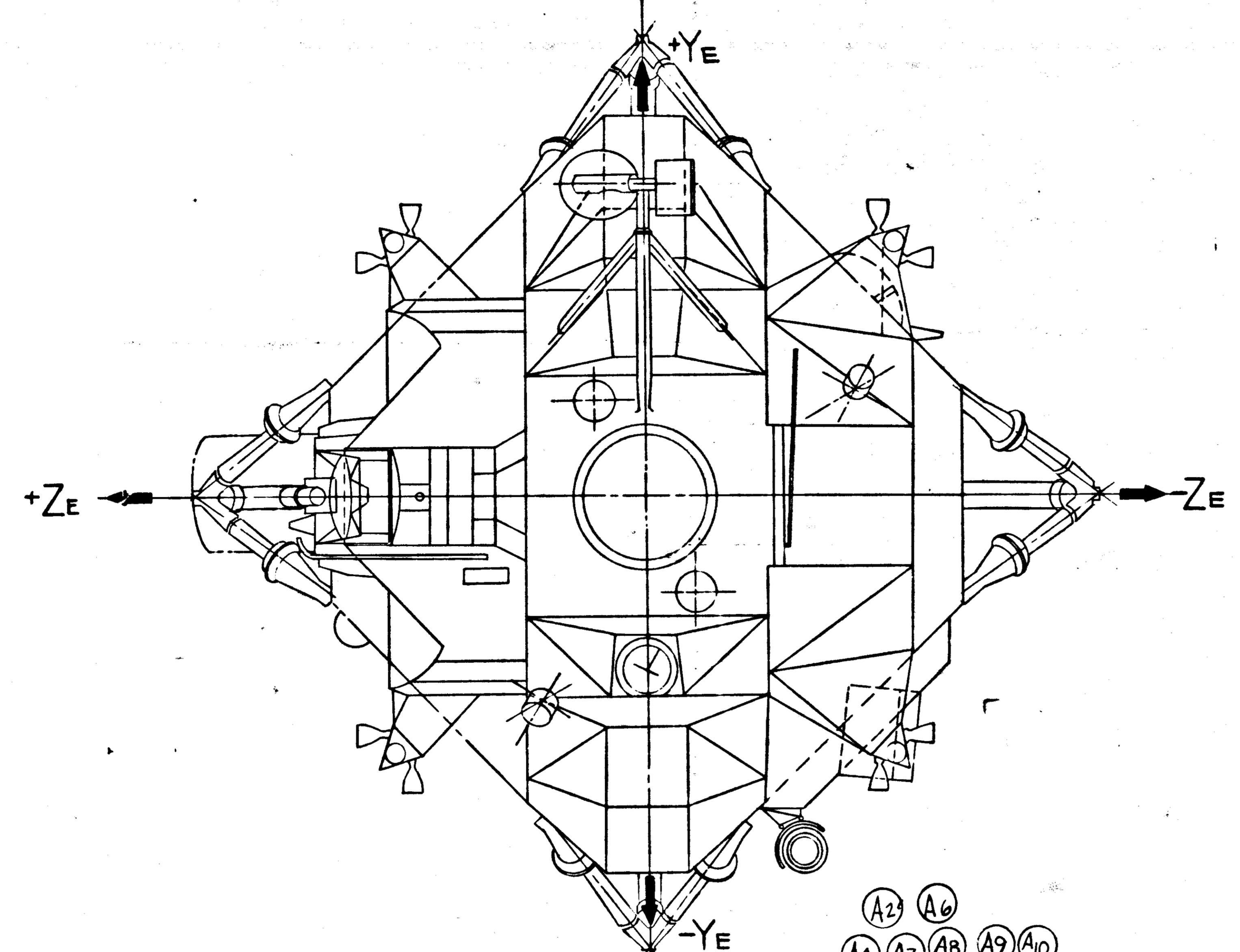


4 3 2

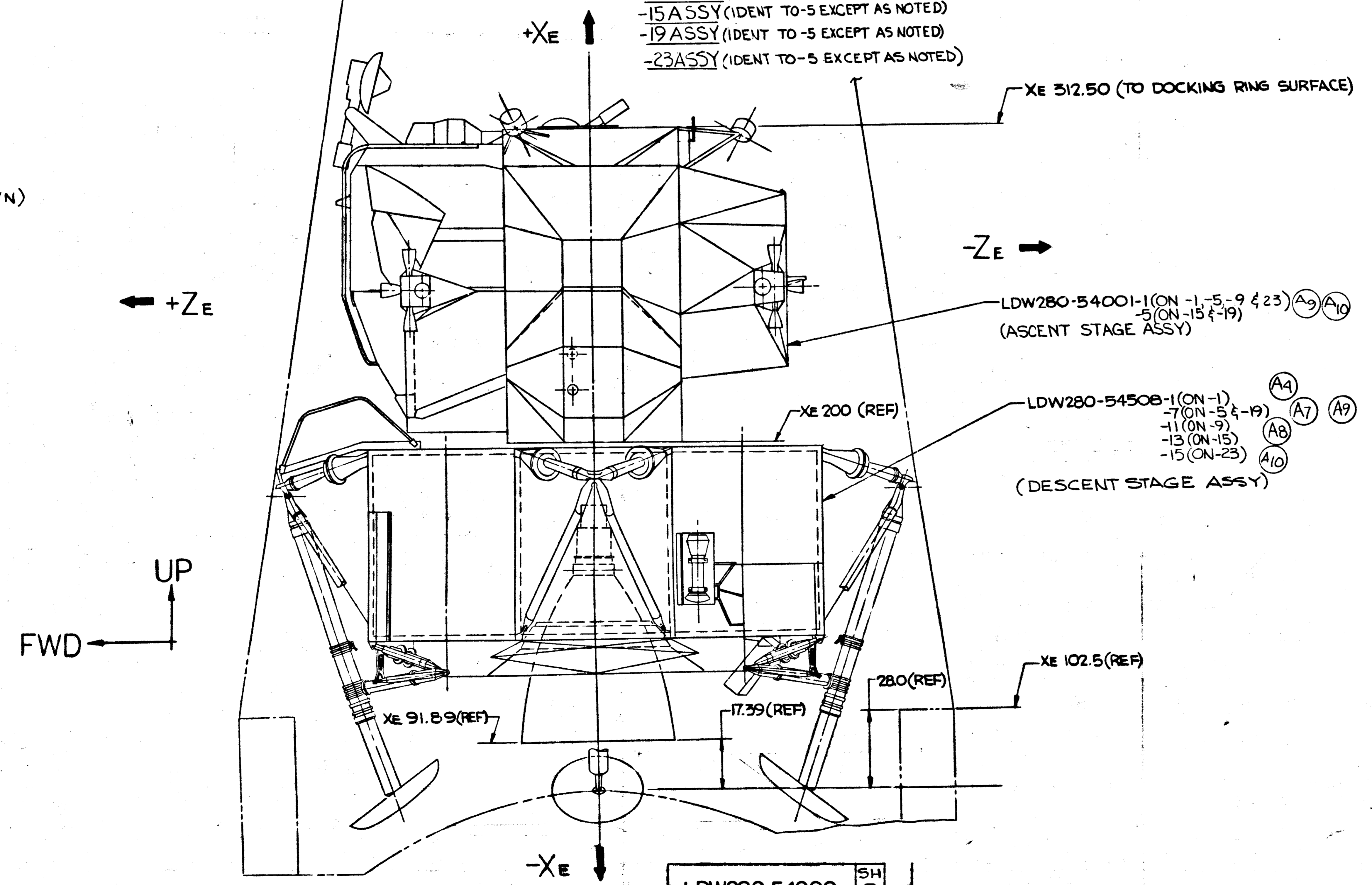


ADAPTER (SLA) (REF)

LDW280-54000-1 ASSY  
 VIEW LOOKING DOWN  
 -5 ASSY (IDENT TO -1 EXCEPT AS NOTED)  
 -9 ASSY (IDENT TO -1 EXCEPT AS NOTED)  
 -15 ASSY (IDENT TO -5 EXCEPT AS NOTED)  
 -19 ASSY (IDENT TO -5 EXCEPT AS NOTED)  
 -23 ASSY (IDENT TO -5 EXCEPT AS NOTED)

