DASH NO.	TITLE	STANDARD	STYLE	SEE SHT.
-1	DETAILS, END FITTING	AND10077-날	С	2
-2	DETAILS, BOSSED END	AND10050-4		3
-3	DETAILS, BOSSED END	AND10050-6		4
-4	DETAILS, BOSSED END	AND10050-10		5
-5	DETAILS, BOSSED END	MS33649-10		6
-6	DETAILS, END FITTING	MS33656-4	E	7
<u>-7</u>	DETAILS, END FITTING	MS33656-10	E	8
-8	DETAILS, END FITTING	MS33656-16	E	9
-9	DETAILS, END FITTING	MS33657-16	S	10
-10	DETAILS, END FITTING	M\$33656-8	E	<u>li</u>
-11	DETAILS, END FITTING	AND 10077-3/4	Α	12
-12	DETAILS, END FITTING	MS33657-8	·Ε	13
-13	DETAILS, BOSSED END	AND10050-8		14

"A"

"A"

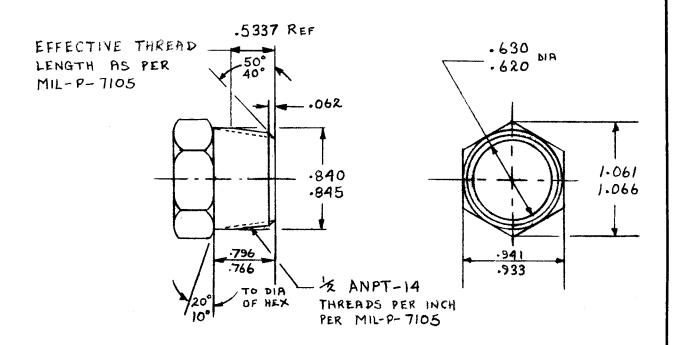
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"A"

DRAWN	RJS	CLASSIFICATION	STANDARD
CHECKED	RJS		
STRESSED		STANDARD DIMENSIONS FOR	DS-68
APPROVED	and	BOSSES AND END FITTINGS	Sht. I of I#
	(may)		

DE HAVILLAND AIRCRAFT of CANADA

- STANDARDS SHEET



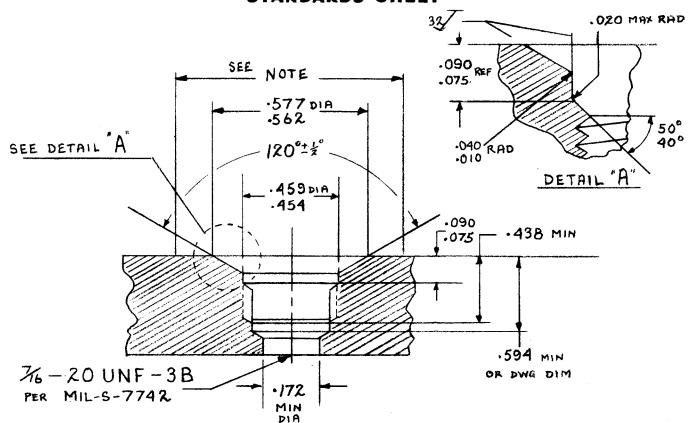
SURFACE FINISH

- Break all sharp edges and remove all hanging burrs and slivers which might be dislodged under use.
- 2. Surface roughness 125 max. unless noted.
- 3. Tolerances as stated.
- 4. Dimensions in inches.

-I DETAILS AND 100077 STYLE-C

DRAWN	RJS	CLASSIFICATION	STANDARD
CHECKED RJS STRESSED			
		STANDARD DIMESNIONS FOR	DS-68 Shrt. 2 of 10
APPROVED	ANI	BOSSES AND END FITTINGS	

STANDARDS SHEET



NOTE: Surface of boss shall be spotfaced minimum .828 finish 64.

