

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. EDWARDS	TEST COUPON	CSP 542
CHECKED	D. DESROCHES		
STRESSED			SHEET: 1 of 7
APPROVED	B. EDWARDS		

REV:

REV:

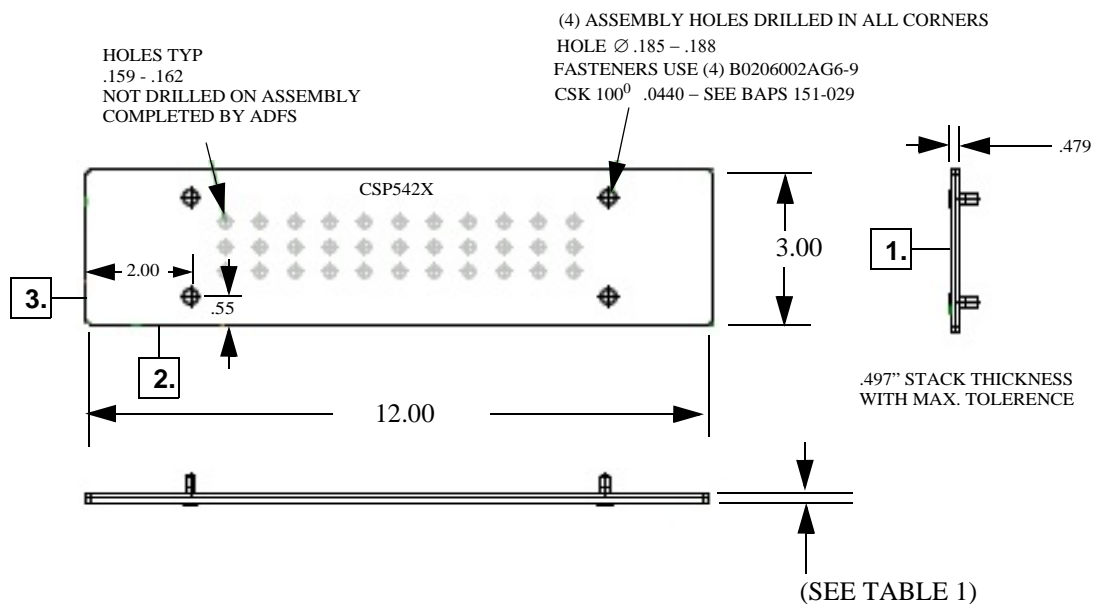
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REV:

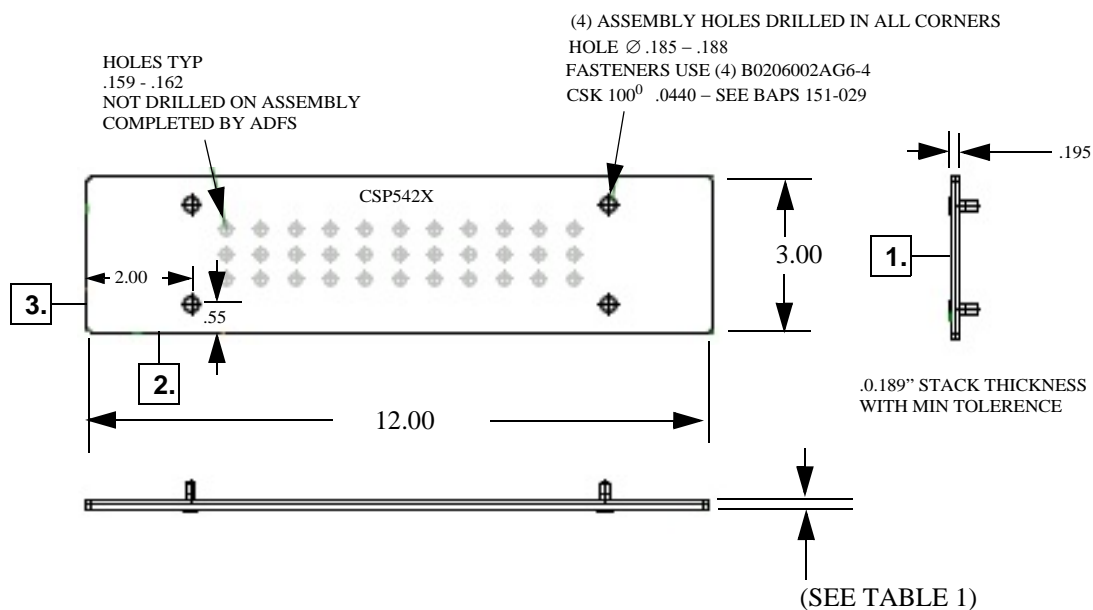
REV:

