


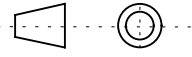


CONFIDENTIAL INFORMATION			UNLESS OTHERWISE STATED INTERPRET DRAWING ACCORDING TO RAFAEL PROCEDURE 18.00.10	
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REVISIONS				
REV	DESCRIPTION	ECO_NO	ID/SIGNATURE	DATE
A	R.P.A		BINYAMS	2014-10-19

PRODUCTION ROUTING CHART				
ALL DIMENSIONS ARE IN MILLIMETER UNLESS OTHERWISE SPECIFIED.				
PRODUCTION SEQUENCE IS OBLIGATORY.				
NOTES NUMBERS ARE ASCENDING, BUT NOT NECESSARILY SEQUENTIAL.				
ALL DOCUMENTS LISTED BELOW ARE IN THEIR LATEST VERSION, UNLESS OTHERWISE SPECIFIED.				
No.	Description	Oper	Date	
10	MACHINING BY CAD FILE AND PARTIAL DRAWING			
20	DIMENSIONS INCLUDE SURFACE TREATMENT EFFECTS			
30	MATERIAL			
30.1	ALUMINUM ALLOY 6061-T651 PLATE L=144. W=48. T=0.5 INCH COMMERCIAL, CAT NO. 5015378079 , DIM 66x560 , QTY 0.14 , UNIT KG , PER: Q.A GEN_1111-1			
40	UNLESS OTHERWISE SPECIFIED (WHEN IN CONFLICT, THIS PARA. OVERRIDES TITLE BLOCK REQ.):			
40.1	DATA FILE NAME MATCHES DRAWING NO. & VERSION			
40.2	IN-PROCESS PRESERVATION PER PS-38-576104			
40.3	BREAK SHARP EDGES ~0.2X45°, EXTERNAL EDGES MAY BE PERFORMED AS R0.5+0.5			
50	PRODUCTION SEQUENCE:			
50.1	MACHINING			
60	FIRST ARTICLE INSPECTION BY MANUFACTURER (MARK THIS PART):			
60.1	MODEL - PART COMPATIBILITY VERIFICATION			
60.2	ALL SPECIFIED DIMENSIONS			
60.3	100% VISUAL INSPECTION			
70	FOLLOW-UP PRODUCTION INSPECTIONS BY THE MANUFACTURER:			
70.1	100% VISUAL INSPECTION			
70.2	SAMPLING METHOD FOR ALL OTHER DIMENSIONS & REQUIREMENTS: ZO SQUEGLIA, INDEX VALUE 2.5%. PER PS-TILDOCS#172373. ACCEPTANCE CRITERIA: ZERO NONCONFORMITY.			
80	LAST ARTICLE INSPECTION BY MANUFACTURER (MARK THIS PART):			
80.1	ONE MIN REPRESENTATIVE HOLE DIAMETER, ROUND RADIUS, SLOT WIDTH AND OTHER DIMENSIONS OF FEATURES BASED ON A TOOL SIZE			
90	INSPECTION VERIFICATION BY CUSTOMER'S REPRESENTATIVE			
100	SURFACE TREATMENT			
100.1	SURFACE COATING:CONVERSION COATING FOR IMPROVED CORROSION RESISTANCE PER PS- 111.21			
110	INSPECTION VERIFICATION BY CUSTOMER'S REPRESENTATIVE			
120	ATTACHMENT OF C.O.C. AND OTHER DOCUMENTS SPECIFIED IN THE PURCHASE ORDER			
130	PACKING FOR SHIPMENT PER PS-38-576104			

MATERIAL SEE RC		CAT NO SEE RC	DIM SEE RC	RAFAEL  COPYRIGHT PROTECTED ©					
		QTY SEE RC	UM SEE RC		ID/SIGNATURE	DATE			
TOLERANCES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS AND INCLUDE EFFECTS OF SURFACE TREATMENTS. ⌀ 0.2 A B C FOR THREADS. ⌀ 0.2 M A B C FOR CIRCULAR BOSSES & HOLES. +0.2 FOR HOLES, -0.02 +0.02 FOR CIRCULAR BOSSES. -0.2 0.3 A B C FOR OTHER FEATURES		PROCESS/TREATMENT SEE RC			DESIGNED	N9BB	2014-10-19		
					CHECKED	LIORMI	2014-10-19		
					.	.	.		
					Q.A	BINYAMS	2014-10-19		
					APPROVED	BINYAMS	2014-10-19		
					.	.	.		
		SURFACE TEXTURE  Ra3.2			SCALE	CLASS	SIZE	DRAWING NO.	SHT OF
					1:1	Unclassified	A3	R00-214822	1 1
					REV A				

SURFACE TEXTURE		SCALE	CLASS		
		1:1	Unclassified		

Cad System: PROE 4		MODEL NAME	TRS_IGN_BOX		
		DRAWING NAME	TRS_IGN_BOX		
				PDM REV	A.14

