

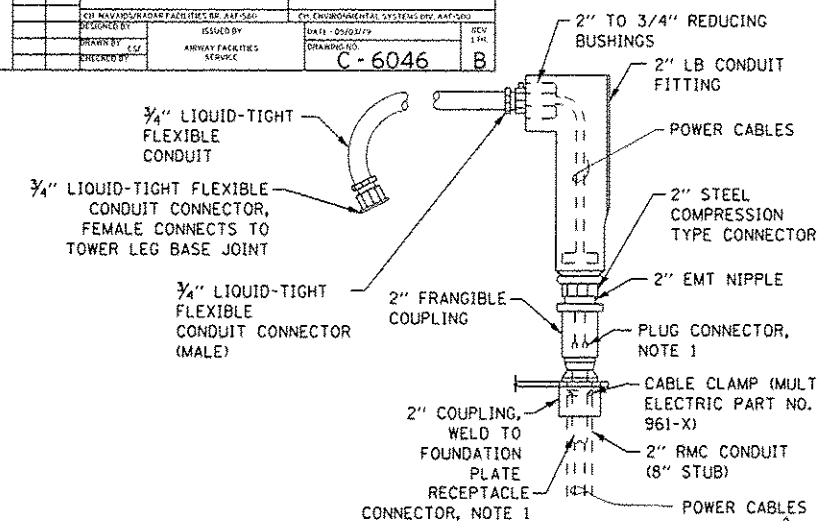
IMPACT TEST SETUP

1. FRANGIBLE COUPLING CONSIST OF COUPLING, NUT, AND COMPRESSION RING.
2. ANY METHOD OF CASTING MAY BE USED, PROVIDED THE TOLERANCES ARE HELD.
3. MACHINING IS PERMITTED ON CASTING FOR CUTTING THREADS OR FRANGIBLE GROOVE ONLY. GRIND OR WIRE BRUSH ALL INTERNAL AND EXTERNAL BURRS AND CASTING RIDGES.
4. TWO SLOTS SHALL BE PROVIDED ON COUPLINGS MADE OF ALLOY 380.0 SLOTS SHALL BE .187 TO .250 INCHES WIDE, 1.125 INCHES LONG AND EXTEND NO CLOSER THAN .0625 INCHES OF EXTERIOR SURFACES.
5. ANODIZING, WHEN REQUIRED BY THE TABLE, SHALL BE PERFORMED ON ALL COMPONENTS IN ACCORDANCE WITH MIL-A-8625, TYPE II, CLASS 1, TO A MINIMUM THICKNESS OF 0.001 INCHES. TOLERANCES INDICATED ON THIS DRAWING SHALL INCLUDE ANODIZING COAT THICKNESS.
6. 2.207 +.010/- .000 IS TO PROVIDE SLIP FIT FOR ST'D 2 (NOMINAL) ELECTRICAL METALLIC TUBING (EMT) WITH 2.192" MINIMUM AND 2.202" MAXIMUM OUTSIDE DIAMETER.
7. NUT SHALL HEXAGONAL, THREADED AS REQUIRED TO BE FREE RUNNING ON COUPLING THREADS. NUT AND COMPRESSION RING DETAILS SHALL BE SIMILIAR TO THOSE USED ON ST'D 2" EMT WATER-TIGHT FITTING.
8. QUALITY CONTROL
 - A. ALUMINUM VENDOR CERTIFIED PER QQ-A-591 AND/OR QQ-A-250 AS APPLICABLE.
 - B. ANODIZING VENDER CERTIFIED PER MIL-A-8825.
 - C. IMPACT TEST CONDUCTED BY CONTRACTOR AND WITNESSED BY FAA USING TEST SET-UP BELOW TO VERIFY THAT COUPLING WILL WITHSTAND 20FT LB IMPACT LOAD. SAMPLES CONTRACTOR FURNISHED, SELECTED AT RANDOM BY FAA AT RATE OF 5 PER 100 FOR THE FIRST 200 UNITS PRODUCED, 2 PER 500 FOR QUANTITIES PRODUCED THERE-AFTER.
9. DEPTH OF FRANGIBLE GROVE ESTABLISHED AS REQUIRED FOR COUPLING TO MEET REQUIRMENTS OF NOTE 8C.
10. MATERIALS - COUPLING AND NUT - ALUMINUM 423.0 OR 380.0 PER QQ-A-591 OR ALUMINUM .3003-H14 PER FED. SPEC. QQ-A-250/2 (REFER TO LATEST ISSUE OF EACH FED. SPEC)
11. TENSION TEST - CONDUCTED AND CERTIFIED BY THE CONTRACTOR A MINIMUM OF 20 LB FORCE SHALL BE REQUIRED TO PULL A 2INCH (NOM) EMT FROM THE FRANGIBLE COUPLING AFTER THE NUT (WITH COMPRESSION RING) HAS BEEN TIGHTENED.

TYPE	MAT'L NOTE 11	SLOTS NOTE-5	ANODIZING	NOTE-6
1	MG-20		7'-1"	SUM L(FOR
2	MG-20		6'-5"	MG-20 &MG-30)
3	MG-20		6'-9"	=51'-10''x60"



B	01/07/90	UPDATE DRAWING			
A	01/07/90	DELETED NOTE 4, CLASSIFIED NOTES 5 & 6 AND ADDED NOTES 3 & 12		JA	7
REV.	DATE	DESCRIPTION		CHECKED	APPROVED
<p align="center">DEPARTMENT OF TRANSPORTATION FEDERAL AVIATION ADMINISTRATION WASHINGTON, D.C. 20591</p> <p align="center">FRANGIBLE COUPLING TYPE 1 AND TYPE 1A, DETAILS</p>					
RECEIVED BY	SUBMITTED BY			APPROVED BY	
	CON. NAVJAG/NAVARA FACILITIES BR. AAF-580 SECTION 2			CM. ENVIRONMENTAL SYSTEMS BR. AAF-580	
	DRAWN BY: CMU CHECKED BY:			DATE: 02/07/79 DRAWING NO:	
			AIRWAY FACILITIES SERVICE		
			C-6046		

1. WHENEVER NEW COUPLINGS ARE REQUIRED CONTRACTOR MUST PERFORM FIELD TESTING AS DESCRIBED ABOVE IN PRESENCE OF FAA AND DIRECTOR.
2. SEE PLAN AND PROFILE DRAWINGS FOR LAMP CENTERLINE ELEVATIONS
3. ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED



FRANGIBLE COUPLING

① ADDED SHEET
GLD-09-1

	USER NAME = mksafr	DESIGNED <i>SJM</i>	REVISED -	<p align="center">STATE OF ILLINOIS DEPARTMENT OF TRANSPORTATION</p>	<p align="center">NAVAIDS FRANGIBLE COUPLING DETAILS</p>				F.A.P. RTE. 330	SECTION 0105 WRS&HB	COUNTY COOK	TOTAL SHEETS 605	SHEET NO. 605B
	PLOT SCALE = 2H	CHECKED <i>SPG</i>	REVISED -						CONTRACT NO. 60G37				
	PLOT DATE = 26-DEC-2012	DATE	REVISED  12/26/12 ADDENDUM 1		SCALE:	N.T.S.	SHEET NO. 6 OF 16 SHEETS	STA. N/A	TO STA. N/A	ILLINOIS F&D PROJ# 07			

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