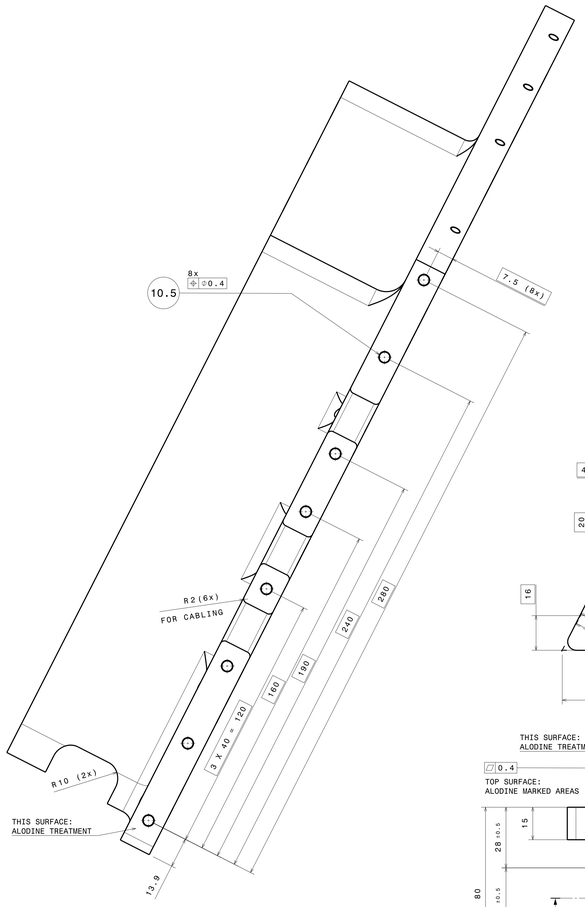
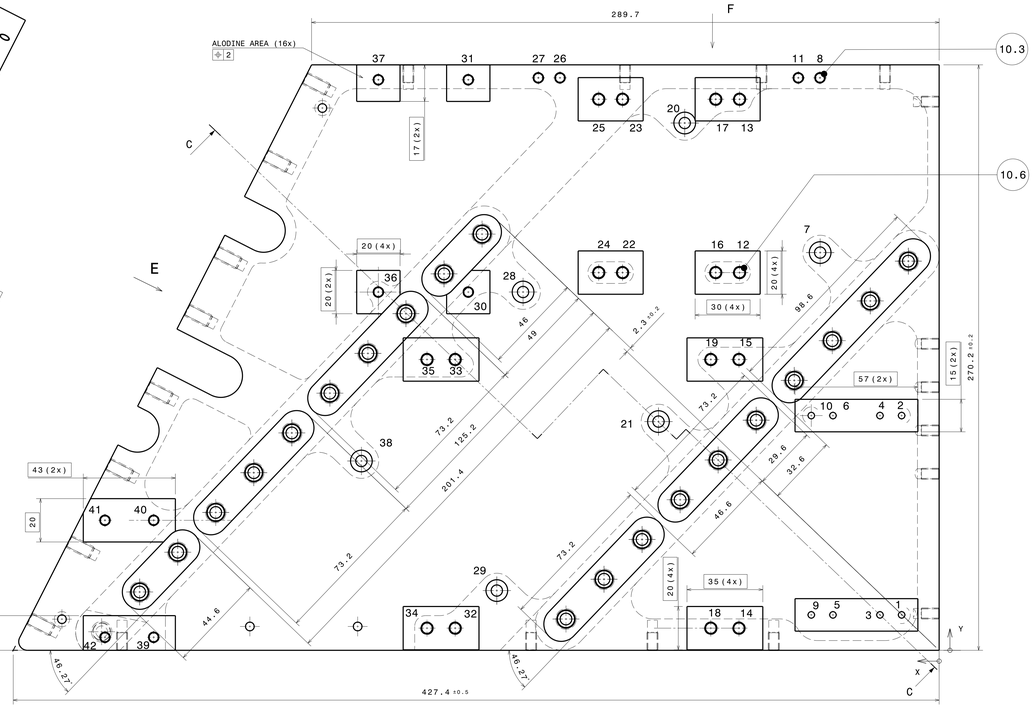
REV.	DATE	DRAWN	CHECKED	APPR.	DESCRIPTION
A	22-2-2008	PP	KVDW	JVS	Added: Covered by tape / Modified drawing name
B	2-4-2008	PP	KVDW	JVS	Modified: Chapter no. / Added alodine to side surfaces, primer for inserts
C	4-7-2008	GE	KVDW	JVE	DIM 3X38 CHANGED INTO 3X40
D	14-11-08	PP	KVDW	JVE	Removed: Counterbore bottom view REF 15, 20
E	24-3-2009	PP	KVDW	JVS	Modified: Partslist Pos. 10.4 QTY to 21, Radius counterbored holes to R4.8 (4x) for pre-heater

