CARLO GAVAZZI CARLO GAVAZZI SPACE SpA	0	**RICH SYSTEM** **Engineering Change Order**	1 ECO ref	Doc N°: **ECO-00004** Date: **11.11.04** Page **1** of **1** attach. **A**

2 **DRAWING N° / REV. / TITLE:**
13-RICSYS-00.007 Rev / - Rich System Angular External

3 **SHEETS AFFECTED:**
1/1

4 **PREPARED BY:**
A. MORONI

5 **ORIGIN:**
N.A.

6 **REASON FOR REVISION:**

3D Model modification

7 **CHANGE DESCRIPTION:**

- N° 4 holes added on top surface for helicoil M4x1d selflocking (See annex A).
- Section F added in order to indicate helicoil insertion direction (See annex A).
- N° 2 thru holes added on top surface – 6.4 mm diameter (See annex A).

8 **OTHER DRAWINGS AFFECTED:**
13-RICSYS-00.000 REV / - RICH SYSTEM STRUCTURE BEAM ASSY

C.C.B. DISPOSITION:

9	10 CLASS:	11 Eng.	12 P.A.	13 C.C.	14 Date
Approved ☒ Rejected ☐	3	11/11/04	11.11.04		18/11/04

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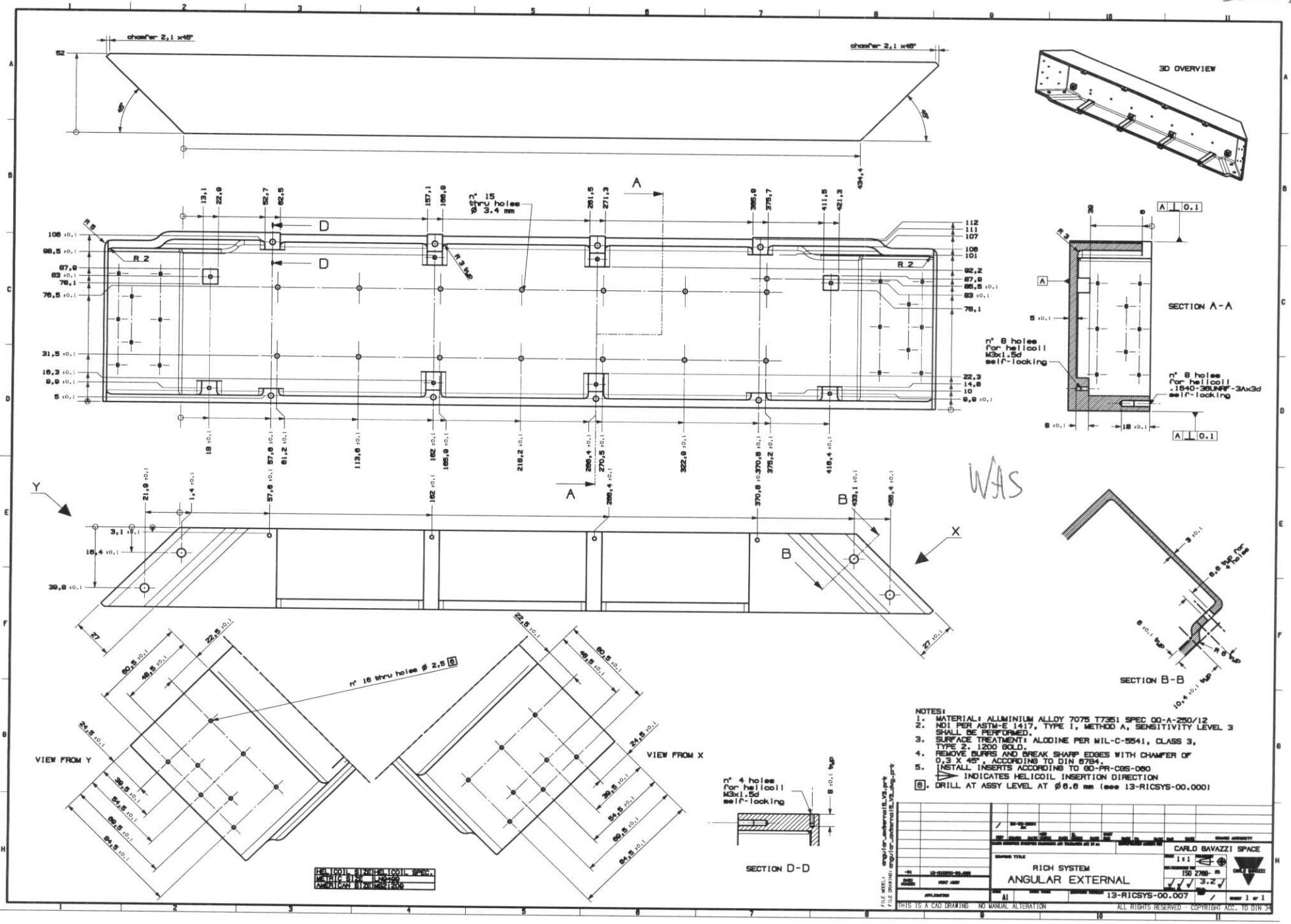
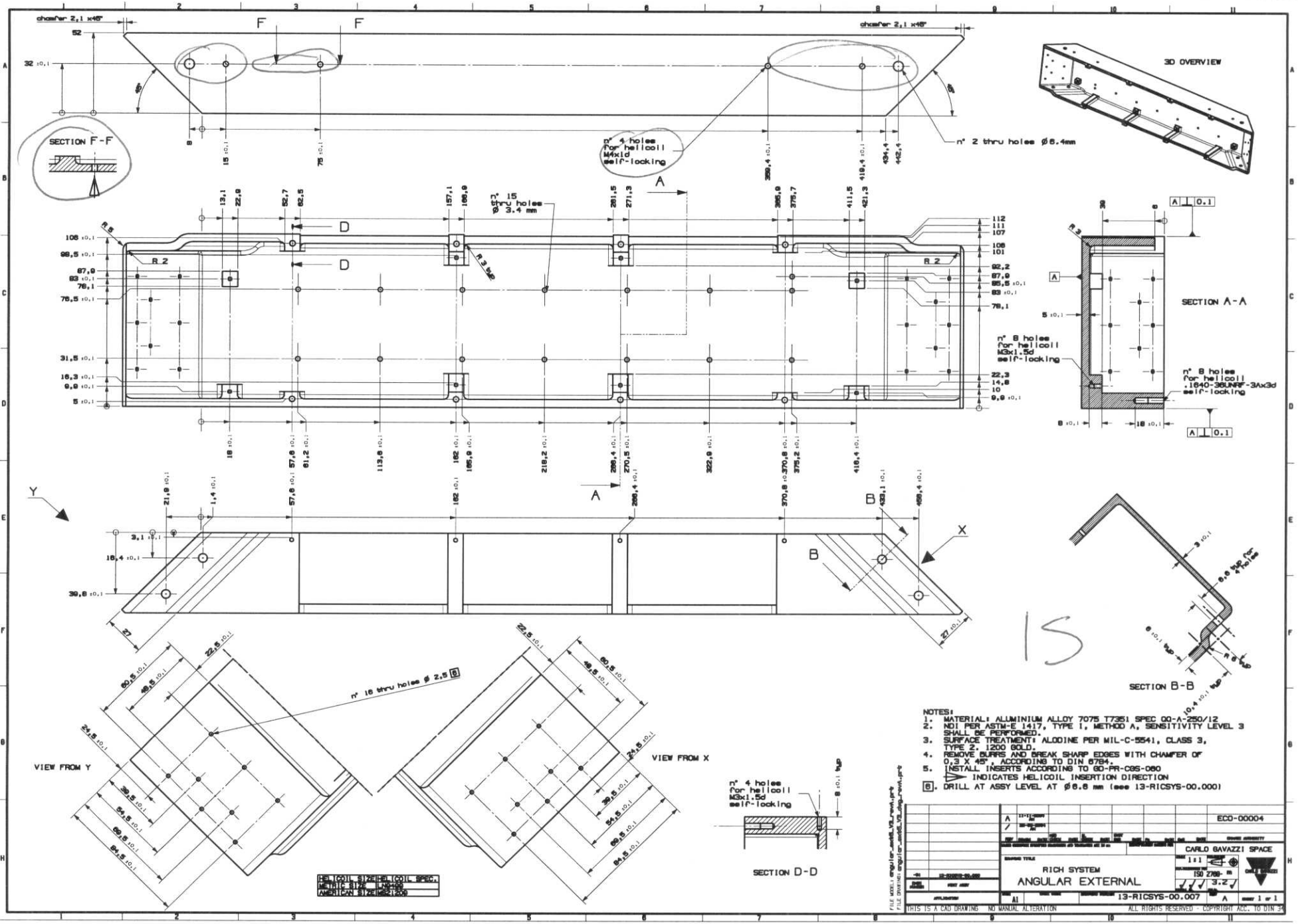
ANNEX A TO ECO-00004



