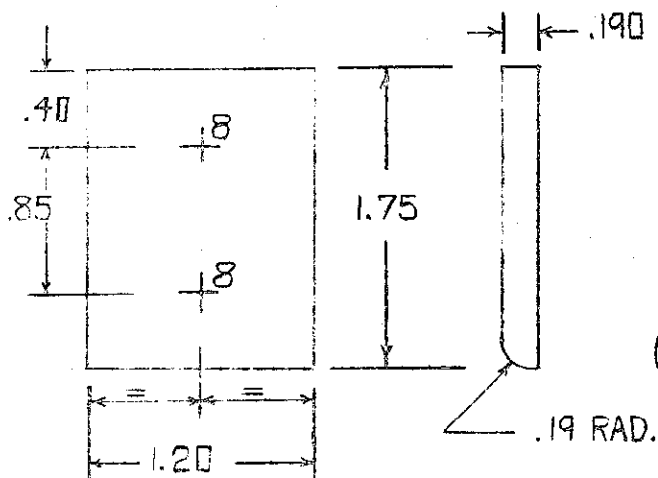
(A) -11 ADDED

QAR 30 MAR 82

(B) -12 ADDED M.R. 5 MAY 82



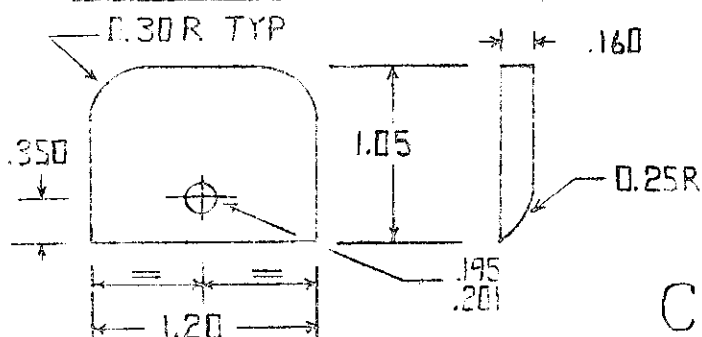
STANDARDS SHEET



MATERIAL : 7075/T6
QQ-A-250/13

FINISH: CI + FI9

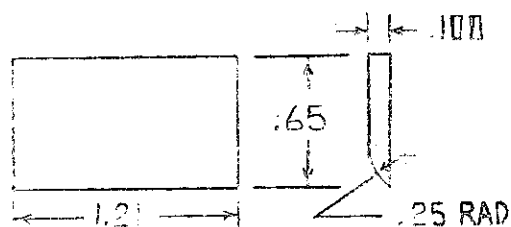
CSP 306-13



MATERIAL: .160 2024 T3
QQ-A-250/5

FINISH: AI + FI9

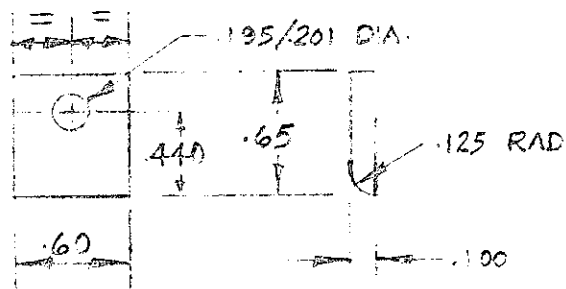
CSP 306-14



MATERIAL : .100 2024 T3
QQ-A-250/5

FINISH: AI + FI9

CSP 306-15



MATERIAL: .100 2024 T3
QQ-A-250/5

FINISH: CI + FI9

CSP 306-16

DRAWN	M. ROSS	CLASSIFICATION	STANDARD
CHECKED	D. CHENG	WASHER - SADDLE	CSP 306
STRESSED	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		

DATE: 17.5.82

② -16 ADDED
27.3.82

-15 ADDED 9 JULY 82 M. ROSS

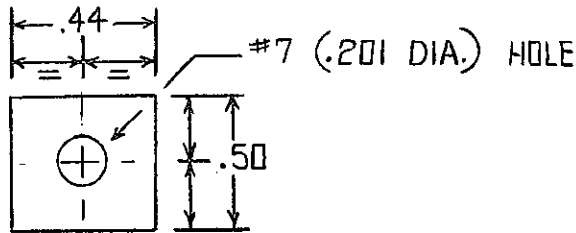
-14 ADDED 7 JUNE 82 M. ROSS

②

①



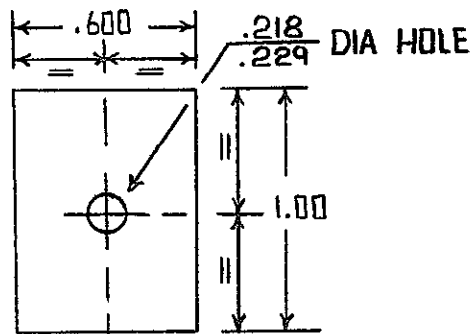
STANDARDS SHEET



MATERIAL : 303Se COND. A
QQ-S-764

FINISH: PASSIVATE TO
P.P.S. 31.05

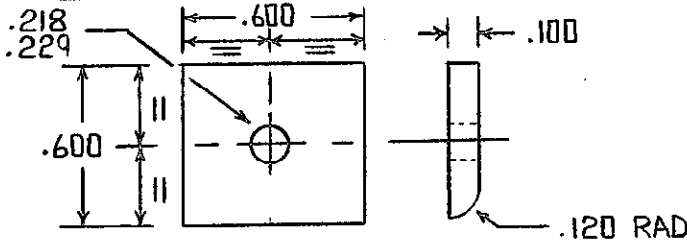
CSP 306-17



MATERIAL : .125 2024-T3 CLAD
QQ-A-250/5

FINISH: C1+F19

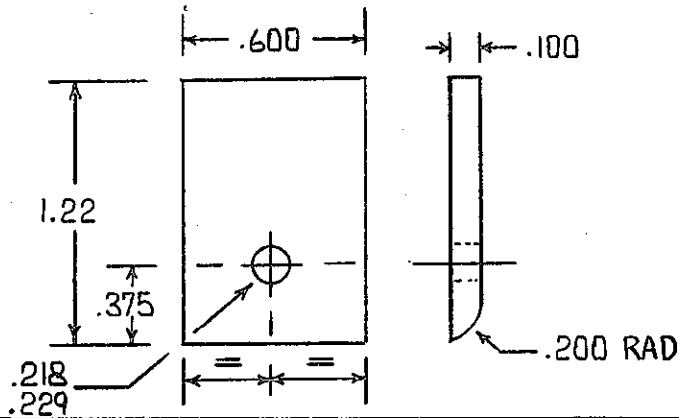
CSP 306-18



MATERIAL : .100 2024-T3 CLAD
QQ-A-250/5

FINISH: C1+F19

CSP 306-19



MATERIAL : .100 2024-T3 CLAD
QQ-A-250/5

FINISH: C1+F19

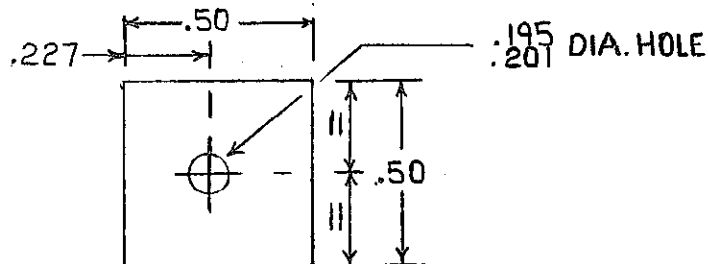
CSP 306-20

(A) -18-19-20 ADDED. M. RUSSO 8 DEC 82

DRAWN	M. RUSSO	CLASSIFICATION	STANDARD
CHECKED	RAY	WASHER-SADDLE	CSP 306
STRESSED	RAY		
APPROVED	SCHWARTZ		



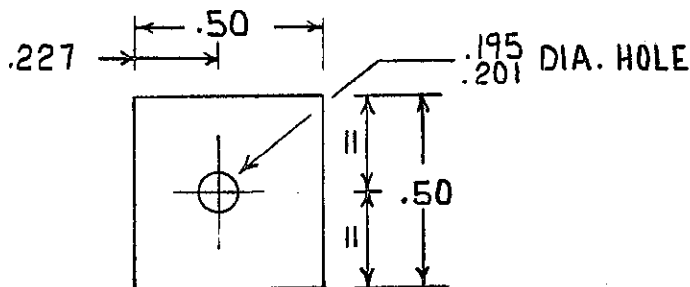
STANDARDS SHEET



MATERIAL : .100 7075 T6
QQ-A-250/13

FINISH : AI + FI9

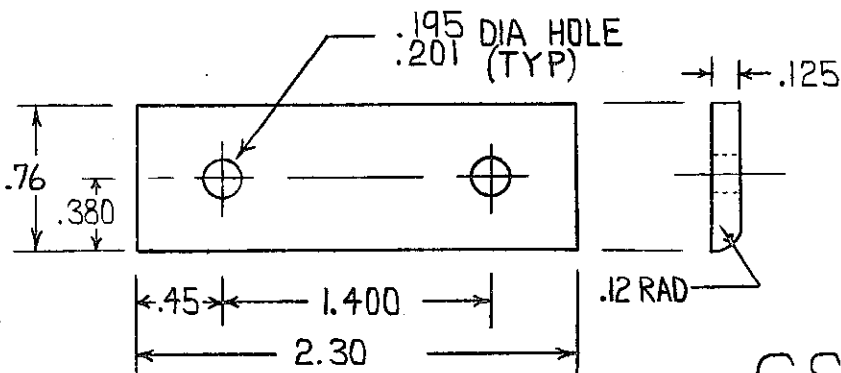
CSP 306-21



MATERIAL : .100 7075 T6
QQ-A-250/13

FINISH : AI + FI9

CSP 306-22



MATERIAL : .125 7075 T6
QQ-A-250/13

FINISH : AI + FI9

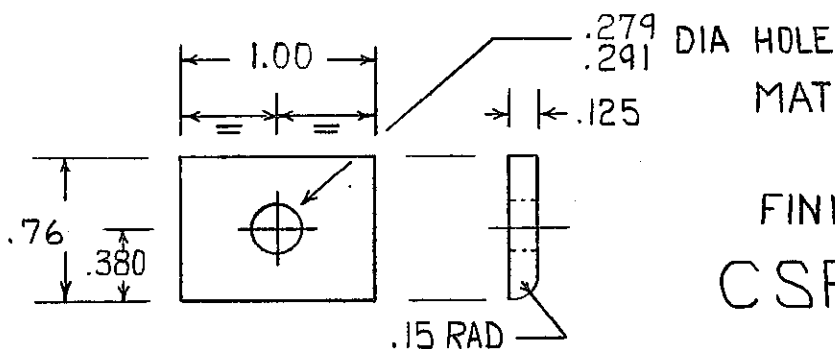
CSP 306-23

DRAWN	M. ROSSO	CLASSIFICATION	STANDARD
CHECKED	Kromkamp	WASHER- SADDLE	CSP 306
STRESSED	M. Elliott		
APPROVED	S. J. Smith		

STB HCV 13 JAN 83

B-23 ADDED M. ROSSO 22 APRIL 83
A-22 ADDED M. ROSSO 9 MAR 83

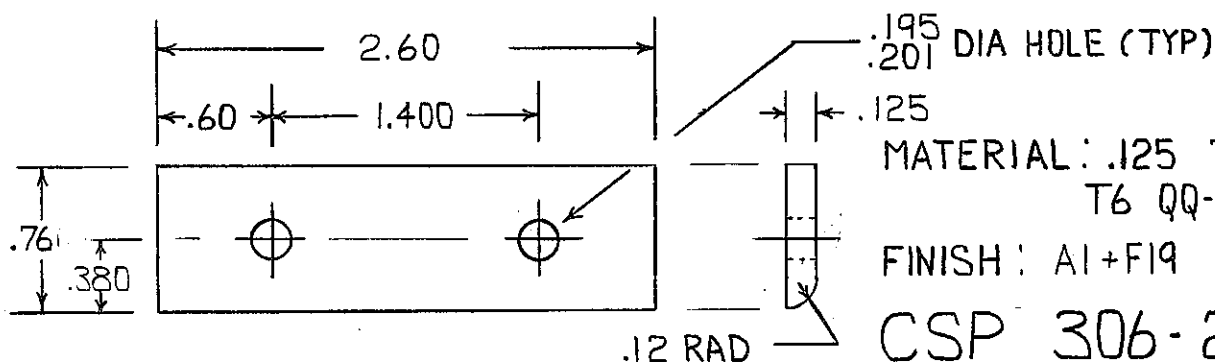
STANDARDS SHEET



MATERIAL : .125 7075 T6
QQ-A-250/13

FINISH : AI+FI9

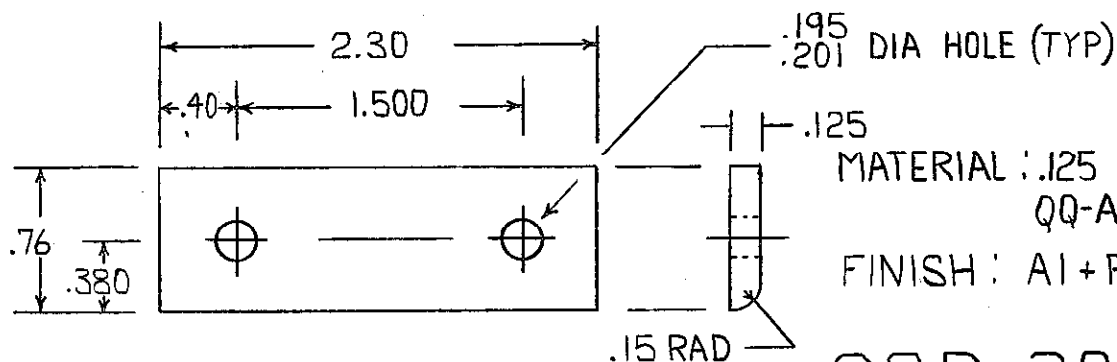
CSP 306-24



MATERIAL : .125 7075 T6
QQ-A-250/13

FINISH : AI+FI9

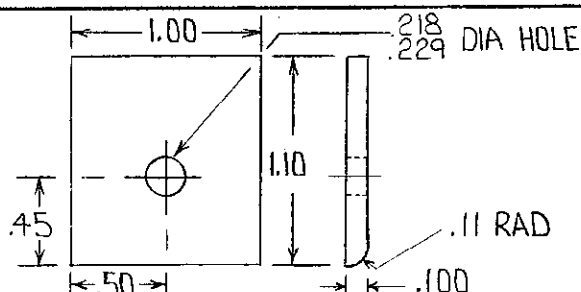
CSP 306-25



MATERIAL : .125 7075 T6
QQ-A-250/13

FINISH : AI+FI9

CSP 306-26



MATERIAL : .100 2024 T3
QQ-A-250/5

FINISH : CI+FI9

CSP 306-27

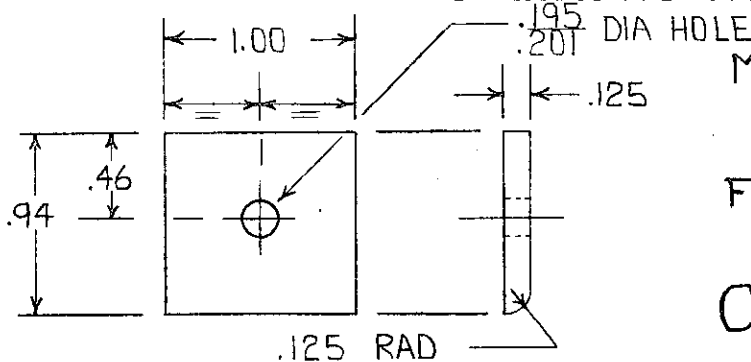
DRAWN	M.ROSSO	CLASSIFICATION	STANDARD
CHECKED	Kromkorp	WASHER-SADDLE	CSP 306
STRESSED	11/11/80		
APPROVED	Schmitt		