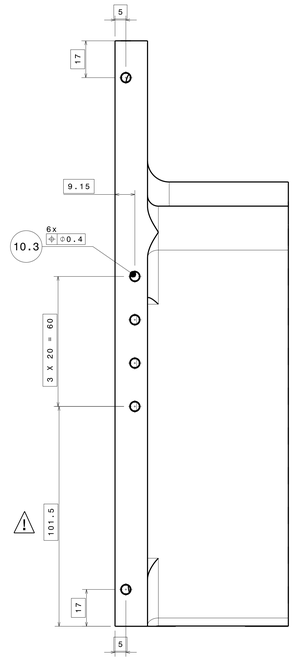


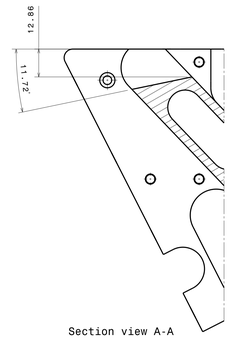
Auxiliary view E



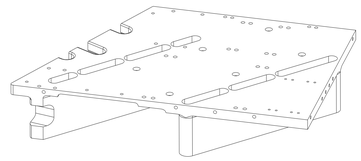
TOP VIEW LOCATION OF HOLES			0.4
REF.	X	Y	Diameter/ Part No.
1	17.31	16.34	3
2	17.31	108.34	3
3	27.31	16.34	3
4	27.31	108.34	3
5	49.01	16.34	3
6	49.01	108.34	3
7	54.92	183.59	5.2
8	55	264.24	P10.3
9	59.01	16.34	3
10	59.01	108.34	3
11	65	264.24	P10.3
12	92.12	174.35	P10.6
13	92.12	254.35	P10.6
14	92.39	10.22	P10.6
15	92.39	134.22	P10.6
16	103.12	174.35	P10.6
17	103.12	254.35	P10.6
18	105.39	10.22	P10.6
19	105.39	134.22	P10.6
20	117.43	243.39	5.2
21	129.54	105.58	5.2

LOCATION OF HOLES			0.4
REF.	X	Y	Diameter/ Part No.
22	146.12	174.35	P10.6
23	146.12	254.35	P10.6
24	157.12	174.35	P10.6
25	157.12	254.35	P10.6
26	175	264.24	P10.3
27	185	264.24	P10.3
28	192.05	165.38	5.2
29	204.16	27.57	5.2
30	217.33	165.34	P10.3
31	217.33	263.34	P10.3
32	223.39	10.22	P10.6
33	223.39	134.22	P10.6
34	236.39	10.22	P10.6
35	236.39	134.22	P10.6
36	258.83	165.34	P10.3
37	258.83	263.34	P10.3
38	266.67	87.38	5.2
39	362.53	6	P10.3
40	362.53	60	P10.3
41	385.03	60	P10.3
42	385.03	6	P10.3

