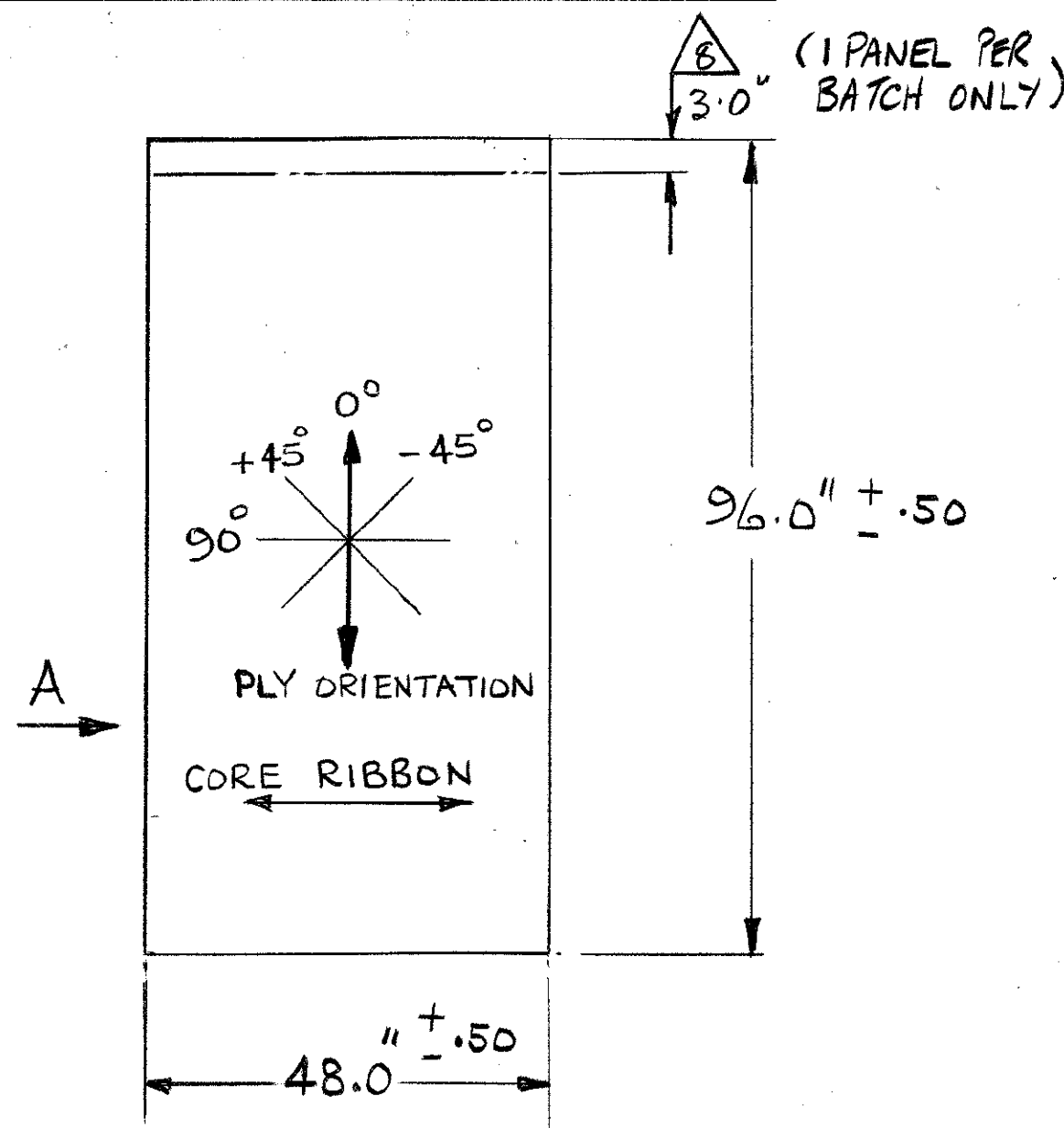


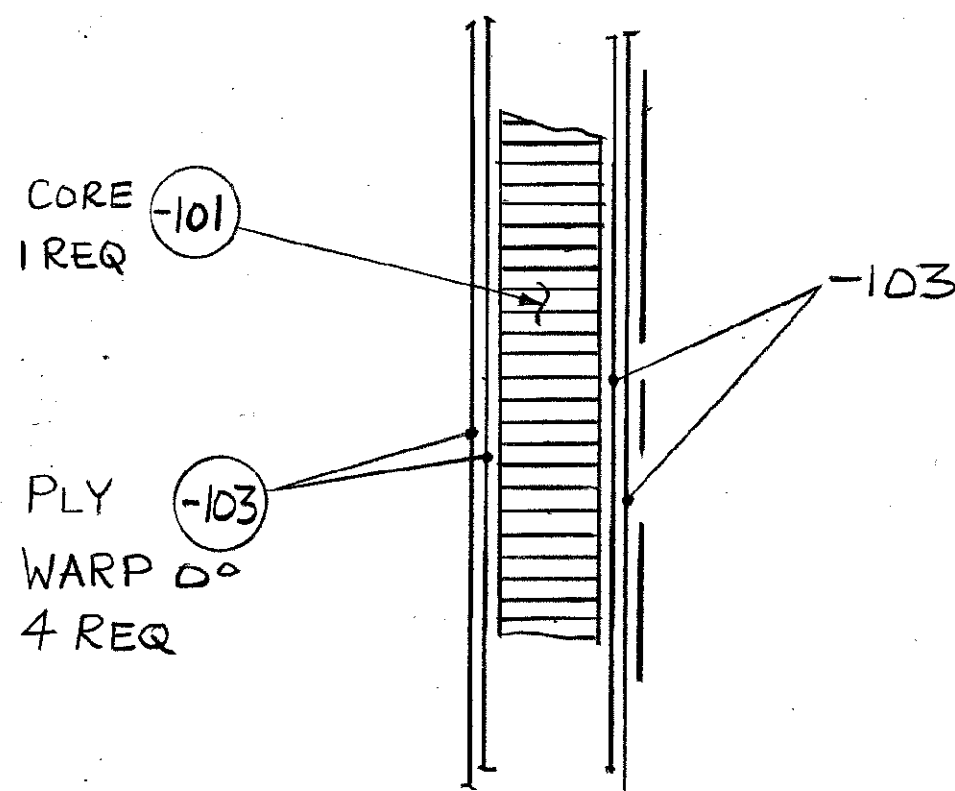
**REPORT ALL DRAWING ERRORS TO
ENGINEERING**

REVISIONS

CHANGE ITEM NO.	ZONE	DESCRIPTION	MOD. NO.	DATE	DRAWN	CHECKED	STRESS
A		ADDED NOTE 		MAY 7 84	W. L. L.	W. L. L.	W. L. L.



- ① CORE - HONEYCOMB, ARAMID FIBRE, PHENDLIC COATED DHMS PI.26,
•50 THK, $\frac{1}{8}$ CELL, 3 lb/ft³.
- ② CLOTH - ARAMID FIBRE, EPOXY PRE-IMPREGNATED, DHMS PI.24
TYPE 2, (.010 THK NOM)
- 3/ MANUFACTURE PANEL TO PPS 10.35, TOOL SURFACE BOTH SIDES. CURE AT 35 P.S.I.
- 4/ MANUFACTURING TOLERANCES TO DS 99
- 5/ 1 OVERLAPPING SPLICE PER PLY PERMITTED IF REQUIRED.
STAGGER SUBSEQUENT SPLICES 1.0" MIN^M
- 6/ SPLICE CORE WITH DHMS A6.06 IF REQ^D. MAX^M OF 2 SPLICES PERMITTED.
- 7/ MACHINE TO PPS 10.39.
- ⑧ REMOVE 3" STRIP AS SHOWN AND TEST TO QAMTR 032 ON 1 PANEL PER PRODUCTION BATCH.



VIEW 'A'
TYP PICTORIAL EDGE LAY UP.
DO NOT SCALE DWG

NEXT ASSY	USED ON	NO. REQ PER A/C	EFFY.	

PART NO.

			ZONE	SHEET	CODE	PART NO.	DESCRIPTION	MATERIAL	MATL. SPEC.	FINAL HEAT TREAT	PRO FINI	
QUANTITY REQ. PER												
			LIST OF MATERIAL									