25 APRIL 83

-27 ADDED 3 OCT 84 M.ROSSO

(A)

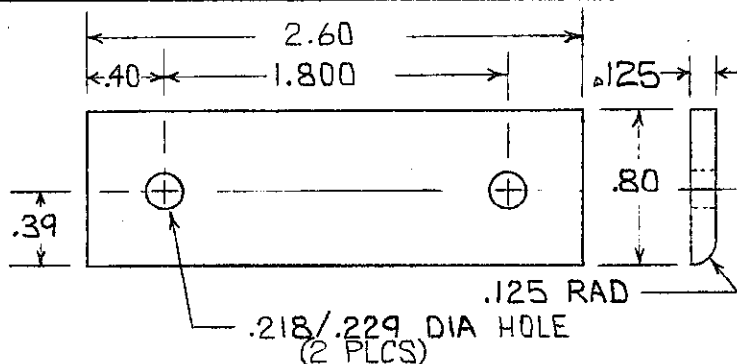
STANDARDS SHEET



MATERIAL: .125 2024 T3
QQ-A-250/15

FINISH: CI + FI9

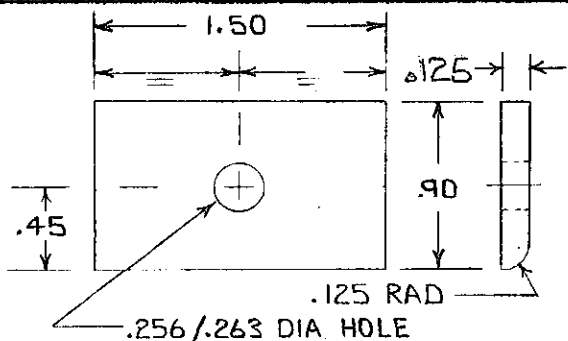
CSP 306-28



MATERIAL: .125 7075 T6
QQ-A-250/13

FINISH: AI + FI9

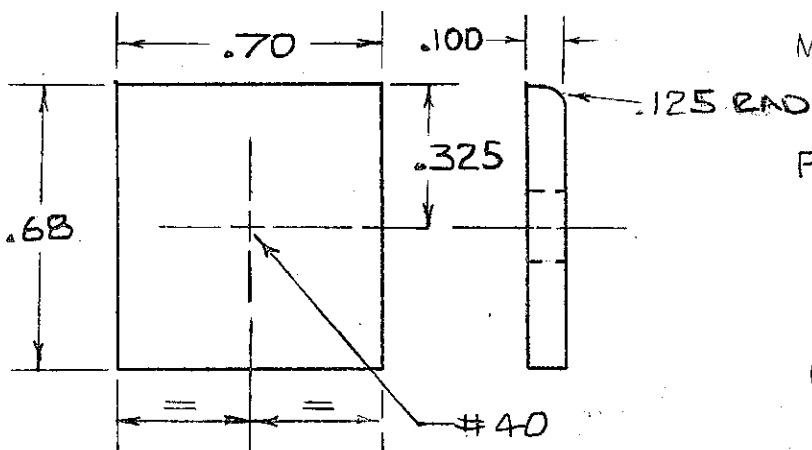
CSP 306-29



MATERIAL: .125 7075 T6
QQ-A-250/13

FINISH: AI + FI9



CSP 306-30




MATERIAL: 2024-T3
QQ-A-250/5
.100 THK

FINISH: CI + FI9

CSP 306-31

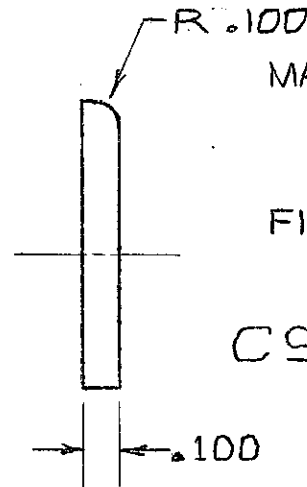
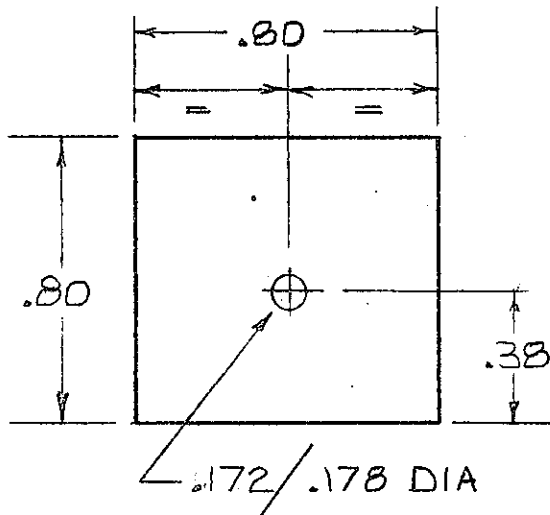
-31 ADDED, 7-10-86 R.S. 
 -29-30 ADDED, 8 JAN 86 M.ROSSO 

DRAWN	M.ROSSO	CLASSIFICATION	STANDARD
CHECKED	KROHMAN	WASHER - SADDLE	CSP 306
STRESSED			
APPROVED	SCHATTNER		

9 SEPT 85



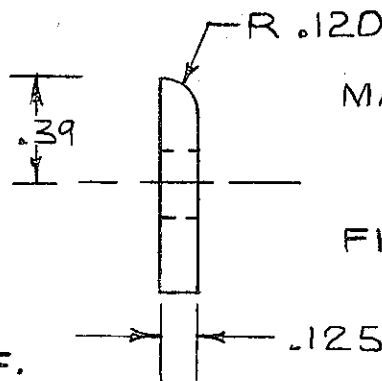
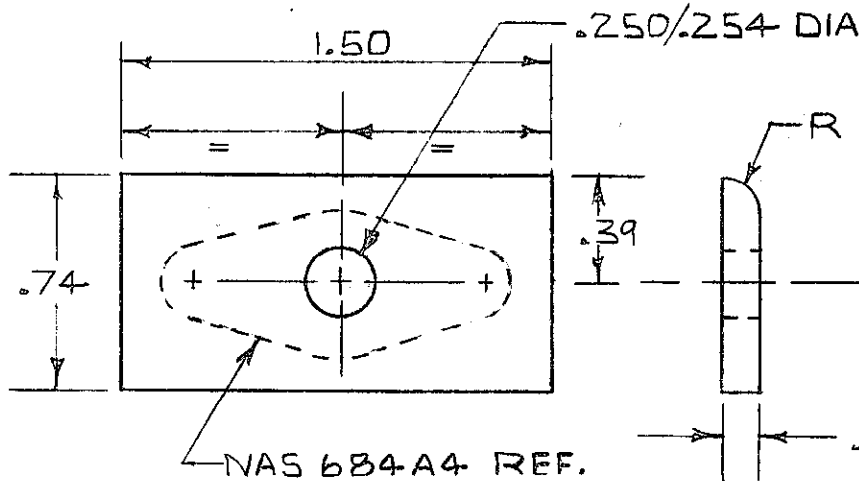
STANDARDS SHEET



MATERIAL: 2024-T3
QQ-A-250/5
.100 THK

FINISH: C1 + F19

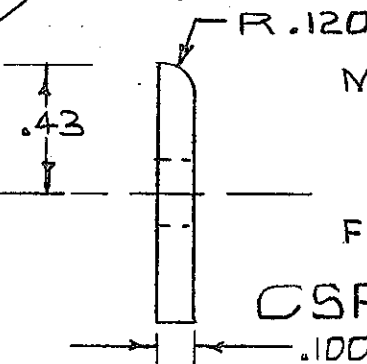
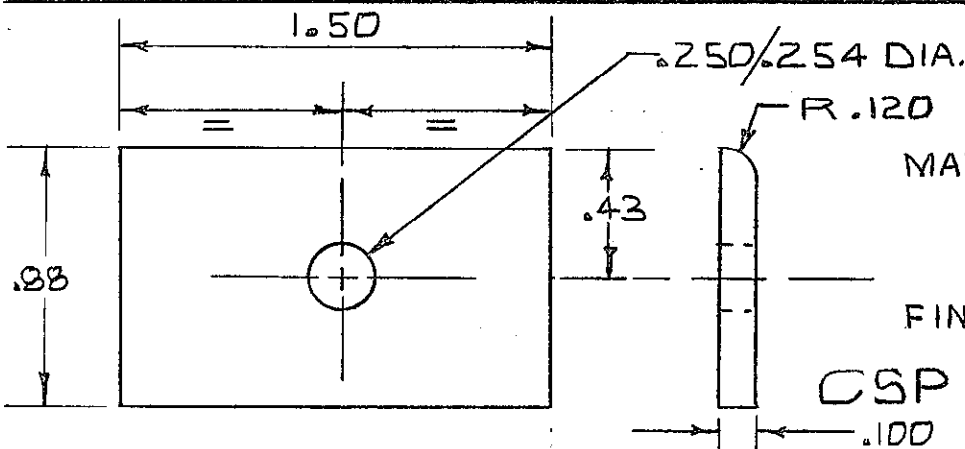
CSP 306-32



MATERIAL: 2024-T3
QQ-A-250/5
.125 THK

FINISH: C1 + F19

CSP 306-33



MATERIAL: 2024-T3
QQ-A-250/5
.100 THK

FINISH: C1 + F19

CSP 306-34

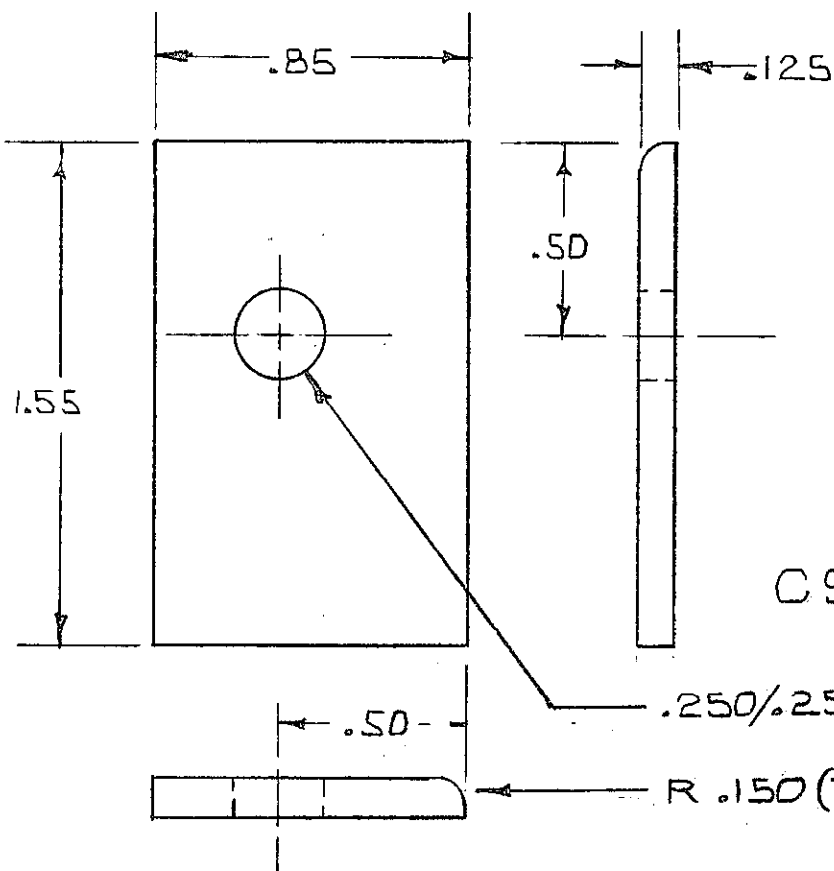
DRAWN	R STOKES	CLASSIFICATION	STANDARD
CHECKED	P Lam	WASHER-SADDLE	CSP 306
STRESSED	M. G. H.		
APPROVED	SCHWARTZ		