REV:

APPROVED: 03 DEC 2014



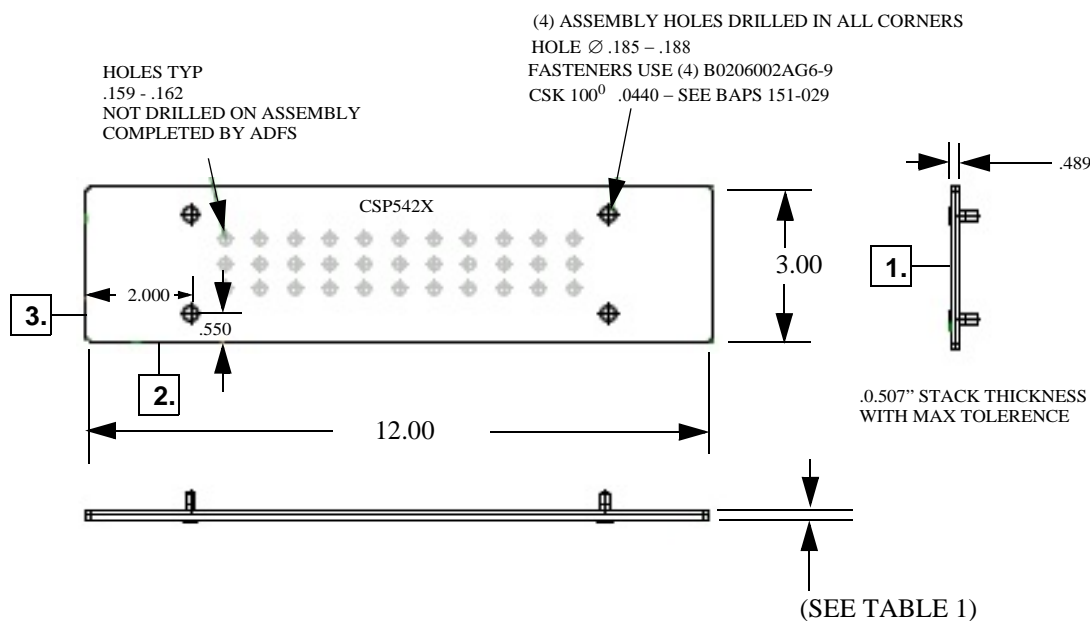
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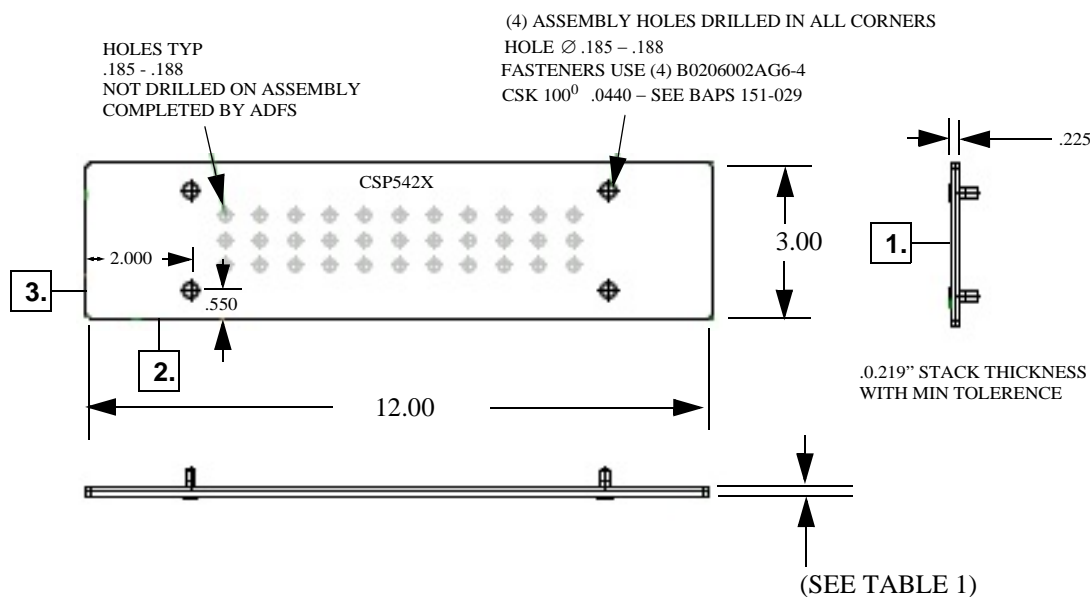
TYPE D