			REQUIREMENTS - UNLESS OTHERWISE SPECIFIED				MOD NO.		THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED			
			GENERAL		LIMITS		DRAWN		DOWNSVIEW			
			1. DIMS ARE IN INCHES		1. DECIMALS		GBRISLOE					
			2. SURFACE ROUGHNESS		1 PLACE ± .1		CHECKED		ONTARIO			
			125 √ MAX.		2 " ± .03		D.P. 2					
			3. REMOVE SHARP EDGES		3 " ± .010		APPROVED					
			.015 MACHINE PARTS		2. DIMENSIONS & TOLERANCES APPLY AFTER PLATING		P. Persaud		DRAWING TITLE			
F 19			4. EDGE FINISHING OF PARTS IN ACCORDANCE WITH P.P.S. 27-02		3. ANGLES ± 0°-30'		STRESS		PANEL - KEVLAR			
C 1			5. THREADS IN ACCORDANCE WITH MIL-S-7742				P. Persaud		HONEYCOMB			
E 1							STD., M.&P.					
A 1							CH. DRAFTN.					
			PRODUCTION PROCESS STANDARDS (P.P.S.) AND OTHER STANDARDS LISTED ON DWG. IN ADDITION TO THOSE STANDARDS CALLED UP IN THE FIELD OF THIS DRAWING SHALL FORM PART OF THIS DRAWING FOR ALL MANUFACTURING AND QUALITY REQUIREMENTS.				TECH. DES.					
							VA. OPS.					
CODE			PROTECTIVE TREATMENT				DWG. SIZE		CODE IDENT. NO.	DRAWING NO.	RELEASE	REV
			DE HAVILLAND PRODUCTION PROCESS SPECN.				C		71867	CSP 395	P	A
							SCALE		WG. CALC.	ACTUAL	SHT.	OF SH