16 FEB 87

1-6-68 887



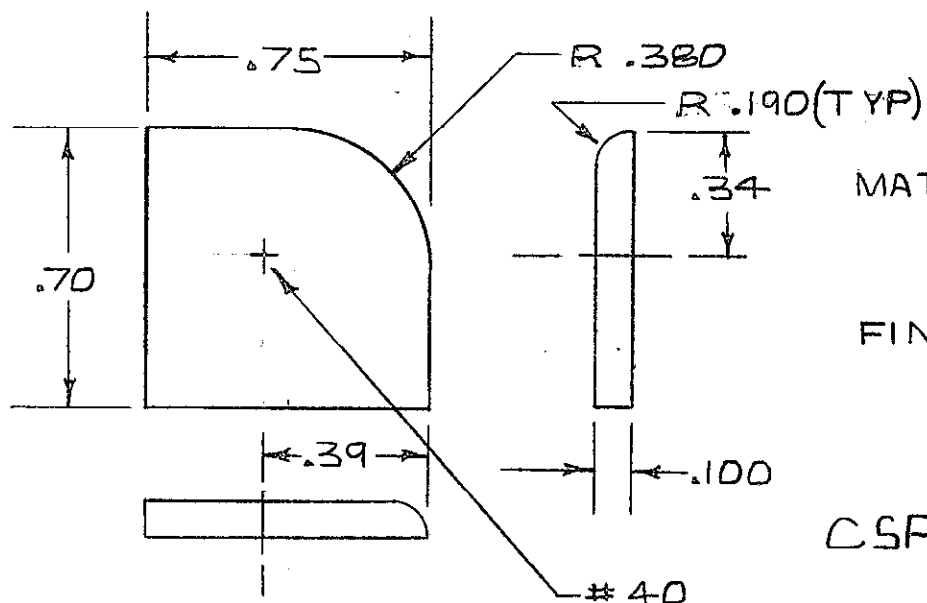
STANDARDS SHEET



MATERIAL: 2024-T3
QQ-A-250/5
.125 THK

FINISH: CI+F19

CSP 306-37



MATERIAL: 2024-T3
QQ-A-250/5
.100 THK

FINISH: CI+F19

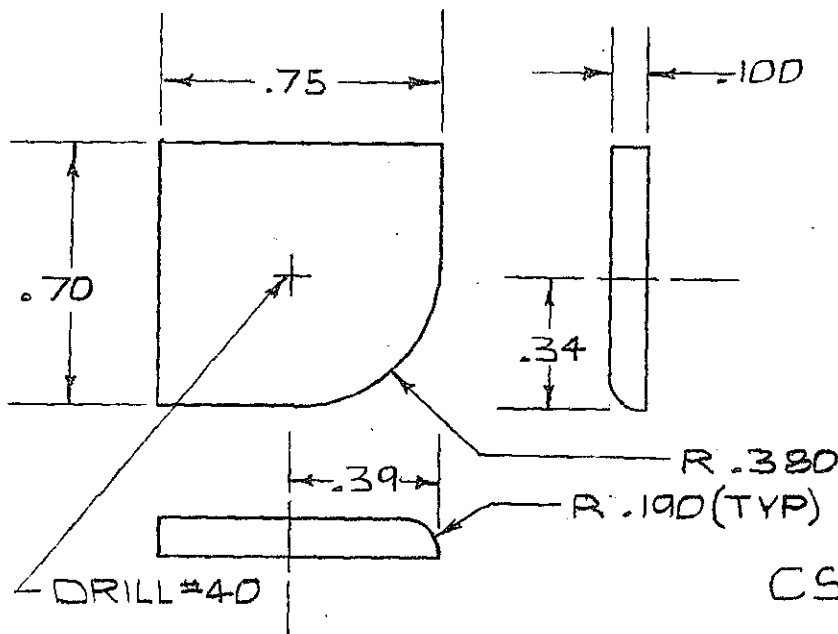
CSP 306-38

DRAWN	R. STOKES	CLASSIFICATION	STANDARD
CHECKED	P. LAM	WASHER SADDLE	CSP 306
STRESSED	M. S. S. S.		
APPROVED	SCHWARTZ		

16 FEB 57



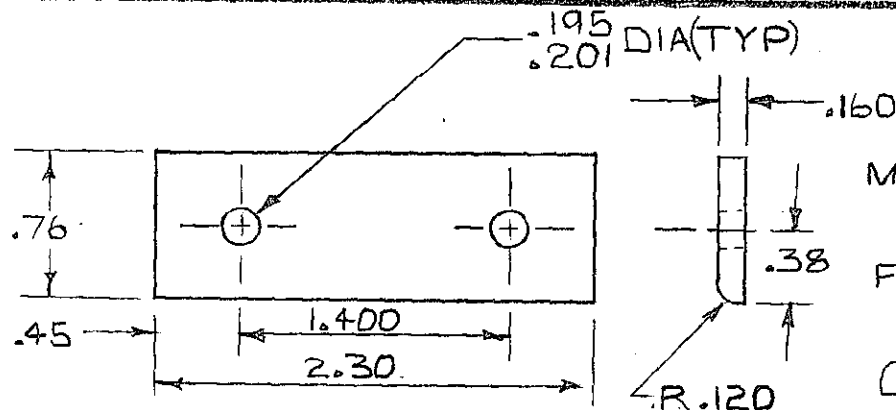
STANDARDS SHEET



MATERIAL: 2024-T3
QQ-A-250/5
.100 THK

FINISH: C1 + F19

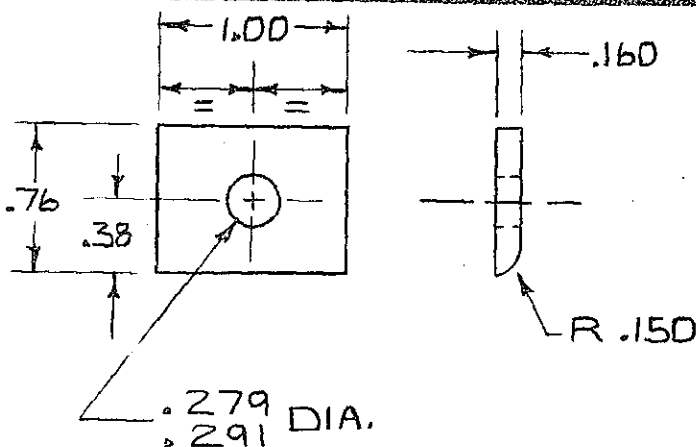
CSP 306-39



MATERIAL: 7075-T6
QQ-A-250/13
.160 THK

FINISH: A1 + F19

CSP 306-40



MATERIAL: 7075-T6
QQ-A-250/13
.160 THK

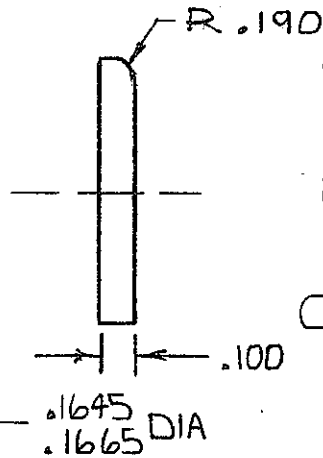
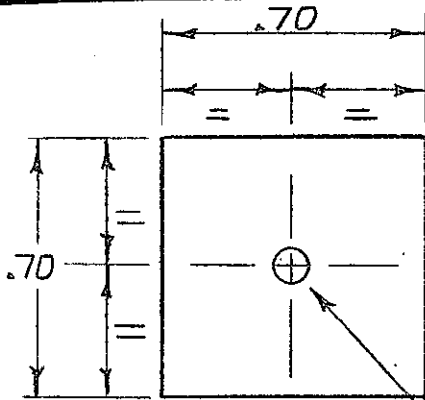
FINISH: A1 + F19

CSP 306-41

DRAWN	R. STOKES	CLASSIFICATION	STANDARD
CHECKED	P. L. H. H.	WASHER SADDLE	CSP 306
STRESSED	M. H. H.		
APPROVED	S. H. H.		

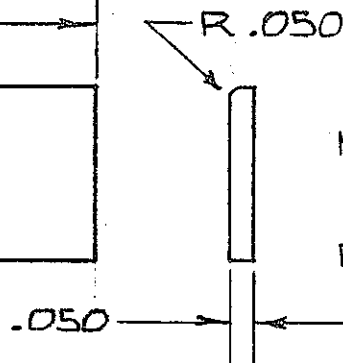
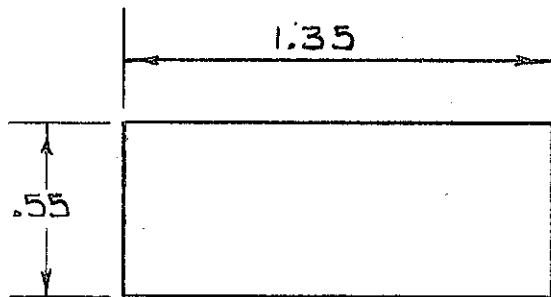


STANDARDS SHEET



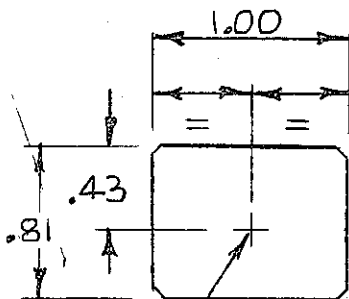
MATERIAL: 2024-T3
QQ-A-250/5
.100 THK
FINISH: CI+F19

CSP 306-42

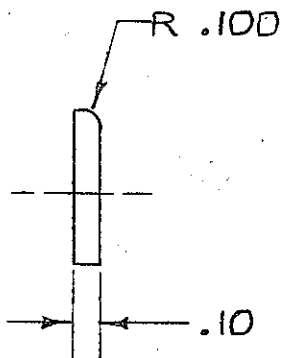


MATERIAL: 2024-T3
QQ-A-250/5
.050 THK
FINISH: CI+F19

CSP 306-43

#40
HOLE

.05 x 45°
CHAMFER 4 PLC'S



MATERIAL: 2024-T3
QQ-A-250/5
.100 THK
FINISH: CI+F19

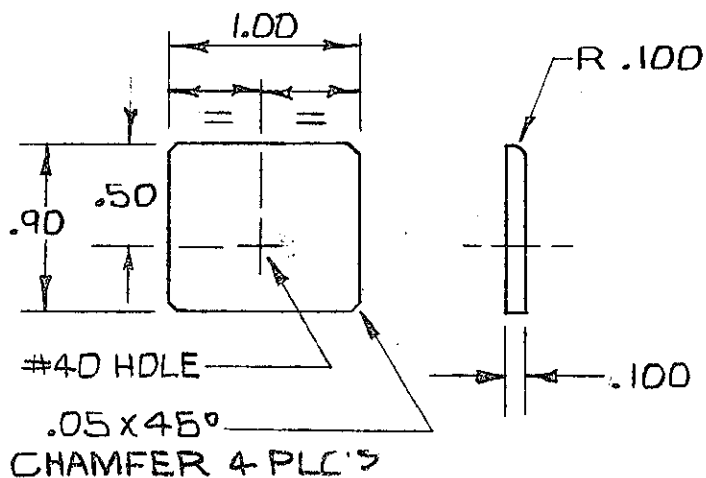
CSP 306-44

DRAWN	R. STOKES	CLASSIFICATION	STANDARD
CHECKED	SCHRAMM	WASHER-SADDLE	CSP 306
STRESSED	M. Smith		
APPROVED	B		

16 FEB 87

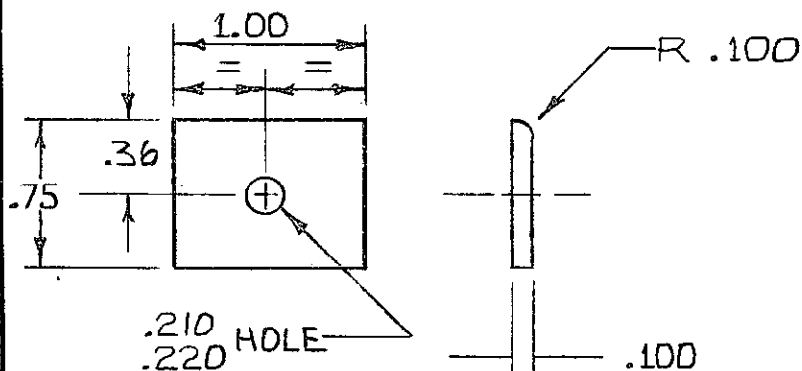


STANDARDS SHEET



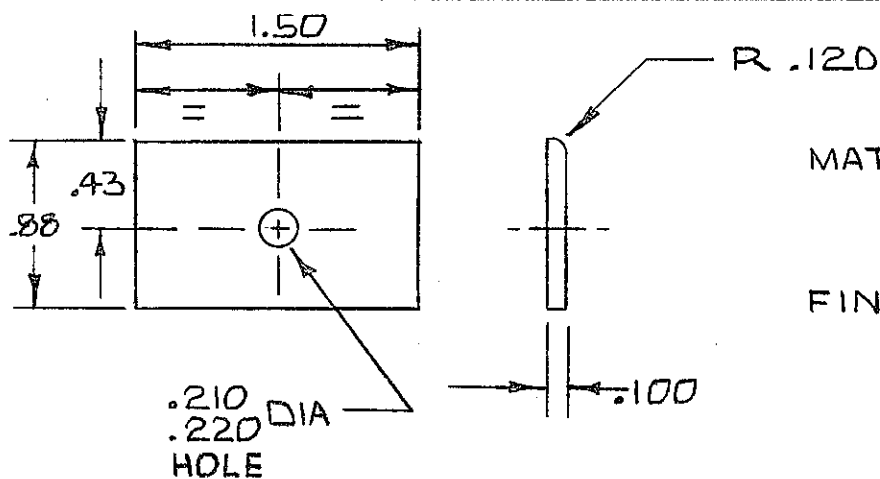
MATERIAL: 2024-T3
QQ-A-250/5
.100 THK
FINISH: CI + FI9

CSP 306-45



MATERIAL: 2024-T3
QQ-A-250/5
.100 THK
FINISH: CI + FI9

CSP 306-46

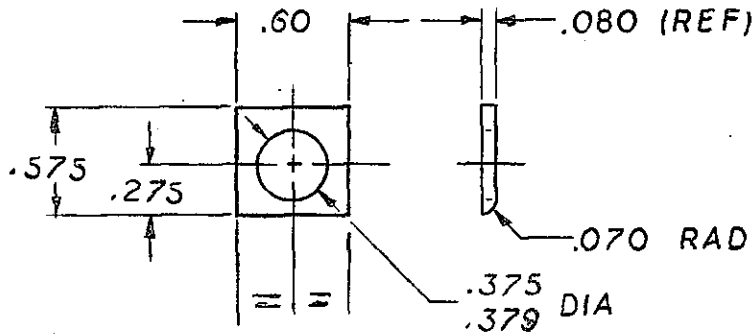


MATERIAL: 2024-T3
QQ-A-250/5
.100 THK
FINISH: CI + FI9

CSP 306-47

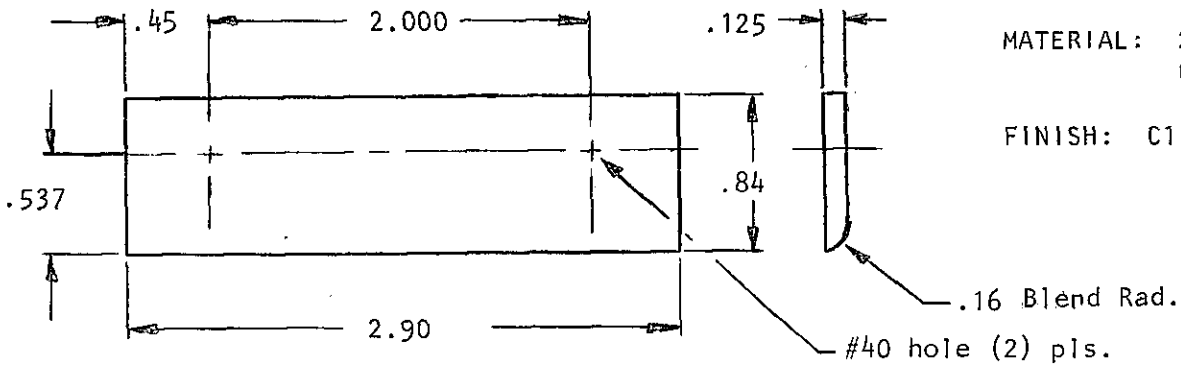
DRAWN	R STOKES	CLASSIFICATION	STANDARD
CHECKED	<i>Schubert</i>	WASHER - SADDLE	CSP 306
STRESSED	<i>W. H. H.</i>		
APPROVED	<i>R</i>		

STANDARDS SHEET



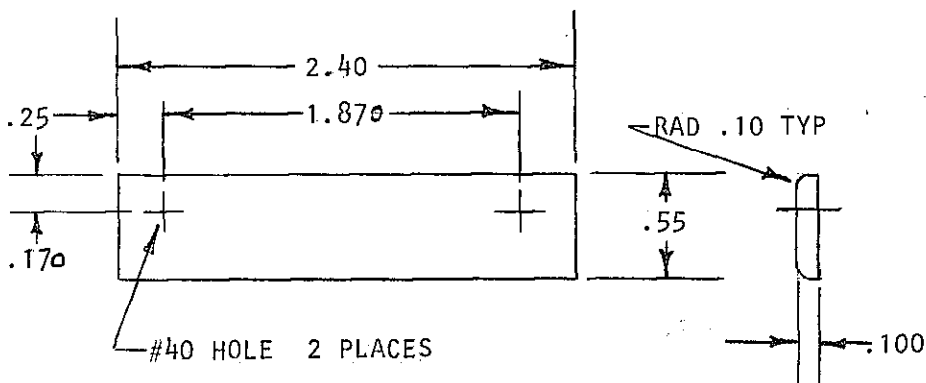
MAT'L: 2024 T3
QQ-A-250/5
.080 THICK
FINISH: C1 & F19

