1. FOR ADDITIONAL INFORMATION, SEE SHEETS 02 THRU 03.
2. THIS ITEM IS FRACTURE CRITICAL
3. MATERIAL: ALUMINUM PLATE 7075-T651 PER FEDERAL SPEC QQ-A-250/12
4. CERTIFICATION OF CHEMICAL AND MECHANICAL PROPERTIES REQUIRED
5. ULTRASONIC INSPECT PER MIL-STD-2154, TYPE I, QUALITY LEVEL CLASS A, PRIOR TO FABRICATION. ACCEPTANCE CRITERIA PER SECTION 5.5.4 AND TABLE VI.
6. 3.2 Ra ALL MACHINED SURFACES UNLESS OTHERWISE NOTED.
7. ALL RADII TO BE 6-7mm UNLESS OTHERWISE SPECIFIED.
8. ROUGH MACHINED AND FINISHED PART MUST PASS DYE PENETRANT INSPECTION PER ASTM E1417. ACCEPTANCE PER MIL-STD-1907.
9. HEAT TREAT BEFORE FINISH MACHINING BY AGING TO T7351 CONDITION PER MIL-H-6088.
10. ELECTROCHEMICAL ETCH DRAWING PART NUMBER 67212MEDH211 ON SPECIFIED SUFACE PER SAE AS478, METHOD 7A. (ZONE D28/29)
11. SURFACE TREAT ENTIRE PART PER MIL-C-5541 USE IRIDITE 14.2 OR APPROVED EQUIVALENT PER MIL-C-81706, CLASS 3, FORM II, METHOD B OR C AS APPLICABLE. SPOT TOUCH UP BY METHOD B. PRIOR TO INSTALLING KEENSERTS.
12. HARD FLAT BLACK ANODIZE INTERIOR AND EXTERIOR SURFACES (EXCEPT SURFACES INDICATED PER NOTE 13, AND TAPPED HOLES) PER MIL-A-8625, TYPE III, CLASS 2, .001-.002 INCH THICK PRIOR TO INSTALLING KEENSERTS. ALL DIMENSIONS APPLY AFTER ANODIZE.
13. DO NOT BLACK ANODIZE SURFACES INDICATED.
14. INSTALL KEENSERT KNCL0632J PER MANUFACTURER'S SPECIFICATIONS AFTER SURFACE TREATMENT PER NOTES 11 & 12.
15. INSTALL KEENSERT KNCML 4X0.7 PER MANUFACTURER'S SPECIFICATIONS AFTER SURFACE TREATMENT PER NOTES 11 & 12.
16. INSTALL KEENSERT KNML 6X1.0 PER MANUFACTURER'S SPECIFICATIONS AFTER SURFACE TREATMENT PER NOTES 11 & 12.
17. INSTALL KEENSERT KNML 8X1.25 PER MANUFACTURER'S SPECIFICATIONS AFTER SURFACE TREATMENT PER NOTES 11 & 12.
18. CLEAN SURFACES WITH 190 PROOF ETHYL ALCOHOL. WIPE WITH CLEAN COTTON SWABS AND/OR LINT-FREE CLOTH.
19. HANDLE WITH CLEAN, LINT-FREE GLOVES.
20. BEFORE STORAGE, PROTECT WITH CONTAMINATION BARRIER. USE CLEAN, NEW TRANSPARENT, POLYETHYLENE BAG FOR SMALL ITEMS, OR 4 MIL THICK MINIMUM POLYETHYLENE SHEET SEALED WITH FIBERGLASS PACKAGING TAPE. SEAL AND MARK WITH IDENTIFICATION NUMBER ON TAG ATTACHED TO BAG.
21. LAST DATUM USED: -EE-.
22. LAST SECTION OR VIEW LETTER USED: EE.
23. PROCESS PLAN REQUIRED.
24. ESTIMATED WEIGHT: 18.651 Kg.

REVISIONS

CHG	ZONE	DESCRIPTION	APP/DATE
G	SHT. 3 E/11&12	SECTION W-W & VIEW V-V: .750-16 SPIRALOCK INCH... WAS .4375-20 INCH SPIRALOCK...	MJA 11/17/99
F	E16	Ø486.055-485.755 WAS Ø486.21-486.07	JAI 08/02/99
E	SHT.1 E16; SHT.2 C24; G29; F28; B17. SHT.3 G23.	Ø486.21-486.07 WAS Ø20.001-20.003 INCH. ADDED SURFACE FINISH TO CHAMBER SIDE FACE. DETAIL CC: FINISH 0.4 WAS 32 INCH; REMOVED "C" CIRCULAR REF; 1.6 SURFACE FINISH WAS 63 INCH. REMOVED Ø28 DIMENSION. VIEW R-R: ADDED SURFACE FINISH BOUNDARY.	MJA 06/29/99
D	D28& 29; H8; F8; NOTES; SHT2 G29;	MODIFIED 6 HOLE CALLOUT AND DIM'S TO INCH; PART NO. ETCH CALLOUT SYMBOL 10 WAS 9; 40X 9°0' WAS 36X 10°0'; NOTE REF 16 WAS 15; NOTE 14: KNCL0632J WAS KNCML 3X0.5; DETAIL CC: ADDED "GROOVES" TO GROOVES SURFACE FINISH NOTE.	MJA 06/10/99
C	C20; B11& B9; C11: A15& 16. NOTES H28& 29.	ADDED CHAMFER TO FOUR ELECTRICAL CONNECTION PORTS; ON STOP TABS 35°30' WAS 35° AND 34°30' WAS 28°30'. STOP TAB ROUNDS: R3-4 WAS R1.5-2. STOP TAB CUT 10 WAS 3. NOTE 12: REFERENCE TO NOTE 13 WAS 12; NOTES 14, 15, 16, & 17: REFERENCE TO NOTES 11 AND 12 WERE 10 AND 11. SECTION B-B: ADDED & MODIFIED MISSING DETENT LOCATION DIMENSIONS; 16.6 WAS 19; 76.5 WAS 77; 2X 30° WAS 2X 34°.	MJA 05/21/99
B	H1	CHANGED MATERIAL AND HEAT TREAT NOTES	JAI 05/06/99
A	F8	40 HOLES WAS 36	JAI 04/22/99