SURFACE FINISH

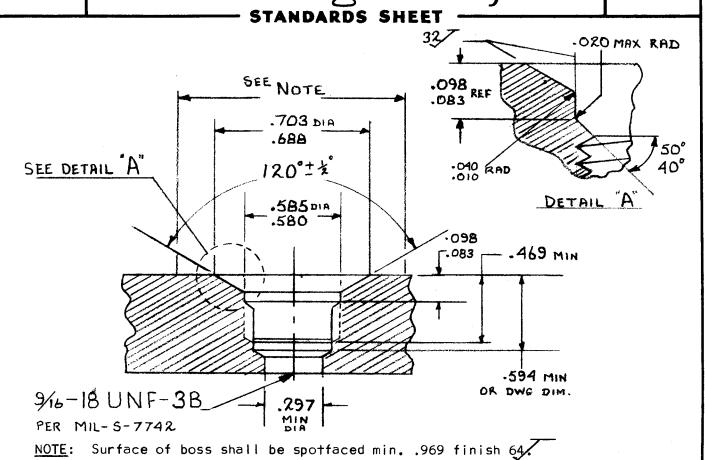
- 1. Break all sharp edges and remove all hanging burns and slivers which might be dislodged under use.
- 2. Surface roughness 125 Junless noted.
- Tolerances as stated.
- 4. Dimensions in inches.
- 5. Diameter .577, diameter .459, and thread shall be concentric within .005 inch full indicator reading.
- 6. Squareness between thread and face of boss at diameter .577 shall not exceed .005 inch.
- 7. The countersink of diameter .577 and counterbore of diameter .459 shall be free from longitudinal and spiral tool marks.

- 2 DETAILS

DRAWN	RJS	CLASSIFICATION	STANDARD
CHECKED	RJS		
STRESSED		STANDARD DIMENSIONS FOR	DS-68
APPROVED	14/20	BOSSES AND END FITTINGS	Sht. 3 of 10

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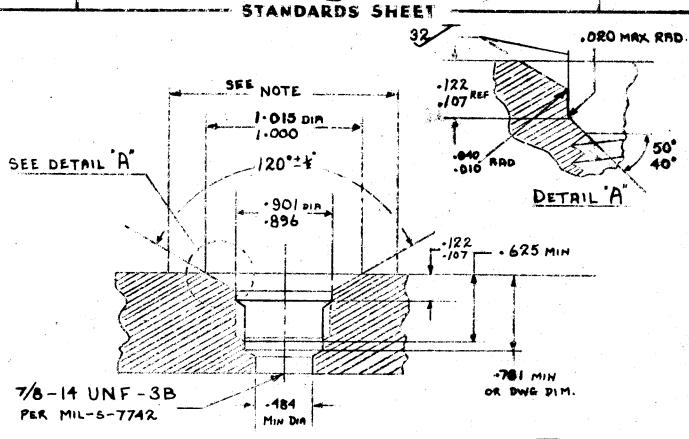


SURFACE FINISH

- Break all sharp edges and remove all hanging burrs and slivers which might be dislodged under use.
- 2. Surface roughness 125 unless noted.
- 3. Tolerances as stated.
- 4. Dimensions in inches.
- 5. Diameter .703, diameter .585, and thread shall be concentric within .005 inch full indicator reading.
- 6. Squareness between thread and face of boss at diameter .703 shall not exceed .005 inch.
- 7. The countersink of diameter .703 and counterbore of diameter .585 shall be free from longitudinal and spiral tool marks.

- 3 DETAILS AND 10050-6

DRAWN	RJS	CLASSIFICATION	STANDARD
CHECKED	RJS	CTANDADD DIMENSIONS FOR	DS-68
STRESSED		STANDARD DIMENSIONS FOR BOSSES AND END FITTINGS	Sht. 4 of 10
APPROVED	177	BOSSES AND END LITTINGS	3.7.

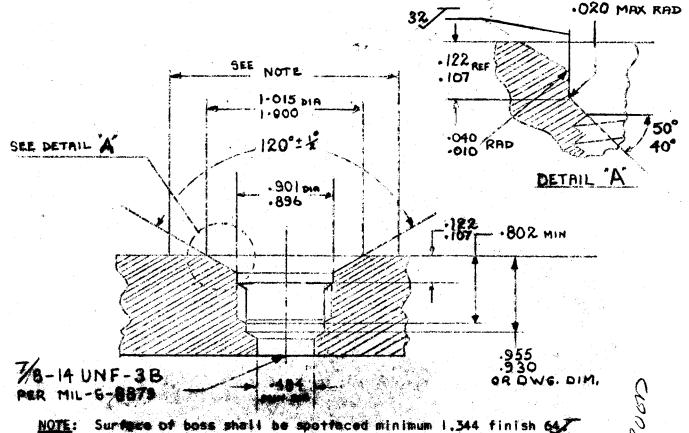


NOTE: Surface of boss shall be spotfaced min. 1.344 finish 64.