CSP 306-48



MATERIAL: 2024 T3
QQ-A-250/5
FINISH: C1 & F19

CSP 306-49



MATERIAL: 2024 T3
QQ-A-250/5
.100 THK
FINISH: C1 & F19

CSP 306-50

DRAWN	GILCHRIST	CLASSIFICATION		STANDARD
CHECKED	<i>K. K. K.</i>	WASHER SADDLE		CSP 306
STRESSED	<i>S. S. S.</i>			
APPROVED	SCHREATTNER			

M & S 14 APRIL 87

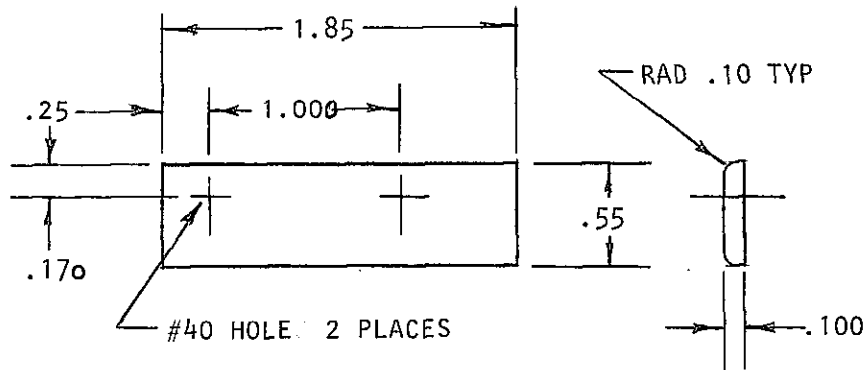
-49 Added 01/May/87

50 ADDED 10/6/87 RS

A

B

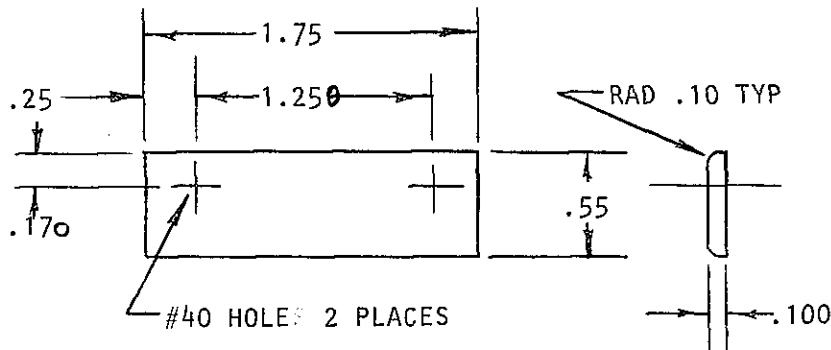
STANDARDS SHEET



MATERIAL: 2024 T3
QQ-A-250/5
.100 THK

FINISH: C1 & F19

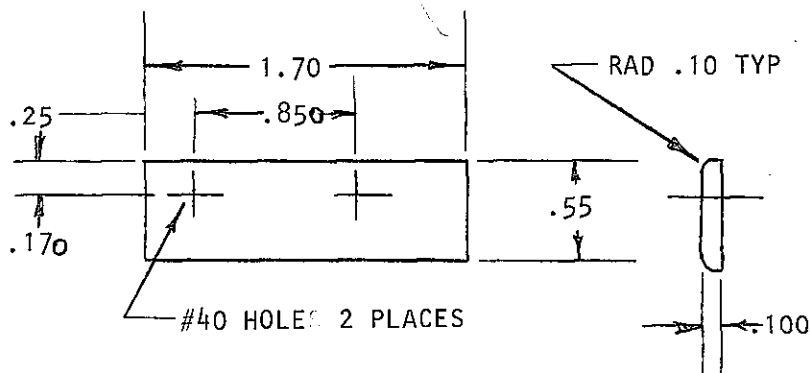
CSP 306-51



MATERIAL: 2024 T3
QQ-A-250/5
.100 THK

FINISH: C1 & F19

CSP 306-52



MATERIAL: 2024 T3
QQ-A-250/5
.100 THK

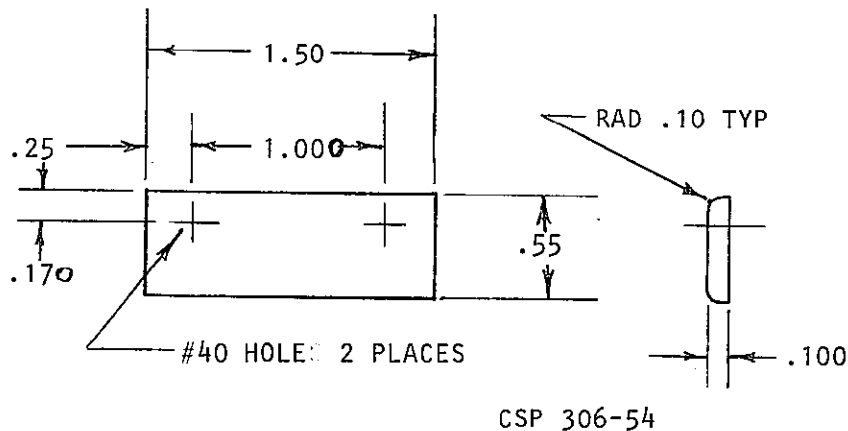
FINISH: C1 & F19

CSP 306-53

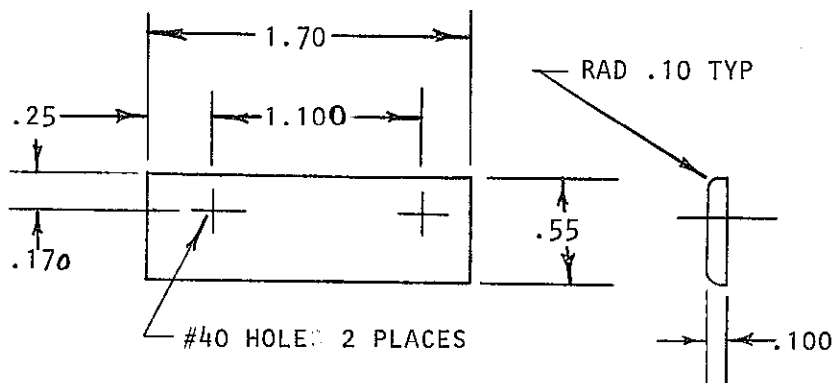
DRAWN	STOKES	CLASSIFICATION	STANDARD
CHECKED	KRAMKAMP	WASHER-SADDLE	CSP 306
STRESSED	WAV		
APPROVED	SCHWARTZ		



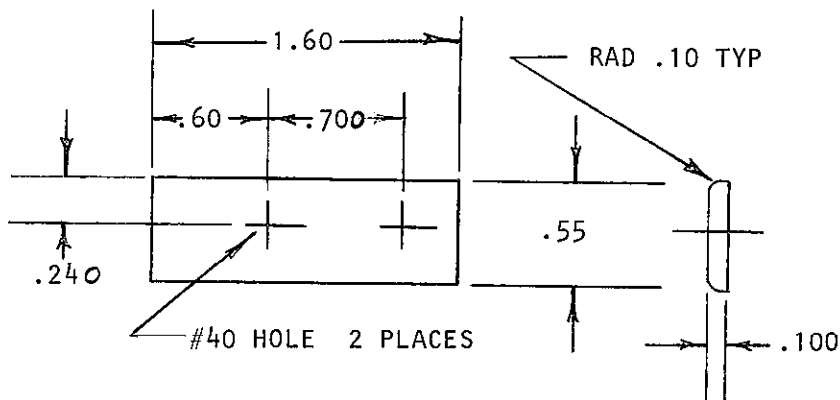
STANDARDS SHEET



CSP 306-54



CSP 306-55

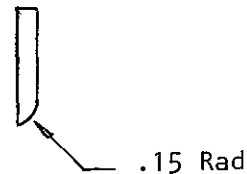
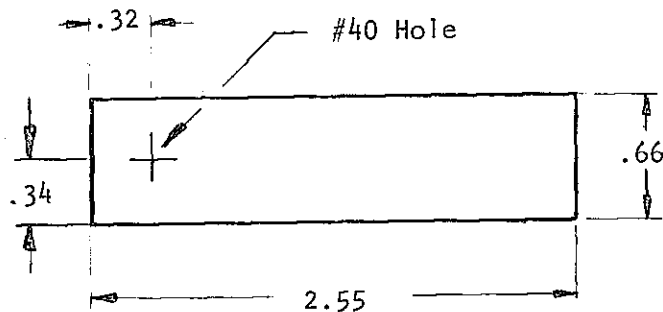


CSP 306-56

DRAWN	STOKES	CLASSIFICATION	STANDARD
CHECKED	KRONKAMP	WASHER-SADDLE	CSP 306
STRESSED	WAV		
APPROVED	SCHATTNER		

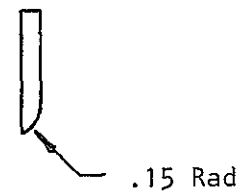
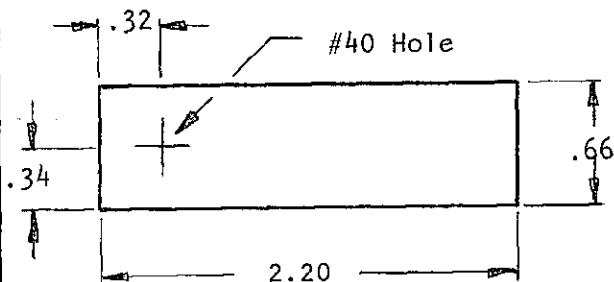


STANDARDS SHEET



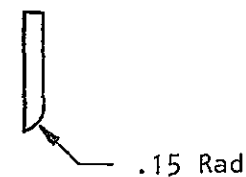
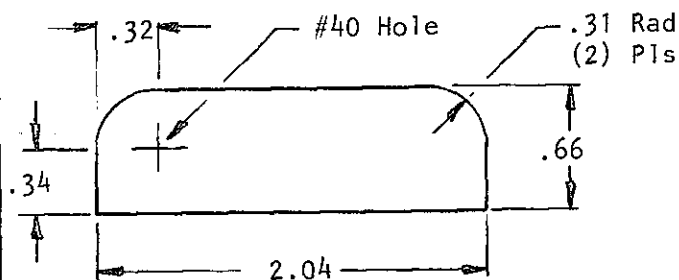
Mat'l: QQ-A-250/5
2024-T3
.100 thk
Finish: C1 & F19

CSP 306-57



Mat'l: QQ-A-250/5
2024-T3
.100 thk
Finish: C1 & F19

CSP 306-58



Mat'l: QQ-A-250/5
2024-T3
.100 thk
Finish: C1 & F19

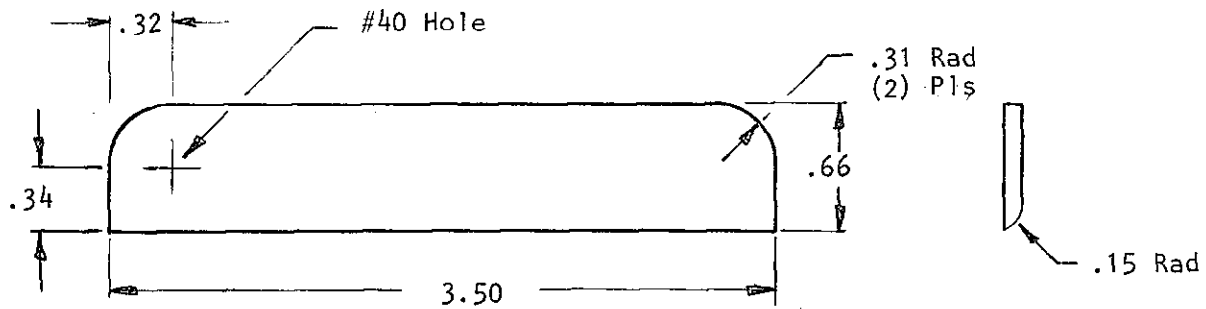
CSP 306-59

DRAWN	GILCHRIST	CLASSIFICATION	STANDARD
CHECKED	STOKES	WASHER - SADDLE	CSP 306
STRESSED	M. Elliott		
APPROVED	SENECHAUZ		

OCT 87

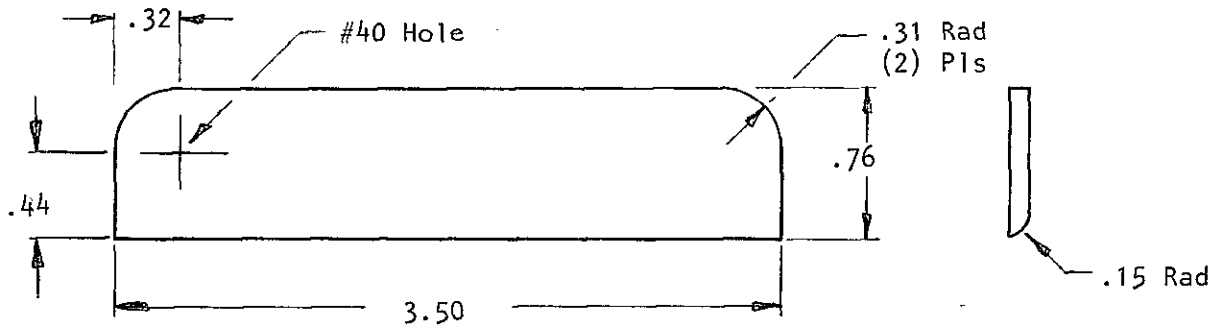


STANDARDS SHEET



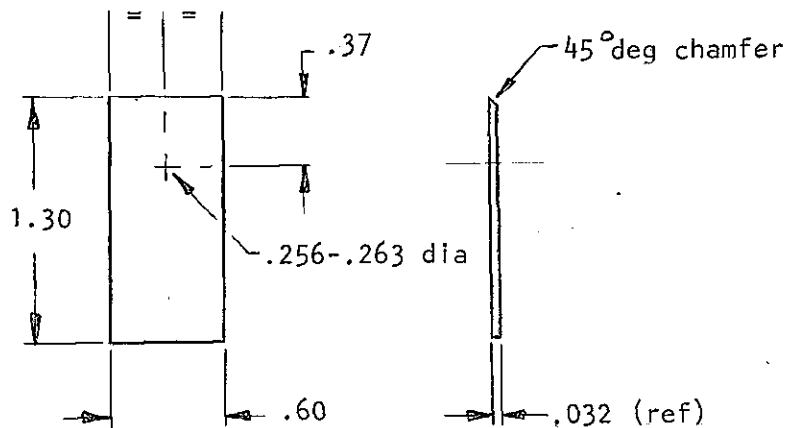
Mat'l: QQ-A-250/5
2024-T3
.100 thk
Finish: C1 & F19

