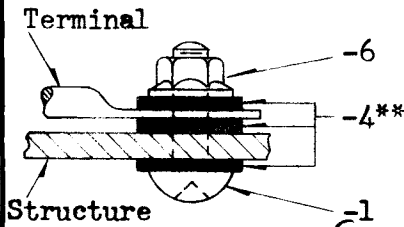
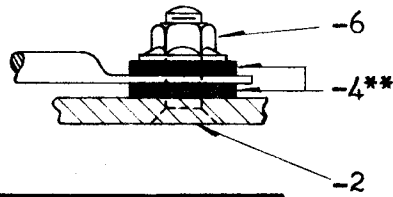


STANDARDS SHEET

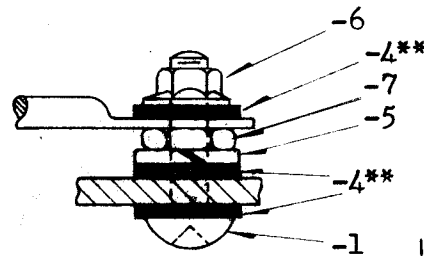
TYPE I MAXIMUM 4 TERMINALS PER STUD.



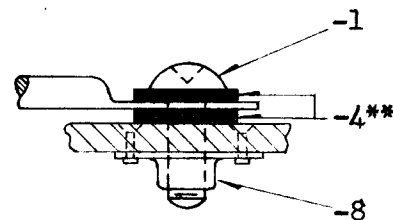
TYPE I B



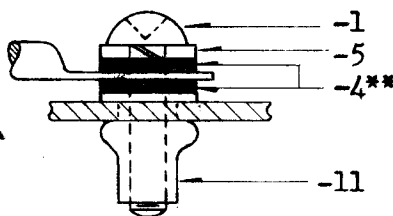
TYPE II



TYPE III



TYPE IV A



Dash No.	Description *** see note on page 2
- 1	Recessed Head Screw
- 2	Countersunk Head Screw
- 3	Hex-Head Bolt
- 4	Flat Washer - untreated aluminum alloy
- 5	Lockwasher (light series)
- 6	Nut (Hex, Self locking)
- 7	Nut - Check (hexagon)
- 8	Anchor Nut (selflocking)
- 9	Nut - castellated
-10	Pin - cotter
-11	Rivnut -

** See Table No. 1 for washer thickness. (page 3).

* See Table No. 2 for washer thickness. (page 3).

For screw or bolt torquing values, see Table No. 3. (page 3).

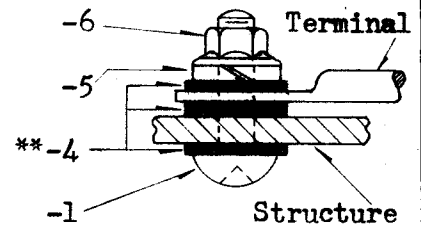
Prepare and refinish bonding and grounding surfaces to PPS 9.06.

This Standard applies only to the following types of aircraft -

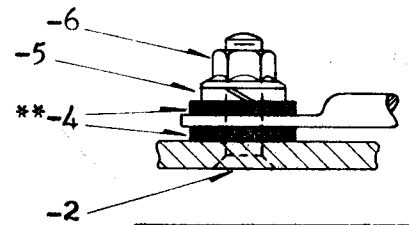
DHC-T2 Turbo Beaver
DHC-4 Caribou
DHC-5 Buffalo
DHC-6 Twin Otter

FOR NEW DESIGN - SEE E M 3-20.