UNLESS OTHERWISE SPECIFIED:
1. ALL DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994
2. ALL DIMENSIONS ARE IN MILLIMETERS
3. BREAK EDGES: 0.2-0.5
4. LINEAR TOLERANCES:
   0.5-6 ±0.1
   OVER 6-30 ±0.2
   OVER 30-120 ±0.3
   OVER 120-315 ±0.5
   OVER 315-1000 ±0.8
   OVER 1000-2000 ±1.2
5. ANGULAR TOLERANCES: 0° 30'

CONTRACT	NAS3-27600
CONTRACTOR	ADF, INC.
TASK ORDER	60
DRAFTER	ADF/ M.AYNIK
ENGINEER	ANLX/ M.POLITI
DESIGNER	ADF/ D.ROBINSON

THIRD ANGLE PROJECTION

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
JOHN H. GLENN RESEARCH CENTER
LEWIS FIELD
CLEVELAND, OHIO

TEST CHAMBER MODULE ASSEMBLY

67212MEDH200

211 INTERFACE RESOURCE RING

PDM REL LEVEL: **RELEASE** PDM REVISION: x.34

PDM DATABASE: FCF

MODEL NAME: 67212MEDH211

PRIOR TO USE VERIFY THE INTENDED PURPOSE IN PDM ("FOR" ATTRIBUTE)

SIZE	DRAWING NUMBER	REV	BLDG	AREA
3000 by 841	67212MEDH211	G	333	-

UNITS: mm

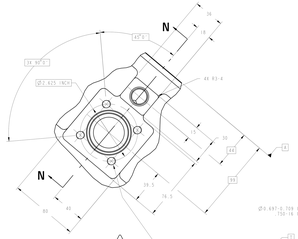
SCALE: 1:1 | INITIAL REL DATE: 04/21/99 | SHEET 1 OF 3 | DISCIPLINE

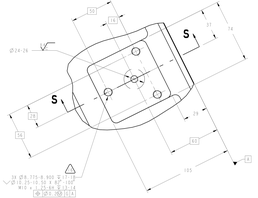
PRO/E VERSION: 18.0

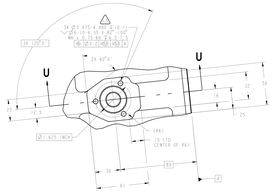
SIZE R3 DRAWING NUMBER 67212MEDH211

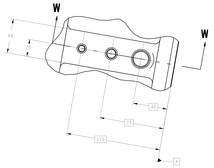
SECTION A-A
SEE SHEET 1
DETAIL CC
SCALE 2:1
SECTION DD-DD
VIEW F-F
DETAIL H
SCALE 4:1
SECTION G-G
VIEW C-C
SECTION D-D
DETAIL E
SCALE 4:1
SECTION CC-CC
VIEW J-J
DETAIL L
SCALE 4:1
SECTION K-K
DOOR SIDE
CHAMBER SIDE
3000 by 841 6722MEDH2R
R3 6722MEDH2R

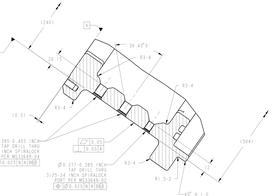
1. SEE SHEET 01 FOR ADDITIONAL INFORMATION, GENERAL NOTES, AND TOLERANCES.

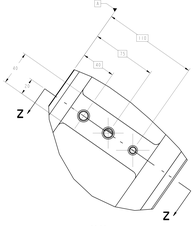


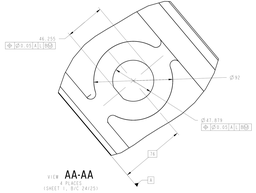


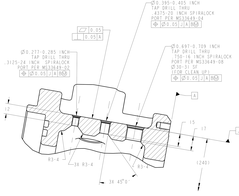


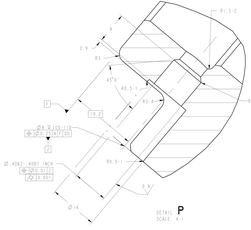


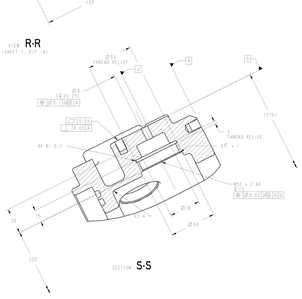


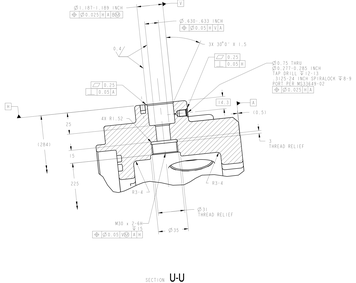


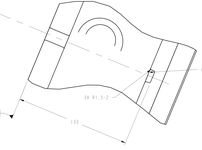












DATE	CODE	DESCRIPTION	APPROVAL
DRAWN BY		DRAWING NUMBER	REV
FORMAT	DRAWING CODEPN		
DRAWN BY		DRAWING NUMBER	REV
DRAWING.CODEPN	DRAWING	<SHEET>	

DRAWING.CODEPN