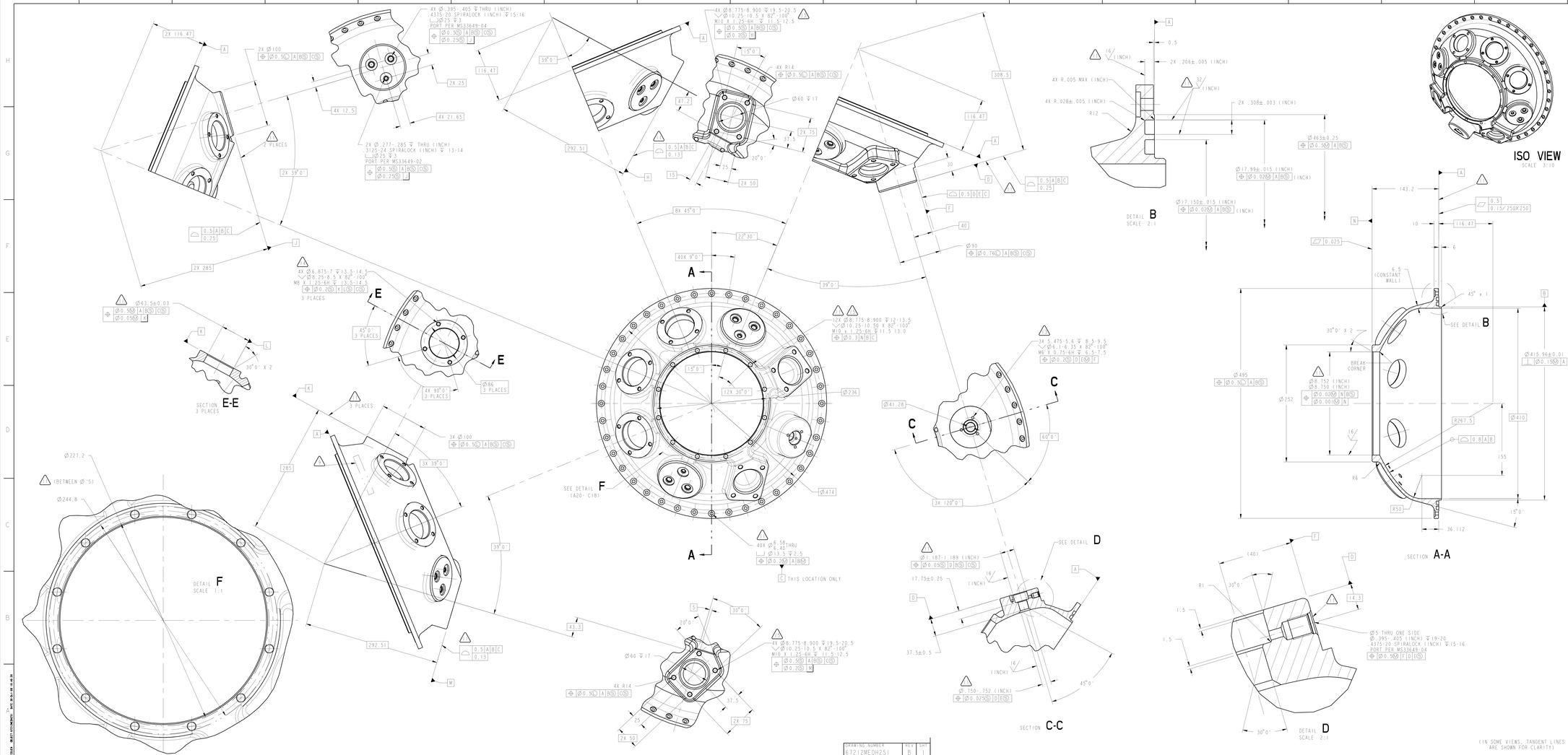

1. THIS ITEM IS FRACTURE CRITICAL
2. MATERIAL:
   ALUMINUM FORGING 7075-T73 PER MIL-A-22771D
3. CERTIFICATION OF CHEMICAL AND MECHANICAL PROPERTIES REQUIRED
4. ULTRASONIC INSPECT PER MIL-STD-2154, TYPE I, QUALITY LEVEL CLASS A. PRIOR TO FABRICATION. ACCEPTANCE CRITERIA PER SECTION 5.5.4 AND TABLE VI.
5. 3.2 Ra ALL INSIDE MACHINED SURFACES, 5 Ra ALL OUTSIDE MACHINED SURFACES UNLESS OTHERWISE SPECIFIED.
6. ALL FILLET RADII TO BE 6 mm UNLESS OTHERWISE SPECIFIED.
7. ROUGH MACHINED AND FINISHED PART MUST PASS DYE PENETRANT INSPECTION PER ASTM E1417. ACCEPTANCE PER MIL-STD-1907.
8. THERMAL STRESS RELIEVE AND TEMPER TO ORIGINAL MATERIAL CONDITION.
9. ELECTROCHEMICAL ETCH DRAWING PART NUMBER 67212MEDH251 ON SPECIFIED SURFACE PER SAE AS478, METHOD 7A. (ZONE D16)
10. 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, PERFORM BEFORE INSTALLING KEENSERTS.
11. DO NOT ANODIZE ANY TAPPED, BLIND, OR THRU HOLES, COUNTERBORES OR SURFACES INDICATED.
12. HARD FLAT BLACK ANODIZE INTERIOR AND EXTERIOR SURFACES PER MIL-A-8625, TYPE III, CLASS 2, PERFORM BEFORE INSTALLING KEENSERTS.
13. INSTALL KEENSERT KNCML 4X0.7 PER MANUFACTURER'S SPECIFICATIONS AFTER SURFACE TREATMENT PER NOTES 10 & 12.
14. INSTALL KEENSERT KNML 5X0.8 PER MANUFACTURER'S SPECIFICATIONS AFTER SURFACE TREATMENT PER NOTES 10 & 12.
15. INSTALL KEENSERT KNML 6X1.0 PER MANUFACTURER'S SPECIFICATIONS AFTER SURFACE TREATMENT PER NOTES 10 & 12.
16. CLEAN SURFACES WITH 190 PROOF ETHYL ALCOHOL. WIPE WITH CLEAN COTTON SWABS AND/OR LINT-FREE CLOTH
17. HANDLE WITH CLEAN, LINT-FREE GLOVES.
18. 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.
19. LAST DATUM USED: -N-.
