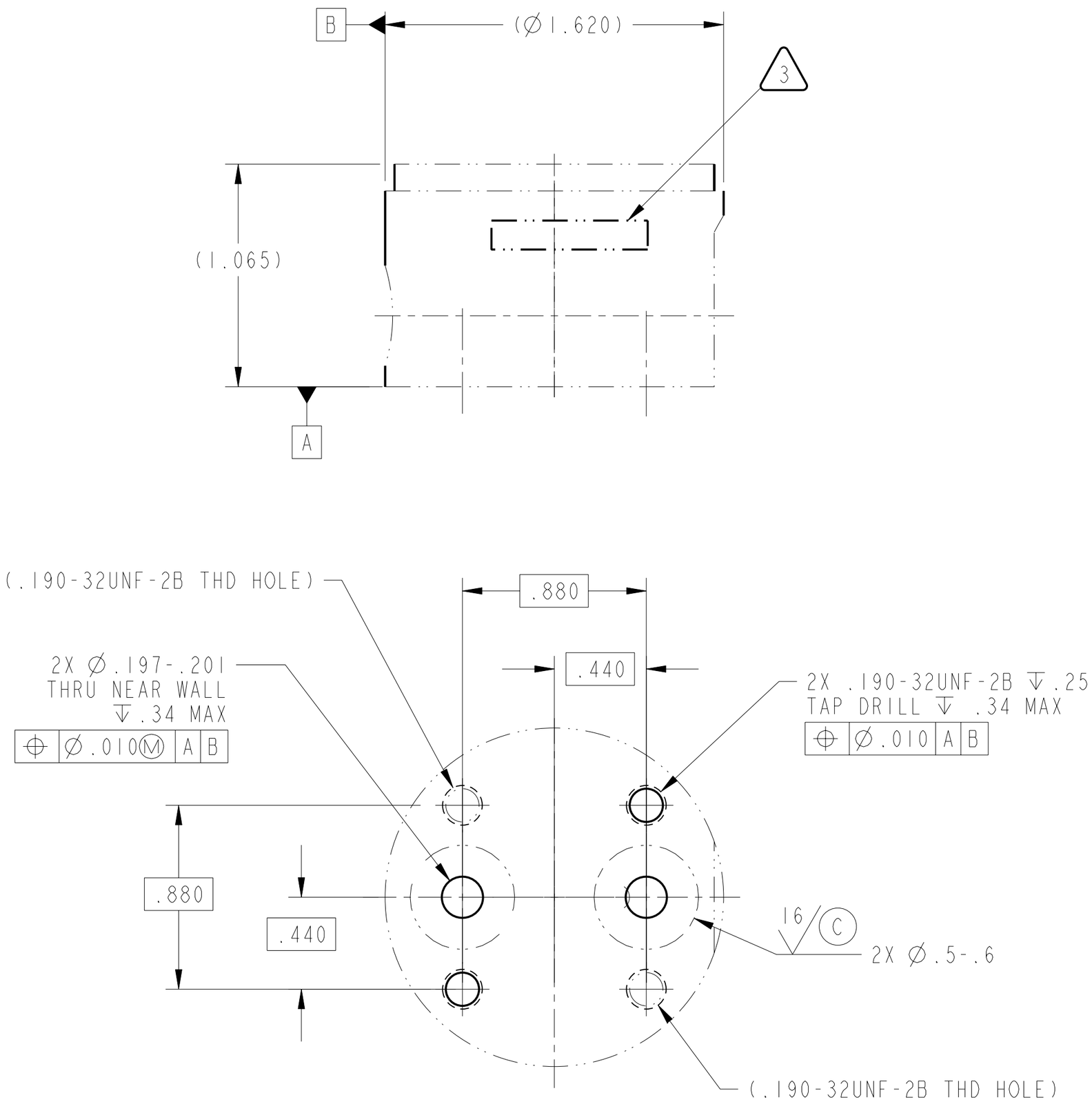

1. MODIFY EXISTING BASE OF SKINNER SOLENOID VALVE ASSEMBLY NO. 71215RN2MV NO L222 C2 AS SHOWN. PROTECT ALL EXISTING SEALING SURFACES AND FEATURES FROM ANY DAMAGE. (MATERIAL: 300 SERIES STAINLESS STEEL)

2. 32 Ra ALL MACHINED SURFACES UNLESS OTHERWISE NOTED.

3. ELECTROCHEMICAL ETCH DRAWING PART NUMBER 67212MEDM247 ON SPECIFIED SURFACE PER SAE AS478, METHOD 7A (ZONE D3).

4. CLEAN SURFACES WITH 190 PROOF ETHYL ALCOHOL. WIPE WITH CLEAN COTTON SWABS AND/OR LINT-FREE CLOTH.

5. HANDLE WITH CLEAN LINT-FREE GLOVES.

6. 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.

7. PROCESS PLAN REQUIRED.

CHG	ZONE	DESCRIPTION	APP/DATE

REVISIONS

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

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCE ON	
.X	± 0.03
.XX	± 0.01
.XXX	± 0.005
FRACTION	± -
ANGULAR	± 0.50°
BREAK EDGES	XXX

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994

CONTRACT	NAS3-27600
CONTRACTOR	ADF, INC.
TASK ORDER	60
DRAFTER	ADF/D.ROBINSON
ENGINEER	ANLX/I.DRALYUK
DESIGNER	ADF/D.ROBINSON

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

EVP MODIFIED SKINNER 1/4" SOLENOID VALVE ASSEMBLY

67212MELM246

247 EVP MODIFIED SKINNER 1/4" VALVE BASE

PDM REL LEVEL: **RELEASE** PDM REVISION: **x.4**

PDM DATABASE: **FCF**

MODEL NAME: **67212MEDM247**

CHECK FOR ANY OUTSTANDING ECO'S PRIOR TO USE

SIZE	DRAWING NUMBER	REV	BLDG	AREA
C	67212MEDM247	-	333	-

UNITS: INCH

SCALE:	INITIAL REL DATE	SHEET	DISCIPLINE
2/1	XX/XX/XXXX	1 OF 1	MECHANICAL

PRO/E VERSION: 20.0

SIZE C DRAWING NUMBER 67212MEDM247 REV -

~~NAME:EDJEN OBJECT:67212MEDM247 DATE:30-Oct-00 11:20:43~~