CSP 306-60



Mat'l: QQ-A-250/5
2024-T3
.100 thk
Finish: C1 & F19

CSP 306-61



Mat'l: QQ-A-250/5
2024-T3
.032 thick
Finish: C1 & F19

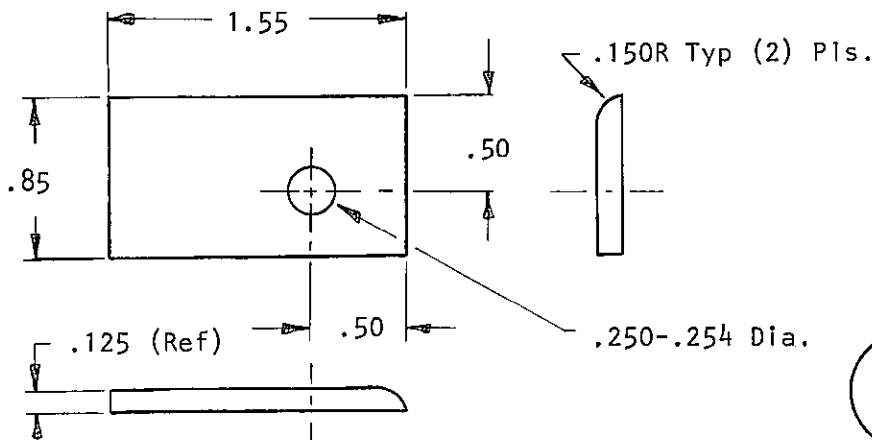
-62

DRAWN	GILCHRIST	CLASSIFICATION	STANDARD
CHECKED	STOKES	WASHER - SADDLE	CSP 306
STRESSED	M. Elmer		
APPROVED	SCHENKEL		

GCT 87

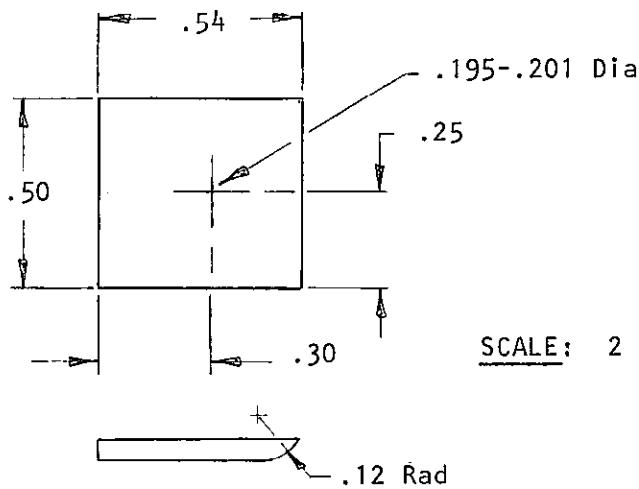


STANDARDS SHEET



MAT'L: QQ-A-250/5
2024-T3
.125 thick
FINISH: C1 & F19

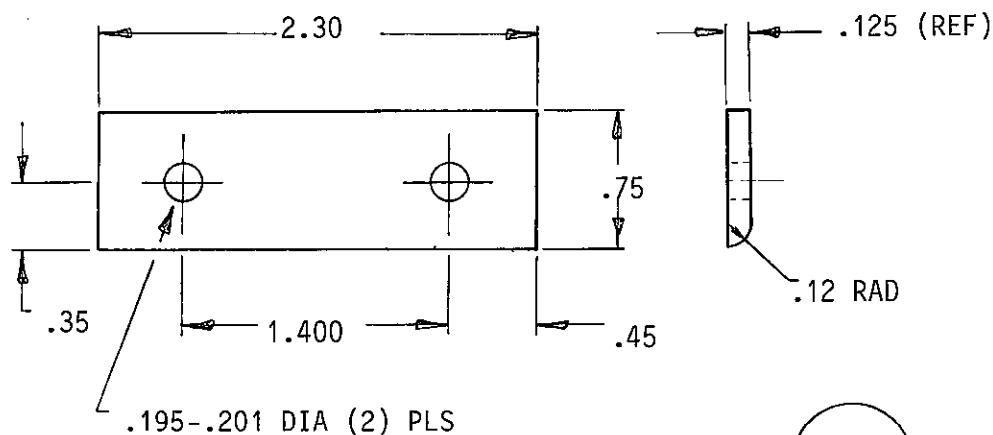
-63



MAT'L: QQ-A-250/5
2024-T3
.063 Thick
FINISH: C1 & F19

SCALE: 2 x Full

-64



MAT'L: QQ-A-250/13
7075-T6
.125 THICK
FINISH: A1 & F19

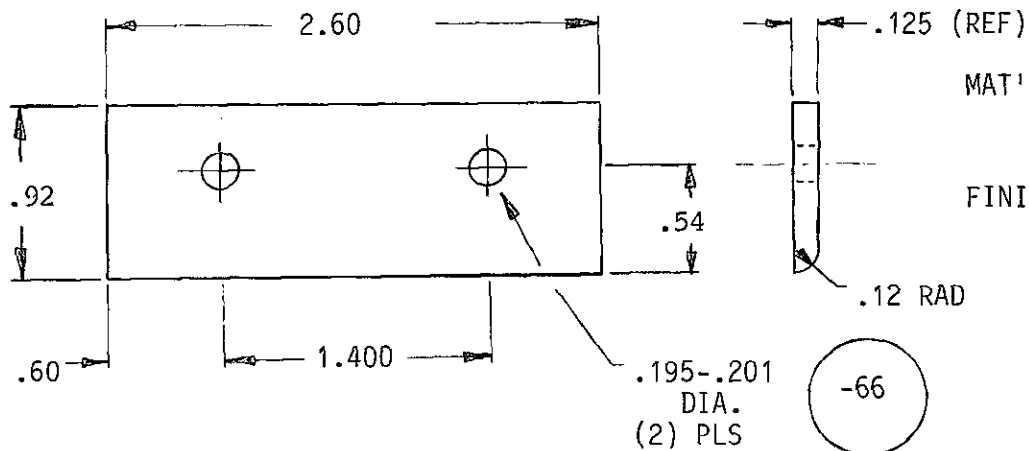
-65

A -65 ADDED 24th MARCH 1988

DRAWN	GILCHRIST	CLASSIFICATION	STANDARD
CHECKED	STOKES	WASHER - SADDLE	CSP 306
STRESSED	M. H. H. H.		
APPROVED	SCHENKEL		

OCT 87

STANDARDS SHEET



FOR 306-67, SEE SHEET 22

FOR CSP-306-68, SEE SHEET 22

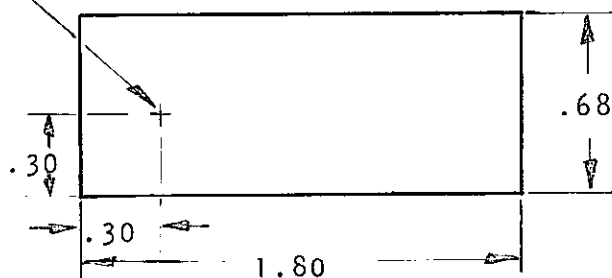
DRAWN	Gilchrist	CLASSIFICATION	STANDARD
CHECKED	STOKES	WASHER - SADDLE	CSP 306
STRESSED	M. M. M.		
APPROVED	KROMKAMP		

Shantree

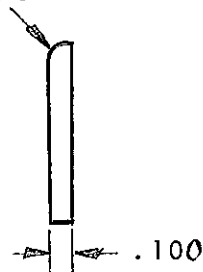


STANDARDS SHEET

#40 HOLE



.120 RADIUS



MATERIAL:

QQ-A-250/13

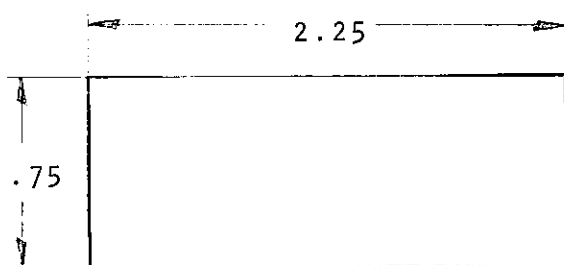
7075-T6

.100 THICK

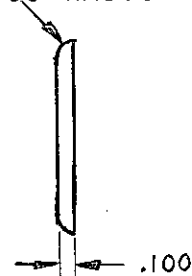
FINISH:

A1 + F19

-67



.100 RADIUS



MATERIAL:

QQ-A-250/5

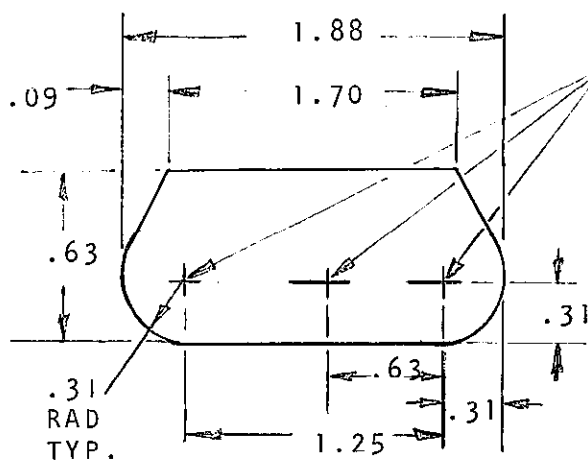
2024-T3 CLAD

.100 THICK

FINISH:

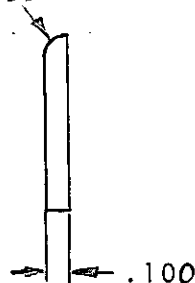
C1 + F19

-68



#40 HOLE (3 PLACES)

.190 RADIUS



MATERIAL:

QQ-A-250/5

2024-T3

.100 THICK

FINISH:

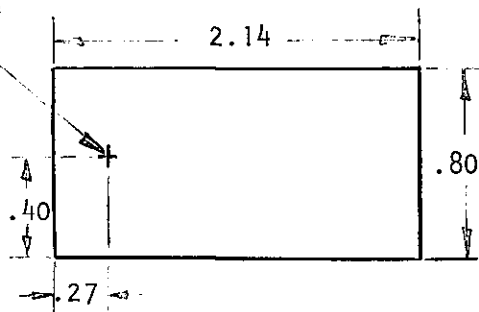
C1 + F19

-69

DRAWN	K. RAI	CLASSIFICATION	STANDARD
CHECKED	KROMKAMP	WASHER -- SADDLE	CSP 306
STRESSED	RAU		
APPROVED	Am		

STANDARDS SHEET

#40 Hole



.100 Radius
Typical

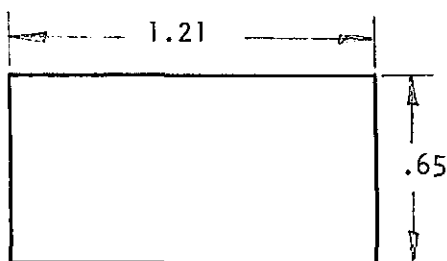
MATERIAL: QQ-A-250/13
7075-T6
.100 THICK

FINISH: C1 + F19

-70

MATERIAL: QQ-A-250/13
7075-T6
.100 THICK

FINISH: C1 + F19



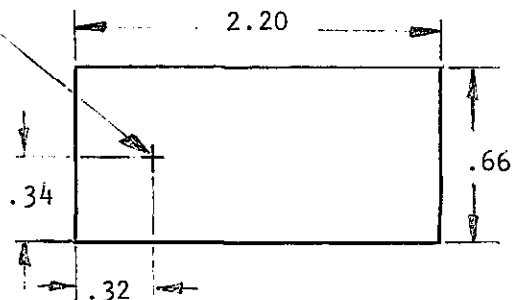
.250 R

-71

MATERIAL: QQ-A-250/13
7075-T6
.100 THICK

FINISH: C1 + F19

#40 Hole



.150
Radius

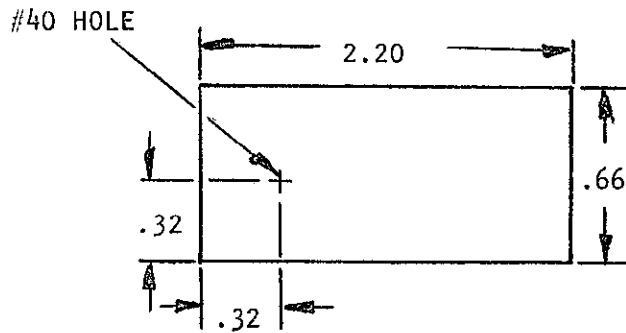
-72

DRAWN	K. Rai	CLASSIFICATION	STANDARD
CHECKED	<i>[Signature]</i>	SADDLE WASHER	CSP 306
STRESSED	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		

PART STANDARD

MATERIAL: QQ-A-250/13
7075-T6
.125 THICK

FINISH: A1 + F19

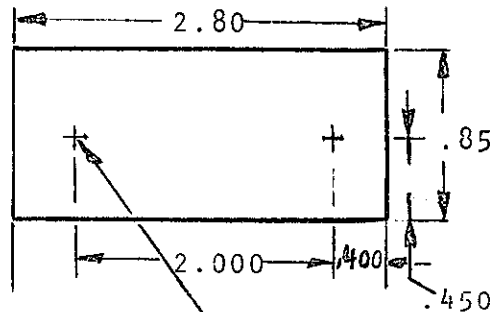


.120
Radius

-73

MATERIAL: QQ-A-250/13
7075-T6
.125 THICK

FINISH: A1 + F19

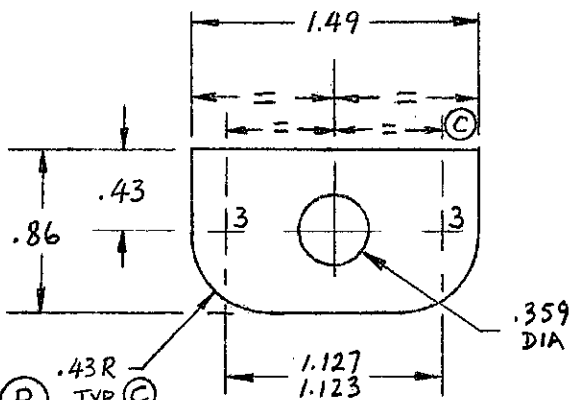


\.200
Radius

- 74

.195/.201 Dia.
Hole Type

Ⓐ



$\cdot .125R$

MATERIAL : QQ-A-250/5
2024-T3
.125 THICK

FINISH: C1 + F19

.359
DIA

-125

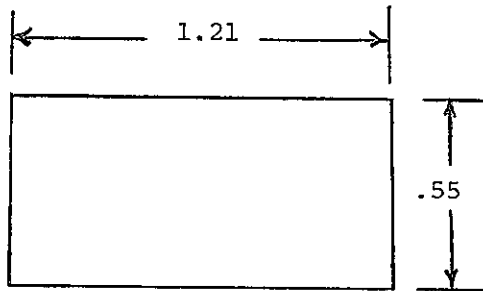
-75

REF: RFS #SA071

TO SUIT DSC 243-3-3

ISSUE	—	AF	B P	C P#					
DATE	3 OCT 89	16 OCT 89	12 FEB 90	11 APR 90					
DRAWN	K. RAI	K. RAI	P. LAM	P. LAM					
APPROVED	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>					
DRAWN	K. RAI	SADDLE WASHER				STANDARD CSP 306			
CHECKED	<i>[Signature]</i>					PAGE 24			
STRESS	<i>[Signature]</i>								
APPROVED	<i>[Signature]</i>								

MATERIAL: QQ-A-250/13
7075-T6
.100 THICK



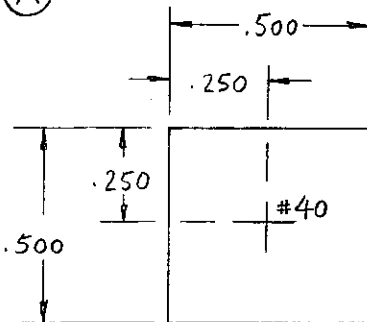
FINISH: C1 + F19

* MAY BE MADE FROM
CSP 306-71

.250 R

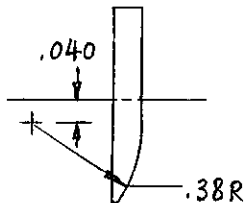
-76

(A)