10-11 (ON -1) (A7) (A8)  
 -13 (ON -9) (A7) (A8)  
 -17 (ON -15) (A7) (A8)  
 -21 (ON -19) (A7) (A8)  
 -25 (ON -23) (A7) (A8)  
 -27 (ON -5) (A7) (A8)  
 BOX IN AREA AS SHOWN)  
 E 142

400-1  
 DEVICES INSTL)



UP  
 FWD

LDW280-54000 SH 3

| MANUFACTURING OPERATIONS  |  |
|---|--|
| UNLESS OTHERWISE SPECIFIED NOTES CHECKED ✓ APPLY TO THIS DRAW.  |  |
| APPLY ALL OTHER MARKINGS IN REGION MARKED (Hatched Area)  | USE BOTH SIDES IF NECESSARY.                                 |
| FILLET AND INSIDE CORNER RADIUS TOLERANCES  | ASR TO .025 ± .005<br>ASR TO .250 ± .010<br>OVER .250 ± .010 |
| DEPTH SHOWN FOR TAPPED HOLES IS FULL THICK. 2-3 MIN THICK. BEYOND PERMISSIBLE.  |  |
| EXTERNAL THREAD LENGTH SHOWN INCLUDES 2 IMPERFECT THREADS MAX.  |  |
| DO NOT CADMIUM PLATE & PAINT HOLES OR SURFACES MARKED WITH DOUBLE ASTERISKS.  |  |
| MISMATCH STEP OF ± .005 PERMISSIBLE DUE TO CHANGE OF CUTTERS AT INSIDE INTERSECTING SURFACES.   |  |
| DIAMETERS MARKED MUST BE CONCENTRIC WITHIN FULL INDICATOR READING.  |  |
| HOLES MUST BE KEPT FREE OF CHROME PLATING SOLUTION.   |  |
| ALL DIMENSIONS SHOWN TO BE MET AFTER CADMIUM PLATING. THICKNESS OF PLATE .002 MIN. TO .005 MAX. MIN. THICKNESS TO BE .002 ON THREADED AREAS. NO ALLOWANCE FOR PLATING IN HOLES. |  |
| ✓ SURFACE ROUGHNESS INCLUDING REAMED HOLES PER MIL-STD-10   |  |
| ✓ FOR ALL DRILLED HOLES   |  |
| REMOVE ALL BURRS. BREAK ALL EDGES .015-.020   |  |
| INSPECTION INFORMATION MINIMUM PERMISSIBLE AVERAGE EDGE DISTANCE MARKED IS  |  |
| SYMBOL ⚡ DENOTES SURFACE TO BE MACHINED   |  |
| UNLESS OTHERWISE SPECIFIED TOLERANCE ON FLANGES IS ± 1/16   |  |
| LENGTHS OF AIR, HAS & HAS ALL ALY BOWS SHORTER THAN 1 INCH ARE NOT SPECIFIED.   |  |
| TOLERANCE ON LOFTED DELINEATIONS IS   |  |

NOTES:  
 1. BOND LDW280-54000-1, -13, -17, -21, -25, -27, TO +Z27.0 BULKHEAD WITH RTV751 AS PER LSP14-22601.  
 2. NAME PLATE PROTECTION IN ACCORDANCE WITH GNI1AC.

02702 NAS 9-1100

|   |       |          |                |
|---|-------|----------|----------------|
| GRUMMAN AIRCRAFT ENGRG CORP., BETHPAGE, L. I., NEW YORK |       |          |                |
| SIZE  | CODE  | DRGT NO. |                |
| J   | LM    | 26512    | LDW280-54000 A |
| MATERIAL OR GRP ITEM                                    | SCALE | 1/20     | SHEET 3.00     |

20 IN. FT.  
 20 IN. FT.  
 FULL SIZE SHEET AREA (ON 1/2")  
 FULL SIZE SHEET AREA (1/4" OF FULL)  
 PRINT THIS LINE  
 LDW280-54000-A  
 LDW280-54000-A  
 LDW280-54000-A  
 2 FR