SUPFACE FINISH

- 1. Breek all sharp edges and remove all hanging burrs and slivers which might be dislodged under use.
- 2. Surface roughness 125 unless noted.
- 3. Tolerances as stated.
- 4. Dimensions in inches.
- 5. Diameter 1.015, diameter .901 and thread shall be concentric within .005 inch full indicator reading.
- 6. Squareness between thread and face of boss at diameter 1.015 shall not exceed .005 inch.
- 7. The countersink of diameter 1.015 and counterbore of diameter .901 shall be free from longitudinal and spiral tool marks.

		- 4 DETAILS	
DRAWN	RJS	CLASSIFICATION	STANDARD
CHECKED	RJS	STANDARD DIMENSIANS FOR	art Maker derfordigen anderfordische Maker in der der der der der 17 in 2016 och der 2015 och der de forden de Der der der der der der der der der der d
STRESSED		STANDARD DIMENSIONS FOR BOSSES AND END FITTINGS	D\$-68
APPROVED	M		Sht. 5 of 10



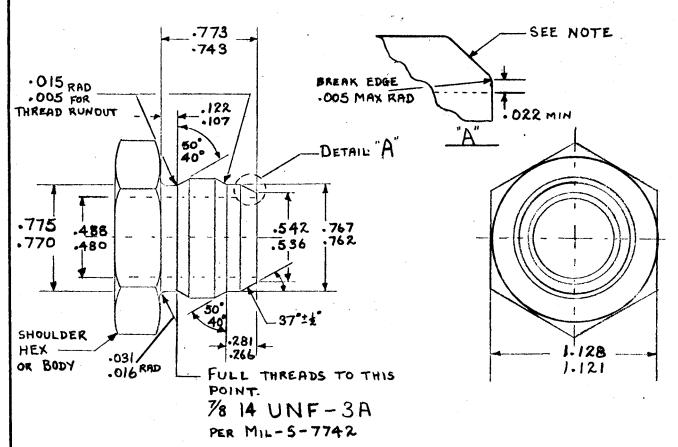
SURFACE FINISH

- 1. Break all sharp edges and remove all hanging burrs and slivers which might be dislodged under use.
- Surface roughness 125 unless noted. 2.
- 3. Tolerances as stated.
- Dimensions in inches. 4.
- 5. Diameter 1.015, diameter .901 and thread shall be concentric within .005 inch full indicator reading.
- 6. Squareness between thread and face of boss at diameter 1.015 shall not exceed .005 inch.
- The countersink of diameter 1.015 and counterbore of diameter .901 7. shall be free from longitudinal and spiral tool marks.

-5 DETAILS

		MS-33649-10			
į	DRAWN	RJS	CLASSIFICATION	STRNDARD	
	CHECKED	RJS			
1	STRESSED		STANDARD DIMENSIONS FOR	DS-68	
	APPROVED	Yes	BOSSES AND END FITTINGS	Sht. 6 of 10	

STANDARDS SHEET



NOTE: This surface shall be a smooth uniform conical surface free from burrs, tool marks and visible flat spots except annular tool marks will be allowed to 100 microinches RHR max.

SURFACE FINISH

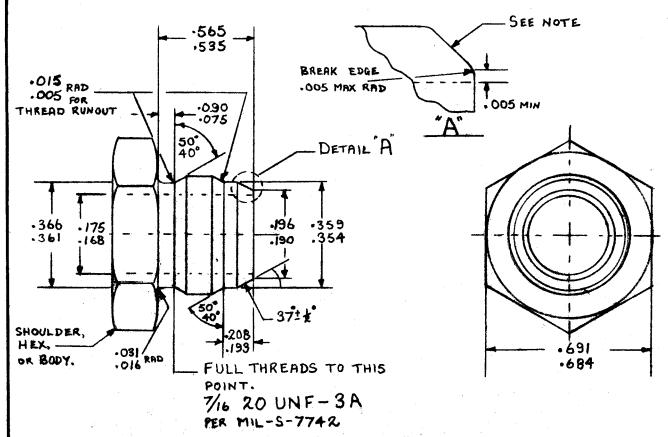
- 1. Concentracity of diameter .767, diameter .542, diameter .775 and thread shall be measured and calculated as an included angle within .005 total indicator reading.
- 2. Surface roughness 125 max unless noted.
- 3. Remove all burrs, slivers and sharp edges.
- 4. Dimensions in inches.
- 5. Squareness between thread and face of hex or body shall not exceed .005.

