DRG. Nº EJF.628
PART Nº JA 61171

1. DO NOT SCALE DRAWING
2. ENGLISH PROJECTION IS USED UNLESS OTHERWISE STATED.
3. TOLERANCES ON DIMENSIONS ARE ± .01 OR ½° UNLESS OTHERWISE STATED.
4. IF IN DOUBT ABOUT THIS DRAWING, RING DRAWING OFFICE BEFORE COMMENCING OPERATIONS.

35"50
27"50 ALONG SURFACE
SEE DETAIL 'B'
6"25
.85 ALONG SURFACE
PUNCHED HOLE - 4 OFF SEE DETAIL 'D'
37"00
9"00
.66
.17
31"90
20"50
'C'
LINE 'G'

23"70
16"25
8"80
3"30
2"80
1"40 RAD.
1"50 CTRS
5"25
1"50 ALONG SURFACE
2"00 DIA
'A' 'A'
'E' 1"35 2"25 'E'
℄ OF AIRCRAFT
23"75
DISHING

DRILL HOLE 1/16 DIA: IN CORNERS OF BLANK TO PREVENT SPLITTING
ALONG SURFACE .67
2"00 ALONG SURFACE
1"00
'F'
.5 ALONG SURFACE
6 HOLES LETTER 'S' DRILL
4"00 FLAT
WELD ITEMS 3 AND 13 TOGETHER
FLANGE OF STIFFENER FLATTENED AT EACH END & JOGGLED
DETAIL "B" LOOKING ON ARROW 'C'

JOGGLE .09 DEEP
1"15 FLAT
.48 ALONG SURFACE
FOR DETAIL OF PUNCHED HOLE SEE DETAIL 'D'
SECTION 'F-F'

3"25 (AT ℄)
.75 (CONSTANT)
.45
STANDARD ¼" SWAGE
SECTION 'E-E' SHOWING TYPICAL SECTION THROUGH REAR STIFFENER

27 RIVETS EQUALLY SPACED, APPROX: 3"0 PITCH
1"25
.07 BEND RADIUS.
.50
SECTION THRO' STIFFENERS ITEMS 2 & 3
STIFFENERS ARE MADE TO SHOPS TEMPLATES

90°
.30 DIA.
4x FULL SIZE SECTION THRO HOLE AFTER CENTRE PUNCHING
HOLE DIA: BEFORE PUNCHING .18
DETAIL 'D'

This drawing is provided in accordance with original Auster/Beagle applicability for use with the initial enquirers' aircraft ONLY.

CORRECT APPLICATION TO THE AIRCRAFT IS THE RESPONSIBILITY OF THE ENQUIRER AND HIS ENGINEER AND NOT OF "AUSTER SPARES" OR LEICESTERSHIRE MUSEUM'S.

Its supply does not confer any right to produce and trade in any of the components. Enquiries for these should be sent to:-

"Auster Spares",

Email: bakerdaveaa@gmail.com

NOTES

1. DIMNS ARE GIVEN TO INSIDE OF METAL.
2. HOLES FOR RIVETS ARE DRILLED Nº 30 UNLESS OTHERWISE STATED
3. DIMNS ARE MEASURED SQUARE UNLESS OTHERWISE STATED
4. FOR DIMNS OF STIFFENERS & RIVET SPACING WORK TO SHOP TEMPLATES
5. CONTOUR OF PANEL IS SYMMETRICAL ABOUT ℄
6. * IF DESIRED PORT & STBD DISHINGS MAY BE DISPENSED WITH BY DECREASING CURVE OF CONTOUR AS SHOWN BY LINE 'G'

⊗ PI Nº JA 60556 IS ALLOTTED TO AN ASSEMBLY OF ITEMS 2 & 14. PI Nº JA 60557 IS ALLOTTED TO AN ASSEMBLY OF ITEMS 3 & 13.

* PANEL TO BE DISHED TO CLEAR LOWER EDGE OF OIL TANK DISH TO SHOP'S TEMPLATE

ALL DIMENSIONS ARE REFERENCE ONLY AND COWLINGS ARE TO BE MADE TO SHOPS TEMPLATES

HOLE FOR BREATHER PIPE

.15 INSIDE
SECTION 'A-A' TYPICAL OF ALL FLANGING ON HOLE EDGES

ITEM Nº	PART Nº	DESCRIPTION	MATERIAL OR DRG. Nº	Nº OFF
14	S 60416	STIFFENER-20SWG	S3	1
13	J 60414	STIFFENER-20SWG	S3	1
12		RIVET-SEMI-TUBULAR Nº11x 3/16	STEEL	8
11		RIVET-SEMI TUBULAR Nº11x 1/2	STEEL	12
10		RIVET-SEMI-TUBULAR Nº11x 5/16	STEEL	51
9				
8	SS 200	DZUS SPRING		6
7		BEAD-WIRE 1/8 DIA.	S.I.	AS REQD
6	J60330	STIFFENER-22SWG	S20	1
5				
4	D64	REINFORCEMENT PLATE	ADF 96	2
3	J60328	STIFFENER-20SWG	S3	1
2	J60327	STIFFENER-20SWG	S3	1
1	J60326	PANEL-22 SWG	L16	1

SEE NOTE ⊗ (items 14, 13)
SEE NOTE ⊗ (items 3, 2)

ISSUE	AMEND Nº	INTERNAL MOD. Nº	INTERNAL CLASS	APP.	R.T.O.
C	CIVIL MOD	3113			
B	CIVIL MOD	2782			
A	CIVIL MOD	2782			

TYPE: CIVIL A/C J/N

PROTECTIVE TREATMENT | Assy. Nº EJF 305 | SCALE: ½ - 1/1 | DRAWN B.J. COONEY | CHECKED | TRACED | TRACING CHECKED

AUSTER AIRCRAFT LIMITED LEICESTER

TITLE: ASSY. OF UNDERSHIELD.

STRESS APPROVAL | DESIGN APPROVAL | APPROVED R.T.O.

PART Nº JA 61171

DRG. Nº EJF 628