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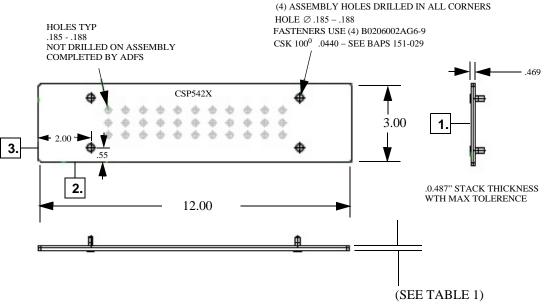
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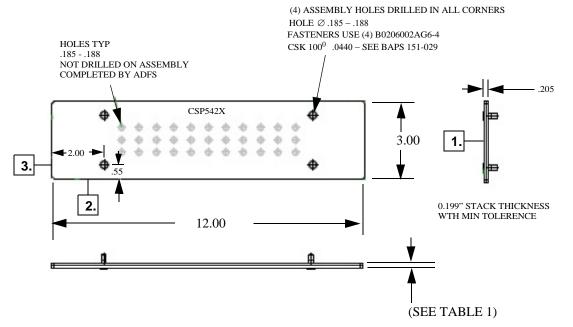
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PPROVED: 03 DEC 2014



TYPE A



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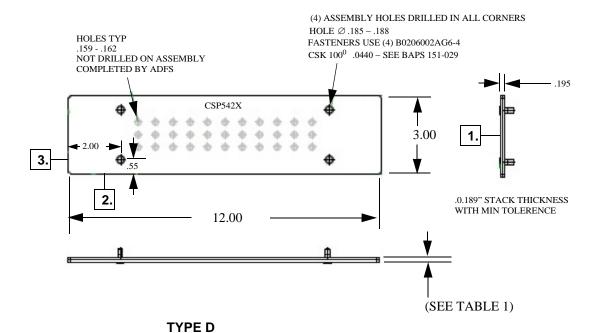
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STRESSED				
APPROVED	B. EDWARDS		SHEET:	1 of 7

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(4) ASSEMBLY HOLES DRILLED IN ALL CORNERS HOLE Ø .185 - .188 HOLES TYP .159 - .162 NOT DRILLED ON ASSEMBLY FASTENERS USE (4) B0206002AG6-9 CSK 100⁰ .0440 - SEE BAPS 151-029 COMPLETED BY ADFS .479 CSP542X 000000000 0 0 0 0 0 0 0 0.0 3.00 1. 2.00 ф di 0 3. 2. .497" STACK THICKNESS WITH MAX. TOLERENCE 12.00 (SEE TABLE 1)

TYPE C



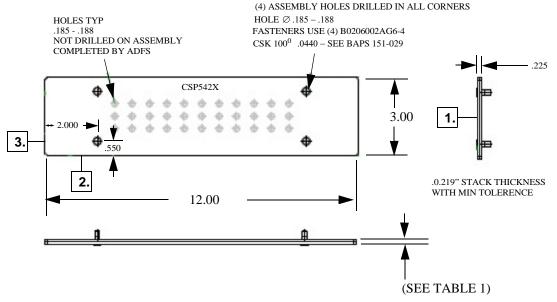
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STRESSED					
APPROVED	B. EDWARDS		SHEET:	2 of 7	

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(4) ASSEMBLY HOLES DRILLED IN ALL CORNERS HOLE Ø .185 – .188 FASTENERS USE (4) B0206002AG6-9 HOLES TYP .159 - .162 NOT DRILLED ON ASSEMBLY CSK 100⁰ .0440 - SEE BAPS 151-029 COMPLETED BY ADFS .489 CSP542X 000000000 0 0 0 0 0.0 0 0.0 3.00 1. ф di ф 0 -0-2.000 -3. 2. .0.507" STACK THICKNESS WITH MAX TOLERENCE 12.00 (SEE TABLE 1)