-7 DETAILS

		MS-33656-IO STYLE E	•	
DRAWN	RJS	CLASSIFICATION	STANDARD	
CHECKED	RJS			
STRESSED		STANDARD DIMENSIONS FOR BOSSES AND END FITTINGS	DS-68	
APPROVED	DN31	BOSSES AND END #111NGS	Sht. 8 of 10	

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NOTE: This surface shell be a smooth uniform conical surface free from burns, tool marks and visible flat spots except annular tool marks will be allowed to 100 microinches RHR max.

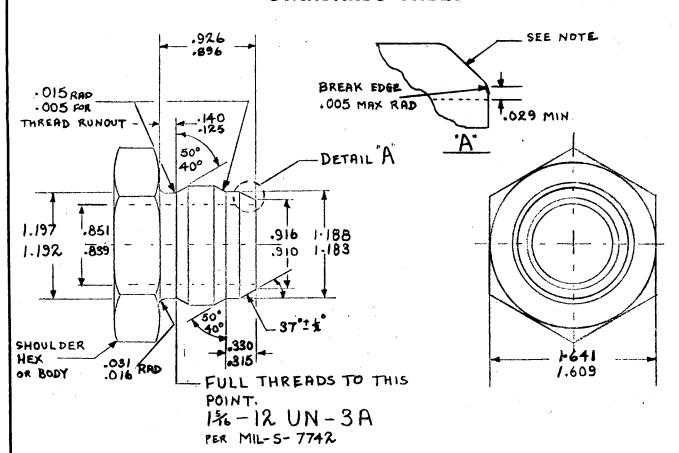
SURFACE FINISH

- 1. Concentricity of diameter .359, diameter .196, diameter .366 and thread shall be measured and calculated as an included angle within .005 total indicator reading.
- 2. Surface roughness 125 max unless noted.
- 3. Remove all burrs, slivers and sharp edges.
- 4. Dimensions in inches.
- 5. Squareness between thread and face of hex or body shall not exceed .005.

-6 DETAILS

		MS-33656-4 STYLE E	and the second s
DRAWN	RJ5	CLASSIFICATION	STANBARD
CHECKED	RJS	STANDARD DIMENSIONS FOR	DC 60
STRESSED		BOSSES AND END FITTINGS	DS-68 Sht.7 of 10
APPROVED	120		3111.7 01 10

- STANDARDS SHEET



NOTE: This surface shall be a smooth uniform conical surface free from burns, tool marks and visible flat spots except annular tool marks will be allowed to 100 microinches RHR max.

SURFACE FINISH

- 1. Concentricity of diameter 1.188, diameter .916, diameter 1.197 and thread shall be measured and calculated as an included angle within .005 total indicator reading.
- 2. Surface roughness 125 max unless noted.
- 3. Remove all burrs, slivers and sharp edges.
- 4. Dimensions in inches.
- 5. Squareness between thread and face of hex or body shall not exceed .008.

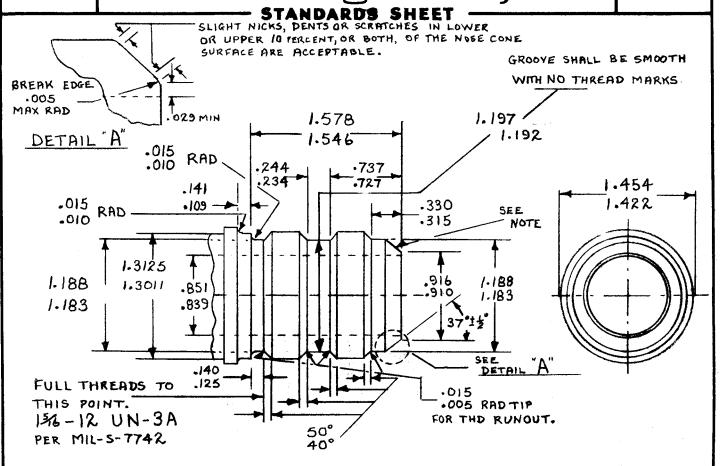
-8 DETAILS

		MS 33656-16 STYLE E	were the control of t
DRAWN	R.J.S.	CLASSIFICATION	STANDARD
CHECKED	R.J.S.		DC (0
STRESSED		STANDARD DIMENSIONS FOR BOSSES AND END FITTINGS	DS-68 Sht-9 of 10
APPROVED	870	DUSSES AND END FILLINGS	311.2 01 10

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NOTE: This surface shall be a smooth uniform conical surface free from burrs, tool marks and visible flat spots except annular tool marks will be allowed to 100 microinches RHR max.

