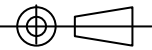


FED. SUPPLY CLASS

INACTIVE FOR DESIGN AFTER 31 MAY 2012. NO SUPERSEDING STANDARD. FOR DESCRIPTION OF STATUS NOTES SEE NAS380.

INACTIVE FOR DESIGN AFTER 31 MAY 2012

THIRD ANGLE PROJECTION 	CUSTODIAN ENGINEERING MANAGEMENT COMMITTEE	REVISION 5
PROCUREMENT SPECIFICATION NONE	TITLE SPAR MILL NUMERICALLY CONTROLLED	CLASSIFICATION SPECIFICATION NAS912 SHEET 1 OF 44

1.0 SCOPE

1.1 Purpose

This specification provides a standard for the manufacture, performance, inspection and procurement of a series of spar milling machines to meet aerospace manufacturing requirements. This standard lists minimum requirements and is not to limit design advances.

1.2 Classification

The machines shall consist of AIA Class IV numerically controlled spar mills with two sizes (widths) of machines available for each class, with equipment and accessories herein to be available at the option of the customer. The machine shall be of the standard gantry type as per this specification equipped with combination of one or more of the carriages.

1.2.1 Type

- I - (2) horizontal twist heads
- II - (2) vertical twist heads
- III - Any combination of horizontal twist and vertical twist heads (6.1.1)

NOTE: See Figures 1 and 2, Sheets 38 and 39 for standard head numbering system and axis nomenclature.

1.2.2 Size

- Small - 36" work space
- Large - 48" work space

1.2.3 Class

- I - Aluminum cutting spar mill
- II - Combination aluminum and steel cutting spar mill (6.1.3)

LIST OF CURRENT SHEETS

NO.	REV.	NO.	REV.	NO.	REV.	NO.	REV.
1	4	12	3	23	4	34	4
2	3	13	3	24	4	35	4
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5	3	16	3	27	4	38	4
6	3	17	3	28	4	39	4
7	3	18	3	29	4	40	4
8	3	19	3	30	4	41	4
9	3	20	3	31	4	42	4
10	3	21	4	32	4	43	4
11	3	22	4	33	4		

④ COMPLETELY REVISED

CUSTODIAN: MANUFACTURING COMMITTEE

PROCUREMENT
SPECIFICATION

TITLE
SPAR MILL
NUMERICALLY CONTROLLED

CLASSIFICATION
SPECIFICATION

NAB Documents
SHEET 1 OF 43