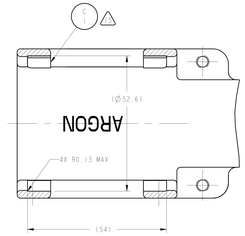
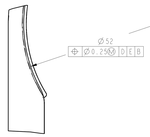
COMMERCIAL PARTS LIST

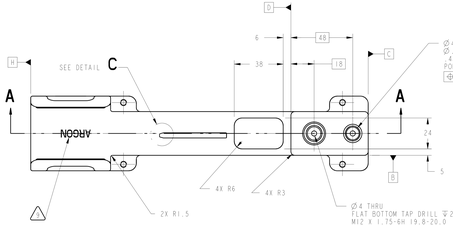
PART TYPE	BALLOON NO	DESCRIPTION	QTY/ ASSY
C	1	BONDABLE TEFLON (PTFE) SHEET PER ASTM D 1710. 53.8-53.9 WIDE X 1/32 INCH THK. LENGTH AS REQUIRED	2
C	2	INSERT, KEENSERT, PART NUMBER KNCML 4 X 0.7 (FOR #40.7 FASTENER)	6

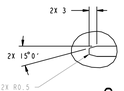


SECTION G-G
SCALE 2:1
TEFLON SHEET BELOW CENTERLINE OMITTED FOR CLARITY

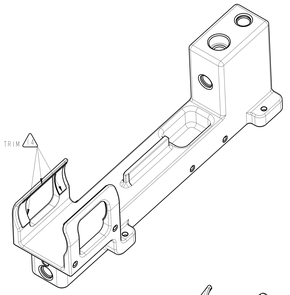


DETAIL F
SCALE 4:1
2 PLACES

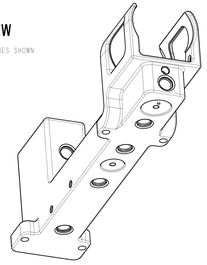




DETAIL C
SCALE 2:1

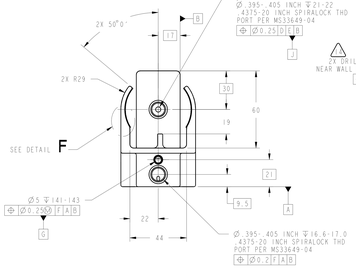


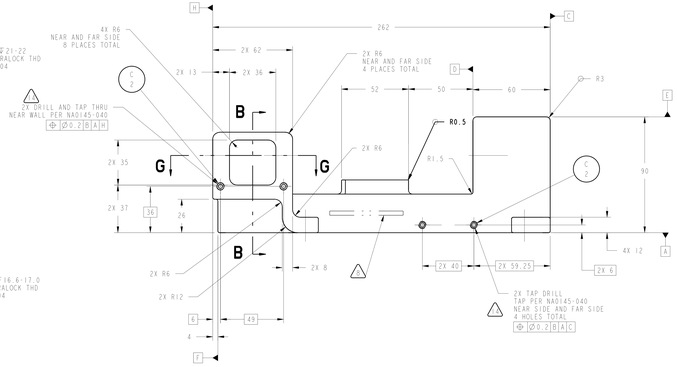
ISO VIEW
TANGENT EDGE LINES SHOWN

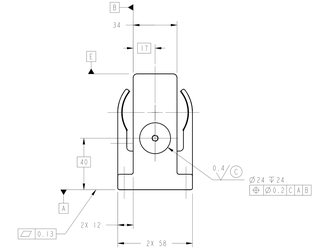


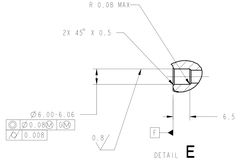
ISO VIEW
TANGENT EDGE LINES SHOWN

1. MATERIAL: 6061-T651 ALUMINUM PER FEDERAL SPEC QQ-A-250/11.
2. CERTIFICATE OF CONFORMANCE REQUIRED FOR ALL MATERIALS.
3. ULTRASONIC INSPECT PER MIL-STD-2154. PRIOR TO FABRICATION. ACCEPTANCE PER SECTION 5.5.4., TABLE VI, CLASS LEVEL A.
4. 3.2 Ra ALL MACHINED SURFACES UNLESS OTHERWISE NOTED PER ANSI/ASME B46.1.
5. ALL OUTSIDE CORNERS TO BE R1.5 UNLESS OTHERWISE SPECIFIED.
6. ALL INSIDE FILLETS TO BE R3.0 UNLESS OTHERWISE SPECIFIED.
7. ALL INTERNAL PORTS MUST BE BLENDED SMOOTH WITH NO FEATHERED EDGES OR BURRS.
8. △ ELECTROCHEMICAL ETCH DRAWING PART NUMBER 67212MEDH966 ON SPECIFIED SURFACE PER SAE AS478, METHOD 7A (ZONE D12).
9. △ ELECTROCHEMICAL ETCH "ARGON" ON SPECIFIED SURFACE IN 9-10 HIGH CHARACTERS AS SHOWN, PER SAE AS478, METHOD 7A (ZONE G13).
10. FINISHED PART MUST PASS DYE PENETRANT INSPECTION PER ASTM E1417. ACCEPTANCE PER MIL-STD-1907.
11. SURFACE TREATMENT PER MIL-C-5541, CLASS 3. USE IRIDITE (4.2 OR REQUESTER APPROVED EQUAL) PER MIL-C-81706, CLASS 3, FORM II, METHOD B OR C AS APPLICABLE PRIOR TO INSTALLING KEENSERTS. SPOT TOUCH UP BY METHOD B.
12. FLAT BLACK ANODIZE EXTERIOR SURFACES EXCEPT TAPPED HOLES, INTERNAL PASSAGES AND AREAS IDENTIFIED PER NOTE 13. PER MIL-A-8625, TYPE II, CLASS 2. PRIOR TO INSTALLING KEENSERTS. ALL DIMENSIONS APPLY AFTER ANODIZING.