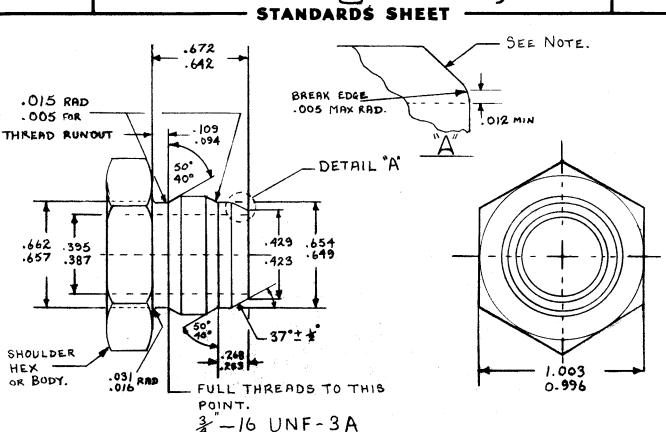
SURFACE FINISH

- 1. Concentricity of diameter 1.188, diameter .916, diameter 1.197 and thread shall be measured and calculated as an included angle within .005 total indicator reading.
- 2. Surface roughness 125 max unless noted.
- 3. Remove all burrs, slivers and sharp edges.
- 4. Dimensions in inches.
- 5. Squareness between thread and face of hex or body shall not exceed .008.

- 9 DETAILS

<u></u>	M5 3365 /- 16 5 LY LE 5			
DRAWN	RJS	CLASSIFICATION	STANDARD	
CHECKED	RUS		20.40	
STRESSED		STANDARD DIMENSIONS FOR	DS-68	
APPROVED	8XY)	BOSSES AND END FITTINGS	Shate 10 of 10	

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NOTE: This surface shall be a smooth uniform conical surface free from burrs, tool marks and visible flat spots except annular tool marks will be allowed to 100 microinches RHR max.

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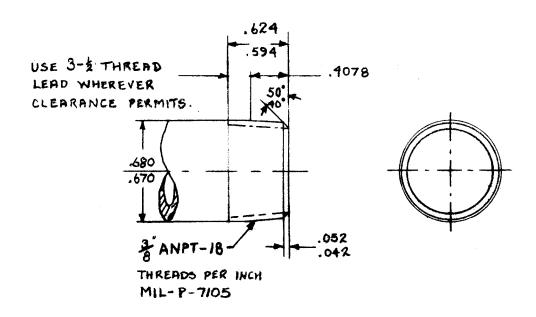
SURFACE FINISH

- I. Goncentricity of diameter .654, diameter .429, diameter .662 and thread shall be measured and calculated as an included angle within .005 total indicator reading.
- 2. Surface roughness 125 max. unless noted.
- 3. Remove all burrs, slivers and sharp edges.
- 4. Dimensions in inches.
- 5. Squareness between thread and face of hex or body shall not exceed .008.

- IO DETAILS

DRAWN	845	CLASSIFICATION	STANDARD
CHECKED	144.	STANDARD DIMENSIONS FOR	DS-68
STRESSED		BOSSES AND END FITTINGS	Sht. II of 14
APPROVED	3/	BOOGLS AND ENDITINGS	3111. 11 01 14

