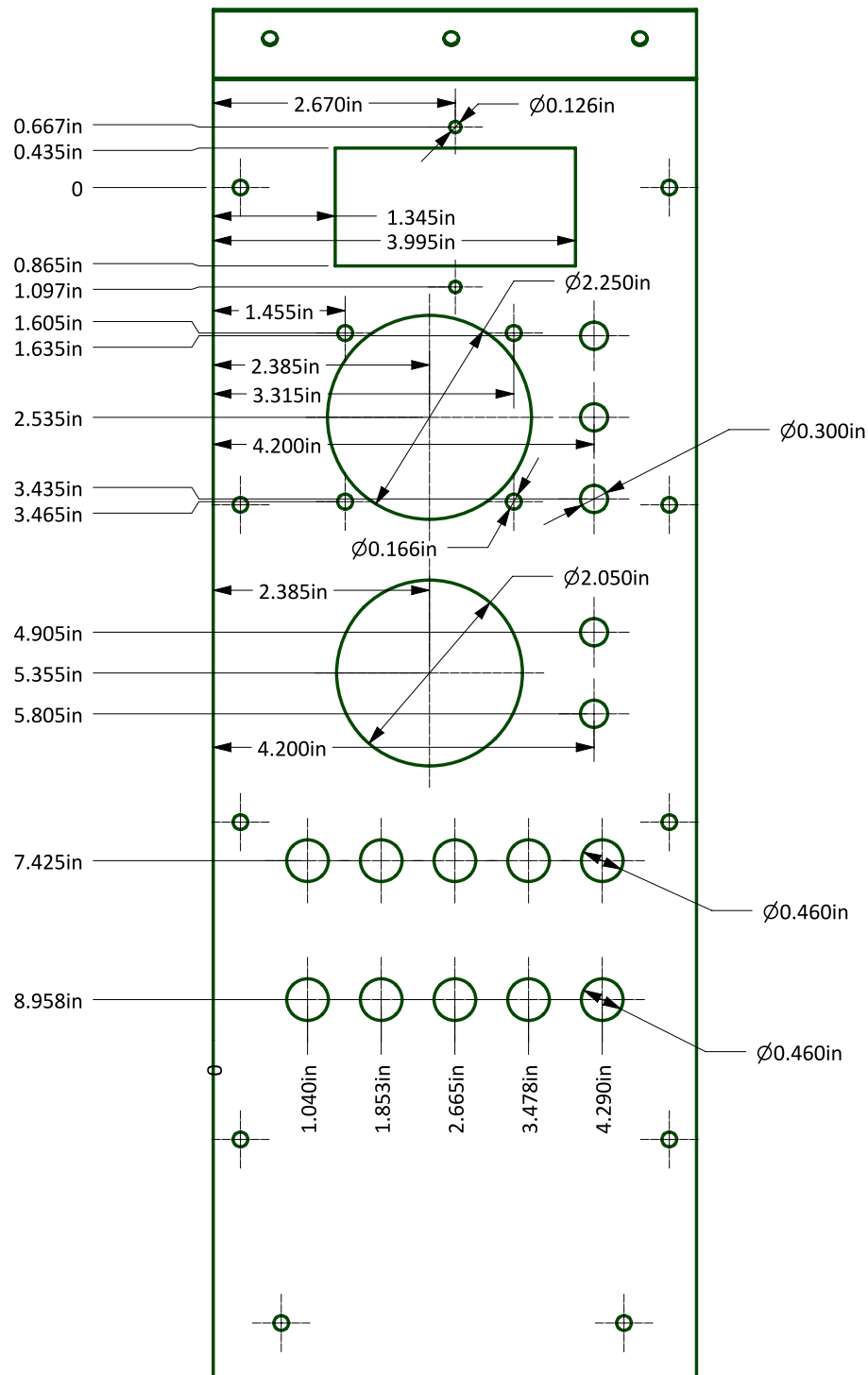


Helicycle Lower Panel Instrumentation and Control cutouts. Revision A.

Cutout pre-formed in assembly with instrument pod. Mounting holes, angles and perimeter pre-established. Upper Left Mounting hole and left edge are master reference datum for instrument cutouts.



Standard Notes: (Unless otherwise specified)

1. Material: 0.048 6061-T6 Aluminum Alclad Sheet.
2. Finish:
 - A. Scuff, etch, Alodine (or equivalent).
 - B. Primer: 2K Epoxy - Color Grey or Black
 - C. Paint all surfaces except as noted, 2K Urethane satin black finish (per supplied paint chip_.
3. Standard Tolerances:
 - ± 0.015 between two or more bends
 - ± 0.015 between hole to bend or hole to edge
 - ± 0.007 between holes on one surface
 - ± 0.007 for holes or cutouts
 - ± 1.0° for angles

SIZE A	CAGE CODE	DWG NO. Lower Panel	REV A
SCALE 1:2	01/26/14	SHEET SDM203	