20. LAST SECTION OR VIEW LETTER USED: F.
21. PROCESS PLAN REQUIRED.
22. ESTIMATED WEIGHT: 7.645 Kg.

CHG	ZONE	DESCRIPTION / REVISIONS	APP/DATE
B	D12 B.D5	REDESIGNED TOP FOR PORT FLANGE W/12 TAPPED HOLES FOR M6X1 KEENSERTS. ADDED 30° X 2 CHAMFER TO INSIDE OF PORT. ADDED MATERIAL BETWEN NEW PORT FLANGE AND THE 2 RECTANG REAR BOSSES.	MJA 08/12/99
	B19& C18	REMOVED BOTTOM VIEW.	
	B13 A B18.	FLATNESS: 0.5 WAS 0.2, 0.4, 0.15 WAS 0.08. DETAIL B: SURFACE FINISH 16 WAS 32; 32 WAS 63.	
	B9&10.	SECTION C-C: 2 SURFACE FINISHES 16 WAS 32.	
	NOTES	REWROTE NOTE 8. REMOVED FORMER NOTE 21 "QUANTITY: ONE REQ'D". NOTE 13 WAS 11. NOTE 11 COMBINED FROM FORMER NOTES 11 & 12.	
A	B14 F/D D4	CHANGED CONFIG OF MTG PADS WAS 4X 10.26 Ø.134 BOSS WAS 6X Ø20 MS33649 PORT THREADS CHANGED TO SPIRALOCK TX ADDED 5Ra SURFACE FINISH TO NOTE 5	NM 04/13/99

UNLESS OTHERWISE SPECIFIED: 1. ALL DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994. 2. UNITS: MILLIMETERS (IN MILLIMETERS) 3. BREAK EDGES: 0.2-0.5 4. LINEAR TOLERANCES: OVER 0-30 ±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.
	SCALE R1
	DRAFTER ADF/N MCMASTER
	ENGINEER ANL/W. POLITI
	DESIGNER ADF/D. ROBINSON
	THIRD ANGLE PROJECTION
PDM REL LEVEL: RELEASE	PDM REVISION: x.20
PDM DATABASE: PCF MODEL NAME: 67212MEDH251	

PRINT TO THE SCALE THE INTENDED FORMAT IN PDM TYPE ATTRIBUTE

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

TEST CHAMBER MODULE ASSEMBLY

67212MELH200

(251) REAR END CAP

SIZE	DRAWING NUMBER	REV	BLDG	AREA
R2	67212MEDH251	B	333	—

SCALE	INITIAL REL DATE	SHEET	DISCIPLINE
1:2	07/12/99	1 OF 1	MECHANICAL

PROJE VERSION: 19

R2 67212MEDH251

DRAWING NUMBER	REV	SHT
67212MEDH251	B	1