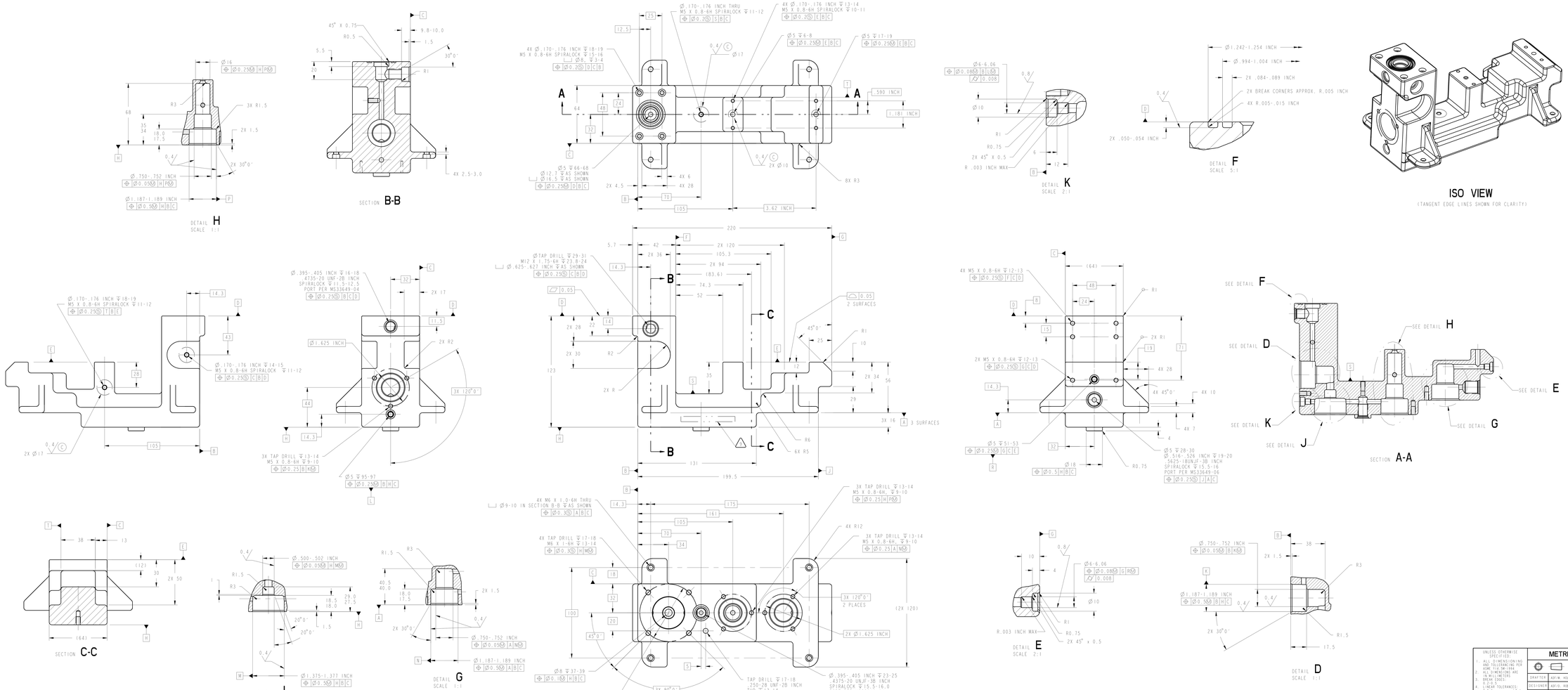

1. MATERIAL: TYPE 316 STAINLESS STEEL, PER QQ-S-766.
2. CERTIFICATE OF CONFORMANCE REQUIRED FOR MATERIALS.
3. ULTRASONIC INSPECT PER MIL-STD-2154, PRIOR TO FABRICATION. ACCEPTANCE PER SECTION 5.5.4., TABLE VI, CLASS LEVEL A.
4. 1.6 Ra ALL MACHINED SURFACES UNLESS OTHERWISE NOTED.
5. ALL OUTSIDE CORNERS TO BE R3 UNLESS OTHERWISE SPECIFIED.
6. ALL INSIDE FILLETS TO BE R3 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 67212MEDM301 ON SPECIFIED SURFACE, PER SAE AS478, METHOD 7A (ZONE D11).
10. CLEAN AND PASSIVATE PER MIL-S-5002, PARAGRAPHS 3.4.2.4 AND 3.4.2.4.1, AND QQ-P-35.
11. CLEAN SURFACES WITH 190 PROOF ETHYL ALCOHOL. WIPE WITH CLEAN LINT FREE CLOTH
12. BEFORE STORAGE, PROTECT WITH CONTAMINATION BARRIER. USE CLEAN, NEW, TRANSPARENT, POLYETHYLENE BAG, FIBERGLASS PACKAGING TAPE. SEAL AND MARK WITH IDENTIFICATION NUMBER ON TAG ATTACHED TO BAG.
13. PROCESS PLAN REQUIRED.
14. ESTIMATED WEIGHT: 4.92Kg.
15. QUANTITY: ONE REQUIRED.

CHG	ZONE	DESCRIPTION	APP/DATE
A	F/D	ADDED SPIRALOCK REQT'S TO VARIOUS TAPPED HOLES	D. ROBINSON 03/19/99

REVISIONS

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
LEWIS RESEARCH CENTER
CLEVELAND, OHIO

301 FUEL MANIFOLD

FUEL MANIFOLD ASSEMBLY

67212MEDM301

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'

METRIC

THIRD ANGLE PROJECTION

DRAFTER: ASF/W. HOLT
DESIGNER: ASF/D. ROBINSON
ENGINEER: ANLY/D. CATALANO
MODEL NAME: ASF/J(MEDM301)
PROJE VERSION: 19.0
RELEASE DATE: 03/08/99

SIZE	DRAWING NUMBER	REV	STAT	BLDG/CELL
R2	67212MEDM301	A	R	3337

SCALE: 1:1 AND NOTED
SHEET 1 OF 1

DRAWING NUMBER	REV	STAT	SHT
67212MEDM301	A	R	1