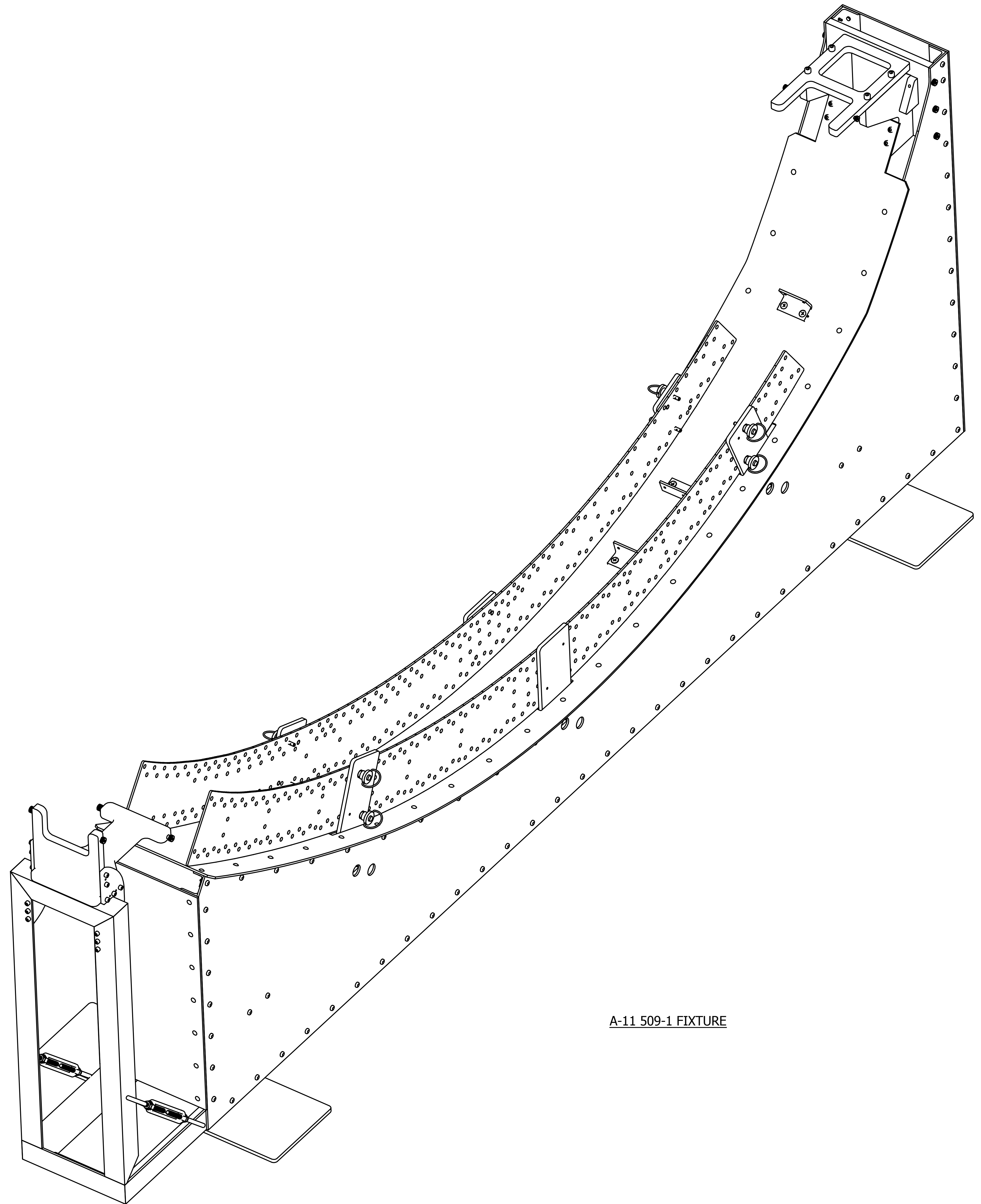


REV		DATE	DESCRIPTION	DRAWN	CHECK'D	APPR'VD
			INITIAL RELEASE	JG		



A-11 509-1 FIXTURE

ITEM	QTY	PART NUMBER	NAME
339	1	AT509A-12	FRAME WELDMENT
45	12	8511A17	Press-Fit Fixture Support
44	148	90203A310	Pan Head Drilling Screw 8-18 x .50
43	2	91259A164	ALLOY STEEL SHOULDER SCREW, 3/16" DIAMETER X 1/8" LONG SHOULDER, 8-32 THREAD
42	8	91259A169	Alloy Steel Shoulder Screw, 1/4" Diameter x 1/8" Long Shoulder, 10-24 Thread
41	14	91259A533	ALLOY STEEL SHOULDER SCREW, 1/4" DIAMETER X 1/4" LONG SHOULDER, 10-24 THREAD
40	8	92384A012	RING GRIP PUSH-BUTTON QUICK-RELEASE PIN
31	4	ANSI B18.3 - 1/4 - 20 UNC - 1 1/4 HS HCS	Hexagon Socket Head Cap Screw
30	12	ANSI B18.3 - 1/4 - 20 UNC - 1 HS HCS	Hexagon Socket Head Cap Screw
29	8	ANSI B18.3 - No. 10 - 24 UNC - 3/4 HS HCS	Hexagon Socket Head Cap Screw
28	16	ANSI B18.3 - No. 8 - 32 UNC - 5/8 HS HCS	Hexagon Socket Head Cap Screw
27	8	ANSI B18.8.2 - 1/8 x 5/8	Pin - Hardened Ground Production Dowel
26	20	MS20426AD-10	RIVET, SOLID, COUNTERSUNK 100 DEG., .125 X .625
25	39	MS20470 AD 4 - 3	RIVET, SOLID UNIVERSAL HEAD
24	2	TS09-15	PLATE
23	1	TS09-18	PLATE
22	1	TS09-19	PLATE
21	1	TS09-21	WEB
20	2	TS09-27	GUSSET
19	1	TS09-32	DRILL TEMPLATE
18	1	TS09-33	DRILL TEMPLATE
17	2	TS09-71	ANGLE
16	2	TS09-73	Brace
