

| REV | ZONE | DESCRIPTION | DATE | APPROVAL |
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3 THE FINISHED PARTS SHALL BE KEPT CLEAN & DRY UNTIL PACKAGED, INDIVIDUALLY, IN A MOISTURE PROOF BAG. EACH BAG SHALL CONTAIN THE PART NUMBER & THE FOLLOWING INSTRUCTIONS: CLEAN THIS PART TO BE KEPT DRY AND CLEAN OF ALL CONTAMINATING GREASE, OIL, & CLEANING COMPOUNDS.

2 ANY RESIDUAL TOOL MARKS ON THESE SURFACES SHALL BE CONCENTRIC WITH THE CENTER OF THE THRUST WASHER.

1 THESE SURFACES TO HAVE A MACHINE FINISH FINISHED TO A SURFACE ROUNDED TO A MINIMUM PROFILES PER SECTION 2. SURFACES UP TO 125 ARE ACCEPTABLE IN EXCESS OF 32 AND POROSITY OF THE MATERIAL.

THESE SURFACES TO BE FLAT AND PARALLEL WITHIN .0010 T.I.R.

1908-B BRONZE MATERIAL (NO BACKING PLATE) RAYBESTOS - MANHATTAN, INC. EQUIPMENT SALES DIVISION 620 FISHER BUILDING, DETROIT 2, MICHIGAN

ALL SURFACES EXCEPT AS NOTED

PROPRIETARY NOTE

THE FOLLOWING LEGEND WILL BE APPLIED TO ALL DRAWINGS UNLESS OTHERWISE NOTED. IF ANY DATA SHOWN HEREON WILL BE SUBJECT TO THE LIMITATIONS ON USE OF ANY INFORMATION CONTAINED HEREON, THE INFORMATION IS HEREBY RELEASED AND ALSO TO ALL OF THE INFORMATION ACCORDING PROPRIETARY INFORMATION BY THE LAW.

1. Release of this information does not constitute an acknowledgment of the accuracy of the information. The user of this information is advised that the user assumes all liability for any use of the information. The user of this information is advised that the user assumes all liability for any use of the information.

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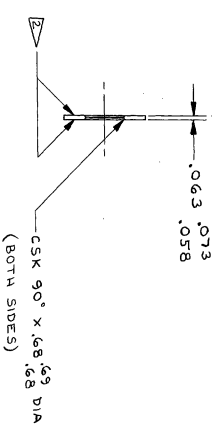
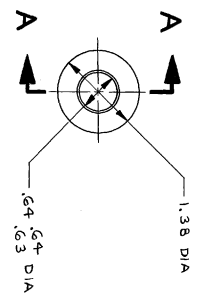
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MANUFACTURING REQUIREMENTS FOR SURFACES

1. MANUFACTURE OF SURFACES IS LIMITED TO MACHINING BY SINGLE POINT CARBIDE TOOL, ST6201-CR (WITH A .005 R TIP RADIUS) OR EQUIVALENT.
2. ANY MANUFACTURING METHOD UTILIZING ABRASIVES SUCH AS GRINDING, LAPING, POLISHING, HONING OR BUFFING IS NOT ACCEPTABLE.
3. USE NO CUTTING OIL OR COOLANT.
4. USE SPINDLE SPEEDS FROM 700 TO 900 RPM AND FEED OF .006 INCH PER REVOLUTION WHEN MACHINING SURFACES.
5. PROTECT FINISHED PARTS AGAINST CONTAMINATION.
6. QUALITY CONTROL SHALL CERTIFY THAT ALL MACHINING REQUIREMENTS OF THIS DRAWING AND PACKAGING REQUIREMENTS PER ARE COMPLIED WITH.

| CONTRACT NUMBER | REVISION | DATE | DESCRIPTION |
|-----------------|----------|----------|-------------------------|
| 9034-1 | 1 | 10-23-77 | INITIAL DESIGN |
| 9034-1 | 2 | 11-15-77 | REVISED TO SHOW CHANGES |
| 9034-1 | 3 | 12-15-77 | REVISED TO SHOW CHANGES |
| 9034-1 | 4 | 1-15-78 | REVISED TO SHOW CHANGES |
| 9034-1 | 5 | 2-15-78 | REVISED TO SHOW CHANGES |
| 9034-1 | 6 | 3-15-78 | REVISED TO SHOW CHANGES |
| 9034-1 | 7 | 4-15-78 | REVISED TO SHOW CHANGES |
| 9034-1 | 8 | 5-15-78 | REVISED TO SHOW CHANGES |
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| 9034-1 | 40 | 1-15-81 | REVISED TO SHOW CHANGES |
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| 9034-1 | 51 | 12-15-81 | REVISED TO SHOW CHANGES |
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| 9034-1 | 98 | 11-15-85 | REVISED TO SHOW CHANGES |
| 9034-1 | 99 | 12-15-85 | REVISED TO SHOW CHANGES |
| 9034-1 | 100 | 1-15-86 | REVISED TO SHOW CHANGES |

| ITEM | DESCRIPTION | QTY | UNIT | REMARKS |
|------|---------------|-----|------|---------|
| 1 | THRUST WASHER | 1 | EA | |
| 2 | THRUST WASHER | 1 | EA | |
| 3 | THRUST WASHER | 1 | EA | |
| 4 | THRUST WASHER | 1 | EA | |
| 5 | THRUST WASHER | 1 | EA | |
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| 98 | THRUST WASHER | 1 | EA | |
| 99 | THRUST WASHER | 1 | EA | |
| 100 | THRUST WASHER | 1 | EA | |

THE BOEING COMPANY
AIRPLANE DIVISION
RENTON, WASHINGTON

THRUST WASHER -
RUDDER TRIM
ACTUATOR

CONTRACT NO. 9034-1
SHEET 1 OF 1