

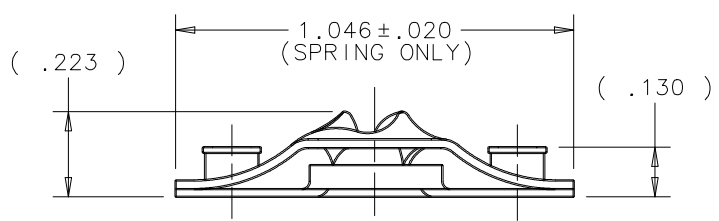
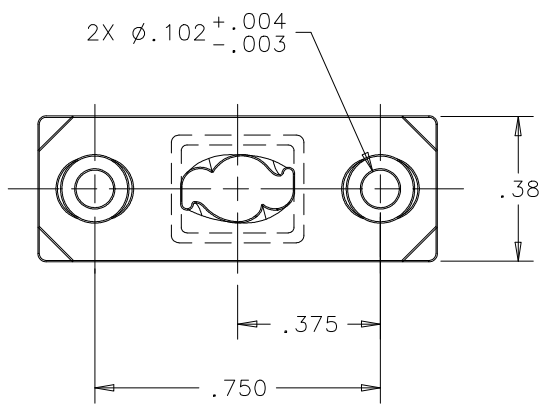
REV	DATE	DRAWN/CHKD	DESCRIPTION	ITEM	PART NUMBER	MATERIAL	FINISH
O	3-8-89	JSS	PRN: 82-237	ASSEMBLY	82-35-302-15		
P	12-13-91	JSS	DWG. NO. WAS J-82-39; CONVERTED FRACT.	SPRING		STEEL	ZINC FLAKE COATING
Q	06AUG2003	AAB/DLH	PRN: P2003-0671	BASE		STEEL	ZINC FLAKE COATING
R	12APR2005	BRP/RLR	PRN: P2005-0589				
S	29MAR2010	MJS/TVA	PRN: P2010-0308				
T	06OCT2015	CMS/MGG	PRN: P2015-1959				
U	16NOV2016	CMS/MWD	PRN: P2016-2610				
V	17JAN2017	CMS/MGG	PRN: P2017-0139				

INCHES

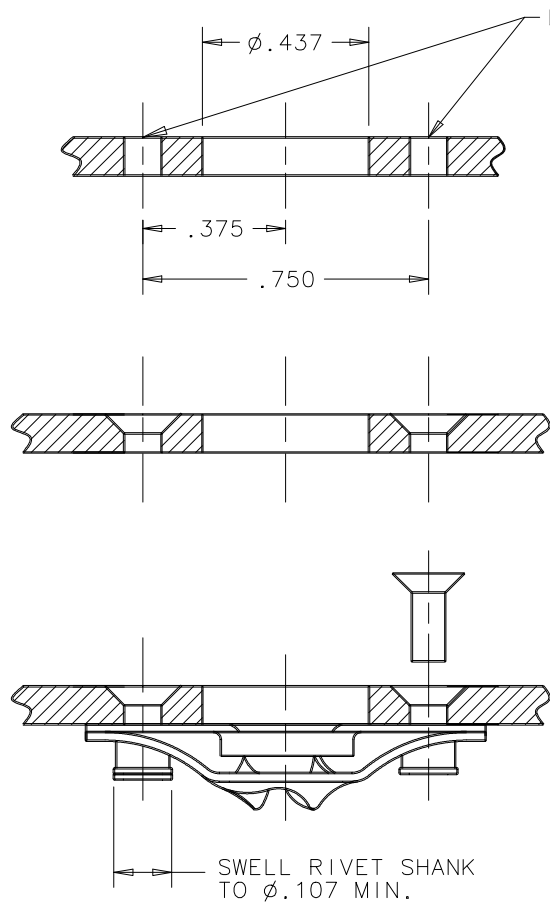
ALL DIMENSIONS WITHOUT TOLERANCES ARE FOR REFERENCE ONLY.

THIRD ANGLE PROJECTION A PAPER SIZE

SHEET THICKNESS (INCHES)	RIVET LENGTH
.030 - .036	.19
.042 - .090	.25
.105 - .135	.31
.125	.31
.187	.38
.250	.44
.312	.50
.375	.56
.437	.63



RIVET TYPE RECEPTACLE INSTALLATION PROCEDURE FOR INNER SHEET



1. DRILL OR PUNCH THE REQUIRED HOLE IN INNER SHEET LOCATED AS SHOWN, MIDWAY BETWEEN MOUNTING HOLES.
2. COUNTERSINK OR DIMPLE HOLES FOR RIVETS. DEBUR ALL HOLES.
3. RIVET-ATTACH SPRING ASSEMBLY TO INSIDE OF INNER SHEET USING RIVETS LENGTH SHOWN IN TABLE AT LEFT.

NOTES:
 A. BE SURE SPRING "FLOATS" FREELY AFTER RIVETING.
 B. SPRINGS MAY BE INITIALLY ADHERED TO THE BASE DUE TO THE ZINC FLAKE COATING APPLIED FOR CORROSION RESISTANCE. SPRINGS SHOULD BREAK FREE AND "FLOAT" AFTER THE FIRST FULL CYCLE OPERATION WITH STUD OR WITH LIGHT HAND PRESSURE.