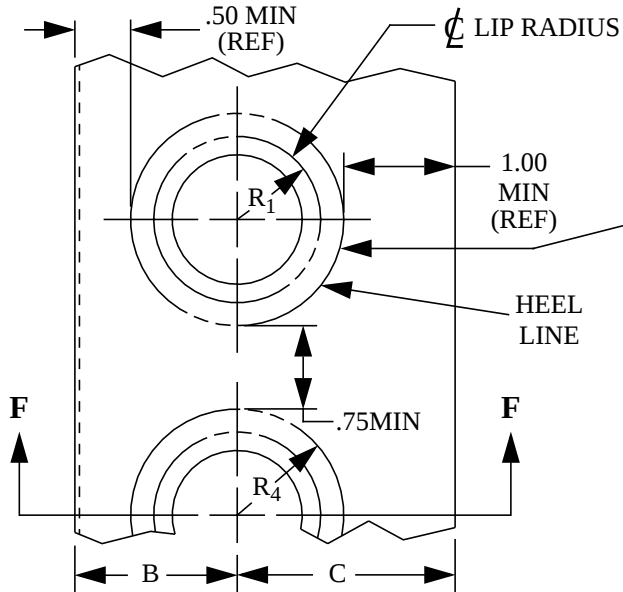


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NOTE:

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

E.G.:

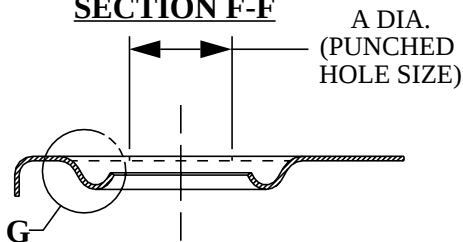
DS 12 - XX DOWN

2) IN PRIMARY STRUCTURE, 'A' MUST NOT EXCEED 'B' OR 'C'.

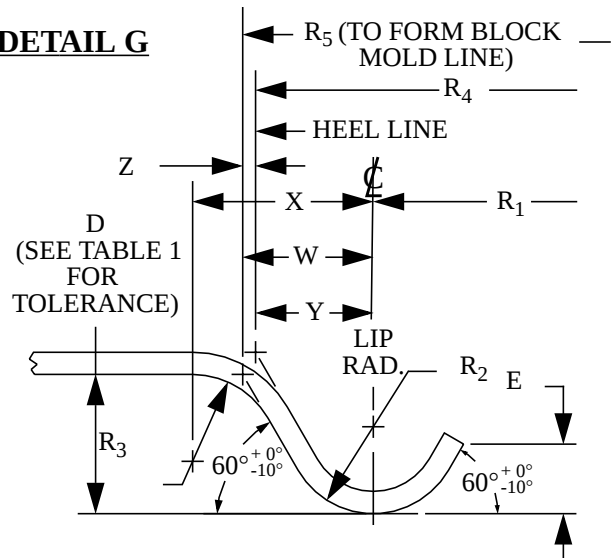
3) ALL LIGHTENING HOLES TO BE CLASS "A" UNLESS OTHERWISE SPECIFIED (SEE TABLE 1 FOR 'D' TOLERANCE DIFFERENCES).

4) ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED

SECTION F-F



DETAIL G



LIST OF CURRENT SHEETS

PAGE	1	2	3								
REVISION	J	G	C								

DATE	December
PREPARED	K. SHAW
STRESS	E. CROMIE
STDS / REL	S. SCHRATTNER

LIGHTENING HOLES RETURN LIP

DS 12
PAGE 1 OF 3

ADDED .063 THK MATERIAL TO SHEET 2 AND 3..

