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NWC TP 5705  
Volume 2

✓ 157

# Low Cost/Optimized Performance Inlets, Volume 2, Phase Two, Production Methods Development

by  
J. L. Arnquist  
E. L. Koetje  
R. F. Northrop  
Boeing Aerospace Company  
for the  
*Propulsion Development Department*

JUNE 1976



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R. G. Freeman, III, RAdm., USN ..... Commander

G. L. Hollingsworth ..... Technical Director

## FOREWORD

This report, Volume 2, describes an effort to develop fabrication methods for low cost production of inlets for an advanced long range air-to-air missile. Volume 1 of this series presents the cost/performance trade studies and the detailed design for a two-dimensional external compression inlet. The investigation was conducted during the period December 1974 through November 1975. The work was sponsored by the Naval Weapons Center (NWC), China Lake, California, under Navy Contract N00123-73-C-2225 and supported by the Naval Air Systems Command under AirTask A3303300/008B/3F31334300.

Mr. R. Reid was the Navy Technical Coordinator and has reviewed this report for technical accuracy.

This report is released for information at the working level and does not necessarily reflect the views of NWC.

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Propulsion Development Department  
20 April 1976

Under authority of  
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(U) *Low Cost/Optimized Performance Inlets. Volume 2, Phase Two, Production Methods Development*, by J. L. Arnquist, E. L. Koetje and R. F. Northrop, Boeing Aerospace Company. China Lake, Calif., Naval Weapons Center, June 1976, 42 pp. (NWC TP 5705, Volume 2, publication UNCLASSIFIED.)

(U) Volume 1 of this report covers phase one of a study to identify, design and fabricate low cost/optimized performance inlets for an advanced long range air-to-air missile. This report, Volume 2, covers the phase two effort to develop fabrication methods for low cost production of inlets. Production methods were developed for low cost forming and welding of titanium sheet metal for the inlet. The resulting hardware has internal features identical to the production hardware. Production hardware costs and weights were re-estimated based on recommended design changes. A set of "close tolerance" inlets for use in freejet testing was also produced in heavy steel plate material.

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NOMENCLATURE

|         |                                          |
|---------|------------------------------------------|
| Boeing  | Boeing Aerospace Company                 |
| C       | Celcius                                  |
| cm      | Centimeter                               |
| F       | Fahrenheit                               |
| FMS     | Fuel Management System                   |
| GFE     | Government Furnished Equipment           |
| in      | Inch                                     |
| kg      | Kilogram                                 |
| lb      | Pound                                    |
| M       | Moment                                   |
| MRE     | Modern Ramjet Engine                     |
| mm      | Millimeter                               |
| NWC     | Naval Weapons Center, China Lake         |
| P       | Load                                     |
| Q       | Lateral Load                             |
| T       | Torque                                   |
| TIG     | Tungsten Inert Gas                       |
| UARL    | United Aircraft Research Labs (Now UTRL) |
| UTC     | United Technology Corporation            |
| V       | Vertical Load                            |
| $\mu$ " | Microinch                                |

## INTRODUCTION

The upward trend in weapon systems costs in the recent past has led to increased emphasis being placed on low cost. It has become apparent that low cost should have as much emphasis as high performance. The basic rationale behind the "Design to Cost" philosophy is that there is a trade between cost and performance which must be considered during the early concept stages of a system development.

The study outlined in this report has been based on the premise that such a trade exists and must be considered if low cost production hardware is the goal.

Volume 1 of this report covers the development of missile performance and cost sensitivities to inlet design and fabrication parameters, trade studies, and selection of a preferred formed and welded titanium sheet metal design.

Volume 2 covers the development of fabrication methods for low cost production of inlets. One inlet was fabricated using materials and methods anticipated for production hardware, resulting in an inlet with internal features identical to the production design. In addition, a set of two inlets were built for use during freejet testing of the MRE propulsion system. These inlets were made of heavy plate steel and incorporated the close tolerances, smooth finishes and sharp corners typical of wind tunnel test inlets.

SUMMARY

Two close tolerance inlets were fabricated for use by NWC in free-jet testing of the MRE propulsion system. These inlets were made of heavy plate steel and incorporated the close tolerances, mirror finishes, razor sharp leading edges, and square corners typical of the earlier subscale models used for development of the inlet configuration. Figure 1 shows an overall view of these two inlets.

One inlet was built using materials and methods anticipated for the large scale production of flight weight inlets. Methods were developed for forming of the 5.1 mm (0.20 in.) thick titanium sheet metal to the required contours, welding of various formed sections to make up the basic inlet and finishing of leading edges and interface areas. This effort resulted in the hardware shown in Figure 2 which has internal features identical to the production design.

The results of this developmental effort were used to reevaluate the costs and weight of the production design. Several design changes were also recommended. Average production cost of the inlets was estimated to be \$3,390 per set, in mid 1974 dollars, based on a production quantity of 1000 sets. This figure compares favorably with the previous estimate of \$4,985 per set which was developed in phase I of this study for trade study purposes.

The weight of the production inlet was reestimated at 47.2 kg (104 lb.) compared to the previous estimate of 48.6 kg (107 lb.) used in the Phase I trade study.

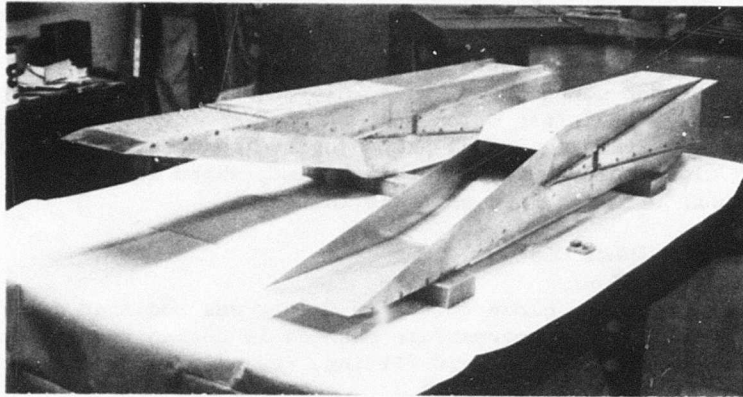


Figure 1: COMPLETED "CLOSE TOLERANCE" INLET HARDWARE.

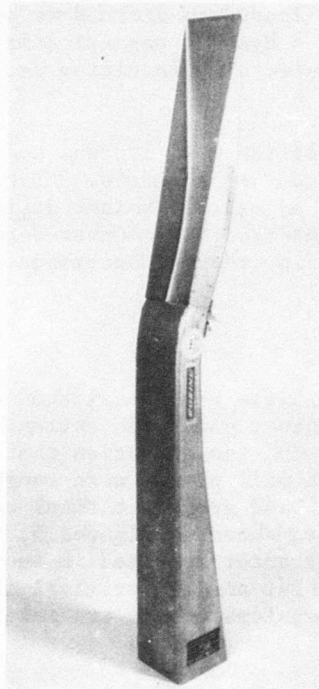


Figure 2: COMPLETED TITANIUM DUCT PORTION  
OF "PRODUCTION SIMULATION" INLET.

FABRICATION OF CLOSE TOLERANCE  
INLETS FOR FREEJET TEST

A set of inlets was fabricated for use by NWC/UTC in freejet testing of the MRE combustor. These inlets were built to Boeing drawing 180-54088. The inlets were built of 12.7 mm (1/2 in.) and 15.9 mm (5/8 in.) thick stainless steel plates bolted together at the corners of the duct. Close tolerances, smooth finishes, sharp leading edges and square corners were required on these inlets.

## CLOSE TOLERANCE INLET DESIGN

The design of the close tolerance inlets was modified prior to fabrication in order to accommodate changes in design requirements. Changes were made to the forward fitting, cowl lip, and diverter.

The forward attachment fitting was strengthened to withstand the increased tunnel unstart loads. Figure 3 shows the envelop of possible vertical loads applied to each inlet in the event of tunnel unstart. These loads are defined as being rapidly applied and, thus, require use of a dynamic magnification factor of 2 for purposes of structural analysis. The resulting revised inlet interface loads are shown in Figure 4.

The internal detail of the cowl lip was modified to match the detail of the subscale wind tunnel models. Also, the diverter was changed to a fixed rather than an adjustable height design upon receipt of a firm decision on diverter height from NWC. Other detail changes were made as the fabrication proceeded in order to accommodate vendor fabrication capabilities.

## FABRICATION METHODS

The close tolerance inlets were fabricated by Huntley Machine & Tool Co., Seattle, Washington, under subcontract to Boeing. Standard shop practices were used with the exception that the 12.7 mm (1/2 in.) thick stainless steel duct wall plates were rough formed by "chipping" on a brake press and then hand ground to final contour. Several views of the completed inlets are shown in Figures 5, 6 and 7. Excellent workmanship by the subcontractor resulted in smooth internal surface finishes throughout the inlet and all critical dimensions were within tolerances. Critical dimensions on the two inlets are summarized in Table 1.

Figure 8 shows the FMS probe and splitter installed in the inlet throat. The 15.9 mm (5/8 in.) diameter boss at the top of the splitter can be seen protruding into the airstream approximately 2.03 mm (0.08 in.). The splitter was designed and fabricated by UTC and

provided as GFE to Boeing for installation in the inlet. Detailed inspection of the splitter and review of the UTC drawing indicated this boss protrusion was within design tolerances. Boeing considered the protrusion into the airstream to be an undesirable condition. The inlets were shipped with the splitters installed and special note made of this condition.

"As Built" Drawings

"As built" drawings of the close tolerance inlets were prepared and are shown in Figure 9.

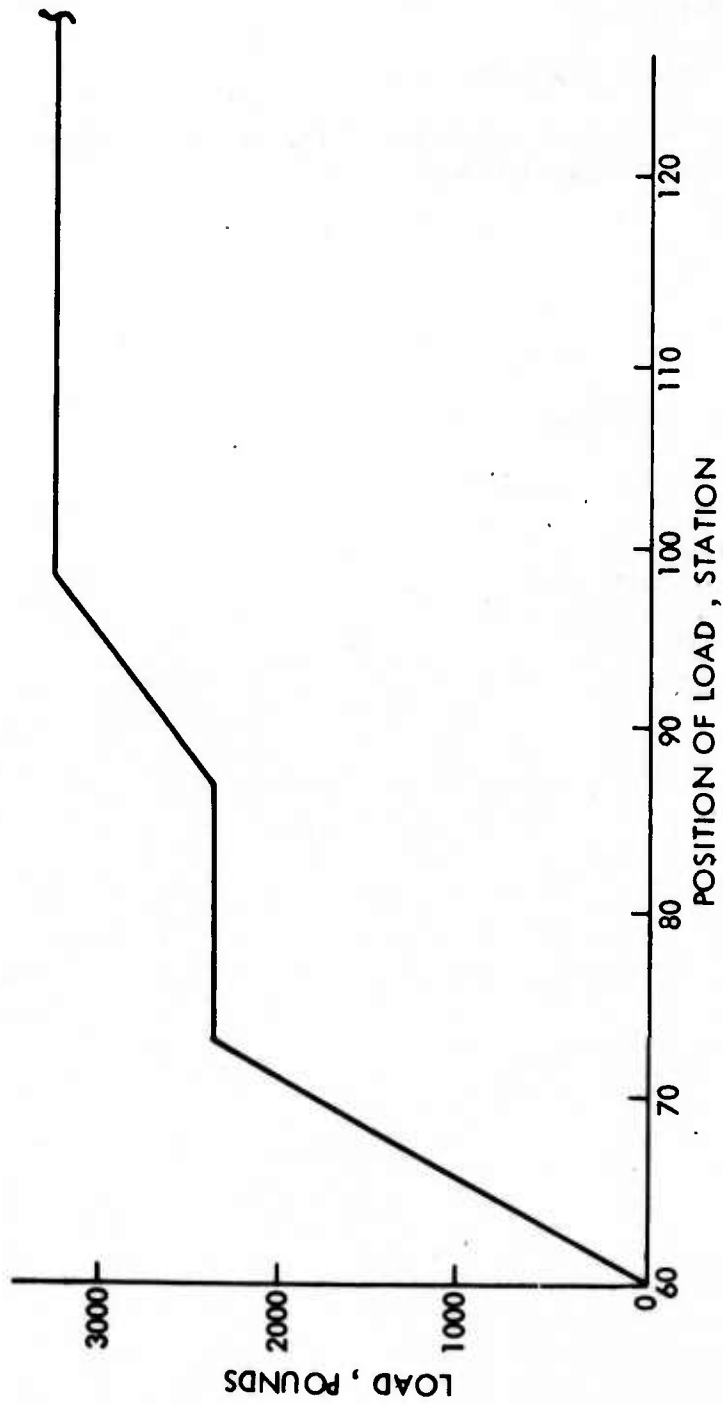


Figure 3 : MAXIMUM LOADS ON INLET FOR TUNNEL UNSTART.

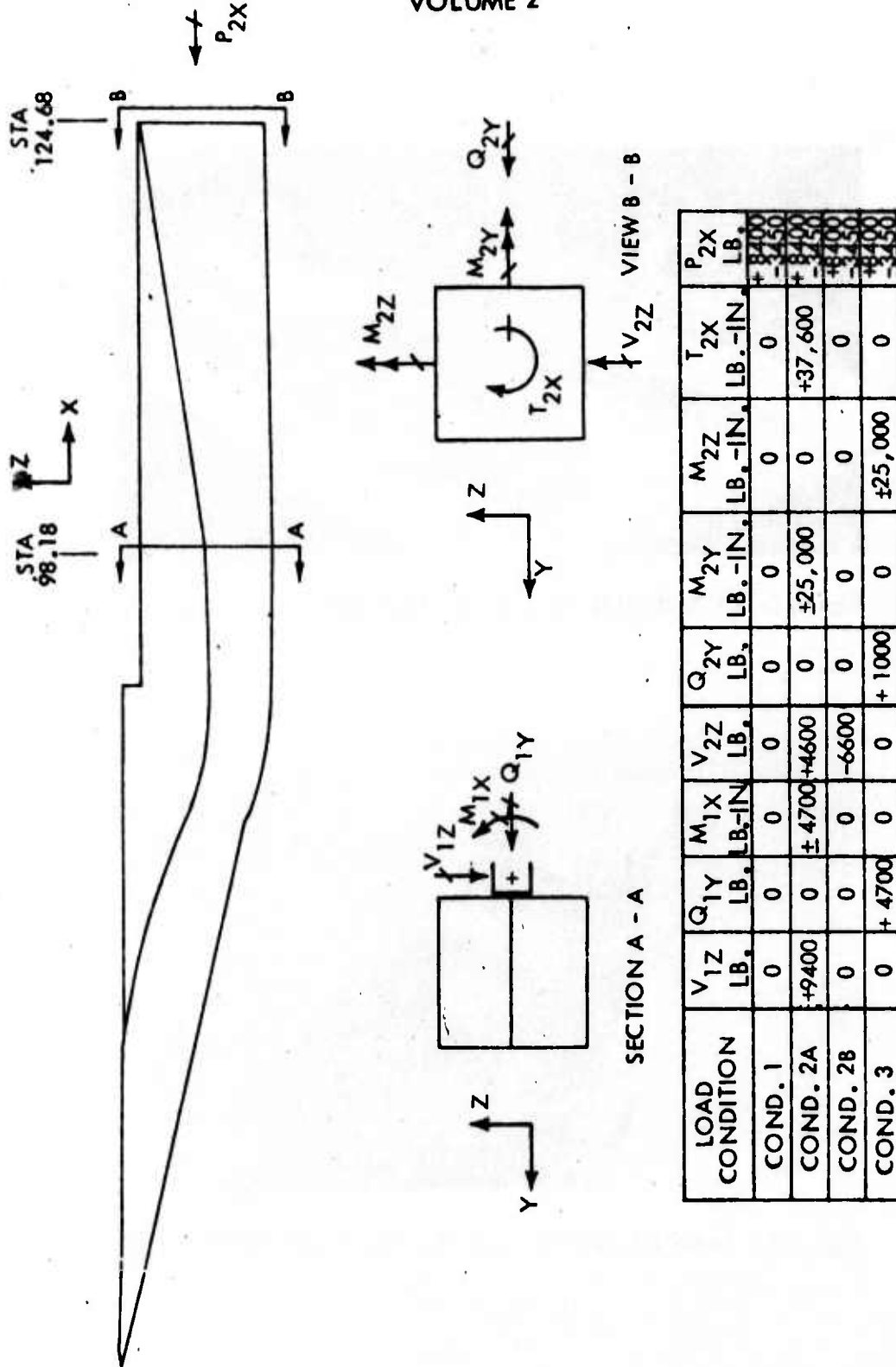


Figure 4 : REVISED INLET INTERFACE LOADS FOR FREEJET TEST DESIGN ONLY.