STANDARDS SHEET

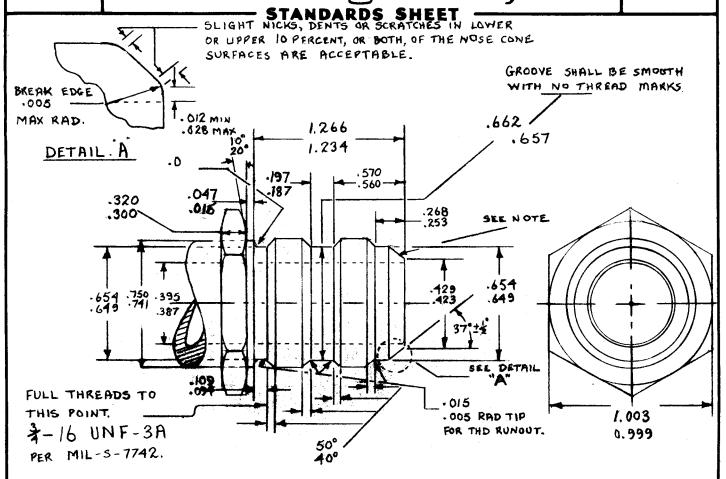


SURFACE FINISH

- Break all sharp edges and remove all hanging burrs and slivers which might be dislodged under use.
- 2. Surface roughness 125 max. unless noted.
- 3. Tolerances as stated.
- 4. Dimensions in inches.

-II DETAILS AND 10077 % STYLE A"

DRAWN	RU	CLASSIFICATION	STANDARD
CHECKED	Res.	STANDARD DIMENSIONS FOR	
STRESSED	STANDARD DIMENSIONS FOR BOSSES AND END FITTINGS	DS-68 9ht. 12 of 14	
APPROVED			



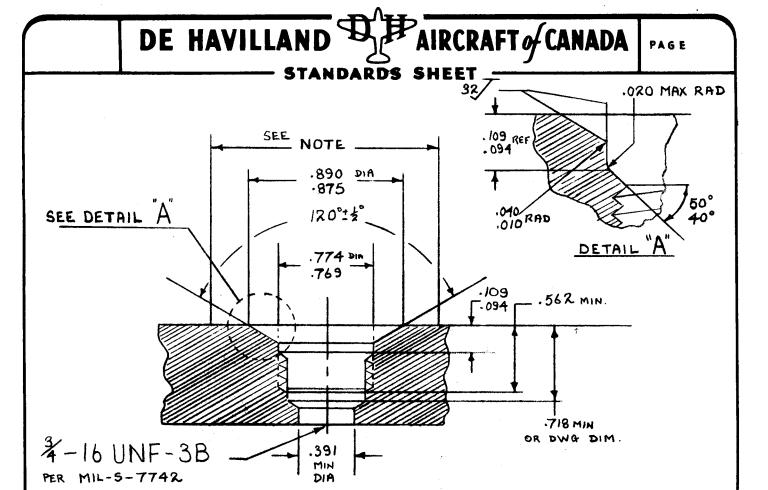
NOTE: This surface shall be a smooth uniform conical surface free from burrs, tool marks and visible flat spots except annular tool marks will be allowed to 100 microinches RHR max.

SURFACE FINISH

- 1. Concentricity of diameter .654, diameter .429, diameter .662 and thread shall be measured and calculated as an included angle within .005 total indicator reading.
- 2. Surface roughness 125 max unless noted.
- 3. Remove all burrs, slivers and sharp edges.
- 4. Dimensions in inches.
- 5. Squareness between thread and face of hex or body shall not exceed .005.

-12 DETAILS

MS-33657-8 STYLE'E'				
DRAWN	R45	CLASSIFICATION	STANDARD	
CHECKED	K 85.	STANDADD DIMENSIONS FOR		
STRESSED		STANDARD DIMENSIONS FOR BOSSES AND END FITTINGS	DS-68	
APPROVED	127		Sht. 13 of 14	



NOTE: Surface of boss shall be spotfaced minimum 1.188 finish 64.

SURFACE FINISH

- I. Break all sharp edges and remove all hanging burrs and slivers which might be dislodged under use.
- 2. Surface roughness 125 unless noted.
- 3. Tolerances as stated.
- 4. Dimensions in inches.
- 5. Diameter .890, diameter .774, and thread shall be concentric within .005 inch full indicator reading.
- 6. Squareness between thread and face of boss at diameter .890 shall not exceed .008 inch.
- 7. The countersink of diameter .890 and counterbore of diameter .774 shall be free from longitudinal and spiral tool marks.

-13 DETAILS AND 10050-8

DRAWN	R45	CLASSIFICATION	STANDARD
CHECKED	44		DS-68 Sht. 14 of 14
STRESSED		STANDARD DIMENSIONS FOR	
APPROVED	120	BOSSES AND END FITTINGS	