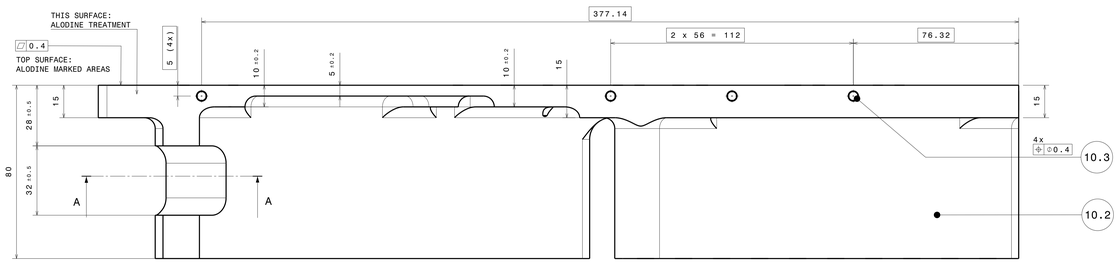


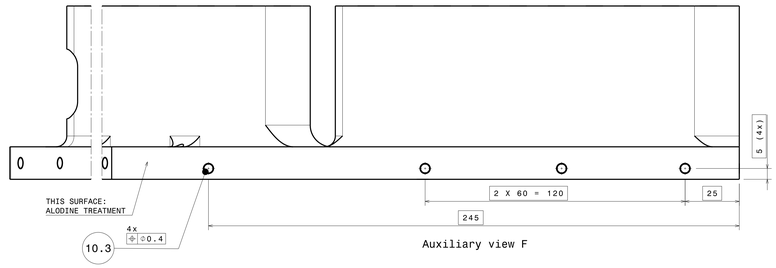


Section view A-A

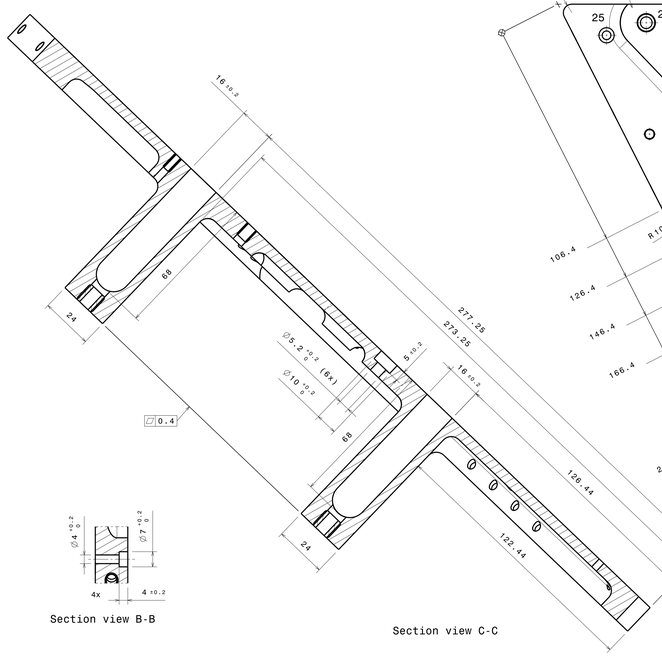


Isometric view

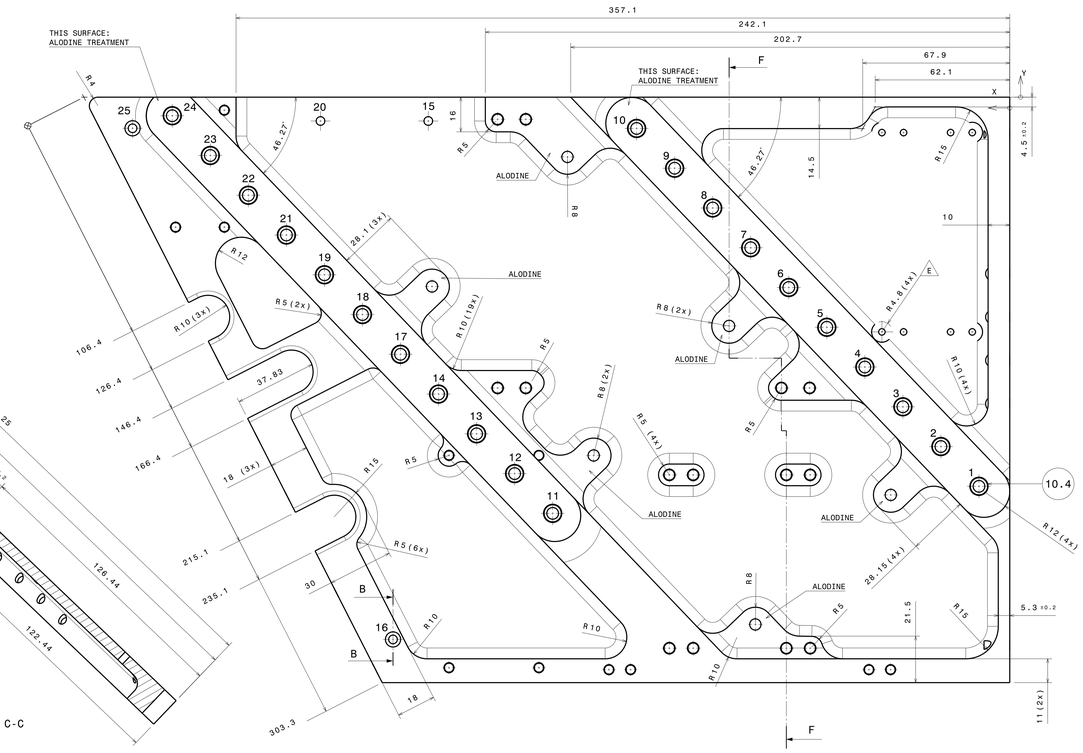




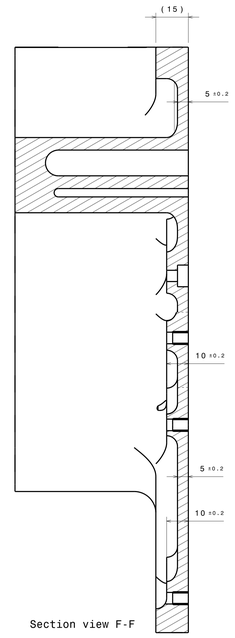
Auxiliary view F



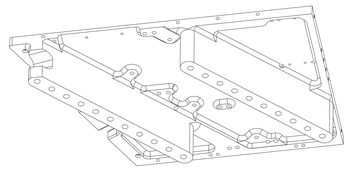
Section view B-B



Section view C-C



Section view F-F



Isometric view

BOTTOM VIEW LOCATION OF HOLES			0.4
REF.	X	Y	Diameter/ Part No.
1	14.21	-179.62	P10.4
2	31.77	-161.27	P10.4
3	49.33	-142.92	P10.4
4	66.89	-124.56	P10.4
5	84.44	-106.21	P10.4
6	102	-87.85	P10.4
7	119.56	-69.5	P10.4
8	137.12	-51.15	P10.4
9	154.68	-32.79	P10.4
10	172.23	-14.44	P10.4
11	210.98	-192.1	P10.4
12	228.54	-173.75	P10.4
13	246.1	-155.4	P10.4
14	263.65	-137.04	P10.4
15	268.39	-11	4
16	284.68	-250.3	4
17	281.21	-118.69	P10.4
18	298.77	-100.33	P10.4
19	316.33	-81.98	P10.4
20	318.14	-11	4
21	333.89	-63.63	P10.4
22	351.44	-45.27	P10.4
23	369	-26.92	P10.4
24	386.56	-8.56	P10.4
25	404.89	-14.36	4

INSTALL INSERTS PER STANDARD MS33537, ASSEMBLE USING MIL-PRF-85582 WET PRIMER

RADII R=5 UNLESS OTHERWISE INDICATED