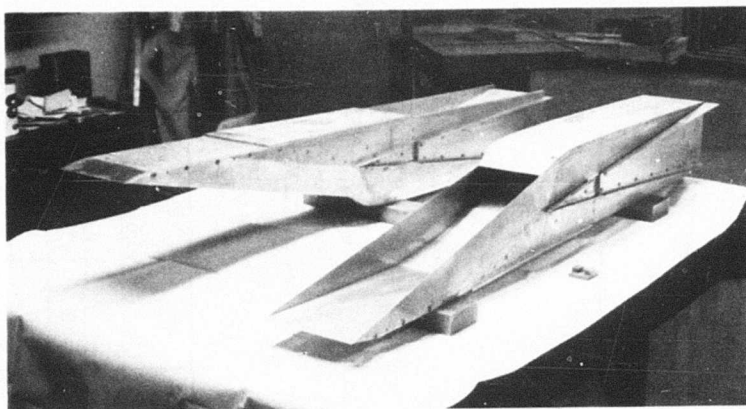


Figure 5: COMPLETED "CLOSE TOLERANCE" INLET HARDWARE.

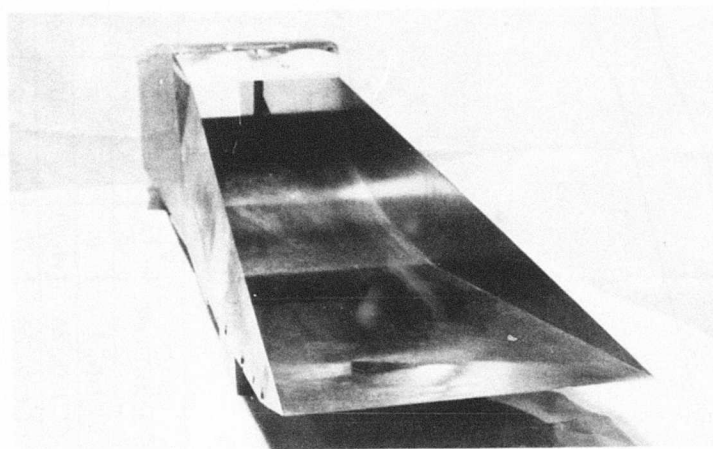


Figure 6: RAMP CONTOUR ON "CLOSE TOLERANCE" INLET.

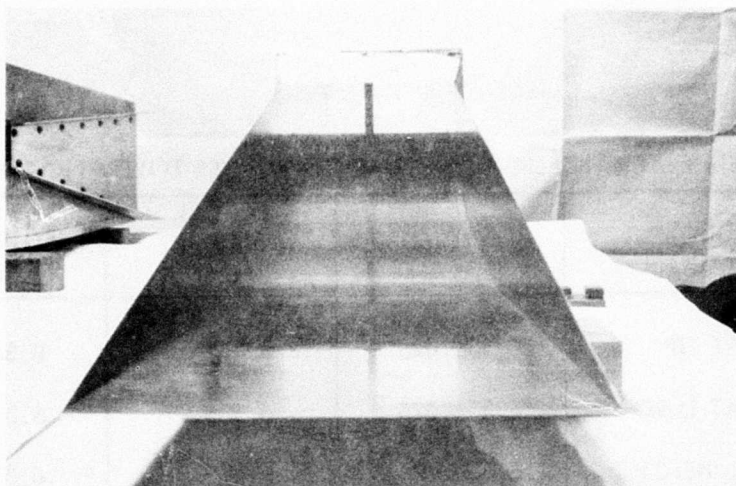


Figure 7 : FRONT END VIEW OF "CLOSE TOLERANCE" INLET.

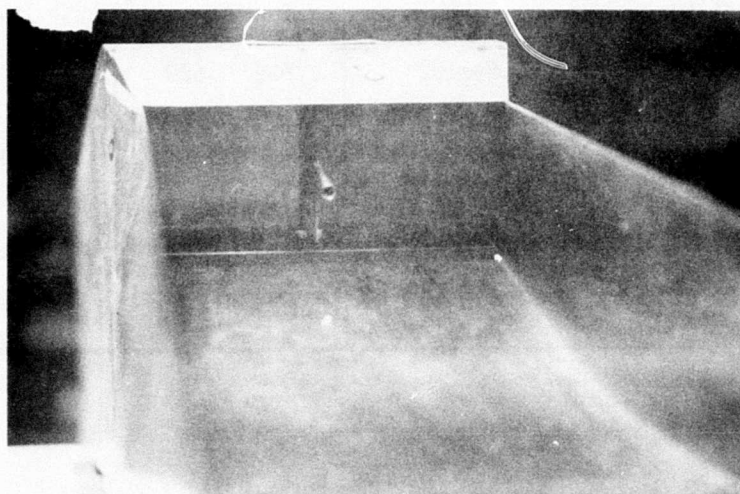


Figure 8 : FMS PROBE AND SPLITTER INSTALLATION IN  
"CLOSE TOLERANCE" INLET.

Table 1 : CRITICAL DIMENSIONS ON "CLOSE TOLERANCE" INLETS.

| CRITICAL DIMENSION              | DRAWING REQ'MT | ACTUAL LEFTHAND INLET | ACTUAL RIGHTHAND INLET |
|---------------------------------|----------------|-----------------------|------------------------|
| WIDTH AT TIP                    | 8.33±.025      | 8.355                 | 8.355                  |
| WIDTH AT THROAT                 | 6.33±.025      | 6.335                 | 6.330                  |
| CAPTURE HEIGHT                  | 6.33±.02       | 6.328                 | 6.310                  |
| RAMP ROUGHNESS                  | 32✓            | LESS THAN 32✓         | LESS THAN 32✓          |
| THROAT ROUGHNESS                | 64✓            | LESS THAN 32✓         | LESS THAN 32✓          |
| DIFFUSER ROUGHNESS              | 125✓           | LESS THAN 64✓         | LESS THAN 64✓          |
| BLEED VENTURI                   | 0.64±.02       | .638 - .620           | .627 - .620            |
| INTERNAL CONTOUR<br>RAMP & COWL | ±.015          | ±.015                 | ±.015                  |
| PROBE STRUT<br>ALIGNMENT TO C   | ±0.5 DEGREES   | ±0.25 DEGREES         | ±0.25 DEGREES          |
| TOTAL LENGTH                    | 64.88±.10      | 64.82                 | 64.83                  |





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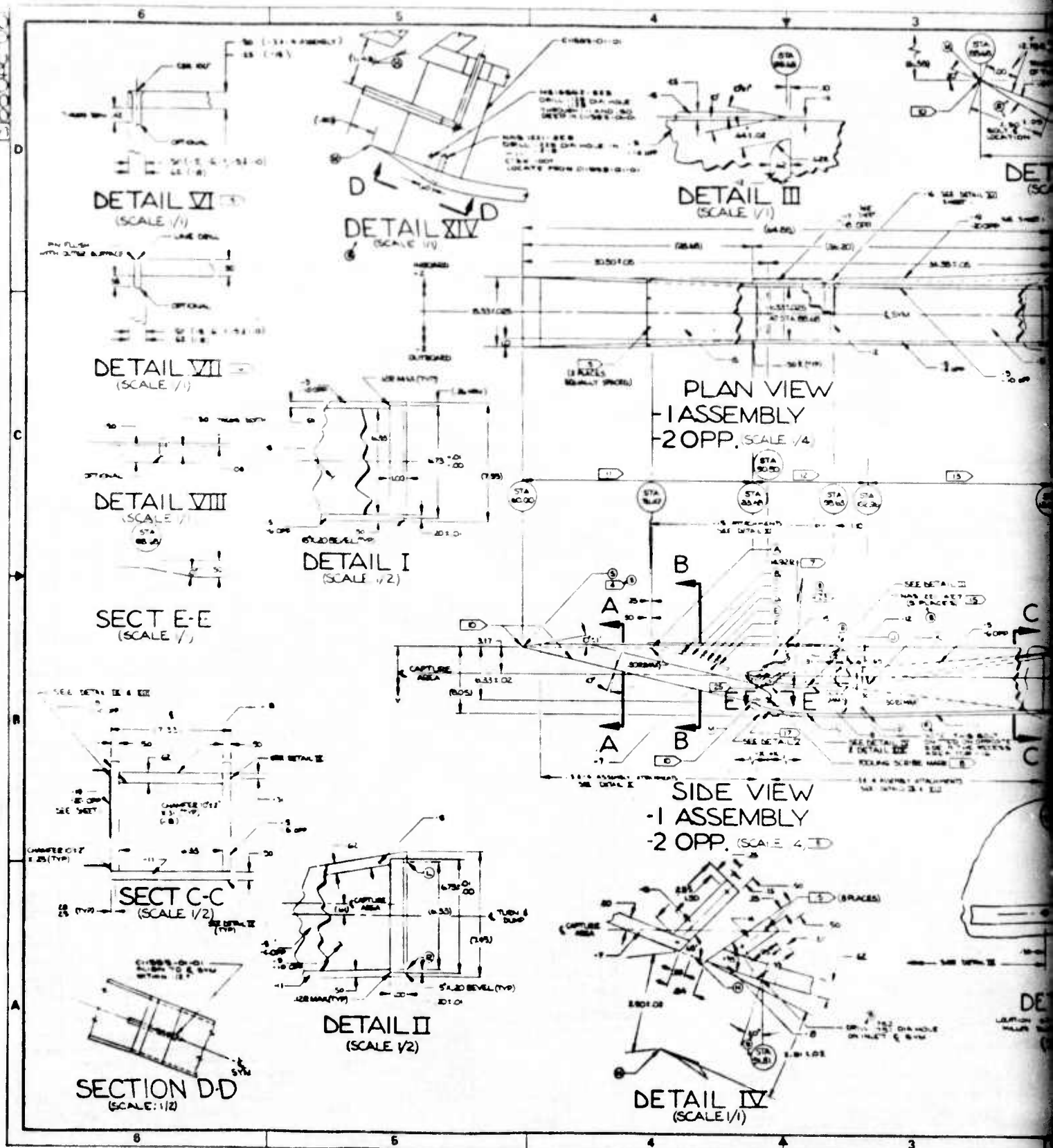
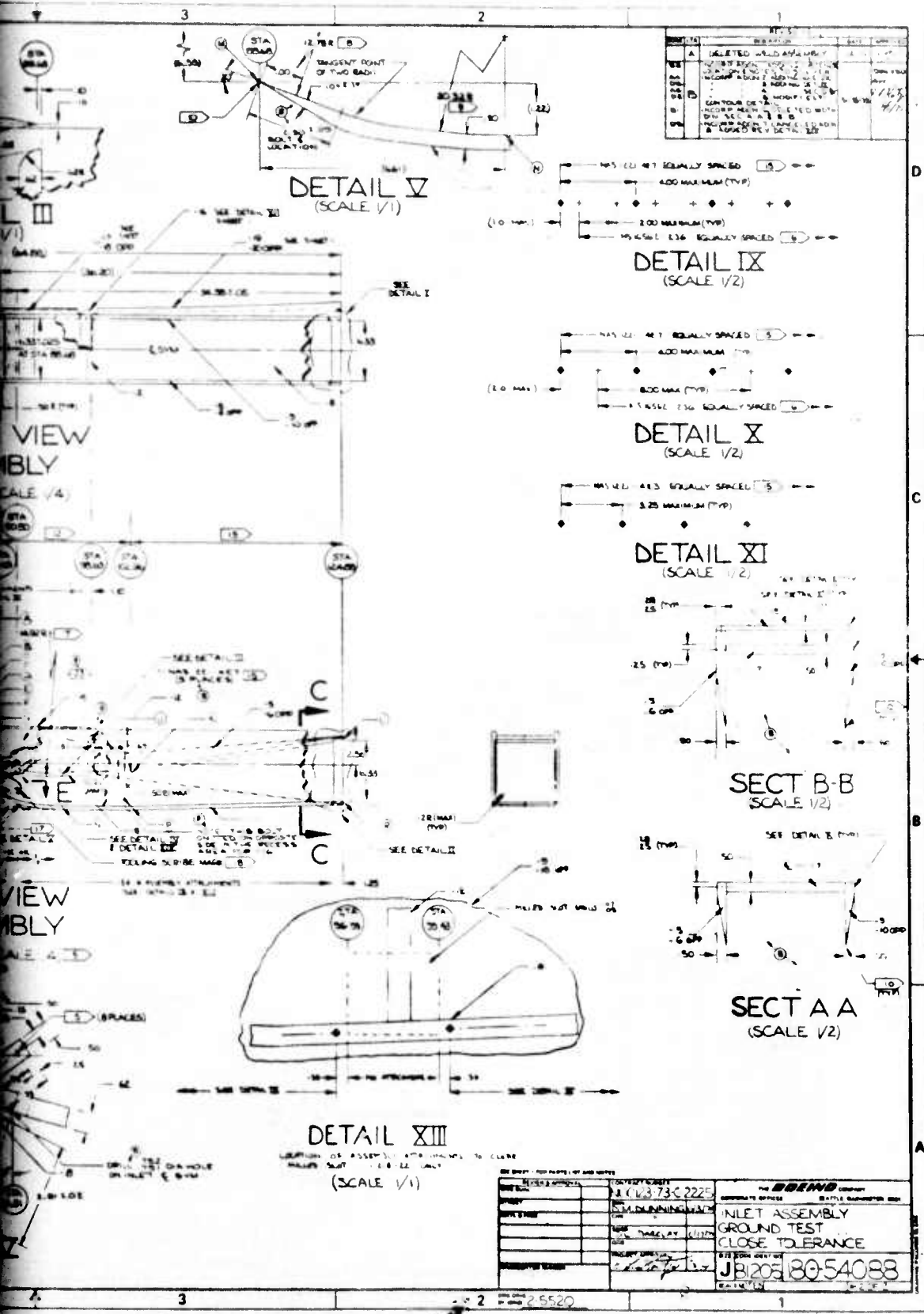
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Figure 9 : (CONTINUED).



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## FABRICATION OF "PRODUCTION SIMULATION" INLET

One left hand "production simulation" design inlet was fabricated in the Boeing shops. The objective of this effort was to develop and demonstrate production processes for fabrication of the basic duct portion of the inlet, and to complete the inlet to the extent necessary for demonstration of internal performance in a wind tunnel test. The inlet duct internal features and materials are identical to those selected for the "production" design. Duct material was 5.1 mm (0.2 in) thick 6Al-4V titanium sheet metal with "as formed" surface finishes.

## "PRODUCTION SIMULATION" INLET DESIGN

The design of the "production simulation" inlet per Boeing drawing 180-54087 was modified early in the Phase II effort in order to accommodate changes in design requirements. Specifically the requirement for freejet test was changed to wind tunnel test with attachment interfaces to be determined at a later date. The revised inlet design is shown in Figure 10. The design of the aft interface area was modified to a "blank" configuration and the diverter and forward fitting were deleted. In addition, the aft fairing was deleted and the forward fairing was changed to 4.57 mm (0.18 in) thick aluminum sheet metal.

The design of the basic duct portion was not changed except to relocate the longitudinal welds from the top and bottom duct walls to the side walls. This was done in order to make the formed parts easier to produce and simplify the welding.

Additional design changes were made during fabrication and are discussed in the following paragraphs.