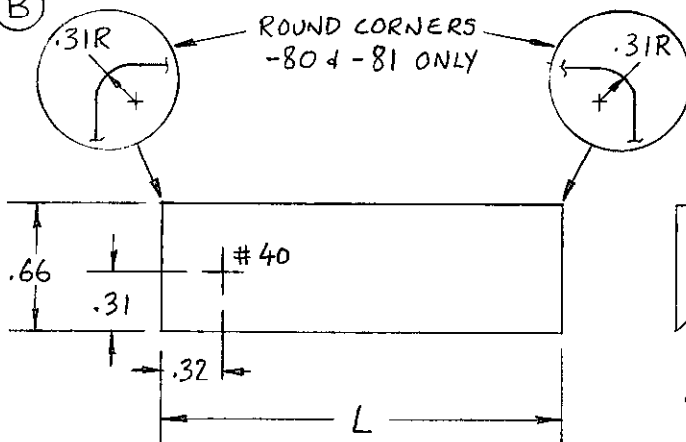
MATERIAL: QQ-A-250/5 2024-T3
.100 THICK

FINISH: C1 + F19



-77

(B)



MATERIAL: QQ-A-250/5 2024-T3
.100 THICK

FINISH: C1 + F19

DASH No.	L
- 78	2.55
- 79	2.20
- 80	2.04
- 81	3.50

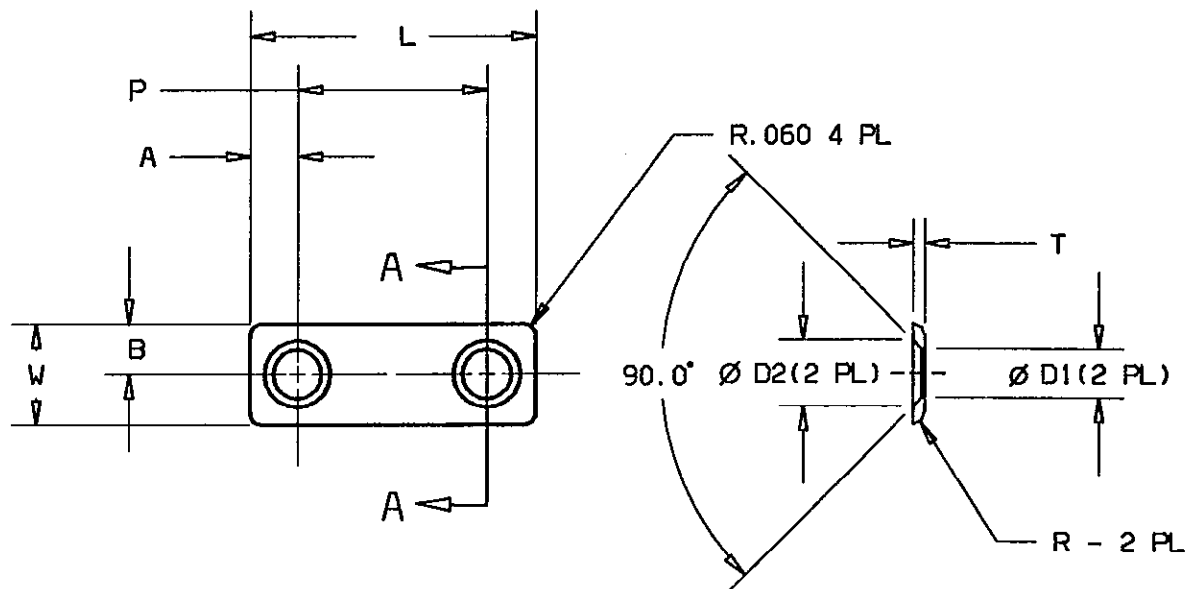
ISSUE	A	B								
DATE	91.03.20	91.04.05								
DRAWN	P. LAM	P. LAM								
APPROVED	KROMKAMP	KROMKAMP								

DRAWN	M. BUREL	WASHER -- SADDLE	STANDARD
CHECKED	P. LAM		CSP 306
STRESS			PAGE
APPROVED			25

20 JUN 90



STANDARDS SHEET



SECTION A-A

DASH NO.	A $\pm .010$	B $\pm .005$	D1	D2	L $\pm .010$	W $\pm .010$	T	P $\pm .005$	R	
-82	.250	.263	252/.255	350/.340	1.500	.526	.063	1.000	.060	
-83	.195	.214	192/.195	290/.280	.960	.428	.090	.570	.060	

MAT'L: SHEET 301 CRES - 1/4 HARD, MIL-S-5059
FINISH: PASSIVATE TO PPS 31.05

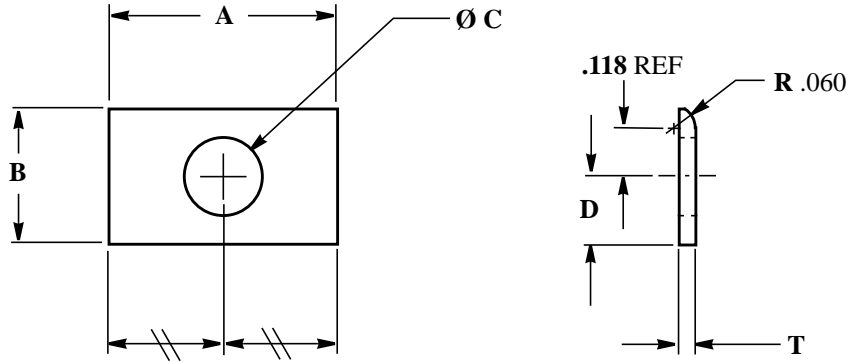
DRAWN	D. GIEB	CLASSIFICATION	STANDARD
CHECKED	<i>[Signature]</i>	WASHER -SADDLE	CSP 306
STRESSED	<i>[Signature]</i>		
APPROVED	P. Lam		

14 MAR 94

de HAVILLAND

CAGE CODE 71867

CSP STANDARD



SCALE: 2:1

DASH NO	A $\pm .010$	B $\pm .010$	C DIA	D $\pm .010$	T $\pm .010$
CSP306-84	.600	.350	.201/.195	.175	.040
CSP306-110	.600	.350	.201/.195	.175	.070

MATERIAL: 301 CRES 1/2 HARD, MIL-S-5059

FINISH: C9 + F19 Ty II

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD	WASHER - SADDLE	CSP 306
CHECKED	P. LAM		
STRESSED	XXX		SHEET: 27
APPROVED	S. HAMID		

A CSP306-110 ADDED

REV:

REV:

REV:

REV:

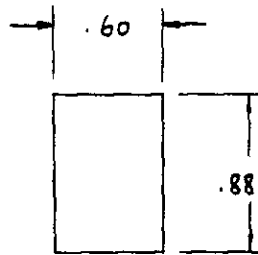
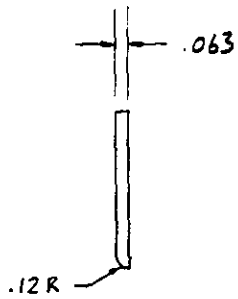
REV:

REV: A - 5 DEC 2000

APPROVED:

**deHAVILLAND**

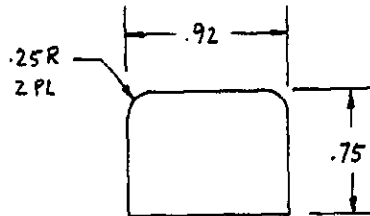
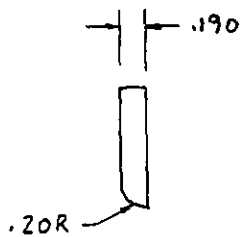
PAGE 28

STANDARDS SHEET

MATERIAL : QQ-A-250/5
2024-T3
.063 THICK

FINISH : C1 + F19

-85



MATERIAL : QQ-A-250/11
6061-T6
.190 THICK

FINISH : C1 + F19

-86

DRAWN	P. Lam	CLASSIFICATION	STANDARD
CHECKED	P. Lam	WASHER - SADDLE	CSP 306
STRESSED	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		

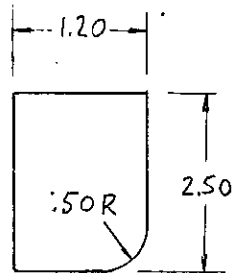
15 APR 1994



STANDARDS SHEET

.187
(REF)

.19R



-87

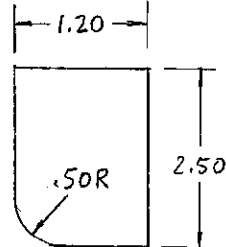
MATERIAL: QQ-A-250/5

2024-T3

.187 THICK

FINISH: C1 + F21 (A)
TYPE I.187
(REF)

.19R



-88

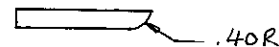
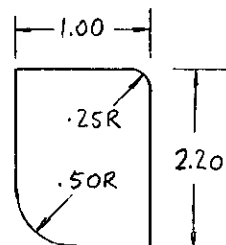
MATERIAL: QQ-A-250/5

2024-T3

.187 THICK

FINISH: C1 + F21 (A)
TYPE I.187
(REF)

.19R



-89

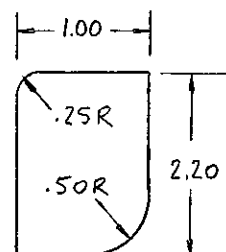
MATERIAL: QQ-A-250/5

2024-T3

.187 THICK

FINISH: C1 + F21 (A)
TYPE I.187
(REF)

.19R



-90

MATERIAL: QQ-A-250/5

2024-T3

.187 THICK

FINISH: C1 + F21 (A)
TYPE I

FINISH - F21 WAS F19
 B. McDONALD 2 JUL 98

(A)

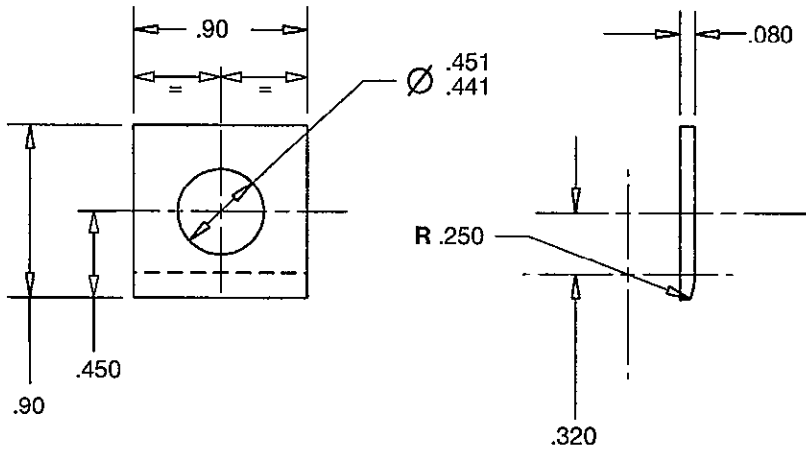
DRAWN	P. Lam	CLASSIFICATION	STANDARD
CHECKED	R. JOHNSON	WASHER - SADDLE	CSP 306
STRESSED	—		
APPROVED	P. Lam		

02 JUL 96

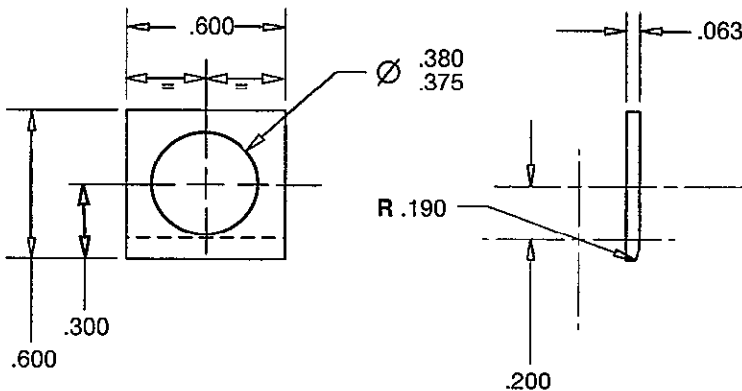
de HAVILLANDCAGE CODE 71867
CSP STANDARD

SHEET 30

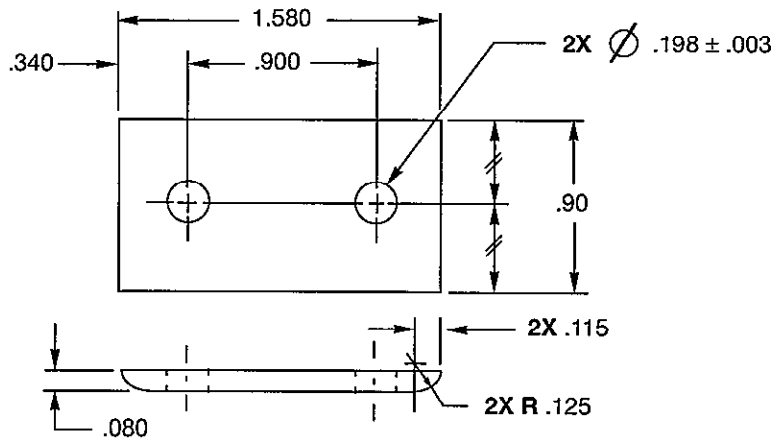
REV. B

**-91**MATERIAL: QQ-A-250/5
2024-T3
.080 THICK

FINISH: C1+F19

**-92**MATERIAL: QQ-A-250/5
2024-T3
.063 THICK

FINISH: C1+F19

**B****-93**MATERIAL: QQ-A-250/13
7075-T6
.080 THICK

FINISH: A1+F19

FOR ORIGINAL SIGNATURES SEE ENGINEERING STANDARDS APPROVAL RECORD

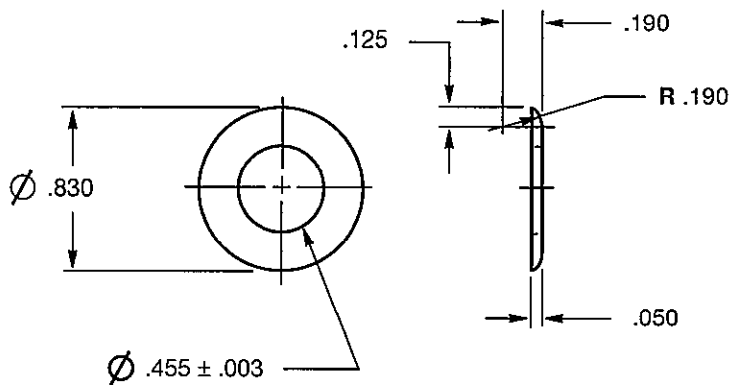
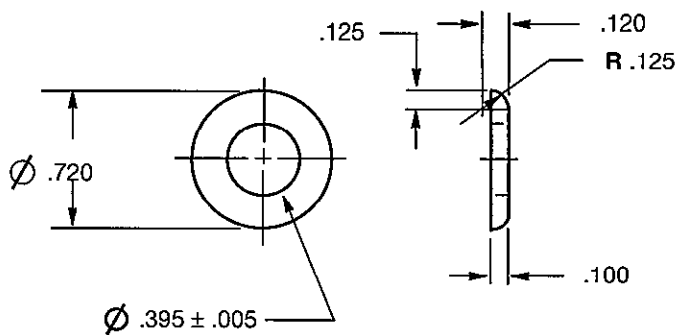
DRAWN	B. McDONALD
STRESS	D. TODD
MAT. TECH	L. SALNAIS
STDS REL	S. HAMID

