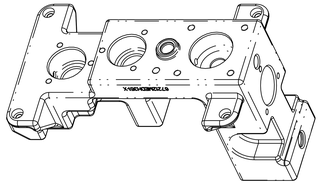
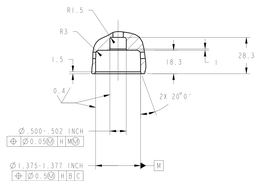
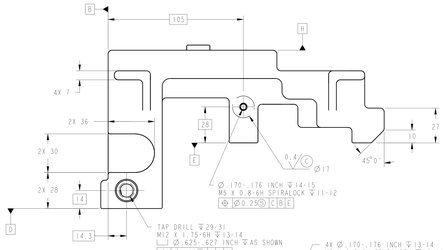
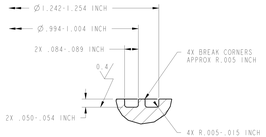


ISO VIEW I
(TANGENT EDGE LINES SHOWN IN PHANTOM)

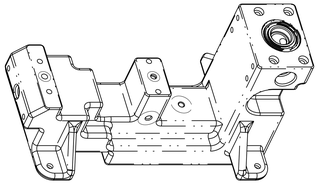


DETAIL H
SCALE 1:1



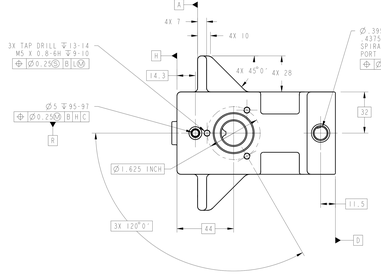


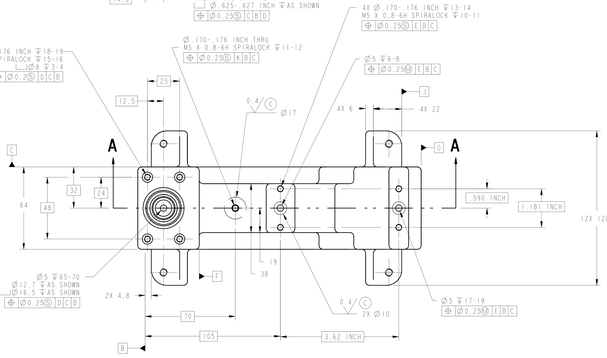
DETAIL J
SCALE 5:1

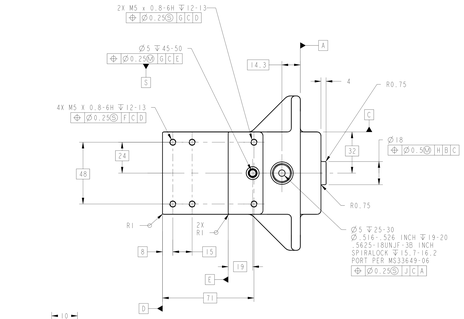


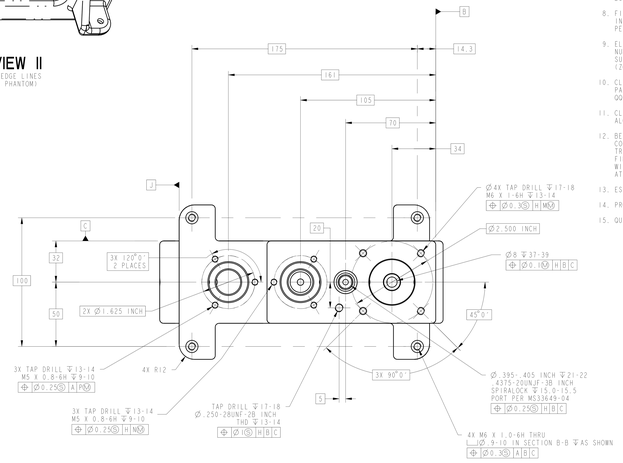
ISO VIEW II
(TANGENT EDGE LINES SHOWN IN PHANTOM)