## DEVELOPMENT OF FABRICATION METHODS

The fabrication was broken down into the four basic steps outlined in Figure 11. Step number 1 is trimming of 5.1 mm (0.20 in) thick 6Al-4V titanium sheet metal. Three sheets were required -- one each for the upper and lower halves of the duct and one for the pre-compression shroud. Step 2 is preforming the flat sheets into channel shapes. Step 3 is forming of the longitudinal contour of the three pieces. Step 4 is trimming and welding of the three pieces into the basic subassembly. Additional steps were required to finish machine the leading edge, bleed slot, and aft end details, and to add the bleed flare plates and bleed plenum to complete the inlet assembly.

The operation of preforming the flat sheets into a channel shape was accomplished by heating the coated titanium sheets to approximately 760°C (1400°F) and forming them over cold steel dies. The dies are shown in Figure 12. The formed metal was manually removed from the dies

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TABLE I  
DUCT GEOMETRY -3

| CONTINUOUS REFERENCE LETTER | COORDINATE | X    | Y |
|-----------------------------|------------|------|---|
| 1                           | -30.90     | 0    |   |
| 2                           | -14.00     | 0    |   |
| 3                           | -0.90      | 6.4  |   |
| 4                           | -5.31      | 8.7  |   |
| 5                           | -6.8       | 1.11 |   |
| 6                           | -7.10      | 1.90 |   |
| 7                           | -6.50      | 1.90 |   |
| 8                           | -5.0       | 1.20 |   |
| 9                           | -0.2       | 5.0  |   |
| 10                          | +4.70      | 4.82 |   |
| 11                          | +12.06     | 4.22 |   |
| 12                          | +34.50     | 4.1  |   |
| 13                          | -1.82      | 6.50 |   |
| 14                          | +6.75      | 1.50 |   |
| 15                          | +2.46      | 7.50 |   |
| 16                          | +34.50     | 6.70 |   |

DUCT INSIDE, UPPER SURFACE STRAIGHT BETWEEN ⑤-②, ③-④ (40° REF.), ⑤-④ (20° REF.), ⑥-④ (2° REF.), ⑥-④ (92° REF.).

DUCT INSIDE, LOWER SURFACE STRAIGHT BETWEEN ④-② AND ④-⑤ (9° REF.).

- 11 BLEND CHAMFER OVER THIS LENGTH
- 12 SURFACE FINISH  $\sqrt{17}$  UNLESS NOTED
- 13 FILL HOLES WITH 50% SILICA GEL CEMENT FILL OR EQUIVALENT. THIN LAYER BUT WASTE THIN
- 14 TACKLE HOLE LOCATION IS AT STATION 20.50 AND 6.50 FROM THE Y REFERENCE PLANE 11
- 15 PLUS AFTER REMOVING WITH  $R_{10}$  DIA. PIN HEAD SCREEN THREADED INTO DUCT WALL 12
- 16 DRILL 1/4"-11 DIA. HOLE AND C/P. 100% IN -10. THREAD 1/8"-20 UNF IN -10 FOR BACKLIFT SCREWS 11
- 17 DRILL 1/4"-11 DIA. HOLE HORIZONTAL TO CENTER LINE OF DUCT. 1/8" DIA. HOLE IN -10 FOR BACKLIFT SCREWS
- 18 DRILL 1/8"-11 DIA. HOLE IN -10 FOR 1/8" DIA. HOLE AND THREAD 1/8"-20 UNF IN -10 FOR 1/8" DIA. HOLE SCREWS 11
- 19 INTERNAL DUCT SURFACE MUST BE SMOOTH AND FREE FROM DISCONTINUITIES (PITS, BUBBLES, SCRATCHES, ETC)
- 20 MEASURE INTERNAL DUCT SURFACE FINISH AFTER REMOVING AND REPORT DATA TO ENGINEERING
- 21 AFTER COMPLETING FITUP OF -10 TO -12, REMOVE -10 AND PLUS THREADED HOLES IN -10 WITH 12
- 22 DRILL 1/8"-11 DIA. HOLE IN -10 FOR HOLE LINE FITTING. DRILL 1/8" DIA. HOLE IN -10 DEPT. MINIMUM. THREAD 1/8"-20 UNF IN -10 FOR 1/8" DIA. HOLE SCREWS 11
- 23 COMP. 8 SIDE WALLS TO 0.7 -10. 300000 CORNERS
- 24 MAXIMUM GAP 0.05
- 25 THE CORN. OF CHAMFER OVER THIS LENGTH TO MATCH CONVECTION THERM CHAMFER
- 26 BLEND CORN. OF CHAMFER OVER THIS LENGTH
- 27 BLEND LEADING EDGE OF -10 TO SUIT CONVECTION THERM CHAMFER
- 28 APT. EDGE OF -10 TO MATCH -12 CHAMFER BOUNDARY LINE
- 29 SHOWN AS REQUIRED

- 1 MATERIAL TYPE 304
- 2 MATERIAL 304-1/2
- 3 MATERIAL 304-1/2
- 4 MATERIAL 304-1/2
- 5 DUCT SECTION NOTE 1. THE TOLERANCE
- 6 0.00 TOLERANCE AT ALL POINTS
- 7 MAXIMUM INTERNAL
- 8 CONTOUR TANGENT
- 9 RADIUS 1/2
- 10 RADIUS 1/2
- 11 RADIUS 1/2
- 12 TO RADIUS
- 13 WELD, FILL
- 14 PENETRANT
- 15 STRESS
- 16 BLEND AT WITH

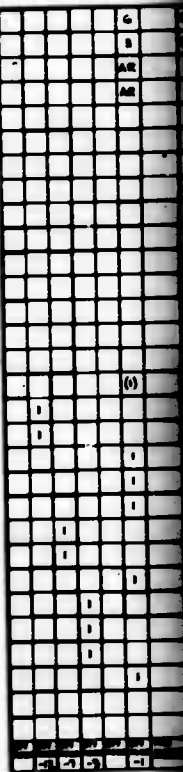
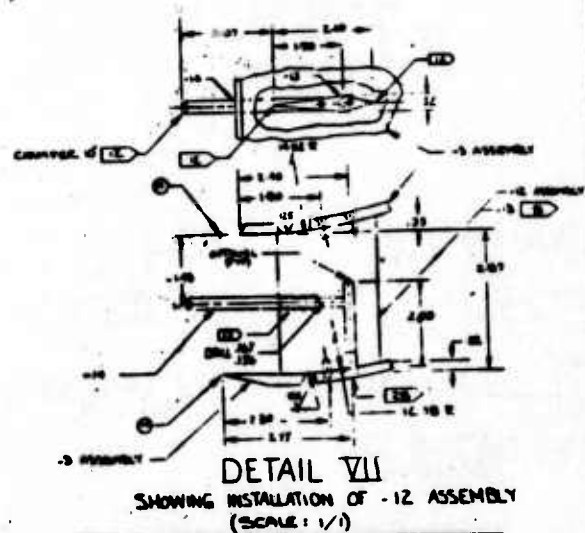
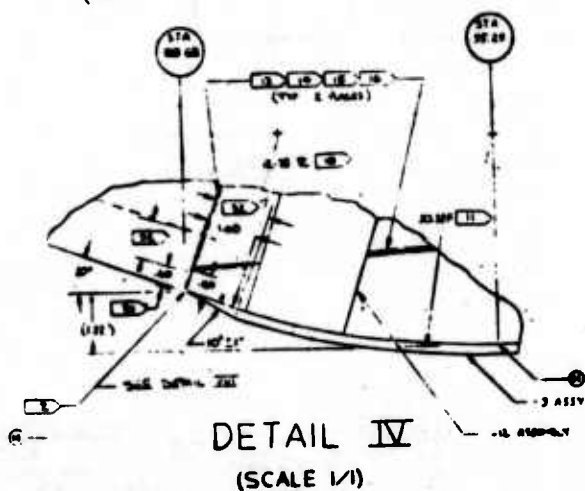
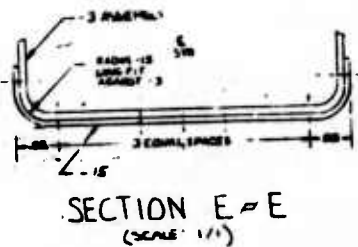
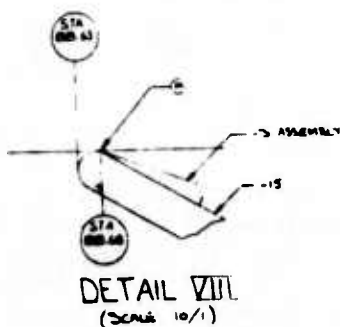
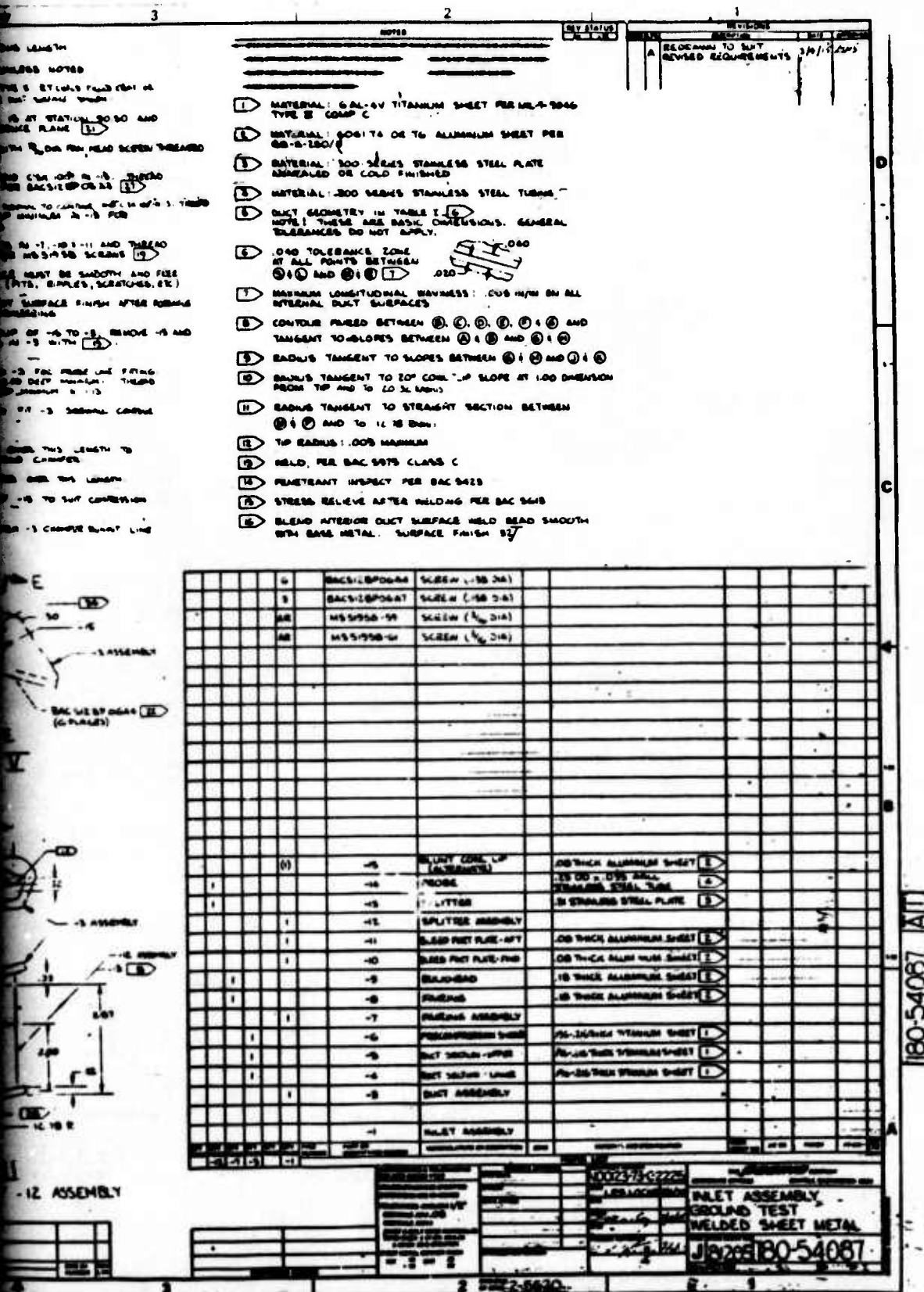
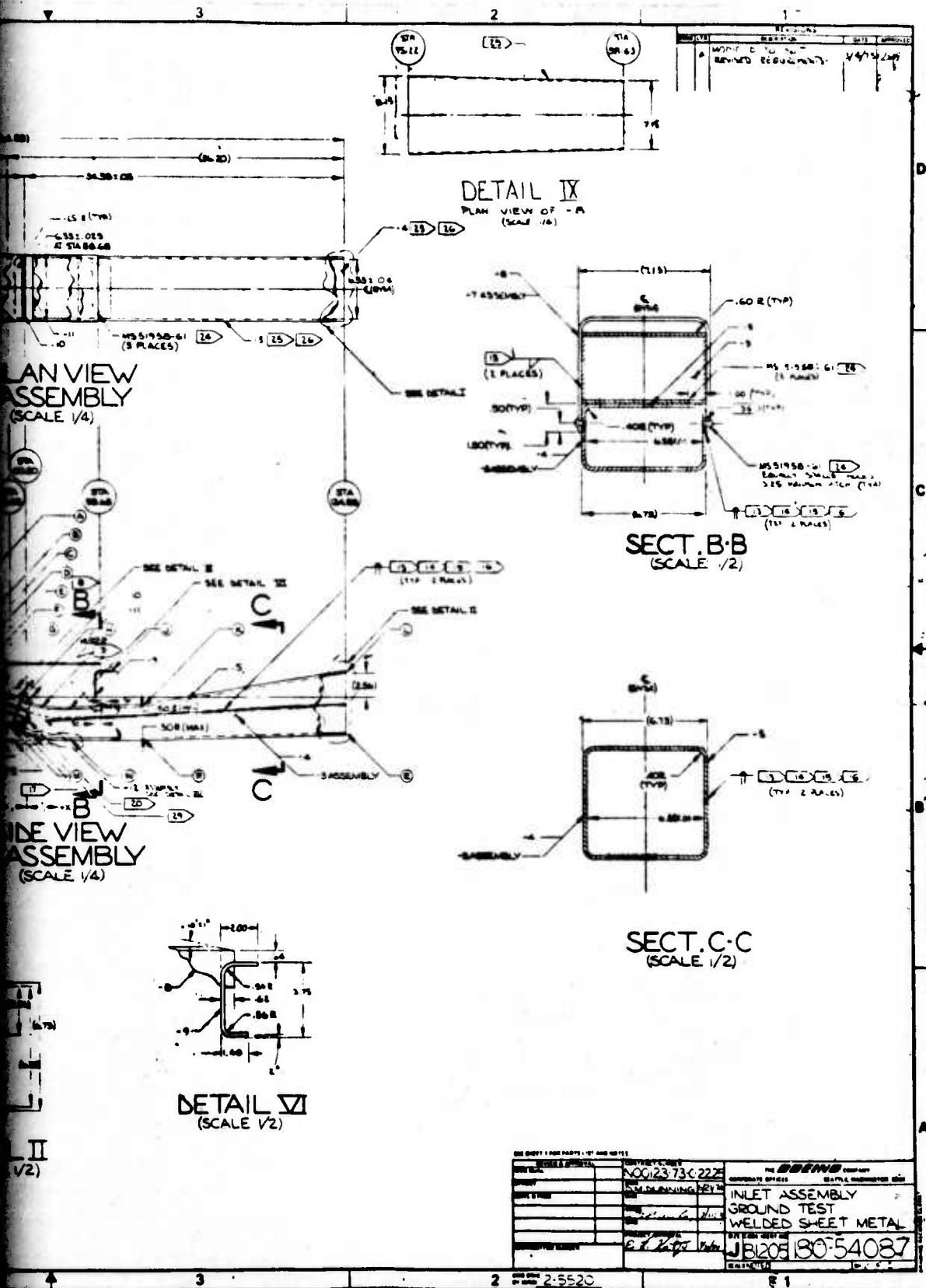