TYPE E

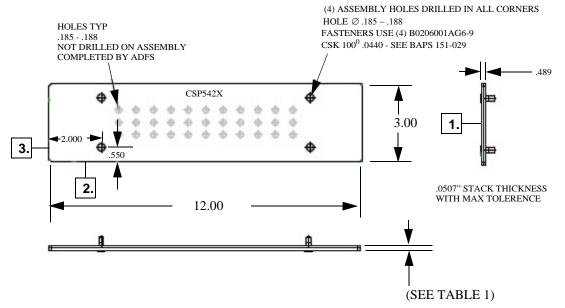


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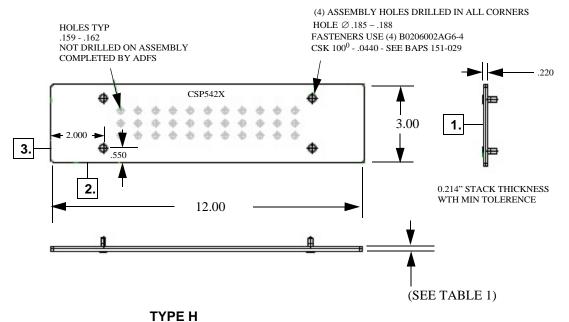
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CHECKED	D. DESROCHES	TEST COUPON	CSP 542	
STRESSED				
APPROVED	B. EDWARDS		SHEET:	3 of 7

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TYPE G

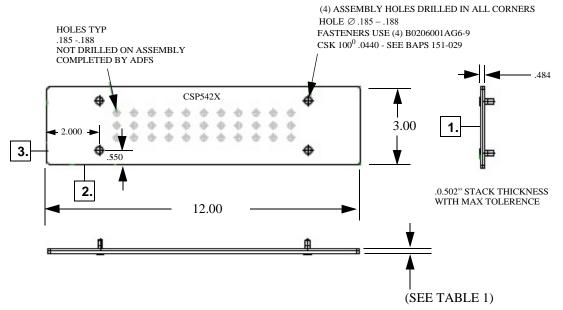


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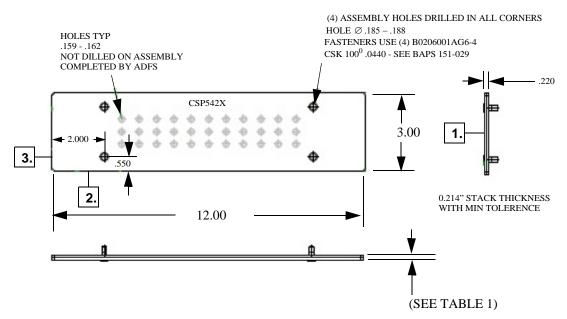
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STRESSED					
APPROVED	B. EDWARDS		SHEET: 4	of 7	

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TYPE I



TYPE J

DRAWN CHECKED	B. EDWARDS D. DESROCHES	TEST COUPON	CSP	CSP 542	
STRESSED					
APPROVED	B. EDWARDS		SHEET:	5 of 7	

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Table 1:

