



NOTES:

1. BOND LDW280-60001-13, 15, 17, 19 TO +22700 BHD WITH RTV-731 PER LSP-14-22601.
2. NO PROTECTIVE COATING REQ'D.
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 .015-.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.
4. FOR EVA ABRASION PROTECTION ON THERMAL SHIELDING SEE LEI280-030.
5. IN THE CABIN, ALL PROTRUDING FASTENER THREADS THAT ARE A CREW HAZARD SHALL BE COATED WITH EPON 919 PER LSP14-14102. THE EPON 919 SHALL BE OVER COATED WITH NON-SPECULAR GRAY VELVET PAINT PER LSP 14-4503.

MANUFACTURING OPERATIONS UNLESS OTHERWISE SPECIFIED NOTES CHECKED ✓ APPLY TO THIS DWG.	
AND ALL OTHER MARKINGS IN REGION MARKED □ USE BOTH SIDES IF NECESSARY.	PART NUMBER
FILLET AND INSIDE CORNER RADIUS TOLERANCES GUR TO .020 ± .010 ASER TO .250 ± .015 OVER .250R ± .030	DEPTH SHOWN FOR TAPPED HOLES IS FULL THRS. 2:3 IMP THRD. 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 ±.002 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 .003 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 ± 1/32
LENGTHS OF AN, HAS & HS AL ALL RIVETS SHORTER THAN 1 INCH ARE NOT SPECIFIED.	TOLERANCE ON LOFTED DELINEATIONS IS

02/02 NAS 9-1100

GRUMMAN AIRCRAFT ENGRG CORP., BETHPAGE, L. I., NEW YORK			
SIZE	J	26512	LDW280-60001 A
LM			
MODEL OR END ITEM		SCALE NONE	SHEET 5.00

THIS IS AN ORIGINAL DRAWING 2 FRAMES

PRINTING INTO ONLY
 FULL SIZE SHEET AREA (ON 4 1/2")
 1/2 SIZE SHEET AREA (1/4 OF FULL)
 4.5 IN. FT.
 10.0 IN. FT.
 LDW280-60001A
 A
 B
 C