

Parts List

Parts Dash	Type	Description	Qty
-2	Plate	0.125T x 3.0W x 11.0L	1
-3	Plate	0.050T x 3.0W x 11.0L	1

Code	Type	Type	Length	Qty
YOF	Rivet	BACR15FT5D*	-6	11
ZSE	Rivet	BACR15GF5D*	-6	11
ZSE	Rivet	BACR15GF6D*	-6	11

General Notes

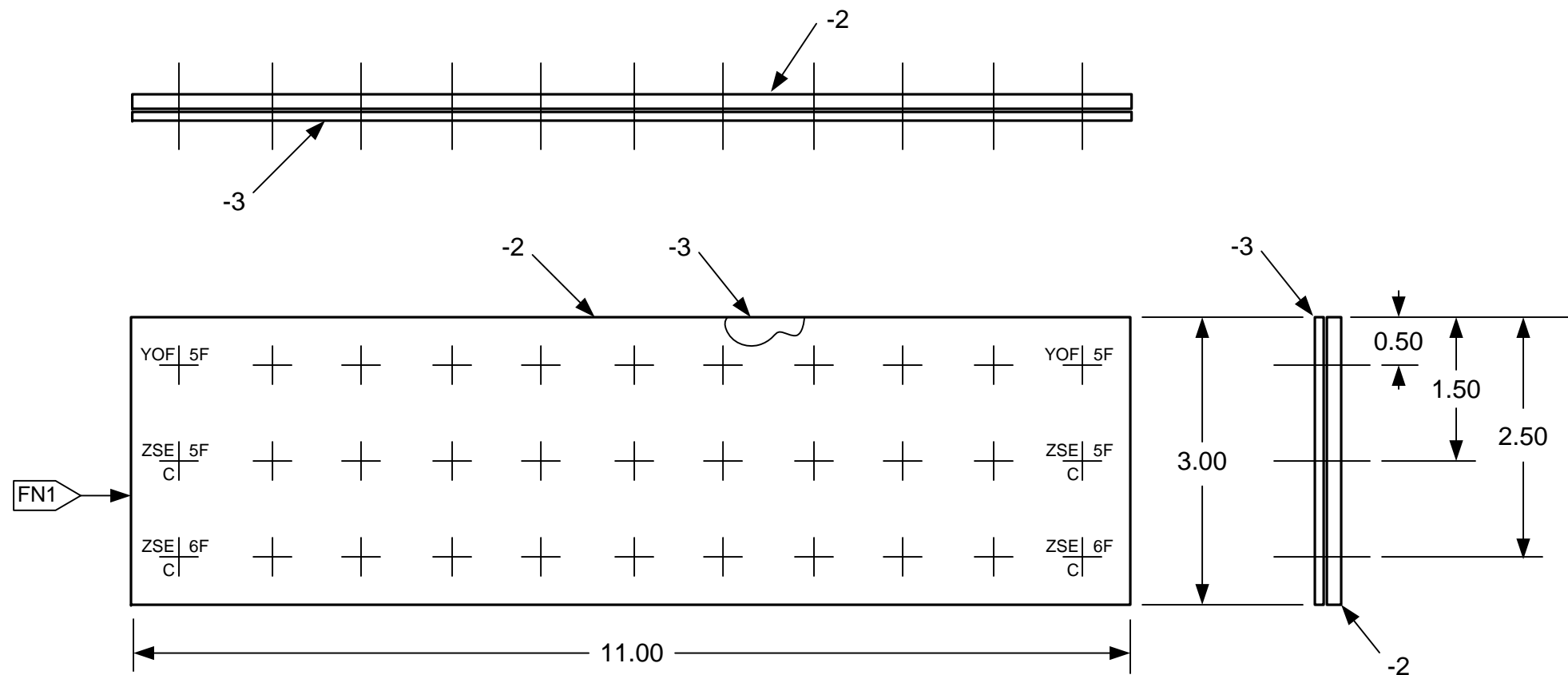
1. Dimension and tolerance per AMSE Y14.5M – 1994.
2. Unless otherwise specified all dimensions are in inches.
3. All Angles $\pm 2^\circ$ Decimals ± 0.03
4. Deburr all sharp edges
5. All holes drilled at $90^\circ \pm 2^\circ$ of surface of material
6. Chamfer all holes prior to fastener installation
7. All holes must be round and free of scratches inside of bore

Flag Notes

FN1 Ref -2 and -3, 2024 T3 preferred. Substitutions allowed due to cost or availability.

This drawing is for training use only. Not approved for production use.

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Assy -1

Drawn B. Hinton	10/01/2012	Part # PRO 001
Checked M. Brinkman	10/15/2012	Drawing PRO 001, Sheet 1 of 1
Approved K. Cole	10/20/2012	Section Manufacturing Skills Training
Engineer P. Kumar	10/22/2012	Module Aerospace Skills, v 1.0

PRO 001 Materials, Tools & Processes

For Classroom Use

Layout Tape
 Non-graphite writing instrument
 6" or 12" steel Scale
 Drawing
 Aluminum Flat Stock .05 x 3.0 x 11.0 (2024 T3)] – Qty 1 per student
 Aluminum Flat Stock .125 x 3.0 x 11.0 (2024 T3)] – Qty 1 per student

For Lab Use

Containment Tray
 3000 PRM Pistol Grip QC Drill Motor
 Ingersol Rand 6P Rivet Gun (AKA 400 Rivet Gun) equivalent or smaller
 #10 Bucking Bar or Bucking Bar
 Full Cup Drill Guide
 Half Cup Drill Guide
 Bell Die
 (Rivet Die to install 5/32 " Reduced Head" rivets)
 Starrett Tap Card
 3" #30 Quick Change Jobber Drill Bit
 3" #30 Threaded Drill bit
 #30 Drill Stop
 #30 Drill Guide Bushing
 3" or 6" .192 Drill bit
 3" 3/16" Single Margin Drill Bit
 3/16" Drill Stop
 3/16" Drill Guide Bushing
 3" or 6" .160 Drill Bit
 3" 5/52" Single Margin Drill Bit
 5/32" Drill Stop
 #20 Drill Guide Bushing
 5/64" Straight Allen Wrench with Handle
 1/16" Straight Allen Wrench with Handle (u/o Set Screw in Handle)
 1/2 x 100 degree Open Face Countersink cutter on wooden handle
 Countersink Stop Body ZT680-QC
 Countersink Cutter (Used for 5/32" GF rivets)
 Countersink Cutter (Used for 6/32" GF rivets)
 "H" Gage (Go/No-Go gage for 5/32 rivet)
 "H" Gage (Go/No-Go gage for 5/32 rivet)
 .003" Feeler Gage
 Ball Peen Hammer
 5/32" Hand Punch (For 3/16 Rivet Removal)
 1/8" Hand Punch (For 5/32 Rivet Removal)
 Cleco Pliers
 #30 Spring Cleco's (Qty Approx. 10 per student)
 5/32" Spring Cleco's (Qty Approx.5 per student)
 3/16" Spring Cleco's (Qty Approx.8 per student)

For Instructor Use

.190 - .196 Check Pin
 .159 - .165 Check Pin

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