NOTES

FORM F/N 1 TO ANGLE SHOWN AND WRAP AROUND F/N 2. ALIGN AND SECURE "A" HOLE.
MATCH DRILL REMAINING 9 HOLES USING 9938 DRILL. DRILL PERPENDICULAR TO MATING SURFACE.
TAP FOR M8-56 HELICAL ST. DRILL AND TAP THRU. INSTALL F/N 1 INTO F/N 2 AFTER PLATING.
TEMPORARILY INSTALL F/N 4, 5, AND 7 AFTER EACH DRILL OPERATION. INSTALL HARDWARE TO SECURE SKIRT PRIOR TO DRILLING NEXT HOLE.
AFTER FORMING F/N 1 AND MATCH DRILLING F/N 2 (SEE NOTE 9). REMOVE AND DISCARD HARDWARE.
ENGRAVE MATCHING SERIAL NUMBERS PER NOTE 6 ON EACH PART. FAS SIDE. MAINTAIN AS A MATCHED SET.
4. THIS DRAWING IS NOT TO SCALE.
5. AFTER FORMING AND MACHINING OPERATIONS ARE COMPLETE. DISASSEMBLE.
DISASSEMBLE F/N 1, 2 AND 3 AND BLACK ANODIZE F/N 1 AND 2.
PER NASA/JSC PRC-5006, TYPE II, CLASS 2, COLOR BLACK.
6. MARK TRIMMING UNITS STARTING WITH SERIAL NUMBER 100 AND FLIGHT WITH 300.
APPLY F/N 9 TO THREADS OF F/N 8 DURING FINAL ASSEMBLY.
APPLY ANODIZED FINISH. CHEM FILM PER MIL-C-5544 CLASS 3.
MATCH DRILL F/N 1 THRU F/N 3 PRIOR TO PLATING. INSTALL F/N 6 AT FINAL ASSEMBLY.