Figure 10: INL





**COPY AVAILABLE TO  
PERMIT FULLY LEGIBLE**



COPY AVAILABLE TO DDC DOES NOT  
PERMIT FULLY LEGIBLE PRODUCTION

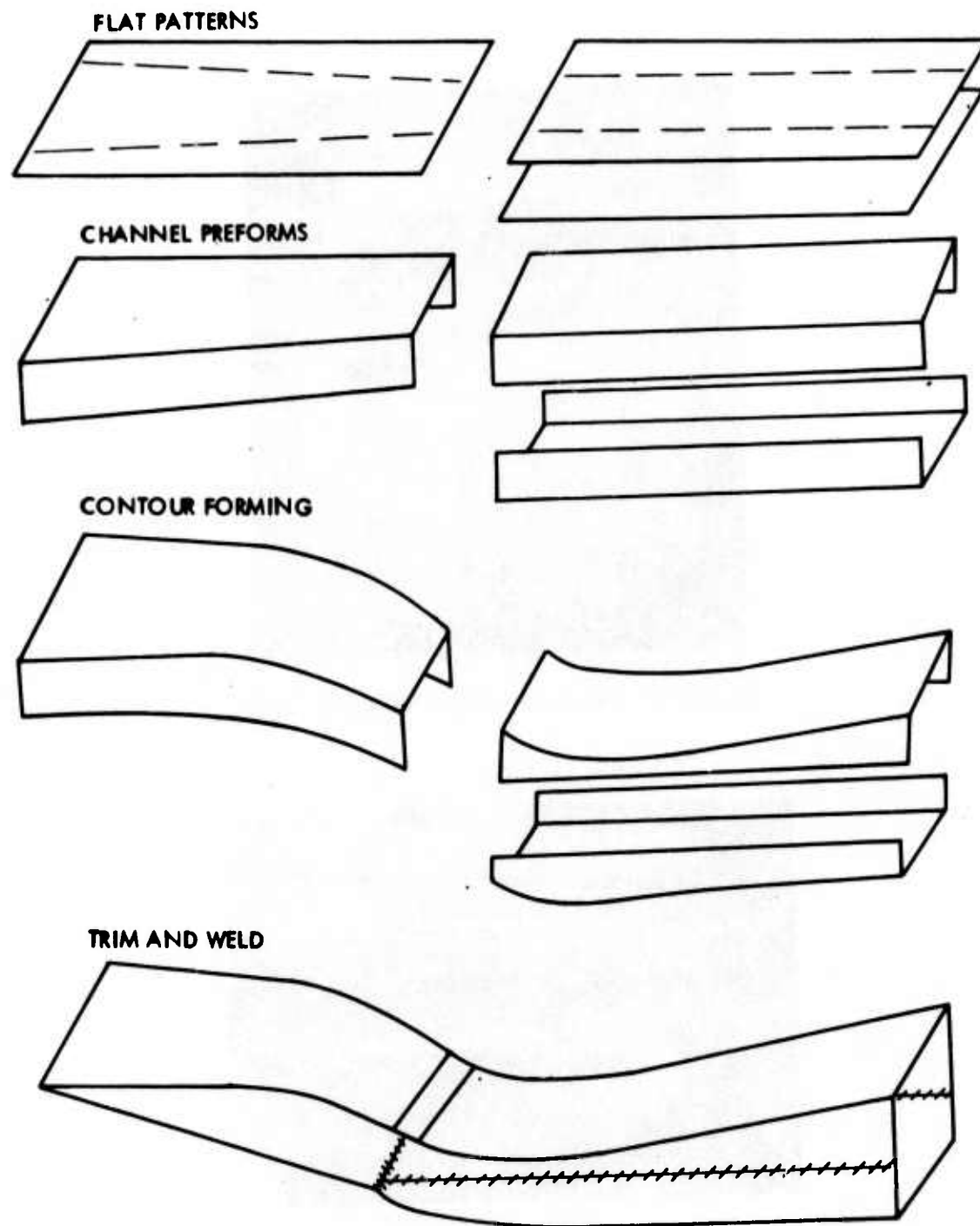


Figure 11 : BASIC FABRICATION STEPS -"PRODUCTION SIMULATION"  
INLET.

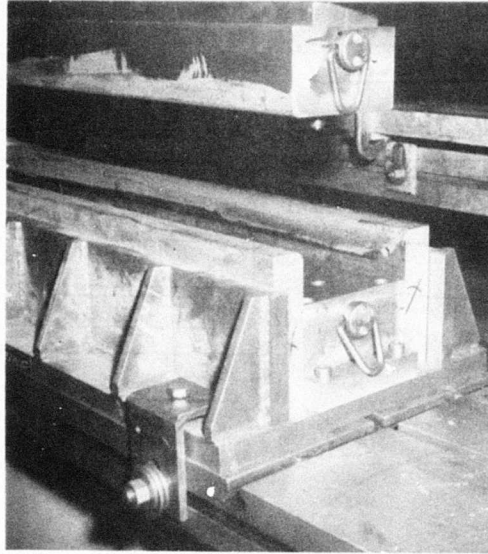


Figure 12: PREFORM DIES IN BRAKE PRESS.

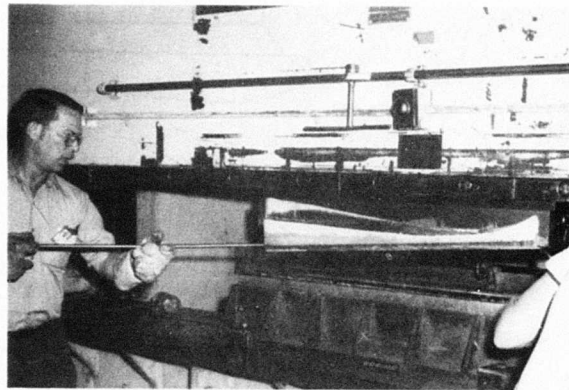


Figure 13: REMOVAL OF PREFORMED PART FROM DIES.

as shown in Figure 13. Figures 14 and 15 show the completed preforms of the three portions of the duct. The holes near the ends of the part were used to prevent slippage and misalignment of the metal during forming.

The longitudinal contour of each of the three pieces was formed in two stages. The first stage was similar to the preform operation using cold dies to form the part to approximate contour. The second stage used heated dies with both vertical and lateral pressure applied and with the part held under temperature and load for approximately 1/2 hour in order to allow creep of the metal to final contour. Figure 16 shows the precompression shroud after the first stage of the contour forming. Some compression buckling of the flange can be seen in the severely formed area of the part. The application of lateral pressure in the second stage removed these buckles and resulted in a part well within the  $\pm 0.5$  mm ( $\pm 0.02$  in.) contour tolerance and 0.005 mm/mm (0.005 in./in.) waviness tolerance originally required. Figures 17 and 18 show the upper half of the duct and the second stage contour dies. Figure 19 shows the part and dies in the hot sizing furnace and Figure 20 shows the completed part.

The subassembly of the two duct halves was done with a two pass external TIG weld. Preliminary tests were conducted on flat sheet metal specimens to develop the details of the weld preparation and welding procedure. Results of these preliminary tests showed a transverse weld shrinkage of approximately 0.5 mm (0.020 in.) was to be expected with weld underbead contour within  $\pm 0.25$  mm ( $\pm 0.010$  in.) of the base metal surface. Figure 21 shows the weld machine and Figure 22 is a view of the completed weld at the aft end of the duct.

The precompression shroud was welded to the duct portion using manual TIG welds and a weld fixture as shown in Figure 23. Three weld passes were used on this weld -- two external and one internal. The internal bead was then ground off to produce a smooth internal contour throughout the cowl lip and throat areas. The weld beads were left "as welded" in the subsonic diffuser portion of the inlet.

Final matching of the inlet details was accomplished using standard procedures for titanium machining with some hand grinding and filing in corner areas to avoid costly tooling. The design of the bleed slot area was modified slightly to add a removable 1.27 mm (0.050 in.) thick spacer at the aft edge of the slot. This feature will allow rapid modification of the bleed area during wind tunnel testing. This spacer plate can be seen in Figure 24 along with the FMS probe and splitter. The small holes in the sidewalls were tapped for attachment of the bleed plenum. These holes will be filled flush with the surface prior to wind tunnel testing. Figure 25 shows the detail of the leading edges on the cowl and precompression shroud. The curved intersection area of the cowl lip and shroud leading edge was found to be costly and difficult to machine. A modification of the design in this area should be considered in future designs.

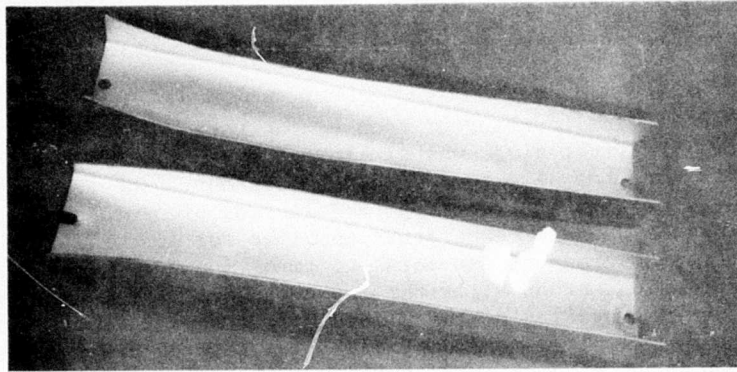


Figure 14: PREFORMS FOR UPPER AND LOWER DUCT HALVES.

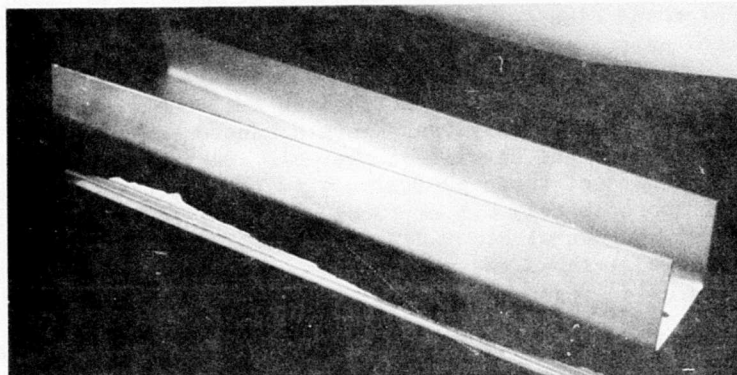


Figure 15: PREFORM FOR PRECOMPRESSION SHROUD.

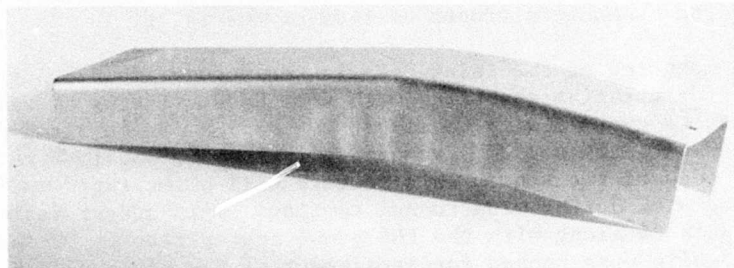


Figure 16: PRECOMPRESSION SHROUD AFTER FIRST STAGE OF CONTOUR FORMING.

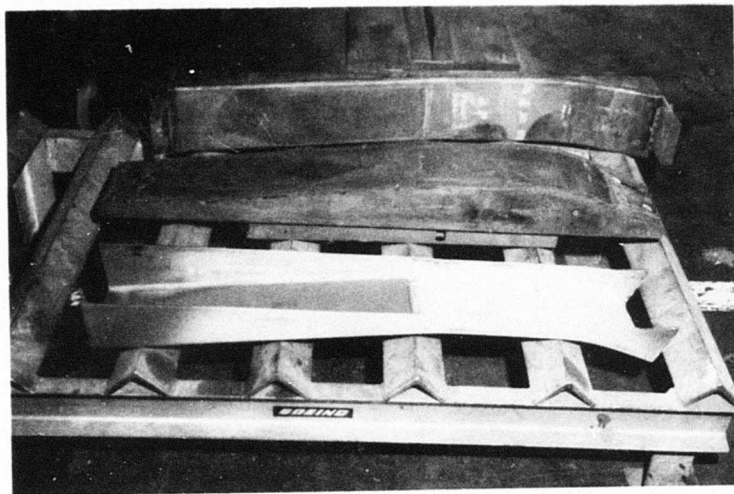


Figure 17: UPPER DUCT HALF WITH SECOND STAGE CONTOUR DIES.

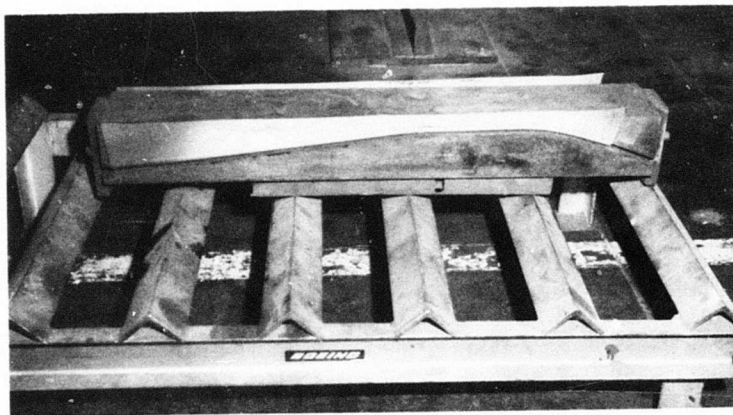


Figure 18: UPPER DUCT HALF LOADED INTO SECOND STAGE CONTOUR DIES.

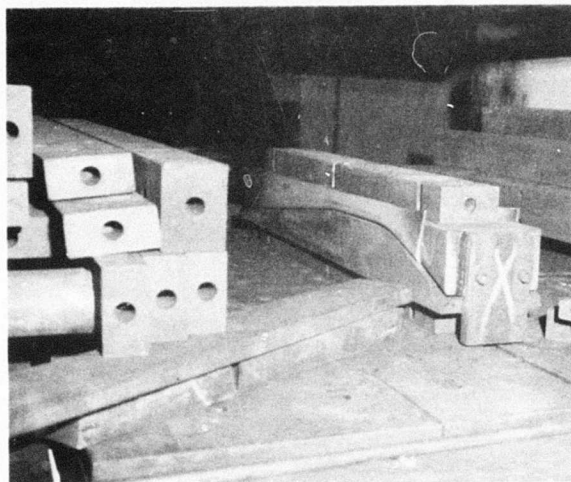


Figure 19 : UPPER DUCT HALF AND SECOND STAGE DIES  
IN HOT SIZING FURNACE.

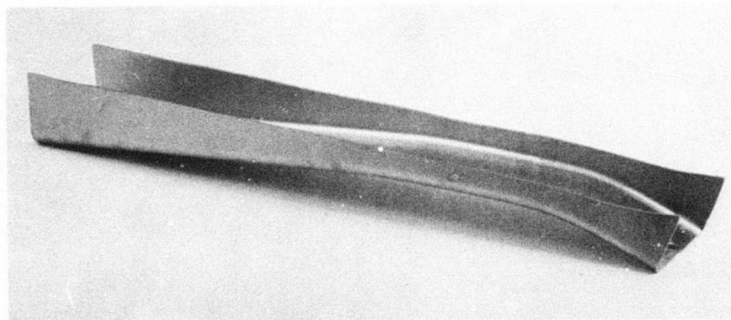


Figure 20: UPPER DUCT HALF AFTER SECOND STAGE CONTOUR FORMING.