TYPE (ref.)	LAMINATION TYPE
A	INTERIOR SPLICE - 0.100" AL 7075-T6 SHIM - 0.032" AL 2024-T3 OR S10249 LAMINATED STRINGER - 0.100" AL-Li 2196 T8511 SHIM - 0.032" AL 2024-T3 OR S10249 LAMINATED CIRCUMFERENTIAL STRAP - 0.080" 2024-T3 CLAD EXTERIOR SKIN - 0.125 AL-Li 2198-T8
В	TRANSITION STRINGER - 0.080" AL 7075-T6 EXTERNAL SKIN (CENTER FUSE) - 0.125" AL-Li 2198-T8
С	EXTERNAL SKIN (CENTER FUSE) - 0.125" AL-Li 2198-T8 ORBITAL SPLICE STRAP - 0.085" AL 2024-T3 CLAD SHIM - 0.032" AL 2024-T3 OR S10249 LAMINATED LONGITUDINAL STRINGER OR PLATE - 0.125" AL-Li 2198-T8 SHIM - 0.032" AL 2024-T3 OR S10249 LAMINATED SPLICE FITTING (CENTER FUSE) - 0.100" AL 7075-T6
D	TRANSITION STRINGER - 0.080" AL 7075-T6 EXTERNAL SKIN (CENTER FUSE) - 0.115" AL-Li 2198-T8
E	SPLICE FITTING (CENTER FUSE) - 0.100" AL 7075-T6 SHIM - 0.032" AL 2024-T3 OR S10249 LAMINATED LOGITUDINAL STRINGER OR PLATE - 0.100 " AL-Li 2196 T8511 SHIM - 0.032" AS 2024-T3 OR S10249 LAMINATED ORBITAL SPLICE STRAP - 0.100" AL 2024-T3 CLAD EXTERNAL SKIN (CENTER FUSE) - 0.125" AL-Li 2198-T8
F	EXTERNAL SKIN (CENTRE FUSE) - 0.125" AL-Li 2198-T8 TRANSITION STRINGER - 0.100" AL 7075-T6
G	SPLICE FITTING (CENTRE FUSE) - 0.100" AL 7075-T6 SHIM - 0.032" AL 2024-T3 OR S10245 LAMINATED LONGITUDINAL STRINGER OR PLATE - 0.100 AL-Li 2196 T8511 SHIM - 0.032" AL 2024-T3 OR S10249 LAMINATED ORBITAL SPLICE STRAP100" AL 2024-T3 CLAD EXTERNAL SKIN (CENTRE FUSE) - 0.125" AL-LI 2198-T8
Н	TRANSITION STRINGER - 0.100" AL 7075-T6 EXTERNAL SKIN (CENTRE FUSE) - 0.120" AL-Li 2198-T8
I	SPLICE FITTING (CENTRE FUSE) - 0.100" AL7075-T6 SHIM - 0.032" AL 2024-T3 OR S10249 LAMINATED LONGITUDINAL STRINGER OR PLATE - 0.100" AL-Li 2196-T8511 SHIM - 0.032" 2024-T3 OR S10249 LAMINATED ORBITAL SPLICE STRAP - 0.100" AL 2024-T3 CLAD EXTERNAL SKIN (CENTRE FUSE) - 0.120" AL-Li 2198-T8
J	TRANSITION STRINGER - 0.100" AL 7075-T6 EXTERNAL SKIN (CENTRE FUSE) - 0.120" AL-Li 2198-T8

DRAWN	B. EDWARDS			
CHECKED	D. DESROCHES	TEST COUPON	CSP 542	
STRESSED				
APPROVED	B. EDWARDS		SHEET: 6 of 7	

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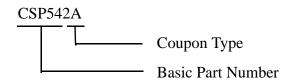
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APPROVED: 03 DEC 2014

NOTES:

- 1. DATUMAREPRESENTS THE EXTERIOR SURFACE OF THE AIRCRAFT.
- 2. NORMAL MAXIMUM ENGINEERING STACK THICKNESS IS 0.050".
- 3. HOLES ARE DRILLED THROUGH STACK WITH COUNTERSINK.
- 4. HOLES ARE PER BAPS 151-029 FOR HI-LITES.
- 5. TOLERANCE ON LAMINATE THICKNESS +/- 0.003.
- 6. FOR INSPECTION OF EDGE DISTANCE, DATUM EDGES BAND ENEED TO BE GROUND TO WITHIN 32 RHR AND NEED TO BE PERPENDICULAR TO WITHIN 0.005".

EXAMPLE OF PART NUMBER CALLOUT:



DRAWN	B. EDWARDS			
CHECKED	D. DESROCHES	TEST COUPON	CSP 542	
STRESSED				
APPROVED	B. EDWARDS		SHEET:	7 of 7