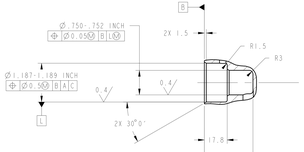
1. MATERIAL: TYPE 316 STAINLESS STEEL PER QQ-S-766.
2. CERTIFICATE OF CONFORMANCE REQUIRED FOR MATERIALS.
3. ULTRASONIC INSPECT PER MIL-STD-2154, PRIOR TO FABRICATION. ACCEPTANCE PER SECTION 5.5.4., TABLE VI, CLASS LEVEL A.
4. 1.6 Ra ALL MACHINED SURFACES UNLESS OTHERWISE NOTED PER ANSI/ASME B46.1.
5. 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 PER PROCESS PLAN ON SPECIFIED SURFACE. PER SAE AS478, METHOD 7A (ZONE B13).
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, POLYETHELENE BAG. SEAL WITH FIBERGLASS PACKAGING TAPE. SEAL AND MARK WITH IDENTIFICATION NUMBER ON TAG ATTACHED TO BAG.
13. ESTIMATED WEIGHT: 4.92 Kg.
14. PROCESS PLAN REQUIRED.
15. QUANTITY: ONE REQUIRED PER ASSEMBLY.



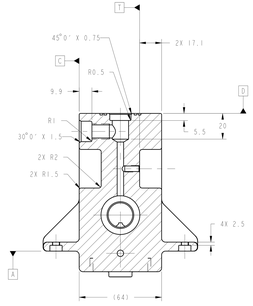




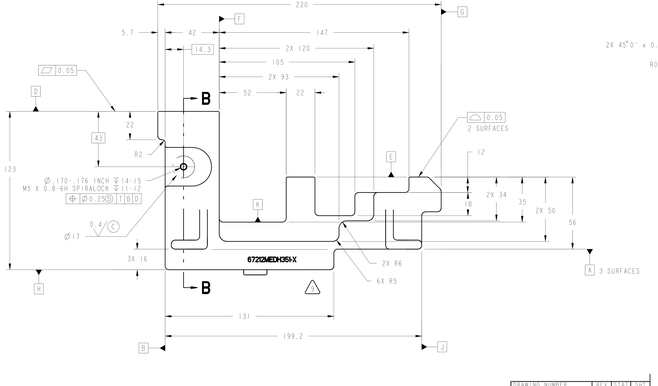


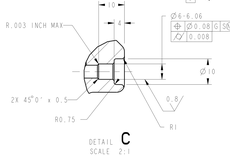


DETAIL G
SCALE 1:1

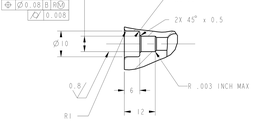


SECTION B-B

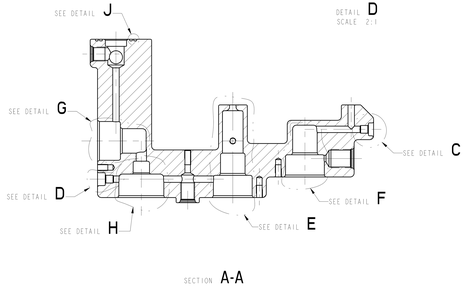




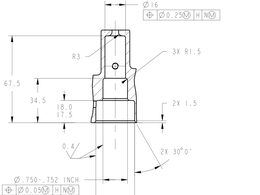
DETAIL C
SCALE 2:1



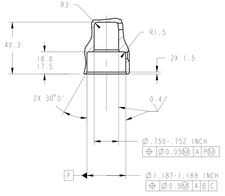
DETAIL D
SCALE 2:1



SECTION A-A



DETAIL E
SCALE 1:1



DETAIL F
SCALE 1:1

CHG	ZONE	DESCRIPTION	APP/DATE
A	F/O	ADDED SPIRALOCK REQT'S TO VARIOUS TAPPED HOLES	D. ROBINSON 03/22/99

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 120-1000 ±0.5, OVER 315-1000 ±0.8, OVER 1000-2000 ±1.2
5. ANGULAR TOLERANCES: 0° ±0°

METRIC

THIRD ANGLE PROJECTION

DRAFTER	ADF/M. STRIR
DESIGNER	ADF/D. ROBINSON
ENG/MGR	ANLT/ E. CATALANO
MODEL NAME	67212MEDM351
PROJ'C VERSION:	19-0
RELEASE DATE:	03/08/99

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
LEWIS RESEARCH CENTER
CLEVELAND, OHIO

351 OXYGEN/DILUENT MANIFOLD

OXYGEN & DILUENT MANIFOLD ASSEMBLIES
67212MEDM350 & MADM

SIZE	DRAWING NUMBER	REV	SCALE	SHEET	OF
R2	67212MEDM351	A	R	1	1

SCALE: 1:1 AND NOTED

DRAWING NUMBER	REV	SCA	SHT
67212MEDM351	A	R	1

67212MEDM351