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DRAWN	B. EDWARDS	TEST COUPON	CSP 542
CHECKED	D. DESROCHES		
STRESSED			SHEET: 2 of 7
APPROVED	B. EDWARDS		



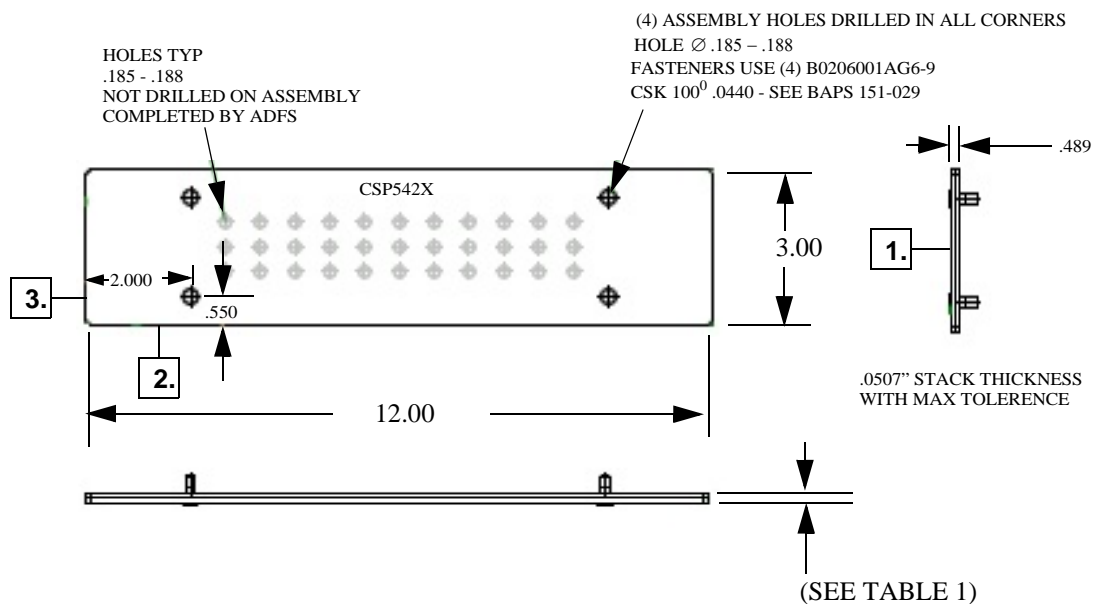
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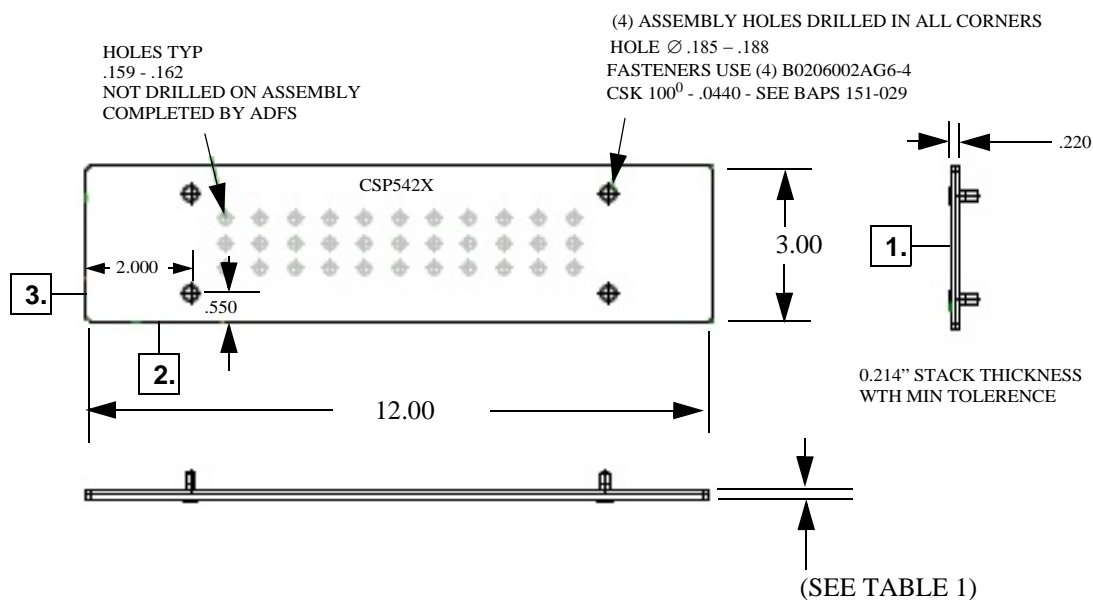
TYPE F