ANNEX A TO ECO-00004



NOTES:
1. MATERIAL: ALUMINIUM ALLOY 7075 T7351 SPEC QQ-A-250/12
2. NDI PER ASTM-E 1417, TYPE I, METHOD A, SENSITIVITY LEVEL 3 SHALL BE PERFORMED.
3. SURFACE TREATMENT: ALODINE PER MIL-C-5541, CLASS 3, TYPE 2. 1200 GOLD.
4. REMOVE BURRS AND BREAK SHARP EDGES WITH CHAMFER OF 0,3 X 45°, ACCORDING TO DIN 6784.
5. INSTALL INSERTS ACCORDING TO GD-PR-CGS-060
   ▷ INDICATES HELICOIL INSERTION DIRECTION
[6]. DRILL AT ASSY LEVEL AT Ø6.6 mm (see 13-RICSYS-00.000)

A	11-11-2004	ECO-00004
/	20-09-2004	
		CARLO GAVAZZI SPACE
		1:1
		ISO 2768- m
		3.2
A1	13-RICSYS-00.007	A
		SHEET 1 of 1

RICH SYSTEM
ANGULAR EXTERNAL

FILE MODEL: angular_mdt5_V3_revA.prt
FILE DRAWING: angular_mdt5_V3_dwg_revA.prt

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