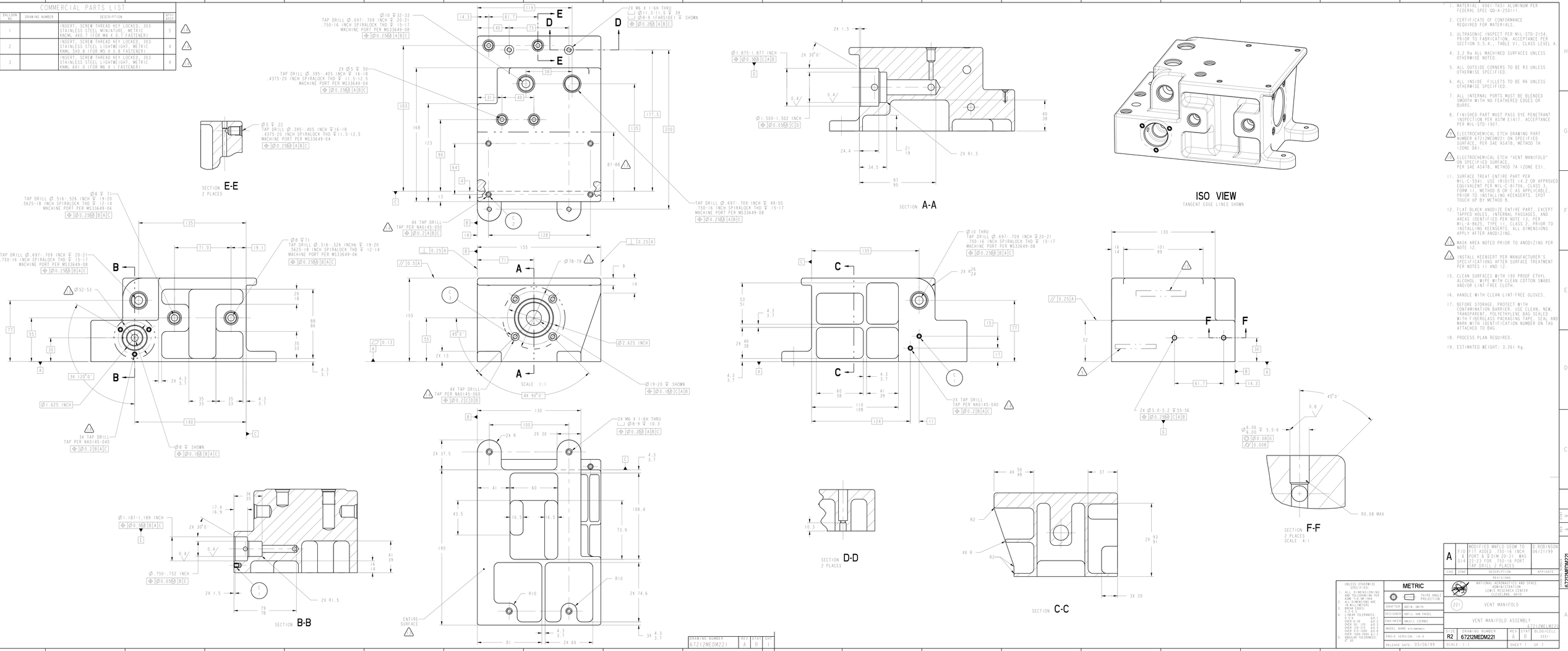
COMMERCIAL PARTS LIST

PART TYPE	BALLOON NO.	DRAWING NUMBER	DESCRIPTION	QTY/ ASSY
C	1		INSERT, SCREW THREAD KEY-LOCKED, 303 STAINLESS STEEL MINIATURE, METRIC, KNML 4X0.7 (FOR M4 X 0.7 FASTENER)	5
C	2		INSERT, SCREW THREAD KEY-LOCKED, 303 STAINLESS STEEL LIGHTWEIGHT, METRIC KNML 5X0.8 (FOR M5 X 0.8 FASTENER)	4
C	3		INSERT, SCREW THREAD KEY-LOCKED, 303 STAINLESS STEEL LIGHTWEIGHT, METRIC KNML 6X1.0 (FOR M6 X 1 FASTENER)	4



1. MATERIAL: 6061-T651 ALUMINUM PER FEDERAL SPEC QQ-A-250/11.
2. CERTIFICATE OF CONFORMANCE REQUIRED FOR 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.
5. ALL OUTSIDE CORNERS TO BE R3 UNLESS OTHERWISE SPECIFIED.
6. ALL INSIDE FILLETS TO BE R6 UNLESS OTHERWISE SPECIFIED.
7. ALL INTERNAL PORTS MUST BE BLENDED SMOOTH WITH NO FEATHERED EDGES OR BURRS.
8. FINISHED PART MUST PASS DYE PENETRANT INSPECTION PER ASTM E1417, ACCEPTANCE PER MIL-STD-1907.
9. ELECTROCHEMICAL ETCH DRAWING PART NUMBER 67212MEDM221 ON SPECIFIED SURFACE, PER SAE AS478, METHOD TA (ZONE D6).
10. ELECTROCHEMICAL ETCH "VENT MANIFOLD" ON SPECIFIED SURFACE, PER SAE AS478, METHOD TA (ZONE E5).
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, PRIOR TO INSTALLING KEENSERTS. SPOT TOUCH UP BY METHOD B.
12. FLAT BLACK ANODIZE ENTIRE PART, 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. INSTALL KEENSERT PER MANUFACTURER'S SPECIFICATIONS AFTER SURFACE TREATMENT PER NOTES 11 AND 12.
15. CLEAN SURFACES WITH 190 PROOF ETHYL ALCOHOL. WIPE WITH CLEAN COTTON SWABS AND/OR LINT-FREE CLOTH.
16. HANDLE WITH CLEAN LINT-FREE GLOVES.
17. 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.
18. PROCESS PLAN REQUIRED.
19. ESTIMATED WEIGHT: 3.261 Kg.

CHG	ZONE	DESCRIPTION	APP/DATE
A	F/D & G/4	MODIFIED MNFLD GEOM TO F/D ADDED .750-16 INCH PORT & ⌀ DIM 20-21 WAS 22-23 FOR .750-16 PORT TAP DRILL 2 PLACES	D.ROBINSON 08/21/99

REVISIONS

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° ±0°

METRIC

THIRD ANGLE PROJECTION

DRAFTER: ADFN: SMITH
DESIGNER: ADFIA: ANN TASSEL
ENGINEER: ANLF12: CERNEC
MODEL NAME: 4711(MEDM2)
PROJE VERSION: 19.0
RELEASE DATE: 05/06/99

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
LEWIS RESEARCH CENTER
CLEVELAND, OHIO

221

VENT MANIFOLD

VENT MANIFOLD ASSEMBLY

67212MEUM22A

SIZE	DRAWING NUMBER	REV	STAT	BLOCK/CELL
R2	67212MEDM221	A	R	3351-

SCALE: 1:1 SHEET 1 OF 1

DRAWING NUMBER	REV	STAT	SHT
67212MEDM221	A	R	1

67212MEDM221

MAX USER: MEDITUSNMD - MB:89:MB:18:MB