

This document and model is the design master and the authority for all product definitions and acceptance for this part.
It conforms to the standings contained in **ASME Y12.41-2003**

OVERVIEW

Part Name	Flange 287	Part Number	8476323	Author	M. Power	CAD System	Catia V5
Revision	11	Last Modification	8/24/1012	Last Change By	J. Horan	Change Approval	D. Burke

TOLERANCES and DIMENSIONS

Unit	mm	General Tolerance	+/- 0.25	Drilled Holes	0.25-0.05	Surface Profile	 .0600 A B C
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MANUFACTURING SPECIFICATIONS

Material	Steel	Screw Threads	BS 84 93 1580 A346	Tapping Drills	BS 1157	Surface Finish	Ra: 0.4
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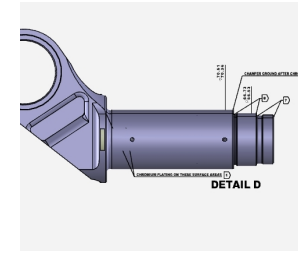
MANUFACTURING NOTES

General	Location Specific
(1) PS1004-4-1 machining requirements for Gallego Steel. (2) PS914 process requirements for Gallego Steel. (3) PCS-2800 temporary corrosion and damage protection of parts. (4) Surface finish 0.4 Micrometers Ra all over unless otherwise indicated. (5) Break edges 2.0/1.0 unless otherwise indicated. (6) Parallelism and squareness tolerance 0.0025 mm/mm. (7) Eccentricity not to exceed 0.13 T.I.R. (8) Machining mismatch not to exceed 0.8 (?). Bent with 12.7/6.35 radius. (9) PS123 shot peen all over before FL20 unless otherwise indicated. Holes less than 12.5 optional. (10) Dimensions apply after chrome plating unless otherwise indicated.	(1) See specification document for plating runout specifications. (2) PS1031-8 Termination of chromed surfaces. No chrome plate on edge break. (3) PS101-7P Chromium plate 0.10 minimum thickness. (4) PS1031-1 termination of chromed surfaces. (5) PS1031-2 termination of chromed surfaces. (6) PS1031-5 termination of chromed surfaces. (7) Do not shot peen. (8) PS134 glass bead peen. (9) Cadmium plate fade out permissible in this bore. (10) Production salvage allowance applies. (11) PS405-341 Electrochemical etch 0.1/0.05 deep or PS405-12. Hand engrave part or serial numbers. (12) Hardness test Rc-53-55 on indicated surface. Subsequently machined. No indentation allowed on finished surface.

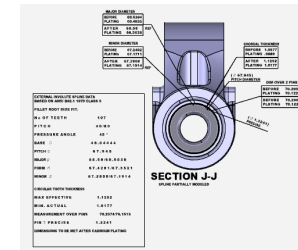


3D CAD ILLUSTRATION / PMI

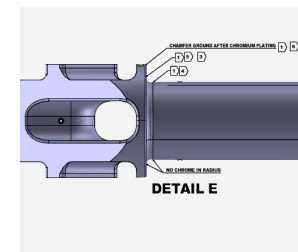
Part Name	Flange 287	Part Number	8476323	Author	M. Power	Units	mm
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DETAIL D



SECTION J-J



DETAIL E

LOCATION SPECIFIC MANUFACTURING NOTES