J

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DESIGN STANDARD

TABLE 1 - TOLERANCE FOR DIMENSION 'D'

DASH NO.	CLASS "A"	CLASS "B"
-1 TO -4	+.000 -.040	+.000 -.080
-4 $\frac{1}{2}$ & UP	+.000 -.062	+.000 -.125

TABLE 2 - DEPTH OF HOLE

X (REF)	D DEPTH	MATERIAL THICKNESS Ⓒ					
		.020	.025	.032	.040	.050	.063
		Y (REF)					
.32	.25	.219	.216	.212	.207	.202	.197
.44	.375	.349	.346	.342	.337	.332	.327
.52	.50	.419	.416	.412	.407	.402	.397
.60	.625	.499	.496	.492	.487	.482	.477
.67	.75	.566	.563	.559	.554	.549	.544

TABLE 3 - DISTANCE FROM FORM BLOCK MOLD LINE TO HEEL LINE

	MATERIAL THICKNESS Ⓒ					
	.020	.025	.032	.040	.050	.063
Z (REF)	.011	.014	.018	.023	.028	.033

Ⓒ ADDED .063 THK MATERIAL TO SHEET 3.

Ⓒ

DATE	December 11,1995	LIGHTENING HOLES RETURN LIP	DS 12 PAGE 2 OF 3
PREPARED	K. SHAW		
STRESS	E. CROMIE		
STDS / REL	S. SCHRATTNER		

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DESIGN STANDARD

TABLE 1 - LIGHTENING HOLES (RETURN LIP) GENERAL DATA

DASH NO.	A PUNCHED HOLE	R ₅ (REF)	D	E ±.032	W	R ₁	R ₂	R ₃	MATERIAL THICKNESS ©					
									.020	.025	.032	.040	.050	.063
									R ₄ (REF)					
-1	.90	.98	.25	.125	.23	.75	.156	.156	.969	.966	.962	.957	.952	.946
-2	1.25	1.23	.25	.125	.23	1.0	.156	.156	1.219	1.216	1.212	1.207	1.202	1.196
-3	1.50	1.61	.375	.187	.36	1.25	.25	.156	1.599	1.596	1.592	1.587	1.582	1.576
-4	2.0	1.86	.375	.187	.36	1.50	.25	.156	1.849	1.846	1.842	1.837	1.832	1.826
-4 $\frac{1}{2}$	2.75	2.235	.375	.187	.36	1.875	.25	.156	2.224	2.221	2.217	2.212	2.207	2.201
-4 $\frac{3}{4}$	3.15	2.440	.375	.187	.36	2.00	.25	.156	2.349	2.346	2.342	2.337	2.332	2.326
-5	3.75	2.735	.375	.187	.36	2.375	.25	.156	2.724	2.721	2.717	2.712	2.707	2.701
-5 $\frac{1}{2}$	4.25	2.985	.375	.187	.36	2.625	.25	.156	2.974	2.971	2.967	2.962	2.957	2.951
-6	4.86	3.43	.50	.187	.43	3.0	.25	.156	3.419	3.416	3.412	3.407	3.402	3.396
-6 $\frac{1}{2}$	5.40	3.70	.50	.187	.43	3.27	.25	.156	3.689	3.686	3.682	3.677	3.672	3.666
-7	5.95	4.135	.625	.187	.51	3.625	.25	.156	4.124	4.121	4.117	4.112	4.107	4.101
-8	7.20	4.76	.625	.187	.51	4.25	.25	.156	4.749	4.746	4.742	4.737	4.732	4.726
-9	7.96	5.13	.625	.187	.51	4.625	.25	.156	5.124	5.121	5.117	5.112	5.107	5.101
-10	9.06	5.83	.75	.187	.577	5.25	.25	.156	5.816	5.813	5.809	5.807	5.799	5.793
-12	9.56	6.08	.75	.187	.577	5.5	.25	.156	6.069	6.066	6.062	6.057	6.052	6.046

© ADDED .063 THK MATERIAL TO SHEET 3



DATE	December 11,1995
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STRESS	E. CROMIE
STDS / REL	S. SCHRATTNER

LIGHTENING HOLES RETURN LIP

DS 12
PAGE 3 OF 3