

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

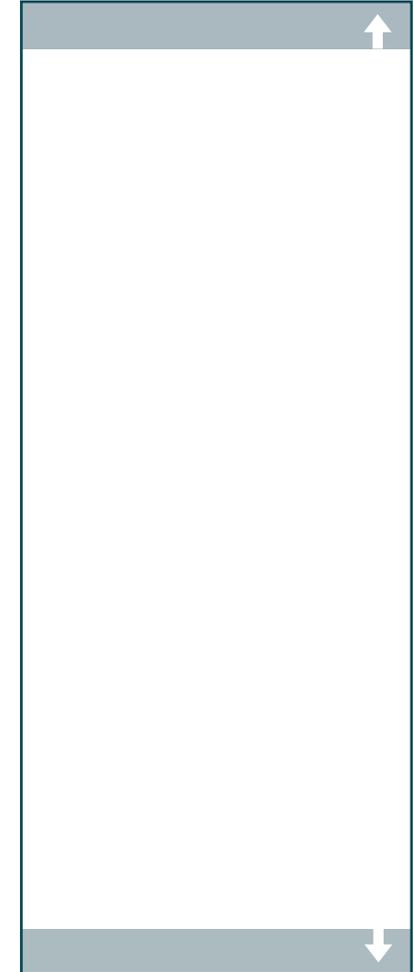
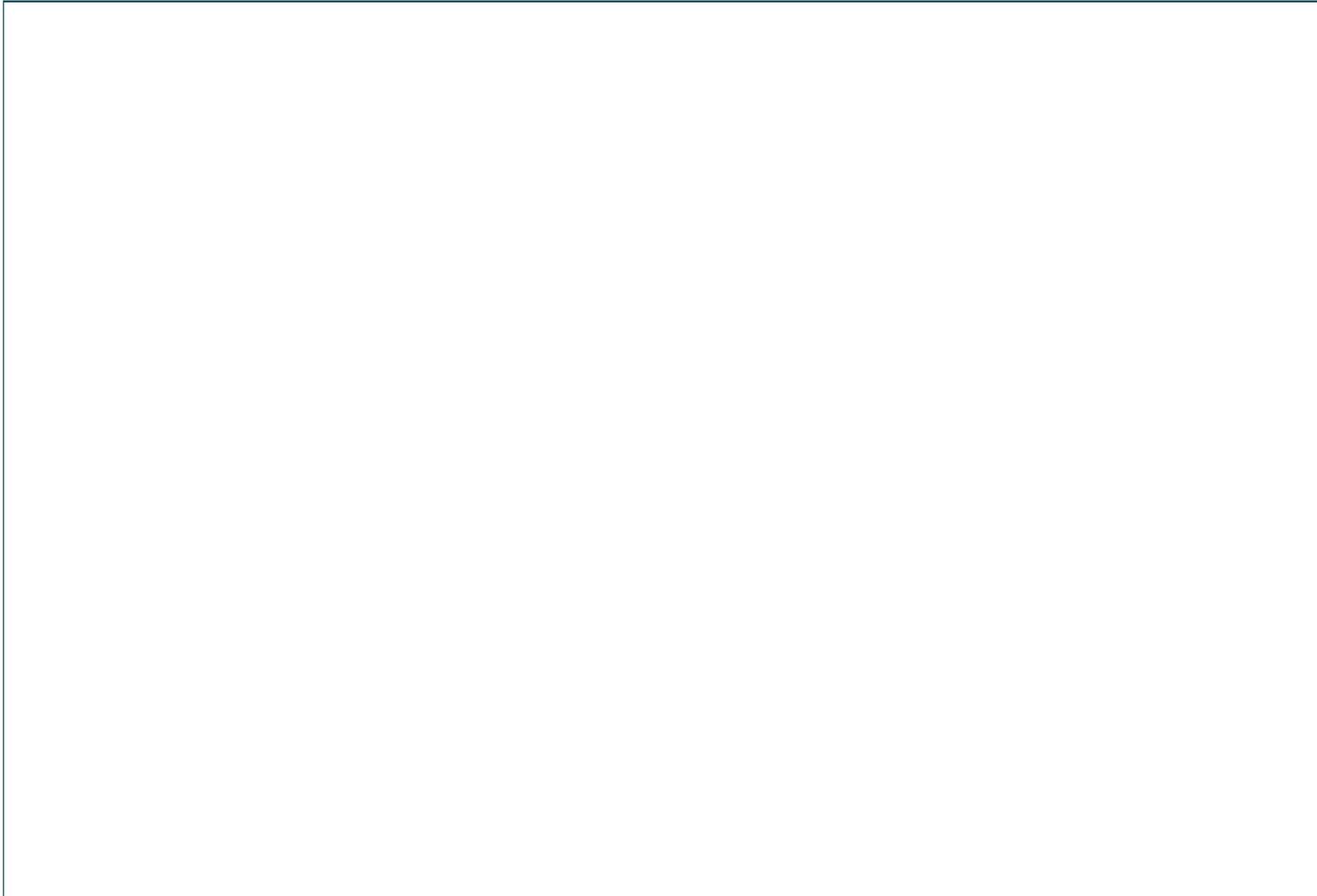
Material	Steel	Screw Threads	BS 84 93 1580 A346	Tapping Drills	BS 1157	Surface Finish	Ra: 0.4
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MANUFACTURING NOTES

General	Location Specific
<ul style="list-style-type: none"> (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. 	<ul style="list-style-type: none"> (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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LOCATION SPECIFIC MANUFACTURING NOTES

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