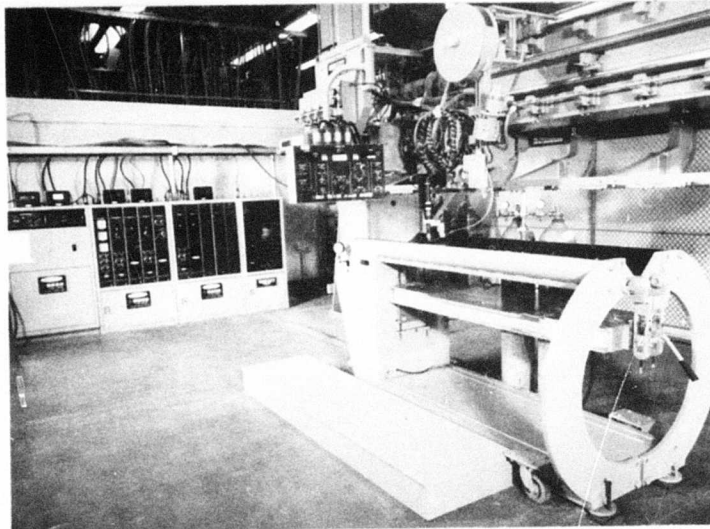


Figure 21 : AUTOMATIC TIG WELDER.

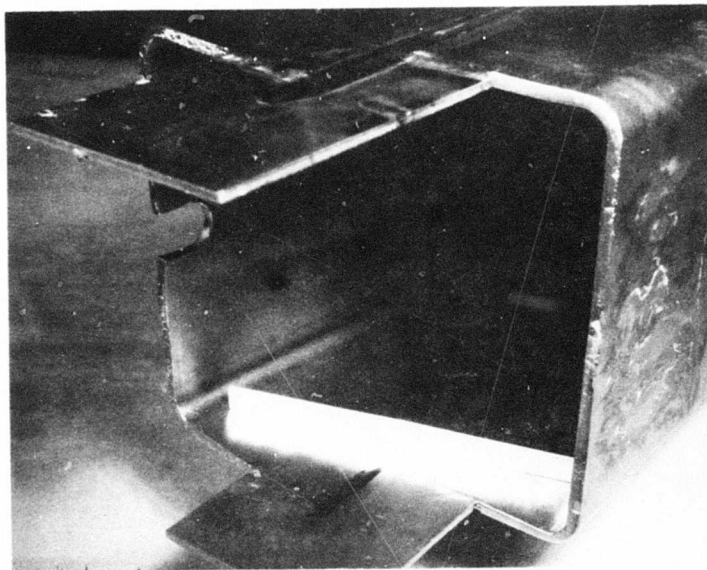


Figure 22 : COMPLETED WELD AT AFT END OF DUCT.

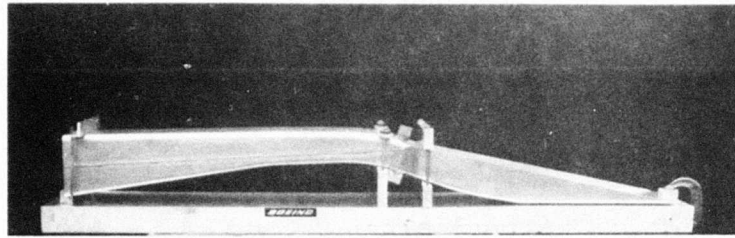


Figure 23: INLET WELDMENT SHOWING LONGITUDINAL WELD OF DUCT HALVES AND VERTICAL WELD OF PRECOMPRESSION SHROUD.

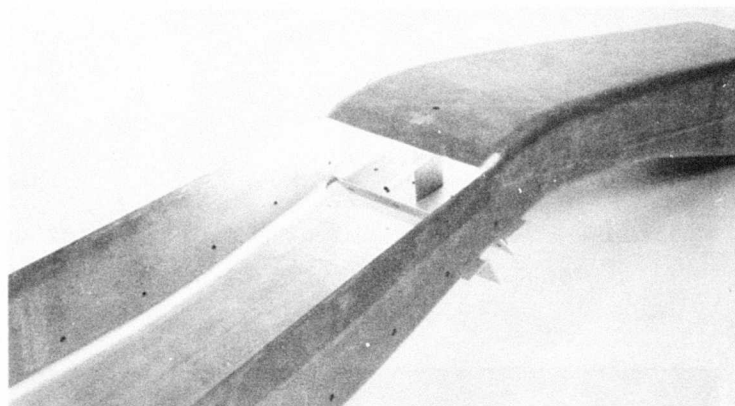


Figure 24: COMPLETED PART SHOWING COWL LIP, SPLITTER, AND BLEED SLOT DETAILS.

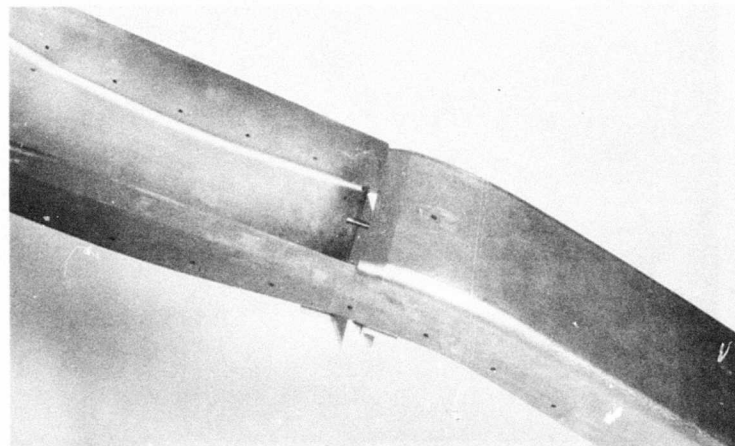


Figure 25: COMPLETED PART SHOWING LEADING EDGE DETAILS.

Figure 26 is an overall view of the completed titanium portion of the inlet. An aluminum bleed plenum was also constructed and added to complete the assembly. The aluminum plenum is for wind tunnel testing only and does not simulate production hardware except in terms of rough shape, location and flow exit venturi detail as shown in Figure 10.

The results of a detailed dimensional inspection of the completed inlet are shown in Figure 27. These results show that overall both duct height and width dimensions are within original tolerances, except for minor deviations.

Figure 28 shows the comparison of actual duct area with original requirements. The area variations are within original tolerances except at Station 95 where the area is 0.03% too large and at the exit (Station 124.88) where it is 0.64% too large. These minor deviations will have no measurable effect on either mass flow or pressure recovery of the inlet.

It should be noted that the dimensional variations of this part compared to the original nominal dimensions could be reduced by additional development efforts on the contours of the hot dies. The part to part variations to be expected on production parts is less than  $\pm 0.76$  mm ( $\pm 0.03$  in.) on all "as formed and welded" dimensions and  $\pm 0.25$  mm ( $\pm 0.01$  in.) on all machined dimensions.

Figure 29 and Table 2 show additional results of the detailed inspection. The capture area dimensions shown in Figure 29 are all within tolerance except for the width of the cowl lip. The capture area computed from these dimensions is well within the original required tolerances.

As shown in Table 2, the details of the bleed slot, bleed venturi, leading edge radii, ramp contours, wall waviness and splitter installation are all satisfactory. There was no requirement originally stated for internal surface roughness since the intent was to use the part in the "as formed" condition. The measured roughness values vary from 0.5 micron (20 microinches) to 2.8 microns (110 microinches) with the higher values only in local small areas in the subsonic diffuser. Roughnesses measured in the supersonic areas do not exceed 1.7 microns (65 microinches). The original requirement for smoothness of the weld beads - 0.8 micron (32 microinches) in the throat area was found to be very difficult and costly to achieve due to restricted access. The 1.3 micron (50 microinches) value actually attained is more representative of an optimum roughness for production hardware. The weld beads were left in the "as welded" condition aft of Station 98 for the same reason. The small protrusions and depressions of the longitudinal welds should have no measurable effect on the subsonic flow in this portion of the duct. Hand filing of the leading edges was found to be required to achieve the 0.13 mm (0.005 in.) radius requirement. Prior to hand filing, the edges varied from razor sharp to a 0.5 mm (0.02 in.) wide flat at the tip.

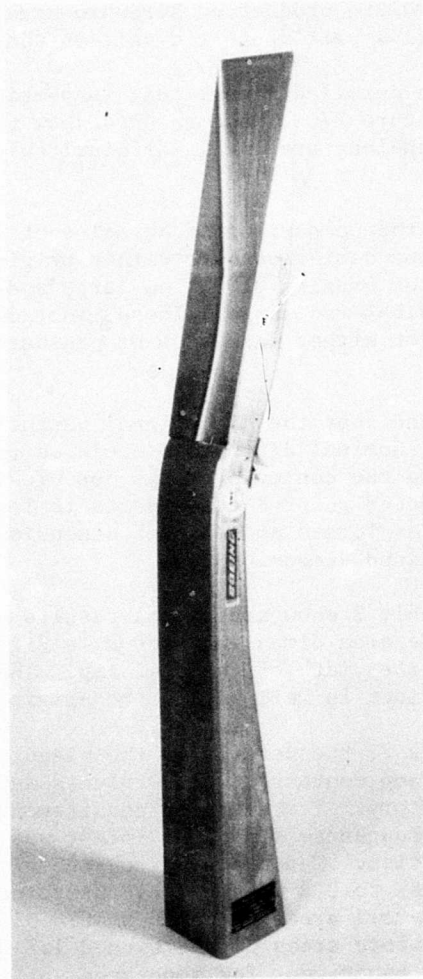


Figure 26 : COMPLETED TITANIUM DUCT PORTION OF  
"PRODUCTION SIMULATION" INLET.

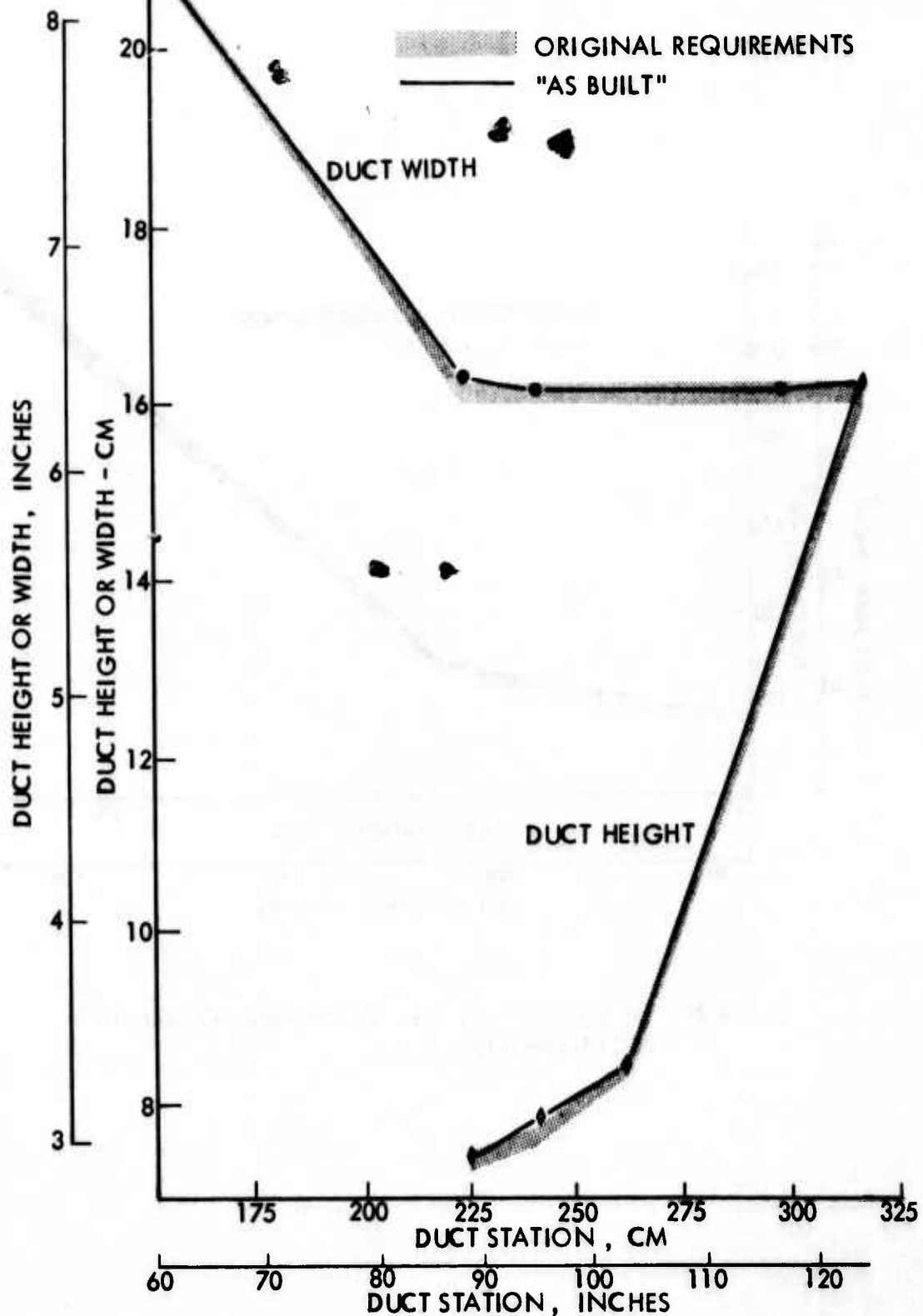


Figure 27: "AS BUILT" DUCT DIMENSIONS COMPARED TO ORIGINAL REQUIREMENTS.