14	1	TS09-80	PLATE
13	2	TS09-81	WEB
11	1	TS09-84	PLATE
10	1	TS09-85	PLATE
9	1	TS09-86	PLATE
8	1	TS09-87	PLATE
7	2	TS09-88	PLATE
6	2	TS09-89	STOP
5	2	TS09-90	ANGLE
4	1	TS09-91	WEB
3	1	TS09-92	PLATE
2	2	TS09-93	GUSSETT
1	1	TS09A-5	CRADLE WEB ASSY

RIVET SYMBOL CODE	
DASH NO FOR DIA.	NEW FASTENER LOCATED BY POINT HOLE
BUMPS HEAD NEAR SIDE	NEW FASTENER LOCATED BY DIMENSION OR AS NOTED
D=DRIPPLE	REMOVE EXISTING FASTENER AND REPLACE WITH NEW FASTENER SAME TYPE AND SIZE
C=CRANK	REMOVE EXISTING FASTENER AND REPLACE WITH DIFFERENT FASTENER
BASIC CODES	
BB=MS20426AD	

TOLERANCES UNLESS NOTED OTHERWISE		PROJECT FILE	
FABRICATION	1. BREAK ALL SHARP EDGES TO .015" MIN	LCD PREBUILD	
X = ± .1	2. DIMENSIONING	APPROVALS	
.XX = ± .01	3. HOLE DRILLING	DATE	
.XXX = ± .005	4. HOLE DRILLING	7/23/2014	
ANGULAR ± 1°	5. HOLE DRILLING	APPROVED	
	6. HOLE DRILLING	J. GENOVA	
	7. HOLE DRILLING		
NOTICE: THIS DOCUMENT CONTAINS RESTRICTED INFORMATION AND MAY NOT BE TRANSMITTED IN ANY FORM OR MANNER WITHOUT THE EXPRESS WRITTEN PERMISSION OF FOKKER/SPRINGER		SCALE	
		1:4	
		SIZE	
		E AT509A-11	
		SHEET	
		1 OF 3	

FOKKER 50F FREIGHTER STC CORP.  
ENGLEWOOD, COLORADO 80112

509-1 ASSEMBLY FIXTURE

PR1





SIZE	DWG NUMBER	REVISION
<b>E</b>	AT509A-11	PR1
SCALE	DO NOT SCALE DRAWING	SHEET
1:3		3 OF 3