



MANUFACTURING OPERATIONS
UNLESS OTHERWISE SPECIFIED
NOTES CHECKED APPLY TO THIS DWG.

PART NUMBER AND ALL OTHER MARKINGS IN REGION MARKED USE BOTH SIDES IF NECESSARY.

FILET AND INSIDE CORNER $\pm .01$ TOLERANCES
HOLE TO HOLE $\pm .005$
HOLE TO EDGE $\pm .015$
OVER $2.00 \pm .010$

DEPTH SHOWN FOR TAPPED HOLES IS FULL THRO. $\pm .015$ THRO. BEYOND PERMISSIBLE.

EXTERNAL THREAD LENGTH SHOWN INCLUDES 2 IMPERFECT THREADS MAX.

DO NOT CADMIUM PLATE & PAINT HOLES OR SURFACES MARKED WITH DOUBLE ASTERISK.

MISMATCH STEP OF $\pm .005$ PERMISSIBLE DUE TO CHANGE OF CUTTERS AT INSIDE INTERSECTING SURFACES.

DIAMETERS MARKED MUST BE CONCENTRIC WITH FULL INDICATOR

READING

HOLES MUST BE KEPT FREE OF CHROME PLATING SOLUTION.

ALL DIMENSIONS SHOWN TO BE MET AFTER CADMIUM PLATING. THICKNESS OF PLATE .003 MIN. TO .006 MAX. MIN. THICKNESS TO BE .002 ON THREADED AREAS. NO ALLOWANCE FOR PLATING IN HOLES.

3. INSTALL THE DROGUE BY ROTATING IT CCW (LOOKING DOWN) INTO THE THREE SUPPORT FITTINGS MOUNTED ON THE INNER SURFACE OF THE DOCKING TUNNEL JUST BELOW THE DOCKING RING. WHEN ONE LEG OF THE DROGUE HITS THE LATCH STOP ON THE RIGHT HAND SUPPORT FITTINGS, CENTRALIZE THE DROGUE AND CHECK THE GAP BETWEEN THE VERTICAL FACE OF EACH DROGUE LEG AND THE ADJACENT FACE OF THE SUPPORT FITTING. THIS GAP SHALL BE .010-.023 AT EACH LOCATION WITH THE DROGUE IN THE ABOVE CONFIGURATION, MEASURE THE GAP BETWEEN THE HORIZONTAL FACE (AT THE TOP) OF EACH DROGUE LEG AND THE ADJACENT HORIZONTAL FACE OF THE SUPPORT FITTING. THIS GAP SHALL BE .010-.018 AT EACH LOCATION. THE ABOVE CHECK IS TO BE MADE WITH THE CABIN IN THE PRESSURIZED (5.2 PSI) AND UNPRESSURIZED CONFIGURATION.

02/02 NAS 9-1100