WASHER - SADDLE**CSP 306**

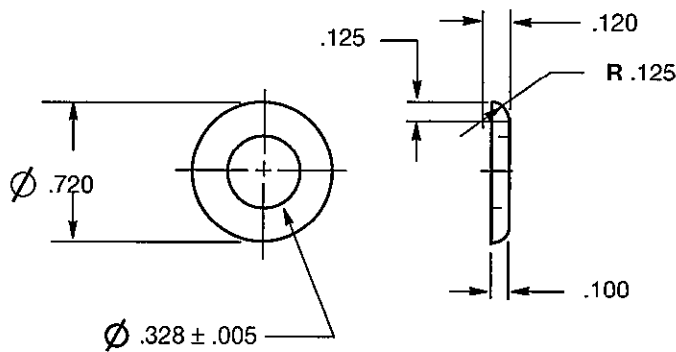
DATE: 12 SEP 96

-93 ADDED
20 FEB 97 - B. McDONALD**B**

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de HAVILLANDCAGE CODE 71867
CSP STANDARDSHEET **31**REV. **B****-94****MATERIAL:** 15-5 PH (AMS 5659)
HEAT TREAT: H1025 (155-175 KSI)
to PPS 30.06
FINISH: C9 + M2 (CLASS 2, TYPE II)**-95****(B) MATERIAL:** 303 CRES (AMS 5640 or
DHMS M2.23)**HEAT TREAT:** ANNEALED**FINISH:** C9

BREAK SHARP EDGES .005 - .015

**-96****(B) MATERIAL:** 303 CRES (AMS 5640 or
DHMS M2.23)**HEAT TREAT:** ANNEALED**FINISH:** C9

BREAK SHARP EDGES .005 - .015

FOR ORIGINAL SIGNATURES SEE ENGINEERING STANDARDS APPROVAL RECORD

DRAWN	B. McDONALD
STRESS	N/A
MAT. TECH	L. SALNAIS
STDS REL	S. HAMID

WASHER - SADDLE**CSP 306**DATE: **18 APR 97****(B)** (AMS 5640 or DHMS M2.23) WAS QQ-S-763
18 APRIL 97 - B. McDONALD

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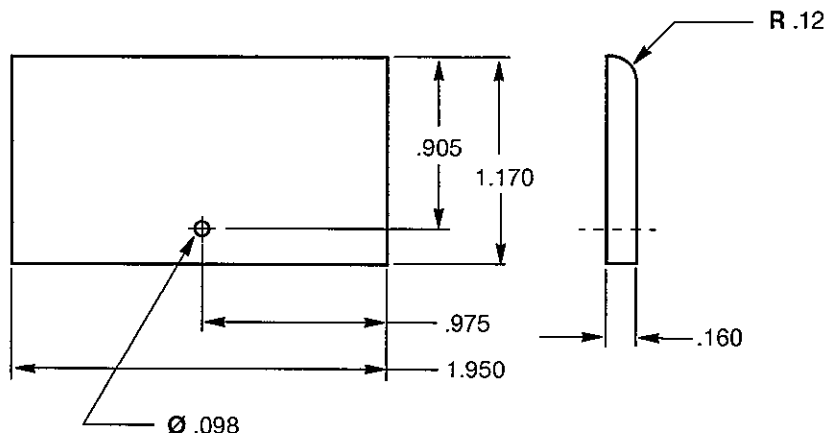
L

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de HAVILLAND

CAGE CODE 71867
CSP STANDARD

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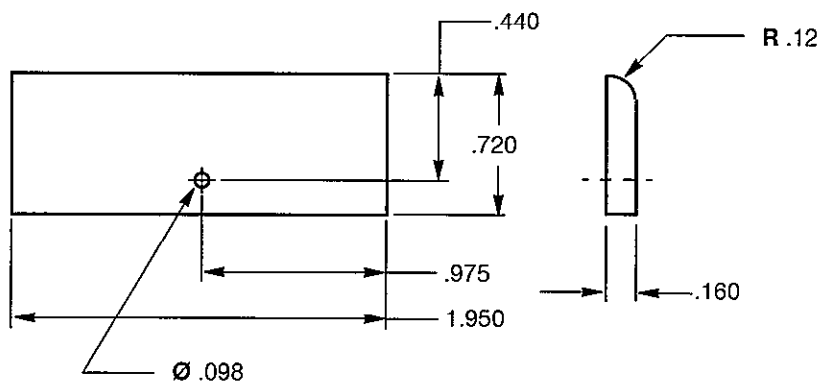


-100

MATERIAL: 2024-T3 to QQ-A-250/5

HEAT TREAT: T3

FINISH: C1 + F19

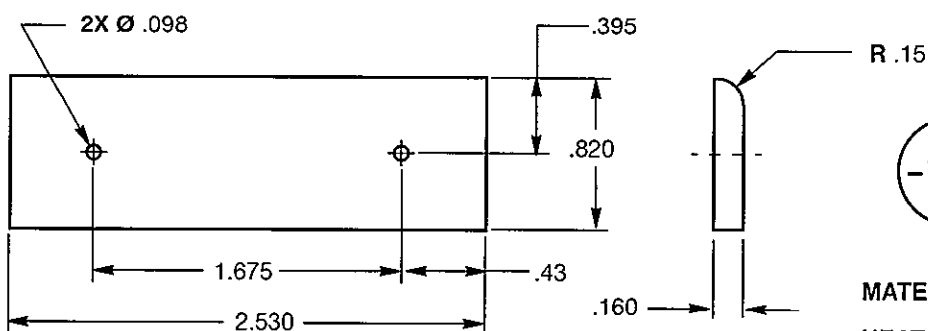


-101

MATERIAL: 2024-T3 to QQ-A-250/5

HEAT TREAT: T3

FINISH: C1 + F19



-102

MATERIAL: 2024-T3 to QQ-A-250/5

HEAT TREAT: T3

FINISH: C1 + F19

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD
CHECKED	P. LAM
STRESSED	N/A
APPROVED	S. HAMID

WASHER, SADDLE

CSP 306

SHEET: **33**

REV:

REV:

REV:

REV:

REV:

REV:

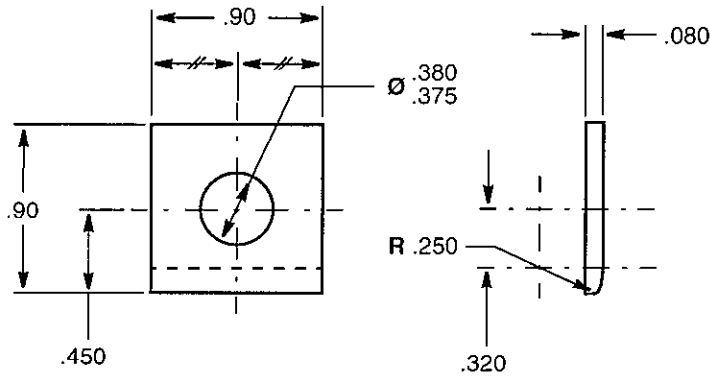
APPROVED: 25 SEP 1998

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de HAVILLAND

CAGE CODE 71867
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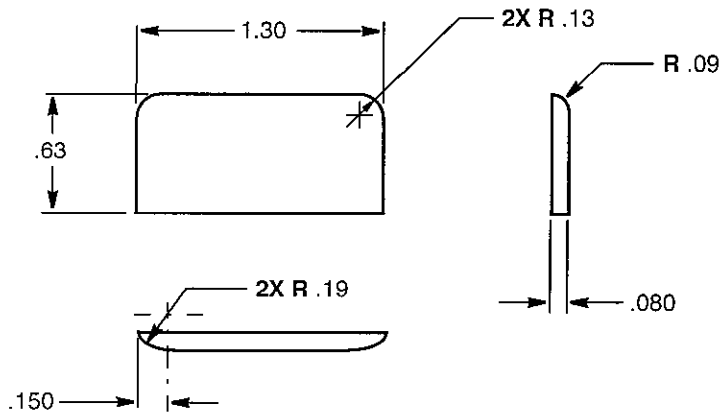


-103

MATERIAL: 2024-T3 to QQ-A-250/5
.080 THICK

HEAT TREAT: T3

FINISH: C1 + F19

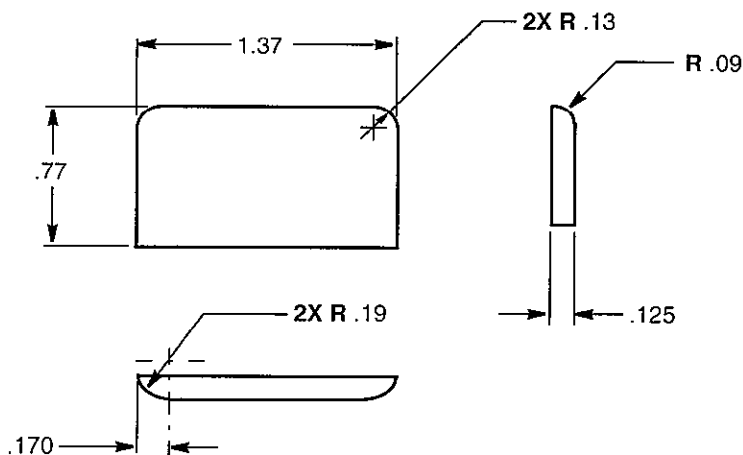


A
-104

MATERIAL: 2024-T3 to QQ-A-250/5
.080 THICK

HEAT TREAT: T3

FINISH: C1 + F19



A
-105

MATERIAL: 2024-T3 to QQ-A-250/5
.125 THICK

HEAT TREAT: T3

FINISH: C1 + F19

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD
CHECKED	P. LAM
STRESSED	---
APPROVED	S. HAMID

WASHER, SADDLE

CSP 306

SHEET: 34

A CSP306-105 & -105 ADDED

REV:

REV:

REV:

REV:

REV:

REV: A - 9 FEB 00

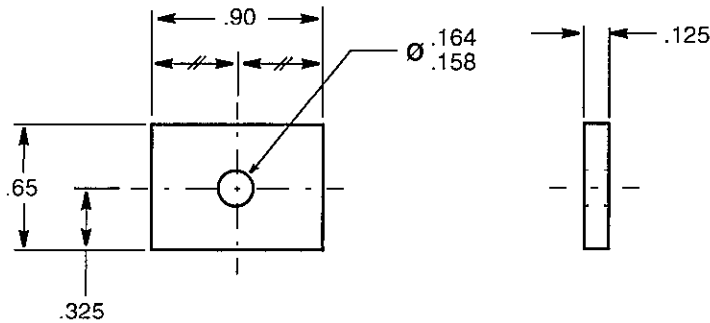
APPROVED: 31 MAR 1999

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CAGE CODE 71867
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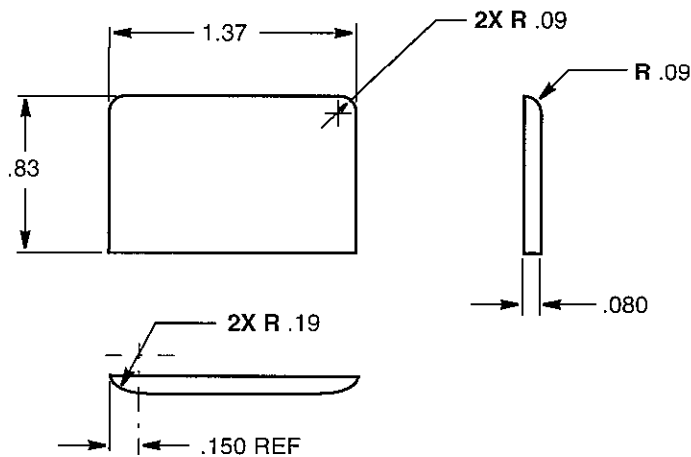


-106

MATERIAL: 2024-T3 to QQ-A-250/5
.125 THICK

HEAT TREAT: T3

FINISH: C1 + F19

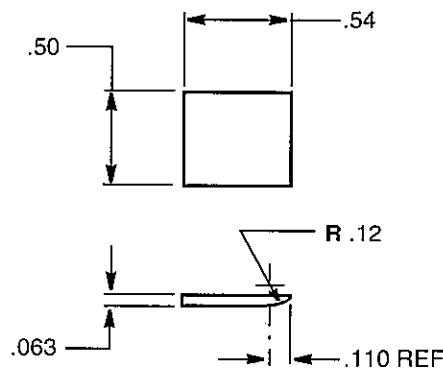


-107

MATERIAL: 2024-T3 to QQ-A-250/5
.080 THICK

HEAT TREAT: T3

FINISH: C1 + F19



-108

MATERIAL: 2024-T3 to QQ-A-250/5
.063 THICK

HEAT TREAT: T3

FINISH: C1 + F19

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD	WASHER, SADDLE	CSP 306
CHECKED	P. LAM		
STRESSED	---		SHEET: 35
APPROVED	S. HAMID		

REV:

REV:

REV:

REV:

REV:

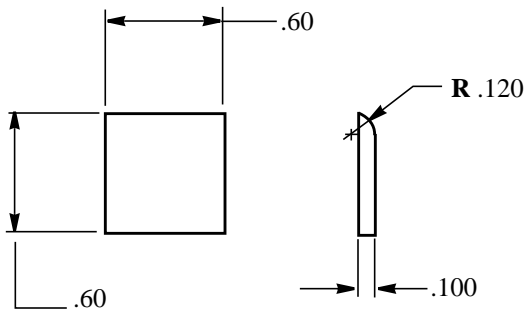
REV:

APPROVED: 9 FEB 2000

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CAGE CODE 71867
CSP STANDARD

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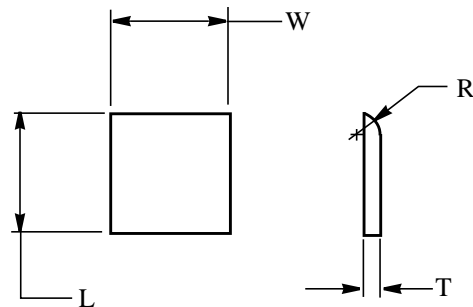


-109

MATERIAL: 2024-T3 to QQ-A-250/5
.100 THICK

HEAT TREAT: T3

FINISH: C1 + F19



MATERIAL: 2024-T3 to QQ-A-250/5
HEAT TREAT: T3 or T351 for .250 thick
FINISH: C1 + F19

DASH No	L	W	T	R
-111	.60	.60	.100	.100
-112	.60	.60	.100	.160
-113	.65	.60	.160	.160
-114	.65	.60	.100	.200
-115	.65	.60	.250	.250

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	EDWARDS
CHECKED	MacCOLL
STRESSED	
APPROVED	EDWARDS

WASHER, SADDLE

CSP 306

SHEET: 36

REV:

REV:

REV:

REV:

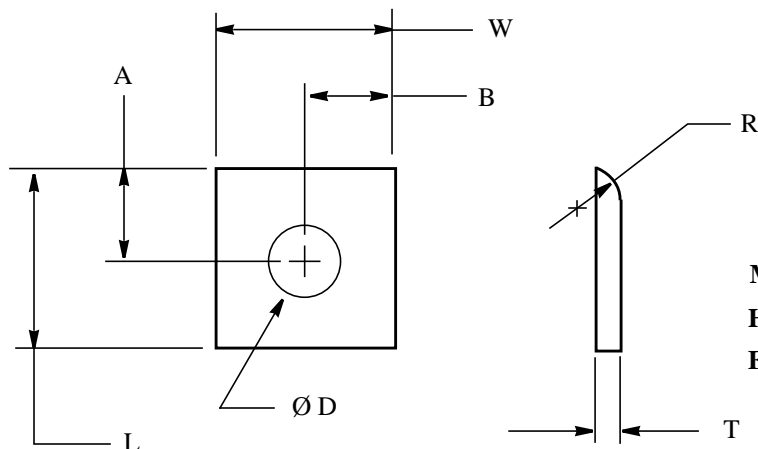
REV:

REV: A - 22 AUG 2001

APPROVED: 5 DEC 2000

-111 THRU -115 ADDED

A

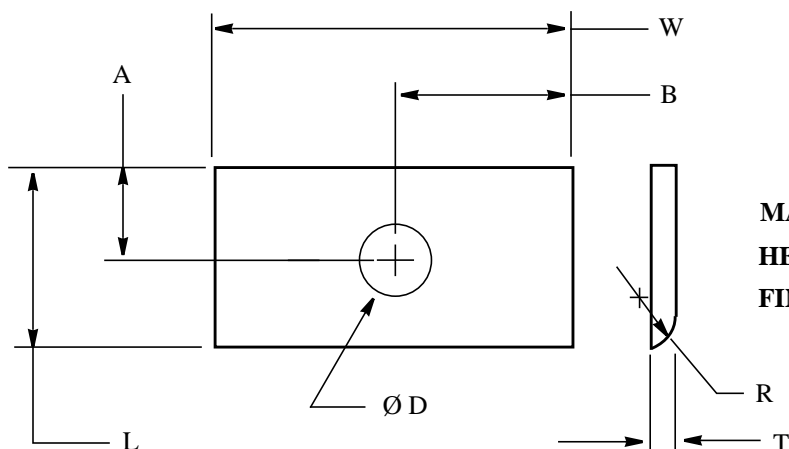


CSP 306 -116

MATERIAL: 2024-T3 to QQ-A-250/5

HEAT TREAT: T3

FINISH: C1 + F19



CSP 306 -117 -118

MATERIAL: 2024-T3 to QQ-A-250/5

HEAT TREAT: T3 or T351

FINISH: C1 + F19

DASH No	L	W	T	R	A	B	Ø D
-116	.54	.50	.063	.12	.270	W/2	.265
-117	.67	1.94	.100	.20	.30	W/2	.25
-118	.70	2.12	.100	.150	.30	W/2	.25

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	EDWARDS
CHECKED	MacCOLL
STRESSED	
APPROVED	EDWARDS

WASHER, SADDLE

CSP 306

SHEET: 37

B -118 RADIUS 'R' NOW .150 WAS .125.

REV: B -09 MAR 2006

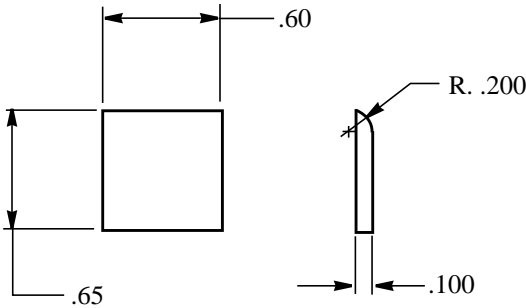
REV: A - 10 AUG 2006

APPROVED: 23 APR 2002

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CAGE CODE 71867
CSP STANDARD

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CSP 306 -119

MATERIAL: 2024-T3 to QQ-A-250/5
HEAT TREAT: T3 or T351 for .250 thick
FINISH: C10

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

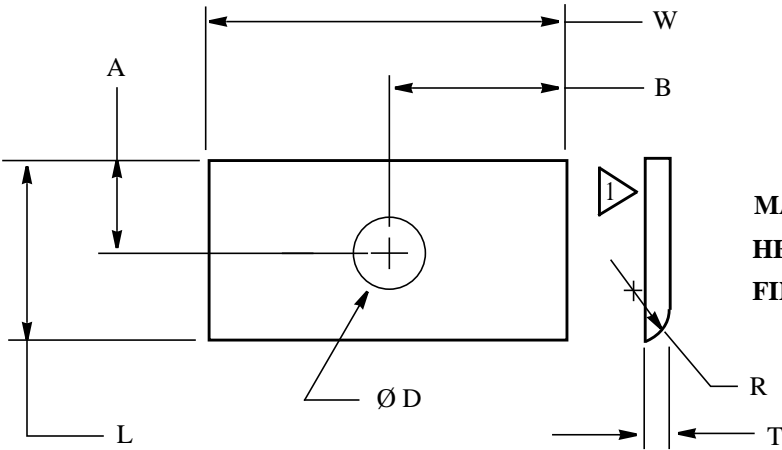
DRAWN	EDWARDS	WASHER, SADDLE	CSP 306
CHECKED	MacCOLL		
STRESSED			SHEET: 38
APPROVED	EDWARDS		

APPROVED: 25 MAY 2006 REV:

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**CSP 306 -120
-121**

MATERIAL: 2024-T3 to QQ-A-250/5
HEAT TREAT: T3 or T351
FINISH: C10 + F19

(A)

DASH No	L	W	T	R	A	B	Ø D
-120	.67	1.94	.100	.20	.30	W/2	.25
-121	.70	2.12	.100	.150	.30	W/2	.25

1 THIS FACE TO BE MASKED OFF FOR C10 ONLY

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	EDWARDS
CHECKED	MacCOLL
STRESSED	
APPROVED	EDWARDS

WASHER, SADDLE

CSP 306

SHEET: 39

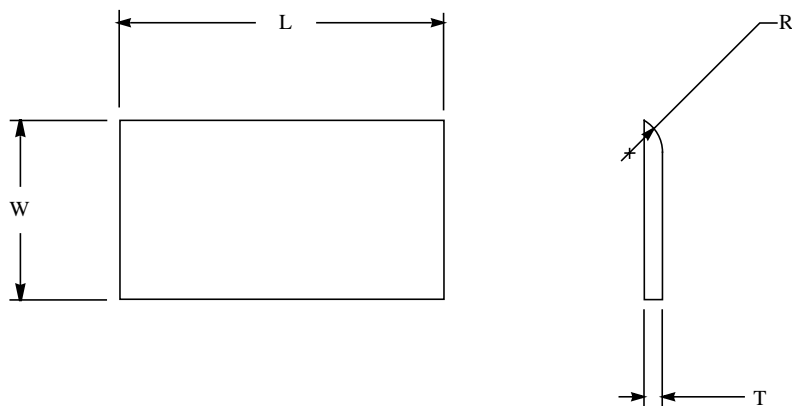
APPROVED: 25 MAY 2006 REV:A - 12 JULY 2006

(A) ADDED HOLE DIMS Ø D

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CAGE CODE 71867
CSP STANDARD

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CSP 306 - WASHER, SADDLE				
PART NUMBER	L	W	T (THICKNESS)	R
CSP306-122	5.40	0.62	0.100	0.12
CSP306-123	7.90	0.62	0.100	0.12
(A) CSP306-125	2.25	0.72	0.100	0.19
(B) CSP306-127	4.40	0.50	0.063	0.070
(C) CSP306-130	4.70	0.50	0.063	0.070

MATERIAL:

ALUMINUM ALLOY 7075 SHEET PER AMS4049 (C)

HEAT TREAT: T6

FINISH: C1 + F19

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	MacCOLL	WASHER, SADDLE	CSP 306
CHECKED	EDWARDS		
STRESSED			SHEET: 40
APPROVED	EDWARDS		

(C) CSP306-130 ADDED (REF: PCR# 45323)
AMS-QQ-A-250/13 CANCELLED AND REPLACED BY AMS4049

REV:

REV:

REV:

REV: C - 25 JAN 2018

REV: B - 4 JUN 2015

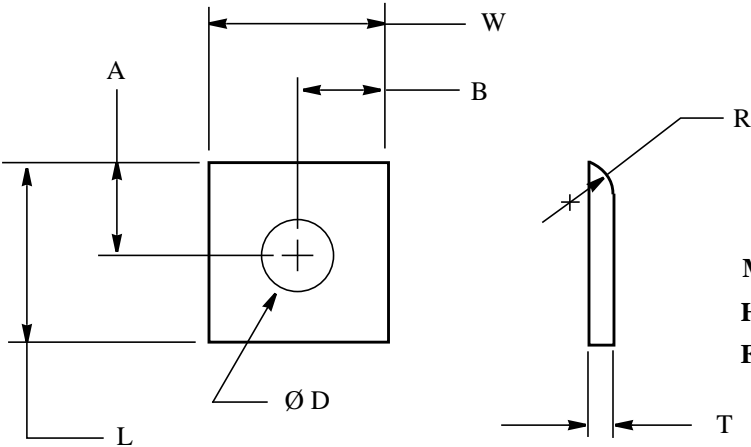
REV: A - 17 APR 2012

APPROVED: 19 SEP 2006

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CSP 306 -124

MATERIAL: 2024 to QQ-A-250/5
HEAT TREAT: T3 or T351
FINISH: C1 + F19

DASH No	L	W	T	R	A	B	Ø D
-124	.53	.53	.100	.20	.265	.265	.173

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	MacCOLL	WASHER, SADDLE	CSP 306
CHECKED	EDWARDS		
STRESSED			SHEET: 41
APPROVED	EDWARDS		

APPROVED: 20 OCT 2006

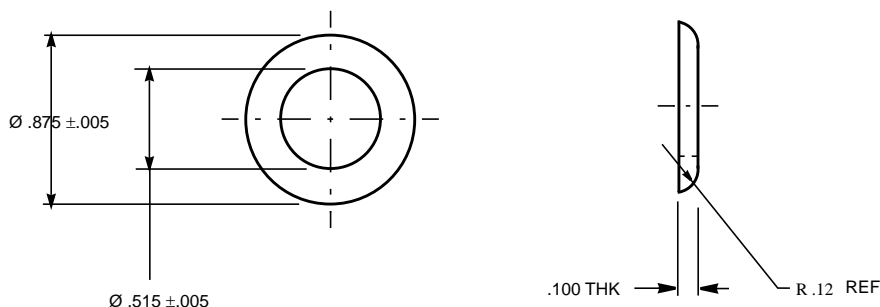
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de HAVILLAND

CAGE CODE 71867

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CSP306-126

MATERIAL:

7075-T7351 ALUMINUM ALLOY ROD PER AMS-QQ-A-225/9, 1.00" DIAMETER

FINISH: A1 + F19

NOTES:

1. WASHER TO BE FABRICATED AS SHOWN. (Ref: 85713050 NIEO07 & NIEO08)
2. REMOVE ALL BURRS AND SHARP EDGES.
3. IDENTIFY FABRICATED WASHER DETAILS PER PPS 15.01.
4. SURFACE TEXTURE: 63 MICROINCHES IN ACCORDANCE WITH ANSI/ASME B46.1.
5. ALL DIMENSIONS ARE IN INCHES.
6. TOLERANCES UNLESS OTHERWISE SPECIFIED TO BE: $.XXX \pm .010$
 $.XX \pm .03$

(A)

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	E. DANESH
CHECKED	B. EDWARDS
STRESSED	N/A
APPROVED	B. EDWARDS

WASHER, SADDLE

CSP 306

SHEET: 42

REV:

REV:

REV:

REV:

REV:

REV: A - JAN 10 2014

APPROVED: 23 APR 2013

MATERIAL SPECIFICATION REVISED, "AMS-QQ-A-250/9" now "AMS-QQ-A-225/9"

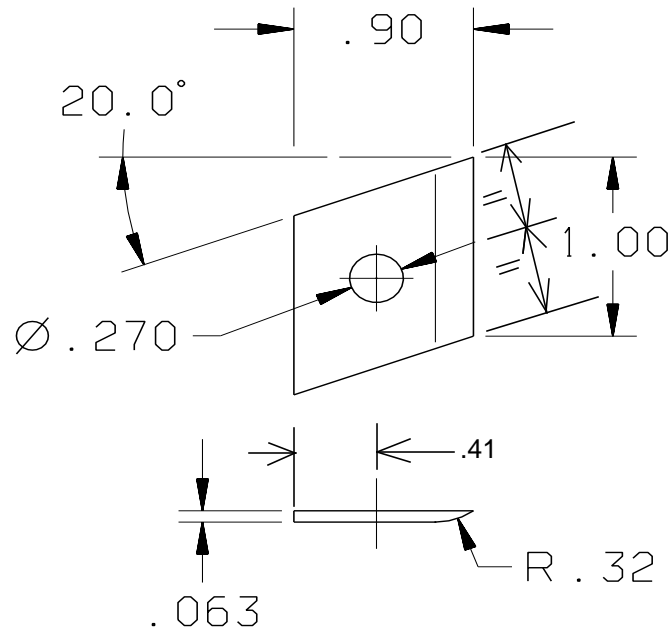
(A)

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CSP306-128

7075-T6
QQ-A-250/13
A1+F19

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. EDWARDS	WASHER, SADDLE	CSP 306
CHECKED	B. EDWARDS		
STRESSED	N/A		SHEET: 43
APPROVED	B. EDWARDS		

REV:

REV:

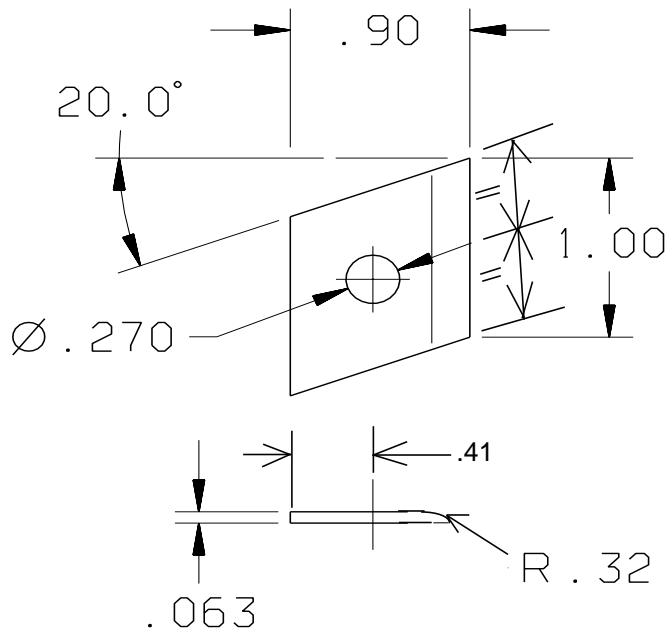
REV:

REV:

REV:

REV:

APPROVED: 21 OCT 2015



CSP306-129

7075-T6
QQ-A-250/13
A1+F19

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. EDWARDS	WASHER, SADDLE	CSP 306
CHECKED	B. EDWARDS		
STRESSED	N/A		SHEET: 44
APPROVED	B. EDWARDS		

REV:

REV:

REV:

REV:

REV:

REV:

APPROVED: 21 OCT 2015