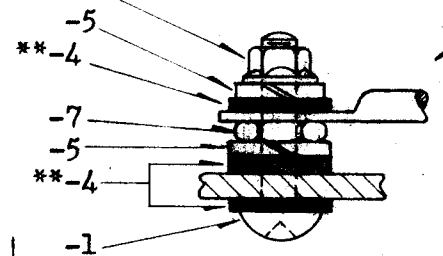
TYPE I A



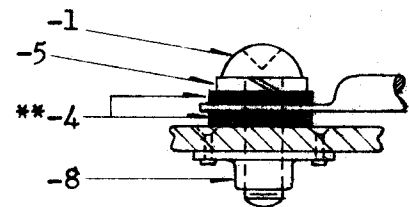
TYPE I C



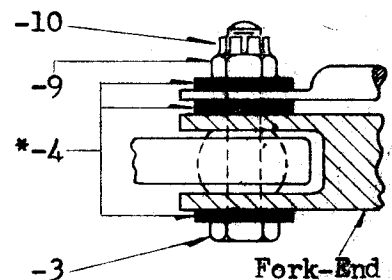
TYPE II A



TYPE III A



TYPE - FORK-END



DRAWN	SEUNG	JUNE 70
CHECKED	LS	
STRESSED		
APPROVED	LS	

CLASSIFICATION

BONDING & GROUNDING
HARDWARE INSTALLATION

STANDARD

DS - 42
Sheet 1

SEE EM 3-20

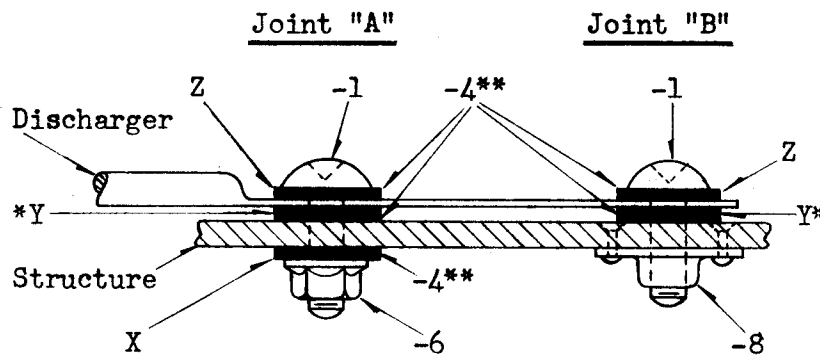
FOR NEW DESIGN

Redesigned & rearranged
25 June 1970
LS



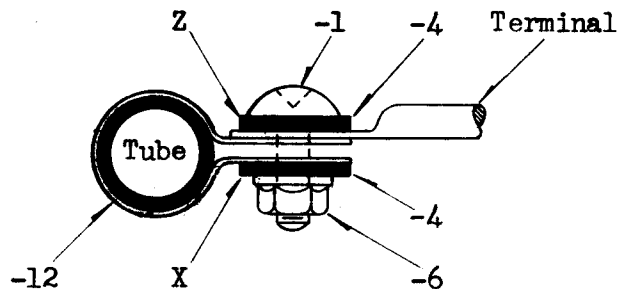
STANDARDS SHEET

TYPE - STATIC DISCHARGER



Dash No.	Description ***
- 1	Screw - Recessed Head
- 4	Flat Washer - untreated aluminum alloy
- 6	Nut, Hex, self-locking
- 8	Anchor Nut, self-locking
-12	Clamp

TYPE - BONDING OF TUBING



Notes -

** See Table No. 1 for washer thickness. (page 3).

* Use two washers instead of one washer when .032 thickness is used.
For X, Y, Z, see Table No. 1.

For screw or bolt torquing values, see Table No. 3.
(page 3).

Prepare and refinish bonding and grounding surface to PPS 9.06.

*** Hardware is to be in accordance to the drawing call-out. The sequence of installation such as washer location and thickness is to be to this STANDARD.

SEE EM 3-20

FOR NEW DESIGN

25 June 1970
A
F
C
Joints indicated.

DRAWN	STUNG JUNE 70
CHECKED	
STRESSED	
APPROVED	

LS

CLASSIFICATION

BONDING & GROUNDING
HARDWARE INSTALLATION

STANDARD

DS - 42
Sheet 2

STANDARDS SHEET

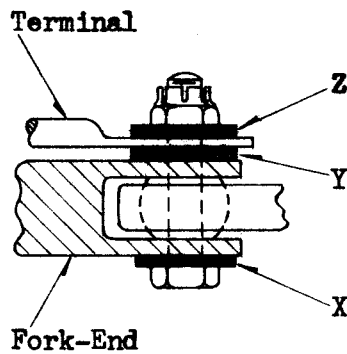
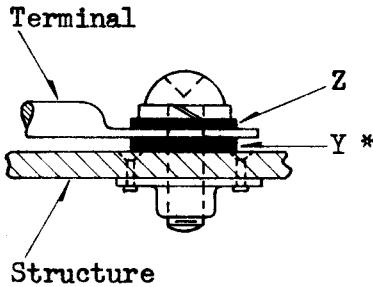
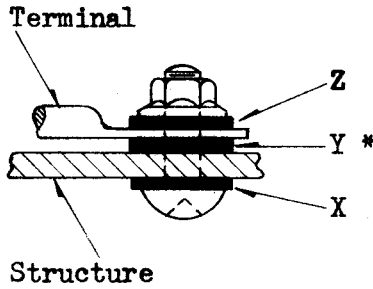


TABLE No. 1 WASHER THICKNESS AND LOCATION

Type of Assembly	Screw Class	Thread Size	Washer Location		
			X	Y	Z
			Washer Thickness		
I, IA, II, IIA, and Static Dis- charger Joint "A"	1 & 2	No. 6 & 8	.016	2 x .032 *	.016
		No. 10 & Up	.016	.063	.016
IB, IC, III, III A, IV A, & Static Dis- charger Joint "B"	1 & 2	No. 6 & 8	-	2 x .032 *	.016
		No. 10 & Up	-	.063	.016

* USE TWO WASHERS instead of one washer when .032 thickness is used at the "Y" location only.

TABLE No. 2 WASHER THICKNESS AND LOCATION

Type of Assembly	Thread Size	Washer Location		
		X	Y	Z
		Washer Thickness		
Fork-End Pivot	1/4	.016	.063	.016
	5/16	.016	.063	.016
	3/8	.016	.063	.016
	7/16	.016	.063	.016
	1/2	.016	.063	.016

** Use only for electrical grounding applications.

TORQUING VALUES FOR PEM STUDS IN. LBS	
#6	5 - 9
#8	15 - 18
#10	25 - 30

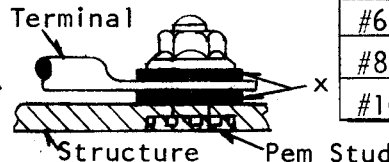


TABLE No. 3 TORQUING VALUES **

Screw Size	Copper Terminal (inch-pound)	Aluminum Terminal (inch-pound)
No. 8	15 - 20	15 - 20
No. 10	25 - 30	25 - 30
1/4	40 - 45	40 - 45
5/16	80 - 85	-
3/8	110 - 125	-
1/2	140 - 155	-

Note: Torque Values For #8 & #10 Pem Studs Are 15-20 In. lbs.

DRAWN	SEUNG JUNE 70	CLASSIFICATION	STANDARD
CHECKED		BONDING & GROUNDING HARDWARE INSTALLATION	DS - 42 Sheet 3
STRESSED			
APPROVED			

LS

TORQUING VALUES FOR PEM STUDS ADDED
 18.3.81
 SEE EM 3-20
 FOR NEW DESIGN -
 Torque Values Altered For Pem Stud Installation Adda
 6.76 BR
 & details
 inged.
 25 June 70
 (B)