

8

7

6

5

4

3

25305

ACP_TOOL_INVAR_1

SH 1

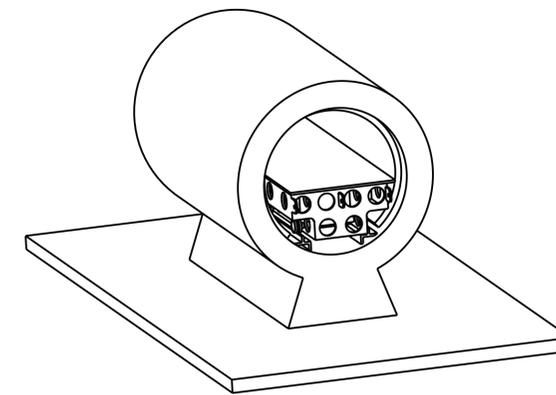
REV.

1

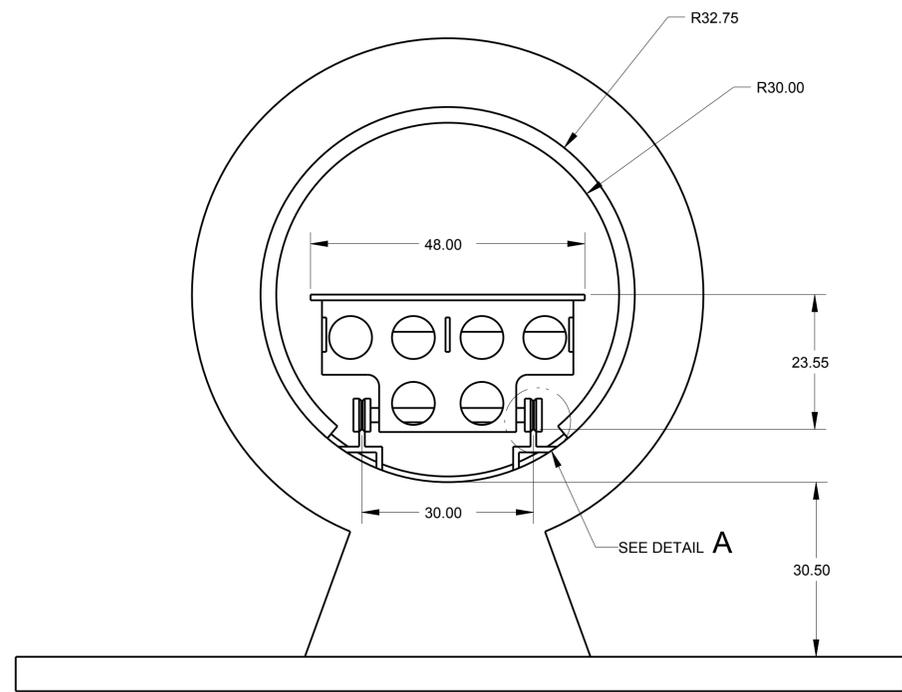
ZONE	REV	DESCRIPTION	DRAWN	CHECKED	LEAD ENGR	BRANCH	DATE

Specifications:

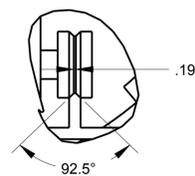
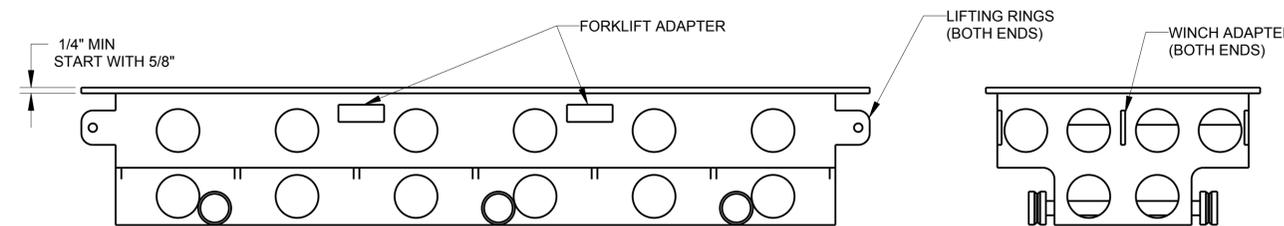
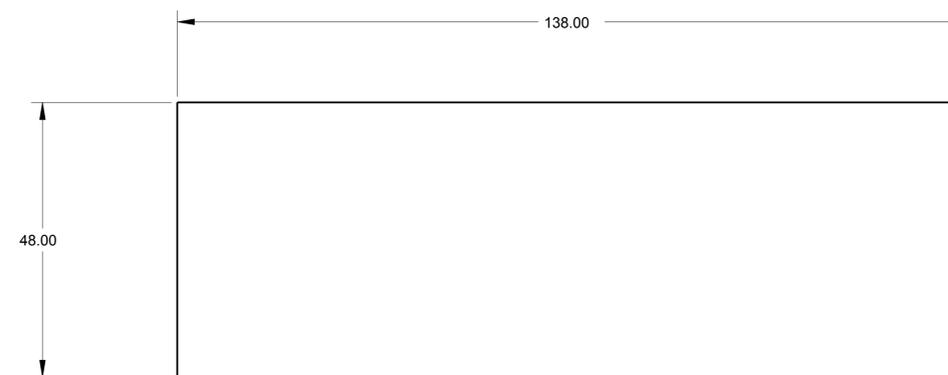
- 4' x 12' x 11.5' INVAR Flat Tool
- Lower structure, egg crate with minimal welds to reduce distortion.
- Fixture to be thermally relieved and finish machined or ground to achieve flatness and surface finish requirements.
SURFACE FINISH 32 MICROINCHES BETTER.
TOLERANCE: +/- .030 ALL DIMS EXCEPT THICKNESS
FLATNESS: MAX 0.015"
- Fixture to have a minimum of 6 laser tracking locations on the outside edge of the top surface.
Positions to have 1/4" carbide bushing inserts.
- Fixture to have forklift slots in the middle to allow for lifting/transportation.
- Fixture to have pad eyes welded in each corner to allow for lifting rings needed for crane use.
- Rollers to match autoclave rails and existing cart rails.
- Must provide drawing/CAD model representing finished product.
- Fixture must include stop pin to attach to existing cart
- Fixture must have winch attachment on both ends to allow it to be pulled out of the autoclave back onto the cart.
- Toolmaker to bake on a sealant coating onto the Invar surface prior to shipment (Frekote B-15)
- Delivery 10 weeks from placement of order.



DRAFT



SCALE 1/16



DETAIL A
SCALE 1/8

LAST UPDATE: 8/6/15

QTY REQD	CAGE CODE	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	ITEM NO.
-1		TBD	TBD		1

PART DASH NO.		QTY REQD PER ASSY	NEXT FINAL	NEXT ASSY	USED ON	APPLICATION	SIMILAR TO	SPECIAL MARKING SYM	FINISH	TREATMENT	CONTRACT NO.	APPROVALS	DATE	TITLE	SIZE	CAGE CODE	DWG. NO.	REV.
-1				TBD	TBD								2015-07-13	ACP TOOL SPECIFICATIONS	D	25305	ACP_TOOL_INVAR_1	1

NATIONAL AERONAUTICS & SPACE ADMINISTRATION
LANGLEY RESEARCH CENTER
HAMPTON, VA 23681-2199

SCALE 1/16 | SHEET 1 OF 1