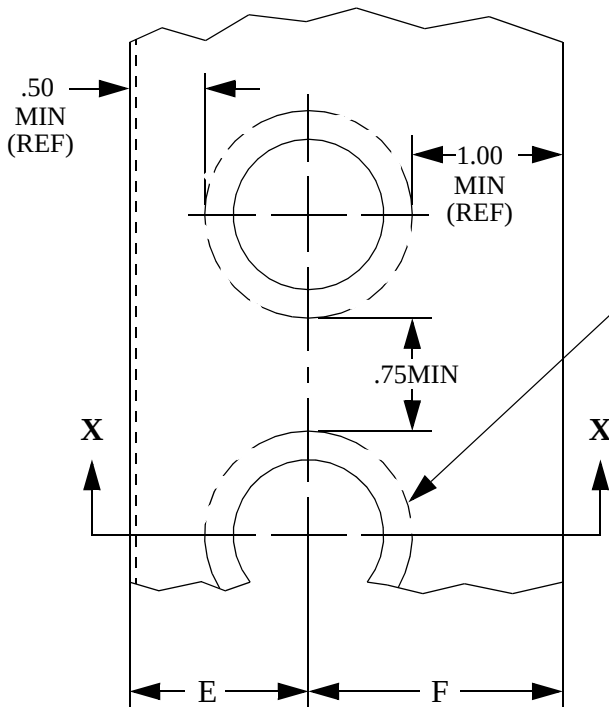


de HAVILLAND

CAGE CODE 71867

DESIGN STANDARD



NOTE:

1) SPECIFY FLANGE DIRECTION ON DRAWING: UP OR DOWN.

E.G.:

DS 11 - XX DOWN

2) IN PRIMARY STRUCTURE, 'A' MUST NOT EXCEED 'E' OR 'F'.

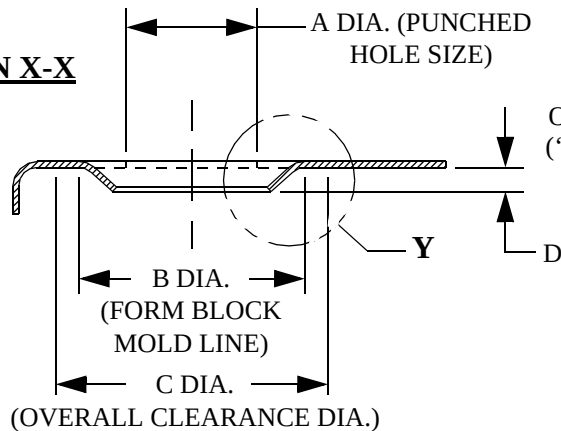
3) 'D' PLUS MATERIAL THICKNESS GIVES TOTAL DEPTH OF FLANGED HOLE.

4) FOR 'R' DIMENSIONS - SEE TABLE 1

5) FOR 'A, B, C AND D' DIMENSIONS - SEE TABLE 2

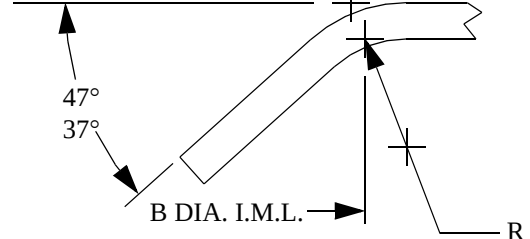
6) ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED

SECTION X-X



DETAIL Y

O.M.L DIA. = $B - (.828 \times T)$
('T' = MATERIAL GAUGE)



LIST OF CURRENT SHEETS

PAGE	1	2									
REVISION	H	H									

ADDED: DS11-08 ON SHEET 2

H

DATE	December 11, 1995
PREPARED	K. SHAW
STRESS	E. CROMIE
STDS / REL	B. EDWARDS

LIGHTENING HOLES FLANGED

DS 11

PAGE 1 OF 2
Revision: H

de HAVILLAND

CAGE CODE 71867

DESIGN STANDARD

TABLE 1 - BEND RADIUS "R"

R	MATERIAL / GAUGE	.016	.020	.025	.032	.040	.051	.064	.071	.080	.090	.100	.125
	2014-T3, 7075-W ALL 'O' TEMPER ALLOYS	.06		.12				.18			.25		
	7075-T6	.12		.18		.25		.50			.75		
	2024-T3	.06		.15				.25			.38		

TABLE 2 - LIGHTENING HOLES (FLANGED) DATA

LIGHT'G HOLE DASH NO.	A PUNCHED HOLE DIA.	B DIA.	C DIA. (APPROX)	D ±.032	WT. METAL REMOVED .032 ALCLAD	EQUIVALENT		
						CS50	G15	DHS500
-04	.50	.75	-	.10	.0006	LEARJET S-118-3		
-06	.75	1.00	-	.10	.0014	LEARJET S-118-4		
-08	.80	1.10	-	.10	.0016			
-10	1.00	1.38	1.81	.12	.0026	-	-10	1.00
-12	1.25	1.62	2.00	.12	.0039	1.25	-	1.25
-14	1.50	1.87	2.30	.12	.0057	1.50	-14	1.50
-16	1.75	2.12	2.50	.12	.0072	1.75	-	-
-17	1.87	2.25	2.68	.12	.0089	-	-17	-
-20	2.00	2.44	2.87	.12	.0100	2.00	-	2.00
-22	2.25	2.87	3.25	.20	.0128	-	-22	2.25
-24	2.50	3.12	3.50	.20	.0158	2.50	-	2.50
-26	2.75	3.35	3.75	.20	.0191	-	-26	2.75
-30	3.00	3.60	4.00	.20	.0227	3.00	-	3.00
-32	3.25	4.12	4.50	.32	.0266	-	-32	3.25
-34	3.50	4.38	4.75	.32	.0307	3.50	-	3.50
-36	3.75	4.62	5.00	.32	.0355	-	-36	3.75
-40	4.00	4.88	5.30	.32	.0402	4.00	-40	4.00
-42	4.25	5.12	5.50	.32	.0456	-	-	4.25
-44	4.50	5.38	5.80	.32	.0510	4.50	-44	4.50
-46	4.75	5.62	6.00	.32	.0567	-	-	4.75
-50	5.00	5.87	6.30	.32	.0630	5.00	-50	5.00
-54	5.50	6.62	7.00	.38	.0762	5.50	-	5.50
-60	6.00	7.12	7.50	.38	.0910	6.00	-60	6.00
-64	6.50	7.62	8.00	.38	.1020	-	-	6.50
-70	7.00	8.12	8.50	.38	.1268	-	-	7.00

DATE	December 11, 1995
PREPARED	K. SHAW
STRESS	E. CROMIE
STDS / REL	B. EDWARDS

LIGHTENING HOLES FLANGED

DS 11
PAGE 2 OF 2
Revision: H

ADDED: DS11-08

H