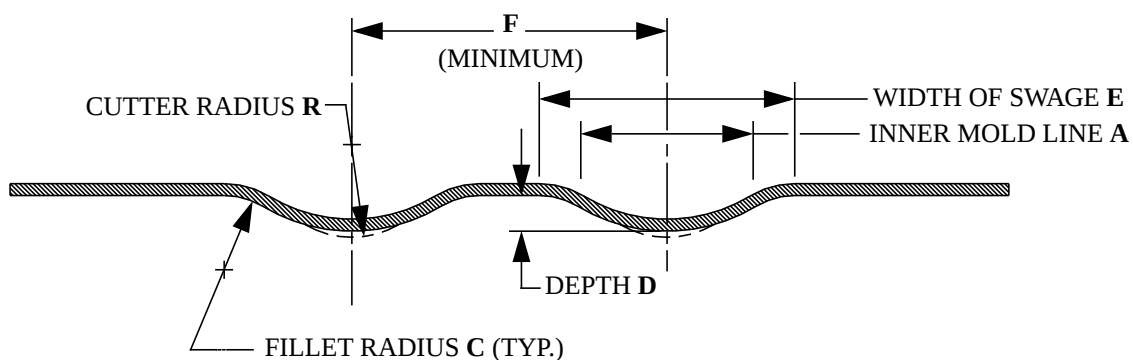
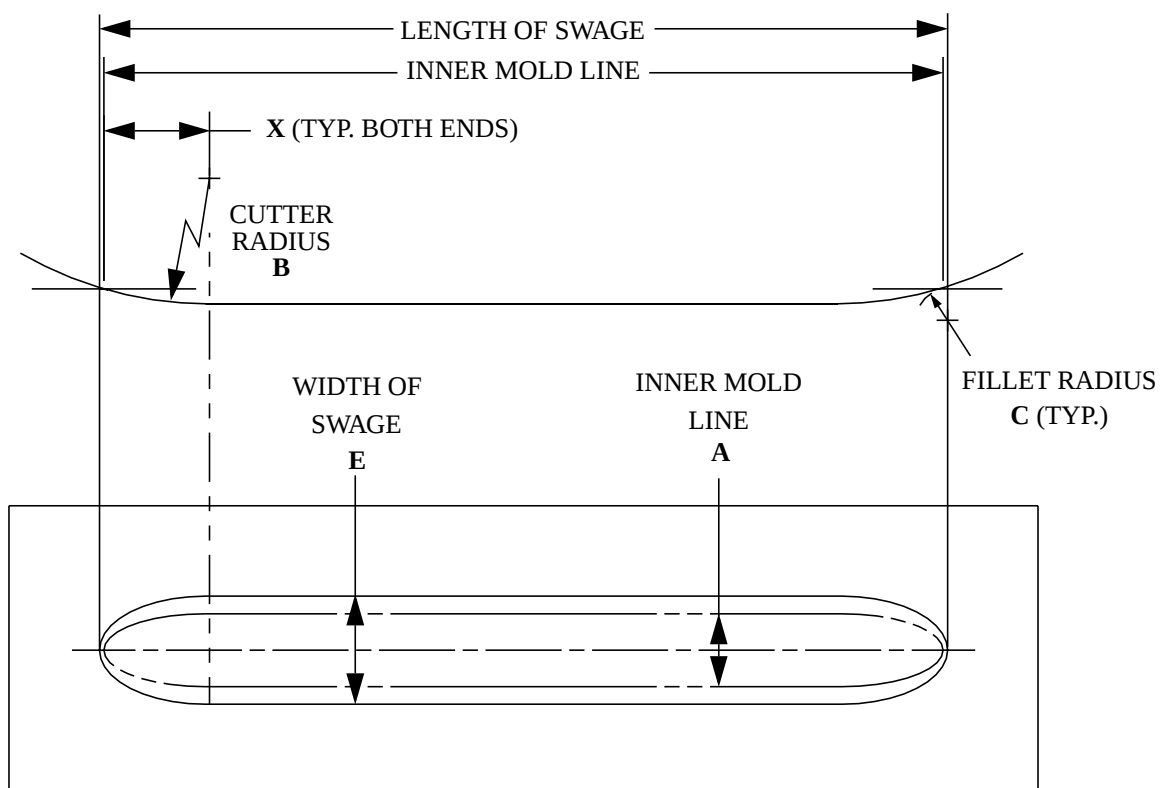


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DESIGN STANDARD



LIST OF CURRENT SHEETS

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DATE	December 11,	SWAGES WITH ELLIPSOIDAL ENDS	DS 13 PAGE 1 OF 2 Revision: D
PREPARED	K. SHAW		
STRESS	E. CROMIE		
STDS / REL	S. SCHRATTNER		

de HAVILLAND

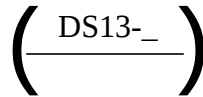
CAGE CODE 71867

DESIGN STANDARD**TABLE 1 - SWAGE DATA**

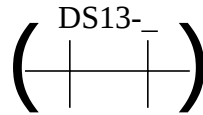
SWAGE	DASH NO.	CUTTER RADIUS B	CUTTER WIDTH (Ref.)	CUTTER RADIUS R	A	FILLET RADIUS C	DEPTH D (± .030)	E	F (min.)	X	REMARKS
STANDARD	-1	6.0	.625	.312	.58	.25	.12	.86	1.06	.84	MATERIAL IN T-4 CONDITION
	-2	8.0	.875	.437	.80	.25	.19	1.06	1.20	1.22	
	-3	8.0	1.25	.625	1.01	.25	.20	1.24	1.34	1.25	
SPECIAL	-4	6.0	.625	.312	.58	.375	.20	.86	1.17	1.08	
	-5	8.0	.875	.437	.80	.375	.25	1.06	1.30	1.39	
	-6	8.0	1.25	.625	1.01	.375	.25	1.24	1.437	1.39	
	-7				.375	.15	.16	.63	USED ON BEAVER TANKS ONLY		

NOTE:

1. ENGINEERING TO SPECIFY LENGTH AND WIDTH OF SWAGE:



2. LOFT TO SPECIFY CUTTER POSITION:



3. ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED.

DATE	December 11, 1995	SWAGES WITH ELLIPSOIDAL ENDS	DS 13 PAGE 2 OF 2 Revision: -
PREPARED	K. SHAW		
STRESS	E. CROMIE		
STDS / REL	S. SCHRATTNER		