13. △ MASK AREA NOTED PRIOR TO ANODIZING PER NOTE 12.
14. △ TEFLON SHEET TO BE BONDED IN PLACE USING 3M SCOTCHWELD 1838 B/A EPOXY AS REQUIRED TRIM TO MATCH CONTOUR OF MANIFOLD (2 PLACES).
15. △ INSTALL KEENSERTS PER MANUFACTURER'S SPECIFICATIONS AFTER SURFACE TREATMENT PER NOTES 11 AND 12.
16. CLEAN SURFACES WITH 190 PROOF ETHYL ALCOHOL. WIPE WITH CLEAN LINT FREE CLOTH.
17. HANDLE WITH CLEAN, LINT-FREE GLOVES.
18. BEFORE STORAGE, PROTECT WITH CONTAMINATION BARRIER. USE CLEAN, NEW, TRANSPARENT, POLYETHYLENE BAG SEALED WITH FIBERGLASS PACKAGING TAPE. SEAL AND MARK WITH IDENTIFICATION NUMBER ON TAG ATTACHED TO BAG.
19. PROCESS PLAN REQUIRED.
20. ESTIMATED WEIGHT=1.038 Kg.

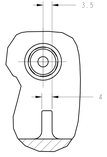




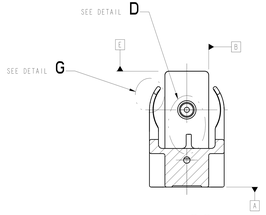




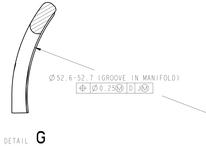
DETAIL E
SCALE 2:1



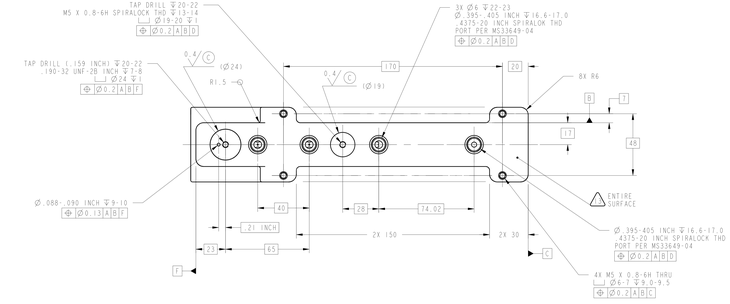
DETAIL D
SCALE 2:1

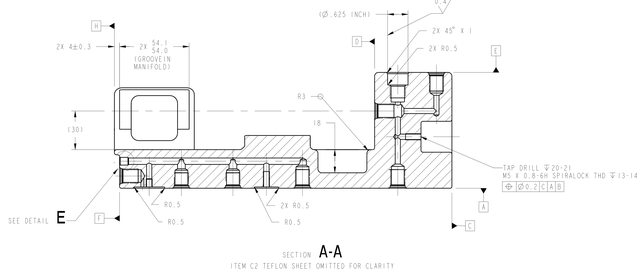


SECTION B-B
TEFLON SHEET ITEM C2 OMITTED FOR CLARITY



DETAIL G
SCALE 4:1





SECTION A-A
ITEM C2 TEFLON SHEET OMITTED FOR CLARITY

DRAWING NUMBER	REV	SHT
67212MEDH966		1

PRIOR TO USE VERIFY THE INTENDED PURPOSE IN PDM (ITEM: ATTRIBUTE)

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: OVER 0-6 ±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'

PDM REL LEVEL: RELEASE
PDM DATABASE: PCF
MODEL NAME: 67212MEDH966
CHECK FOR NEW INSTANCE BEFORE PROCEEDING

CONTRACT: NAS3-27600
CONTRACTOR: ADF, INC.
SCALE: NONE
DRAFTER: ADF/ W. HOLT
ENGINEER: ANI/K.D. CATALANO
DESIGNER: ADF/ D. ROBINSON
THIRD ANGLE PROJECTION

PDM REVISION: w.12*

CHG	ZONE	DESCRIPTION	APP/DATE
		REVISIONS	

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

GC ARGON SUPPLY MANIFOLD ASSEMBLY

67212MEDH965

966 GC ARGON SUPPLY MANIFOLD

SIZE	DRAWING NUMBER	REV	BLDG	AREA
R2	67212MEDH966		333	100
SCALE: AND NOTED	INITIAL REL DATE: 10/23/2014	SHEET: 1	DISCIPLINE: MECHANICAL	

PROJ/E VERSION: 20.0

R2 67212MEDH966