TOLERANCES: ±0.5 UNLESS OTHERWISE STATED

SURFACE TREATMENT:
- ANODIZE PER MIL-A-8625 TYPE I EXCEPT ALODINE AREAS (COVERED BY TAPE)
- ALODINE CLASS 3 PER MIL-DTL-5541

PART NO.	QTY.	PART	MATERIAL	REMARKS
10.6	16	INSERT	CRES	MS21209F1-15
10.5	8	INSERT	CRES	MS21209F1-25
10.4	21	INSERT	CRES	MS21209F4-15
10.3	26	INSERT	CRES	MS21209C0820
10.2	1	BASE PLATE	AL 7475 T7351	DIM: 427.4x270.2x80 mm
10.1	1	ASSEMBLY BASE		

		NOMINAL DIMENSION LARGER THAN	UNTIL INCL.	TOL	NOMINAL LENGTH OF SHORT ANGLE SIDE LARGER THAN	UNTIL INCL.	ANGLE DEVIATION DEG.	MM/100MM
SCALE:	1:1	0,5	3	±0,05				
DATE:	2008-02-05	3	6	±0,05	-	10	±1°	±1,8
DESIGNED:		6	30	±0,1	10	50	±0,5°	±0,9
DRAWN:	P.PUL	30	120	±0,15	50	120	±0,3°	±0,5
CHECKED:	K.V.D.WETERING	120	400	±0,2	120	400	±0,15°	±0,3
APPROVED:	J. VAN ES	400	1000	±0,3				
		DRAWING ACCORDING TO DUTCH STANDARDS						PROJECTION

PROJECT: AMS TTCS

SUBJECT:

TTCBS FM: ASSEMBLY BASE

NATIONAL AEROSPACE LABORATORY

PROJECT CHAPTER NO.: ET5998-08

SIZE: A0 | CATIA DRAWN | DRW. NO.: 10 | ISSUE: E

REMOVE SHARP EDGES
UNLESS OTHERWISE INDICATED

ROUGHNESS: 3.2