



ITEM NO.	DESCRIPTION	QUANTITY	UNIT	REMARKS
1	TUBE 1/2" X 1/2" X 1/8"	1	PC	
2	TUBE 1/2" X 1/2" X 1/8"	1	PC	
3	TUBE 1/2" X 1/2" X 1/8"	1	PC	
4	TUBE 1/2" X 1/2" X 1/8"	1	PC	
5	TUBE 1/2" X 1/2" X 1/8"	1	PC	
6	TUBE 1/2" X 1/2" X 1/8"	1	PC	
7	TUBE 1/2" X 1/2" X 1/8"	1	PC	
8	TUBE 1/2" X 1/2" X 1/8"	1	PC	
9	TUBE 1/2" X 1/2" X 1/8"	1	PC	
10	TUBE 1/2" X 1/2" X 1/8"	1	PC	
11	TUBE 1/2" X 1/2" X 1/8"	1	PC	
12	TUBE 1/2" X 1/2" X 1/8"	1	PC	
13	TUBE 1/2" X 1/2" X 1/8"	1	PC	
14	TUBE 1/2" X 1/2" X 1/8"	1	PC	
15	TUBE 1/2" X 1/2" X 1/8"	1	PC	
16	TUBE 1/2" X 1/2" X 1/8"	1	PC	
17	TUBE 1/2" X 1/2" X 1/8"	1	PC	
18	TUBE 1/2" X 1/2" X 1/8"	1	PC	
19	TUBE 1/2" X 1/2" X 1/8"	1	PC	
20	TUBE 1/2" X 1/2" X 1/8"	1	PC	
21	TUBE 1/2" X 1/2" X 1/8"	1	PC	
22	TUBE 1/2" X 1/2" X 1/8"	1	PC	
23	TUBE 1/2" X 1/2" X 1/8"	1	PC	
24	TUBE 1/2" X 1/2" X 1/8"	1	PC	
25	TUBE 1/2" X 1/2" X 1/8"	1	PC	
26	TUBE 1/2" X 1/2" X 1/8"	1	PC	
27	TUBE 1/2" X 1/2" X 1/8"	1	PC	
28	TUBE 1/2" X 1/2" X 1/8"	1	PC	

WELDING DATA
 TYPE OXYACETYLENE
 ROD B55 (E55-B-A)
 FLUX
 TREATMENT

DETAIL OF BLANK FOR ITEM 22
 SCALE: 1/2

SECTION ON E-E THRU ITEM 19 (TYPICAL)
 SCALE: 1/2

DETAIL OF BLANK FOR ITEM 20
 SCALE: 1/2

INTERNAL PROTECTION OF ENGINE MOUNT
 MEMBER TO BE WELDED TO FUSELAGE
 IN THE EXAMPLE ABOVE SO THERE IS AN
 INTERNAL PROTECTION THROUGHOUT THE
 MOUNT. LINDING IS TO BE INTERNAL. BRASS
 FOR SURFACE FINISHING OFF.

DETAIL OF BLANK FOR ITEM 21
 SCALE: 1/2

SECTION ON F-F THRU ITEM 13 (TYPICAL)
 SCALE: 1/2

VIEW ON ARROW K SHOWING DETAIL OF ITEM 10

VIEW ON ARROW M SHOWING DETAILS OF ITEM 11

VIEW ON ARROW N SHOWING DETAILS OF ITEM 12

VIEW ON ARROW O SHOWING DETAILS OF ITEM 13

VIEW ON ARROW P SHOWING DETAILS OF ITEM 14

VIEW ON ARROW Q SHOWING DETAILS OF ITEM 15

VIEW ON ARROW R SHOWING DETAILS OF ITEM 16

VIEW ON ARROW S SHOWING DETAILS OF ITEM 17

VIEW ON ARROW T SHOWING DETAILS OF ITEM 18

VIEW ON ARROW U SHOWING DETAILS OF ITEM 19

VIEW ON ARROW V SHOWING DETAILS OF ITEM 20

VIEW ON ARROW W SHOWING DETAILS OF ITEM 21

VIEW ON ARROW X SHOWING DETAILS OF ITEM 22

VIEW ON ARROW Y SHOWING DETAILS OF ITEM 23

VIEW ON ARROW Z SHOWING DETAILS OF ITEM 24

VIEW ON ARROW AA SHOWING DETAILS OF ITEM 25

VIEW ON ARROW AB SHOWING DETAILS OF ITEM 26

VIEW ON ARROW AC SHOWING DETAILS OF ITEM 27

VIEW ON ARROW AD SHOWING DETAILS OF ITEM 28

NOTE - AFTER REPAIRING MINIMUM WALL THICKNESS MUST NOT BE LESS THAN .060"

NOTE - SHOPS ARE TO MAKE ALLOWANCES FOR CONTRACTION DURING WELDING TO DIMENSIONS MARKED THIS * AS THESE ARE ENLARGED X FINAL DIMENSIONS AFTER COMPLETING ALL WELDING. WELD WHERE SHOWN THIS * ALL CLUSTERS FULLY WELDED.

APPROVED: [Signature]

DATE: 6/9/17