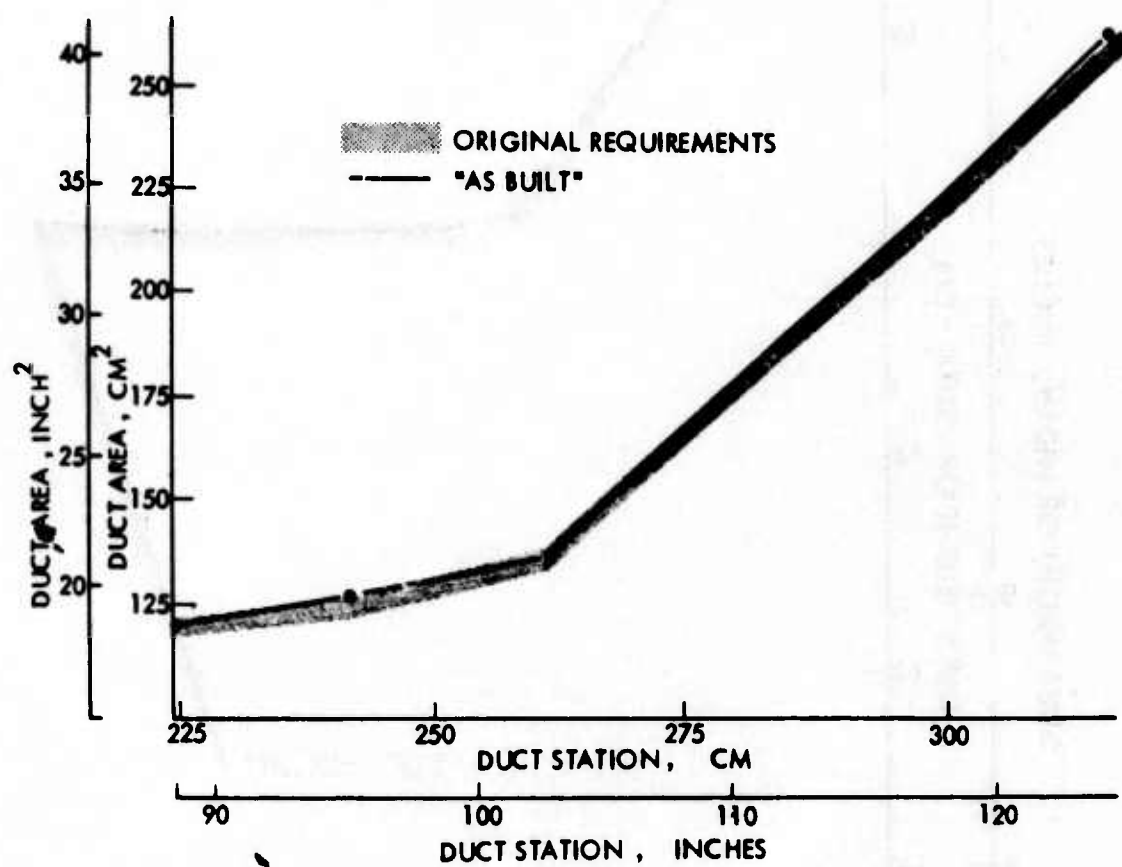
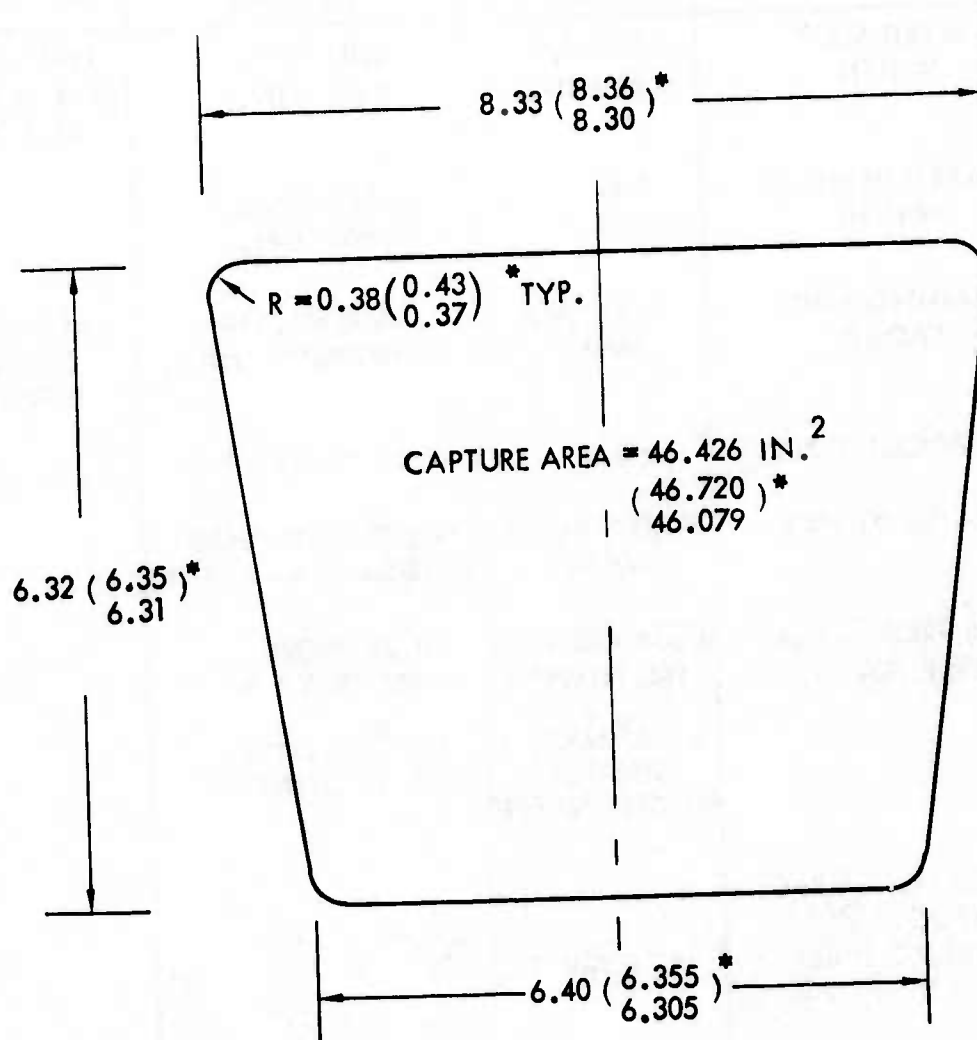


Figure 28: "AS BUILT" DUCT AREA COMPARED TO ORIGINAL REQUIREMENTS.



\* NUMBERS IN PARENTHESES ARE ORIGINAL REQUIREMENT DIMENSIONS. NUMBERS NOT IN PARENTHESES ARE "AS BUILT" DIMENSIONS.

Figure 29 : COMPARISON OF "AS BUILT" CAPTURE AREA DIMENSIONS WITH ORIGINAL REQUIREMENTS.

Table 2 : COMPARISON OF "AS BUILT" DETAILS  
WITH ORIGINAL REQUIREMENTS.

| ITEM                                                         | ORIGINAL REQUIREMENT                                                               | ACTUAL "AS BUILT"                                                                                                                         | COMMENTS                        |
|--------------------------------------------------------------|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------|
| BLEED SLOT WIDTH                                             | 0.87 MAX.<br>0.81 MIN.                                                             | 0.86 MAX.<br>0.84 MIN.                                                                                                                    | REMOVABLE SPACER ADDED FOR TEST |
| BLEED VENTURI HEIGHT                                         | 0.67<br>0.61                                                                       | 0.675 MAX.<br>0.660 MIN.                                                                                                                  |                                 |
| LEADING EDGE RADIUS                                          | 0.005 IN.<br>MAX.                                                                  | 0.005 IN. OR EQUIVALENT MAX.                                                                                                              | HAND FILING OF EDGE REQUIRED    |
| RAMP CONTOUR                                                 | $\pm 0.02$                                                                         | LESS THAN $\pm 0.02$                                                                                                                      |                                 |
| WALL WAVINESS                                                | $\pm 0.005$ IN./IN.<br>MAX.                                                        | NIL (EXCEPT WELD BEADS AFT OF STA 98)                                                                                                     |                                 |
| FMS PROBE AND SPLITTER                                       | 0.80 $\pm$ 0.03 PROBE PROTRUSION<br><br>$\pm 0.5^\circ$ MAX. SPLITTER MISALIGNMENT | 0.78 PROBE PROTRUSION<br><br>0.5 $^\circ$ SPLITTER MISALIGNMENT                                                                           |                                 |
| INTERNAL SURFACE ROUGHNESS (EXCEPT WELD BEADS AFT OF STA 98) | AS FORMED                                                                          | 20 $\sqrt{\text{ }}$ TO 65 $\sqrt{\text{ }}$ WITH 80 $\sqrt{\text{ }}$ & 110 $\sqrt{\text{ }}$ IN SEVERAL SMALL LOCAL AREAS AFT OF STA 98 |                                 |
| WELD BEAD ROUGHNESS                                          | 32 $\sqrt{\text{ }}$                                                               | 50 $\sqrt{\text{ }}$ FWD OF STA 98 AS WELDED AFT OF STA 98 WITH 0.01 MAX. PROTRUSION, DEPRESSION AND MISMATCH                             |                                 |

Hand filing of these edges is neither difficult nor costly as long as local increases in the external chamfer angle up to 15 degrees can be tolerated. This local increase will apply only to a 6.35 mm (0.25 in.) width adjacent to the tip as discussed in Section 5.2.

#### AS BUILT DRAWINGS

Figure 30 shows the "as built" configuration of the "production simulation" inlet. The intent of this drawing is to document the dimensions and details of the part in a convenient fashion for future use.

[illegible]

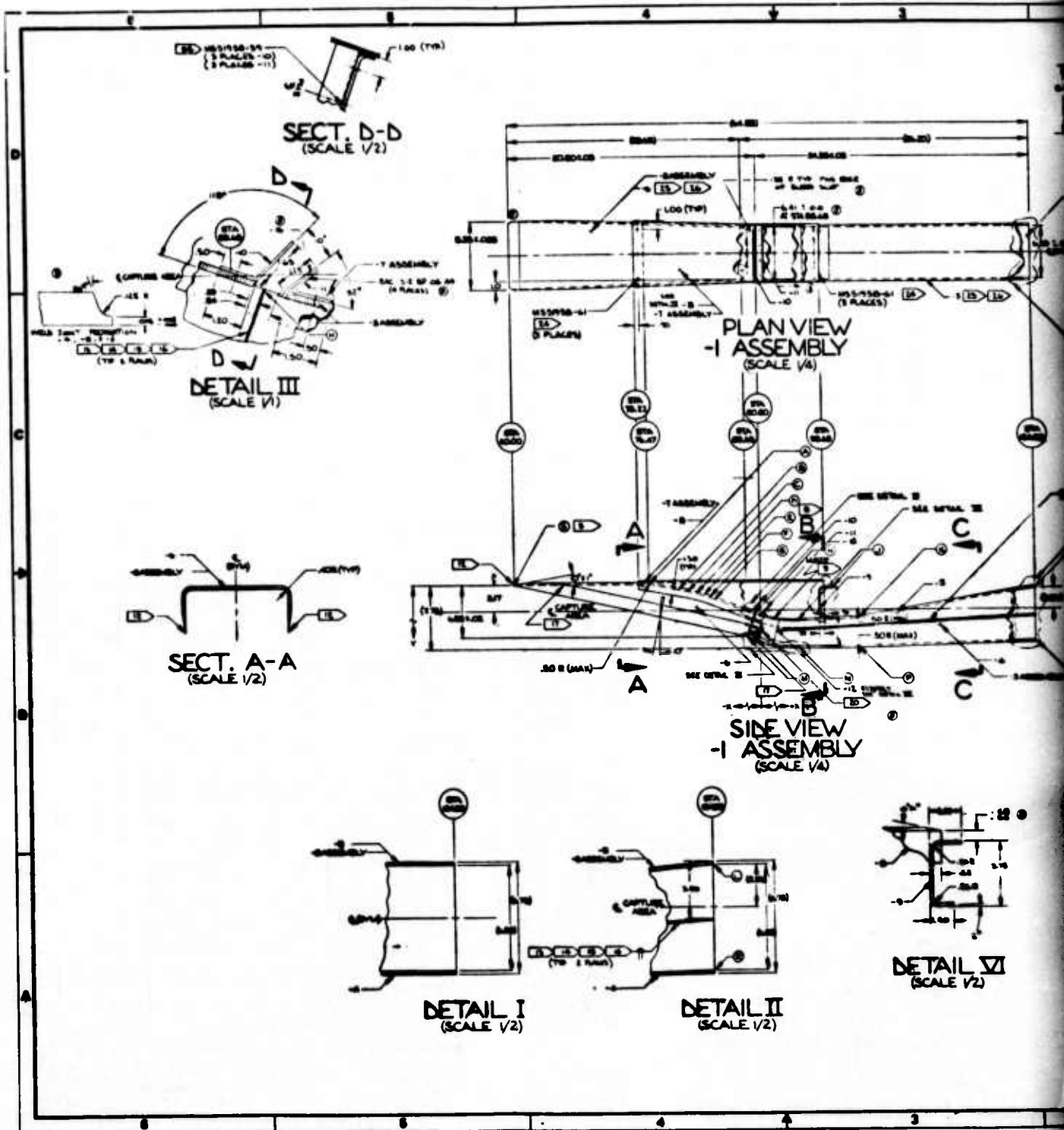
**Figure 30 : INLET ASSEMBLY GROUND TEST**

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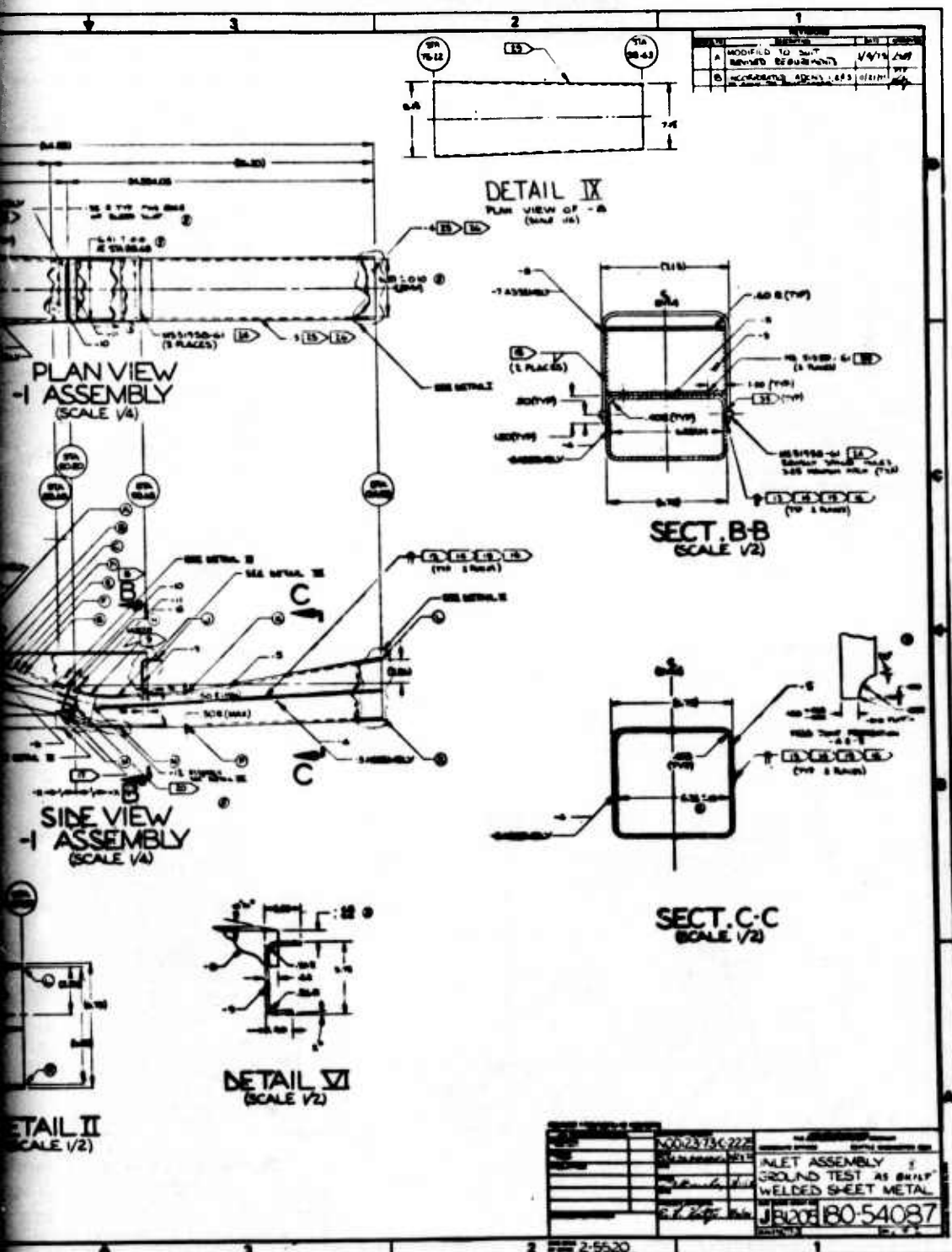
2