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

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



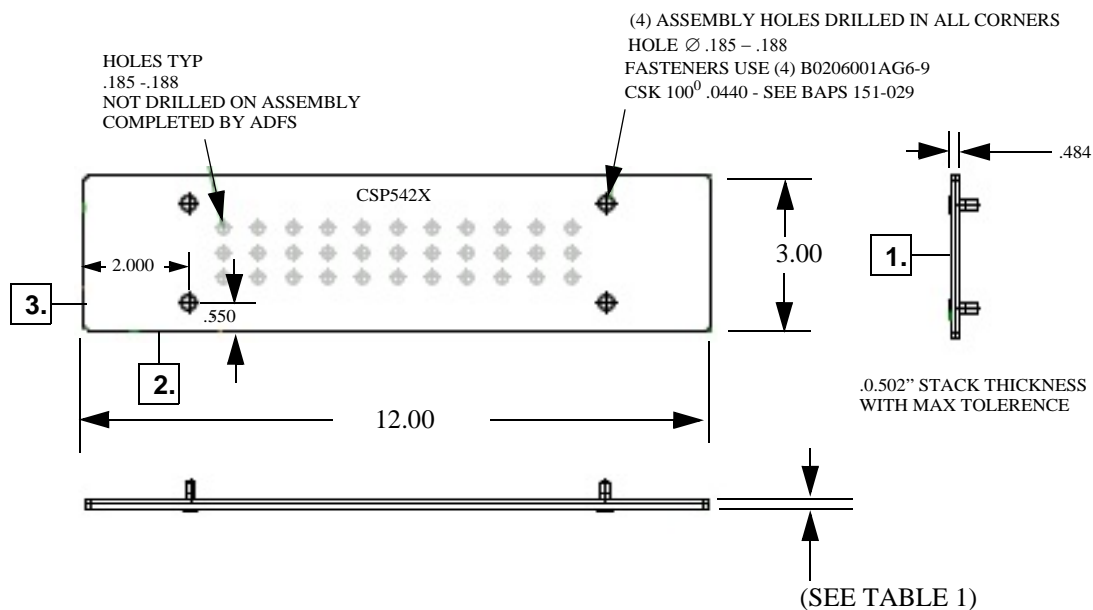
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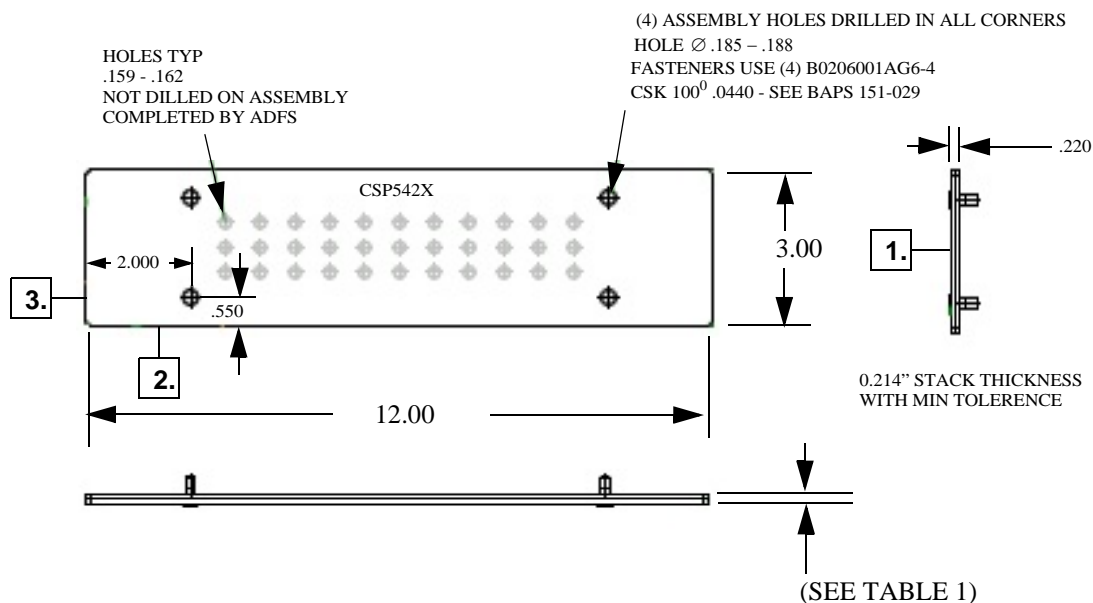
TYPE H

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. EDWARDS	TEST COUPON	CSP 542
CHECKED	D. DESROCHES		
STRESSED			SHEET: 4 of 7
APPROVED	B. EDWARDS		



TYPE I



TYPE J

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

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

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
B	TRANSITION STRINGER - 0.080" AL 7075-T6 EXTERNAL SKIN (CENTER FUSE) - 0.125" AL-Li 2198-T8
C	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 STRAP - .100" AL 2024-T3 CLAD EXTERNAL SKIN (CENTRE FUSE) - 0.125" AL-LI 2198-T8
H	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

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APPROVED	B. EDWARDS		

NOTES:

1. DATUM **[A]** REPRESENTS 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 **[B]** AND **[C]** NEED TO BE GROUND TO WITHIN 32 RHR AND NEED TO BE PERPENDICULAR TO WITHIN 0.005".

EXAMPLE OF PART NUMBER CALLOUT:

CSP542A

Coupon Type

Basic Part Number

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STRESSED			SHEET: 7 of 7
APPROVED	B. EDWARDS		