| 3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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| <p>1 MATERIAL: 6AL-4V TITANIUM SHEET PER MIL-2-2046 TYPE II COMP C</p> <p>2 MATERIAL: 6061-T6 ALUMINUM SHEET PER QQ-A-180/II</p> <p>3 MATERIAL: 300 SERIES STAINLESS STEEL PLATE ANNEALED OR COLD FINISHED</p> <p>4 MATERIAL: 300 SERIES STAINLESS STEEL TUBES</p> <p>5 DUCT GEOMETRY IN TABLE 1 NOTE: THESE ARE BASIC DIMENSIONS. GENERAL TOLERANCES DO NOT APPLY.</p> <p>6 .000 TOLERANCE LONG AT ALL POINTS BETWEEN ① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨ ⑩ ⑪ ⑫ ⑬ ⑭ ⑮ ⑯ ⑰ ⑱ ⑲ ⑳ ㉑ ㉒ ㉓ ㉔ ㉕ ㉖ ㉗ ㉘ ㉙ ㉚ ㉛ ㉜ ㉝ ㉞ ㉟ ㊱ ㊲ ㊳ ㊴ ㊵ ㊶ ㊷ ㊸ ㊹ ㊺ ㊻ ㊼ ㊽ ㊾ ㊿</p> <p>7 MAXIMUM LONGITUDINAL WAVINESS: .005 IN/IN ON ALL INTERNAL DUCT SURFACES</p> <p>8 CONTOUR ROUNDED BETWEEN ① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨ ⑩ ⑪ ⑫ ⑬ ⑭ ⑮ ⑯ ⑰ ⑱ ⑲ ⑳ ㉑ ㉒ ㉓ ㉔ ㉕ ㉖ ㉗ ㉘ ㉙ ㉚ ㉛ ㉜ ㉝ ㉞ ㉟ ㊱ ㊲ ㊳ ㊴ ㊵ ㊶ ㊷ ㊸ ㊹ ㊺ ㊻ ㊼ ㊽ ㊾ ㊿</p> <p>9 RADIUS TANGENT TO SLOPES BETWEEN ① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨ ⑩ ⑪ ⑫ ⑬ ⑭ ⑮ ⑯ ⑰ ⑱ ⑲ ⑳ ㉑ ㉒ ㉓ ㉔ ㉕ ㉖ ㉗ ㉘ ㉙ ㉚ ㉛ ㉜ ㉝ ㉞ ㉟ ㊱ ㊲ ㊳ ㊴ ㊵ ㊶ ㊷ ㊸ ㊹ ㊺ ㊻ ㊼ ㊽ ㊾ ㊿</p> <p>10 RADIUS TANGENT TO TOP CORN. OF SLOPE AT 100 DEGREE FROM TOP AND TO 20 DEGREE</p> <p>11 RADIUS TANGENT TO STRAIGHT SECTION BETWEEN ① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨ ⑩ ⑪ ⑫ ⑬ ⑭ ⑮ ⑯ ⑰ ⑱ ⑲ ⑳ ㉑ ㉒ ㉓ ㉔ ㉕ ㉖ ㉗ ㉘ ㉙ ㉚ ㉛ ㉜ ㉝ ㉞ ㉟ ㊱ ㊲ ㊳ ㊴ ㊵ ㊶ ㊷ ㊸ ㊹ ㊺ ㊻ ㊼ ㊽ ㊾ ㊿</p> <p>12 TOP CORNER RADIUS .5 IN. MINIMUM</p> <p>13 WELD PER SAC WELD CLASS, USE FILL METAL PER SAC WELD CLASS FOR WELDING OF TITANIUM</p> <p>14 PENETRANT INSPECT PER SAC 5412</p> <p>15 STRESS RELIEVE AFTER WELDING PER SAC 5645</p> <p>16 BLEND INTERIOR DUCT SURFACE WELD BEAD SMOOTH WITH BASE METAL ON WELDS FINISHED UP TO 90 DEGREE POINT ① ②</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| SAC 125000-15 | SCREW (.75 DIA) |  | 1 | SAC 125000-16 | SCREW (.75 DIA) |  | 1 | SAC 125000-17 | SCREW (.75 DIA) |  | 1 | SAC 125000-18 | SCREW (.75 DIA) |  | 1 | SAC 125000-19 | SCREW (.75 DIA) |  | 1 | SAC 125000-20 | SCREW (.75 DIA) |  | 1 | SAC 125000-21 | SCREW (.75 DIA) |  | 1 | SAC 125000-22 | SCREW (.75 DIA) |  | 1 | SAC 125000-23 | SCREW (.75 DIA) |  | 1 | SAC 125000-24 | SCREW (.75 DIA) |  | 1 | SAC 125000-25 | SCREW (.75 DIA) |  | 1 | SAC 125000-26 | SCREW (.75 DIA) |  | 1 | SAC 125000-27 | SCREW (.75 DIA) |  | 1 | SAC 125000-28 | SCREW (.75 DIA) |  | 1 | SAC 125000-29 | SCREW (.75 DIA) |  | 1 | SAC 125000-30 | SCREW (.75 DIA) |  | 1 | SAC 125000-31 | SCREW (.75 DIA) |  | 1 | SAC 125000-32 | SCREW (.75 DIA) |  | 1 | SAC 125000-33 | SCREW (.75 DIA) |  | 1 | SAC 125000-34 | SCREW (.75 DIA) |  | 1 | SAC 125000-35 | SCREW (.75 DIA) |  | 1 | SAC 125000-36 | SCREW (.75 DIA) |  | 1 | SAC 125000-37 | SCREW (.75 DIA) |  | 1 | SAC 125000-38 | SCREW (.75 DIA) |  | 1 | SAC 125000-39 | SCREW (.75 DIA) |  | 1 | SAC 125000-40 | SCREW (.75 DIA) |  | 1 | SAC 125000-41 | SCREW (.75 DIA) |  | 1 | SAC 125000-42 | SCREW (.75 DIA) |  | 1 | SAC 125000-43 | SCREW (.75 DIA) |  | 1 | SAC 125000-44 | SCREW (.75 DIA) |  | 1 | SAC 125000-45 | SCREW (.75 DIA) |  | 1 | SAC 125000-46 | SCREW (.75 DIA) |  | 1 | SAC 125000-47 | SCREW (.75 DIA) |  | 1 | SAC 125000-48 | SCREW (.75 DIA) |  | 1 | SAC 125000-49 | SCREW (.75 DIA) |  | 1 | SAC 125000-50 | SCREW (.75 DIA) |  | 1 | SAC 125000-51 | SCREW (.75 DIA) |  | 1 | SAC 125000-52 | SCREW (.75 DIA) |  | 1 | SAC 125000-53 | SCREW (.75 DIA) |  | 1 | SAC 125000-54 | SCREW (.75 DIA) |  | 1 | SAC 125000-55 | SCREW (.75 DIA) |  | 1 | SAC 125000-56 | SCREW (.75 DIA) |  | 1 | SAC 125000-57 | SCREW (.75 DIA) |  | 1 | SAC 125000-58 | SCREW (.75 DIA) |  | 1 | SAC 125000-59 | SCREW (.75 DIA) |  | 1 | SAC 125000-60 | SCREW (.75 DIA) |  | 1 | SAC 125000-61 | SCREW (.75 DIA) |  | 1 | SAC 125000-62 | SCREW (.75 DIA) |  | 1 | SAC 125000-63 | SCREW (.75 DIA) |  | 1 | SAC 125000-64 | SCREW (.75 DIA) |  | 1 | SAC 125000-65 | SCREW (.75 DIA) |  | 1 | SAC 125000-66 | SCREW (.75 DIA) |  | 1 | SAC 125000-67 | SCREW (.75 DIA) |  | 1 | SAC 125000-68 | SCREW (.75 DIA) |  | 1 | SAC 125000-69 | SCREW (.75 DIA) |  | 1 | SAC 125000-70 | SCREW (.75 DIA) |  | 1 | SAC 125000-71 | SCREW (.75 DIA) |  | 1 | SAC 125000-72 | SCREW (.75 DIA) |  | 1 | SAC 125000-73 | SCREW (.75 DIA) |  | 1 | SAC 125000-74 | SCREW (.75 DIA) |  | 1 | SAC 125000-75 | SCREW (.75 DIA) |  | 1 | SAC 125000-76 | SCREW (.75 DIA) |  | 1 | SAC 125000-77 | SCREW (.75 DIA) |  | 1 | SAC 125000-78 | SCREW (.75 DIA) |  | 1 | SAC 125000-79 | SCREW (.75 DIA) |  | 1 | SAC 125000-80 | SCREW (.75 DIA) |  | 1 | SAC 125000-81 | SCREW (.75 DIA) |  | 1 | SAC 125000-82 | SCREW (.75 DIA) |  | 1 | SAC 125000-83 | SCREW (.75 DIA) |  | 1 | SAC 125000-84 | SCREW (.75 DIA) |  | 1 | SAC 125000-85 | SCREW (.75 DIA) |  | 1 | SAC 125000-86 | SCREW (.75 DIA) |  | 1 | SAC 125000-87 | SCREW (.75 DIA) |  | 1 | SAC 125000-88 | SCREW (.75 DIA) |  | 1 | SAC 125000-89 | SCREW (.75 DIA) |  | 1 | SAC 125000-90 | SCREW (.75 DIA) |  | 1 | SAC 125000-91 | SCREW (.75 DIA) |  | 1 | SAC 125000-92 | SCREW (.75 DIA) |  | 1 | SAC 125000-93 | SCREW (.75 DIA) |  | 1 | SAC 125000-94 | SCREW (.75 DIA) |  | 1 | SAC 125000-95 | SCREW (.75 DIA) |  | 1 | SAC 125000-96 | SCREW (.75 DIA) |  | 1 | SAC 125000-97 | SCREW (.75 DIA) |  | 1 | SAC 125000-98 | SCREW (.75 DIA) |  | 1 | SAC 125000-99 | SCREW (.75 DIA) |  | 1 | SAC 125000-100 | SCREW (.75 DIA) |  |
| QTY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | DESCRIPTION    | UNIT            | REMARKS               |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000AT   | SCREW (.75 DIA) | OFFSHORE SAC 125000AT |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-01  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-02  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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              |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |  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                                                                                                                                                                                                                                         | SAC 125000-03  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-04  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-05  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-06  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-07  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-08  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-09  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-10  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-11  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-12  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-13  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-14  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-15  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-16  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-17  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-18  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-19  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-20  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-21  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-22  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-23  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-24  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-25  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-26  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-27  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-28  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-29  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-30  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-31  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-32  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-33  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-34  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-35  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-36  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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 |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |                |                 |  |
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                                                                                                                                                                                                                                         | SAC 125000-37  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-38  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-39  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-40  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-41  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-42  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-43  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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              |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |  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                                                                                                                                                                                                                                         | SAC 125000-44  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-45  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-46  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-47  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-48  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-49  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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              |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |  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 |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |                |                 |  |
| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-50  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-51  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-52  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-53  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-54  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-55  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-56  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-57  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-58  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-59  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-60  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-61  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-62  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-63  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-64  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-65  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-67  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-68  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-69  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-70  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-71  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-72  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-73  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-74  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-75  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-76  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-77  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-78  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-79  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-80  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-81  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-82  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-84  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-85  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-89  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-91  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-95  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-96  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-97  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-98  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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                                                                                                                                                                                                                                         | SAC 125000-99  | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SAC 125000-100 | SCREW (.75 DIA) |                       |   |  |     |             |      |         |   |              |                 |                       |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |         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| <p>17 SAC 125000-101</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>18 SAC 125000-102</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>19 SAC 125000-103</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>20 SAC 125000-104</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>21 SAC 125000-105</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>22 SAC 125000-106</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>23 SAC 125000-107</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>24 SAC 125000-108</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>25 SAC 125000-109</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>26 SAC 125000-110</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>27 SAC 125000-111</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>28 SAC 125000-112</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>29 SAC 125000-113</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>30 SAC 125000-114</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>31 SAC 125000-115</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>32 SAC 125000-116</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>33 SAC 125000-117</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>34 SAC 125000-118</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>35 SAC 125000-119</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>36 SAC 125000-120</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>37 SAC 125000-121</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>38 SAC 125000-122</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>39 SAC 125000-123</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>40 SAC 125000-124</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>41 SAC 125000-125</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>42 SAC 125000-126</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>43 SAC 125000-127</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>44 SAC 125000-128</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>45 SAC 125000-129</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>46 SAC 125000-130</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>47 SAC 125000-131</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>48 SAC 125000-132</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>49 SAC 125000-133</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>50 SAC 125000-134</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>51 SAC 125000-135</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>52 SAC 125000-136</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>53 SAC 125000-137</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>54 SAC 125000-138</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>55 SAC 125000-139</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>56 SAC 125000-140</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>57 SAC 125000-141</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>58 SAC 125000-142</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>59 SAC 125000-143</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>60 SAC 125000-144</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>61 SAC 125000-145</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>62 SAC 125000-146</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>63 SAC 125000-147</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>64 SAC 125000-148</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>65 SAC 125000-149</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>66 SAC 125000-150</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>67 SAC 125000-151</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>68 SAC 125000-152</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>69 SAC 125000-153</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>70 SAC 125000-154</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>71 SAC 125000-155</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>72 SAC 125000-156</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>73 SAC 125000-157</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>74 SAC 125000-158</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>75 SAC 125000-159</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>76 SAC 125000-160</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>77 SAC 125000-161</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>78 SAC 125000-162</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>79 SAC 125000-163</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>80 SAC 125000-164</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>81 SAC 125000-165</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>82 SAC 125000-166</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>83 SAC 125000-167</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>84 SAC 125000-168</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>85 SAC 125000-169</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>86 SAC 125000-170</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>87 SAC 125000-171</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>88 SAC 125000-172</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>89 SAC 125000-173</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>90 SAC 125000-174</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>91 SAC 125000-175</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>92 SAC 125000-176</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>93 SAC 125000-177</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>94 SAC 125000-178</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>95 SAC 125000-179</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>96 SAC 125000-180</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>97 SAC 125000-181</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>98 SAC 125000-182</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>99 SAC 125000-183</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| <p>100 SAC 125000-184</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>101 SAC 125000-185</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>102 SAC 125000-186</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>103 SAC 125000-187</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>104 SAC 125000-188</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>105 SAC 125000-189</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>106 SAC 125000-190</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>107 SAC 125000-191</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>108 SAC 125000-192</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>109 SAC 125000-193</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>110 SAC 125000-194</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>111 SAC 125000-195</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>112 SAC 125000-196</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>113 SAC 125000-197</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| <p>114 SAC 125000-198</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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              |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |  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| <p>115 SAC 125000-199</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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              |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |  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 |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |                |                 |  |
| <p>116 SAC 125000-200</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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              |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |                 |  |   |               |  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| 117 SAC 125000-201 | | | | | |
| 118 SAC 125000-202 | | | | | |
| 119 SAC 125000-203 | | | | | |
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| 197 SAC 125000-281 | | | | | |
| 198 SAC 125000-2 | | | | | |



**Figure 30 : (CONTINUED).**



COPY AVAILABLE TO DDC DOES NOT  
PERMIT FULLY LEGIBLE PRODUCTION

## REEVALUATION OF PRODUCTION DESIGN

As a result of the developmental efforts described previously a re-evaluation of the production design was conducted. Several recommended design changes were developed and revised production cost and weight estimates were made.

## PRODUCTION DESIGN

Figure 32 shows the key features of the production design developed in Phase I of this study per Boeing drawing 180-54089 (see NWCTP 5705, Volume 1).

## RECOMMENDED CHANGES TO THE PRODUCTION DESIGN

Several recommended design changes were developed to further reduce production costs without significant reduction in inlet or missile performance.

The welds specified on the drawing should have optional locations to allow fabrication of the upper half of the duct and the precompression shroud from a single sheet, as shown in Figure 31.

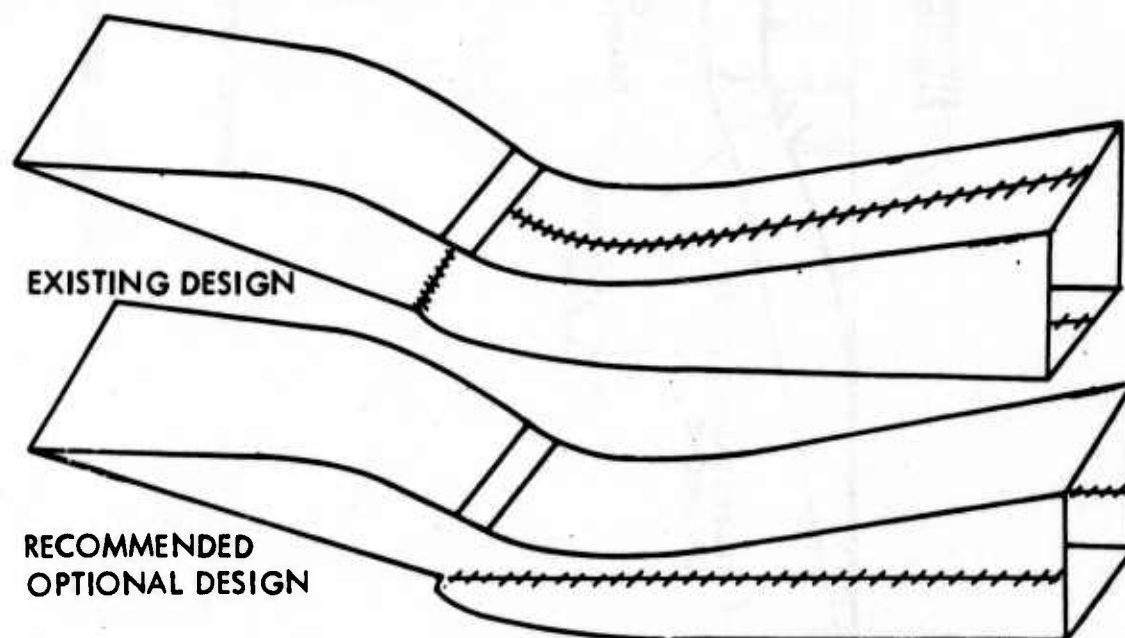


Figure 31: RECOMMENDED MODIFICATION TO WELDMENT DETAIL DESIGN

The cowl lip area detail should be modified to simplify the intersection of the precompression shroud sidewalls with the cowl lip as shown in Figure 33.

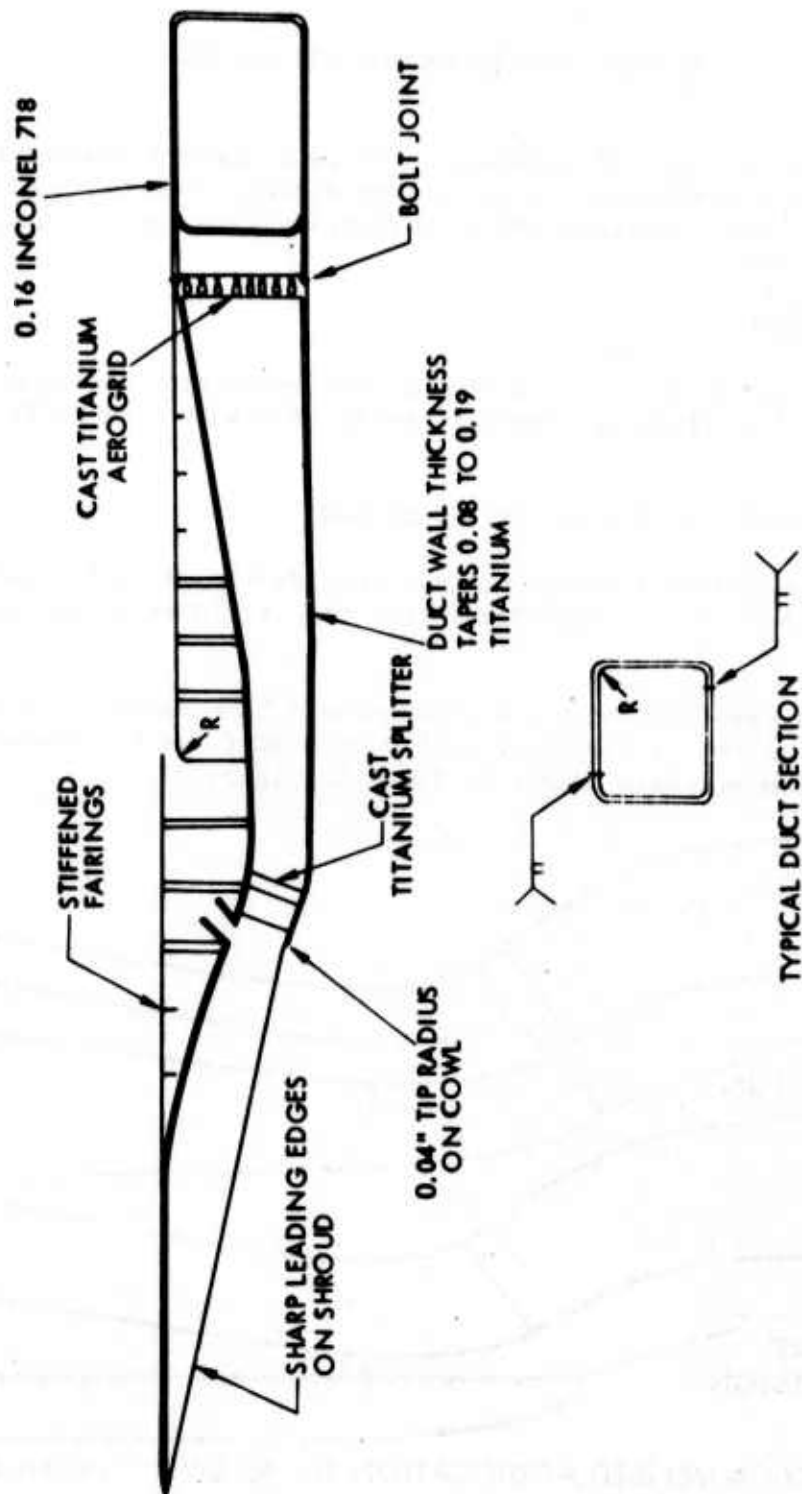


Figure 32 : FINAL DESIGN FEATURES.

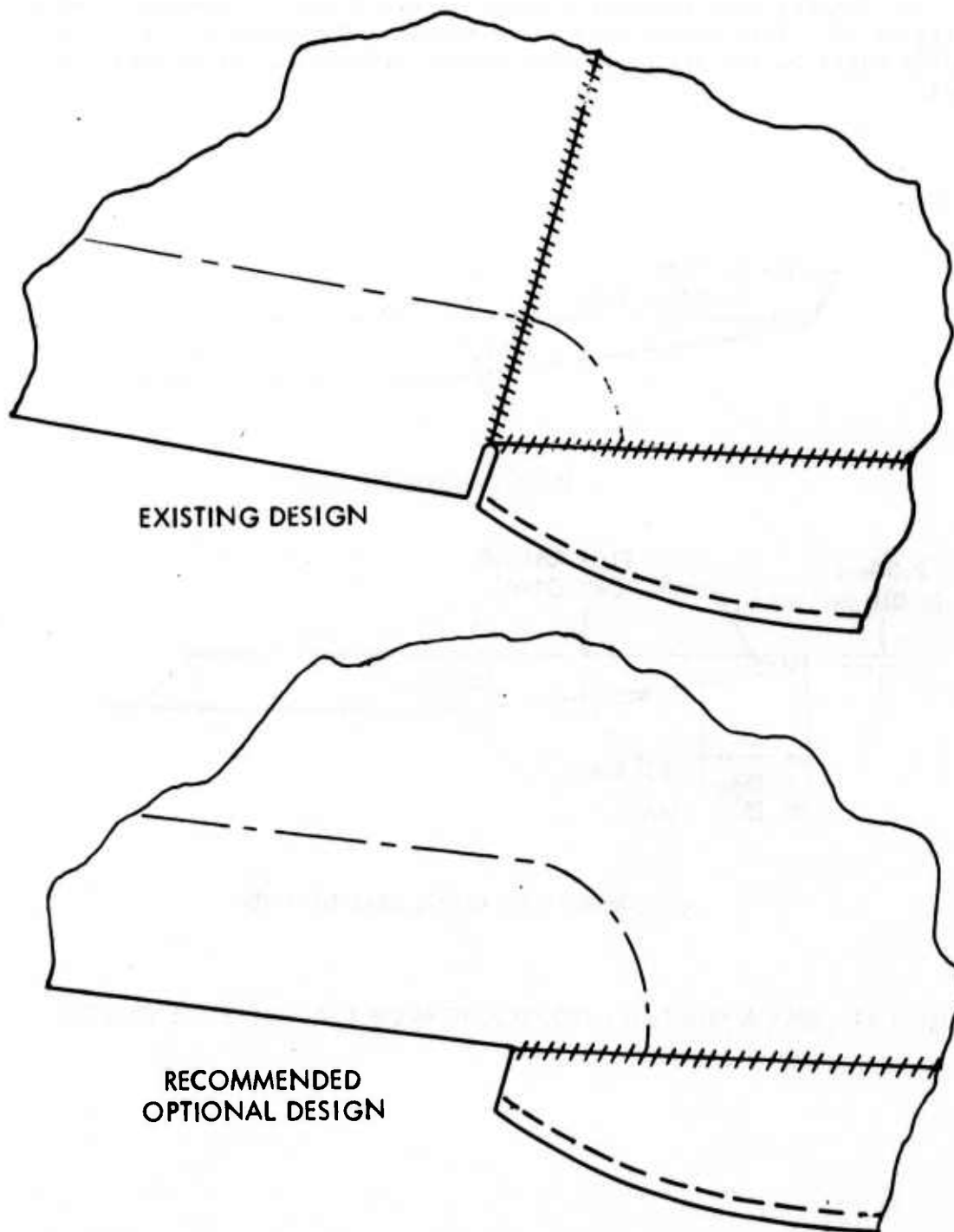


Figure 33: RECOMMENDED MODIFICATION OF COWL LIP DETAIL DESIGN.

The leading edge external chamfer detail should be changed as shown in Figure 34. This change will allow rapid hand finishing of the sharp leading edges on the precompression shroud without extensive metal removal.

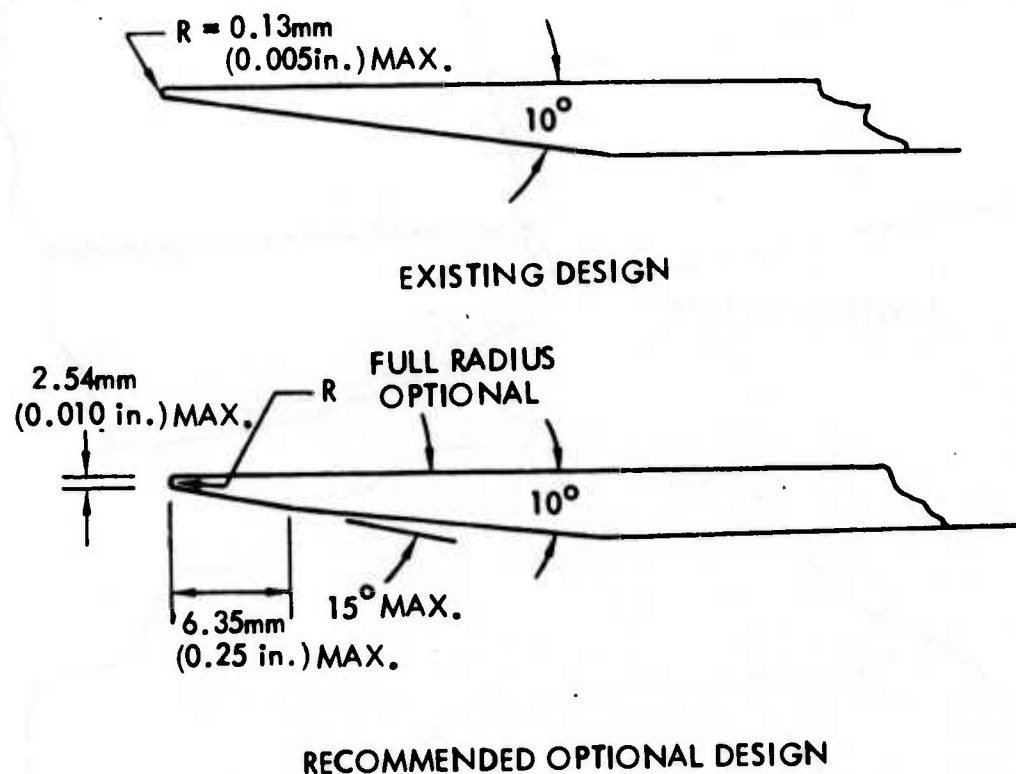
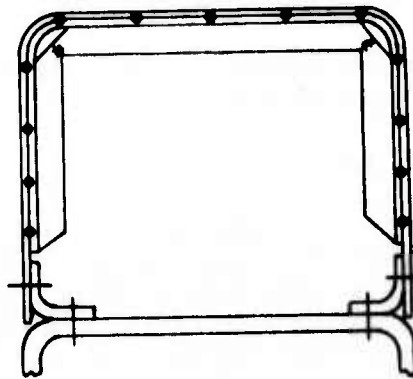


Figure 34: RECOMMENDED MODIFICATION OF LEADING EDGE DESIGN

The design of the forward and aft fairings, fairing stiffeners and fairing attachment provisions should be modified as shown in Figure 35 to further reduce weight and costs.

EXISTING  
DESIGN



RECOMMENDED  
OPTIONAL  
DESIGN

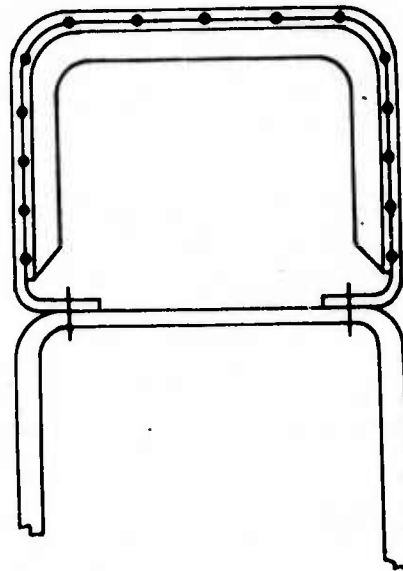


Figure 35: RECOMMENDED MODIFICATION OF FAIRING DESIGN

#### REVISED COST ESTIMATE

A revised production cost estimate was made based on the experience gained in fabrication of the "production simulation" hardware and the recommended design modifications discussed above.

The revised manufacturing plan is outlined in Table 3 and the resulting production cost breakdown is outlined in Table 4.

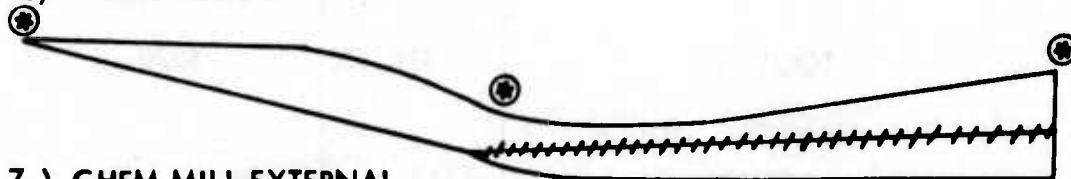
Results show the inlets can be built for \$3390 per set compared to the original estimate of \$4985.

#### REVISED WEIGHT ESTIMATE

The inlet weight estimate was updated based on better definition of details and recommended design changes. Results show the weight of the inlet will be 47.2 kg (104 lbs.). This weight includes the turn and dump section, fairings and diverter, but does not include the aerogrid, splitter, flameholder, injectors, igniter or provisions for their attachment. The previous estimate used in the trade study was 48.6 kg (107 lbs.).

Table 3: REVISED MANUFACTURING PLAN OUTLINE FOR  
PRODUCTION INLETS.

- 1.) FLAT PATTERNS -4 & -5
- 2.) PREFORM ON COLD DIES - HOT METAL
- 3.) HOT FORM CONTOUR ON INTREGRAL HEATED INCONEL OR  
STAINLESS TOOLS
- 4.) TRIM AND WELD PREPARATION
- 5.) LONGITUDINAL WELD TIG WITH BACKUP - 2 PASS WELD
- 6.) STRESS RELIEVE WITH FIXTURE



- 7.) CHEM MILL EXTERNAL
- 8.) MACHINE DETAILS  
AFT END  
BLEED SLOT  
ROUGH CUT LEADING EDGES
- 9.) CLEAN
- 10.) FORM AND WELD TURN AND DUMP - INCONEL 718
- 11.) FORWARD FAIRING AND STIFFENERS
- 12.) AFT FAIRING STIFFENERS AND ATTACH FITTING
- 13.) DIVERTER AND BLEED FLARE ANGLES
- 14.) AERO GRID AND SPLITTER - GFE
- 15.) ASSEMBLY
- 16.) HAND FINISH LEADING EDGES
- 17.) CLEAN
- 18.) NAME PLATE
- 19.) PACKAGE

Table 4: REEVALUATED COST ESTIMATES  
FOR "PRODUCTION INLETS".

|                    | 10<br>SETS | 1000<br>SETS |
|--------------------|------------|--------------|
| MATERIALS          | \$2,000    | \$1,020      |
| TOOLING            | \$10,430   | \$320        |
| MANUFACTURING      |            |              |
| SETUP              | \$510      | \$20         |
| RUN                | \$5,880    | \$2,030      |
| SUB TOTAL          | \$6,390    | \$2,050      |
| TOTAL <sup>a</sup> | \$18,820   | \$3,390      |

<sup>a</sup> AVERAGE COST PER SET FOR 10 OR 1000 SET  
PRODUCTION IN MID 1974 DOLLARS

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101 Chemical Propulsion Mailing List No. 271 dated October 1975, including Categories 1,2,3,4,5