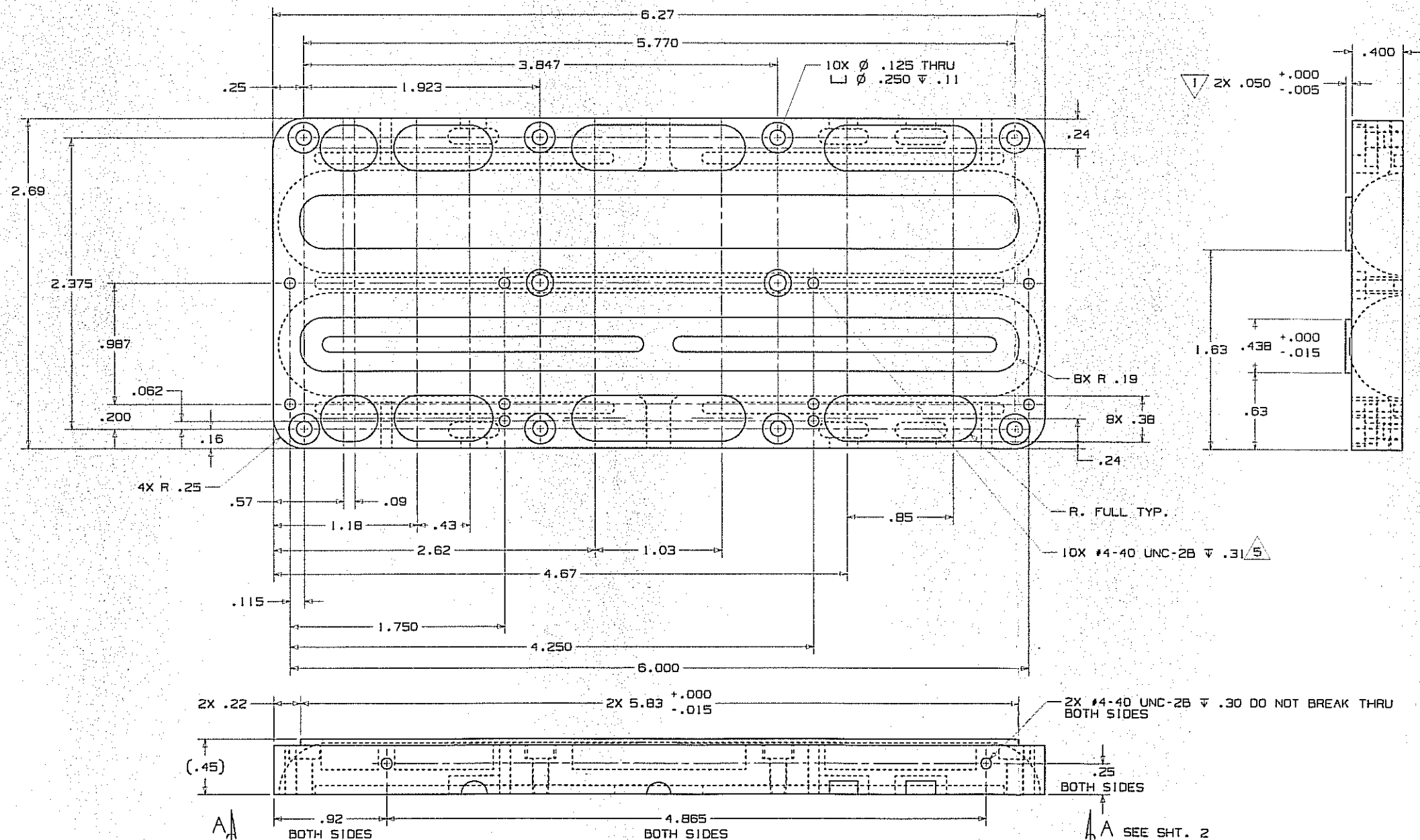


# NOTES

- BREAK ALL SHARP EDGES AND CORNERS.
- INDICATES FEATURE/DIMENSION TO BE CHECKED AT INCOMING INSPECTION.
- MATERIAL CERTIFICATION REQUIRED.
- PART SURFACE FINISH AS NOTED IN TITLEBLOCK UNLESS OTHERWISE SPECIFIED.
- PRIOR TO BEAD BLAST MASK ALL TAPPED HOLES.
- NOTED CAVITY SURFACES TO BE GLASS BEAD BLAST (60-100 GRIT) WITH FRESH MEDIA. OVERSPRAY ON ADJACENT SURFACES PERMITTED. CAVITY SURFACES TO HAVE MATTE FINISH (BEAD BLAST) OVER ENTIRE CAVITY SURFACES. NO SHINY AREAS IN NOTED CAVITIES PERMITTED AFTER BEAD BLAST. TO ENSURE COMPLETE AND ADEQUATE SURFACE FINISH FOR BEAD BLAST, BEAD BLAST NOZZLE SHOULD BE HELD APPROXIMATELY 6.0" FROM NOTED SURFACES. BEAD BLAST NOZZLE SHOULD BE MOVED PERPENDICULAR TO ALL SURFACES OF NOTED CAVITIES. BEAD BLAST PRESSURE GAGE SET TO 25 PSI.
- AFTER BEAD BLAST PART TO BE ELECTROPOLISH FINISHED (ABLE ELECTROPOLISHING, CHICAGO IL) PER SPECIFICATION (#1055-B-DE-0.0020) OR (#1055-B-DE-0.0020 S/R) TO INCLUDE ULTRASONIC CLEANING OF PART AND FINAL RINSE WITH DEIONIZED WATER. THERE SHOULD BE NO DELAY BETWEEN ELECTROPOLISH FINISH AND FINAL RINSE. CERTIFICATION OF THIS PROCESS IS REQUIRED.
- AFTER ELECTROPOLISH NOTED CAVITIES ARE TO HAVE NO AREAS WITH A MIRROR FINISH. ALL SURFACE AREAS OF CAVITIES ARE TO HAVE A DIFFUSE REFLECTIVE FINISH.
- NOTED CYLINDRICAL CAVITY SURFACE FINISH MUST BE ATTAINED PRIOR TO BEAD BLAST AND ELECTROPOLISH, NO MACHINE MARKS ALLOWED - MUST HAVE SMOOTH TRANSITIONS.



REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	REORDERED NOTES; ADDED NOTES 5, 8 & 9; REVISED NOTE 6; ELECTROPOLISH SPEC WAS #1055-B-DE-0.003	KMK	11/28/00	BCT024005
B	SHT. #1 ADDED 2X #4-40 UNC-2B ± .30 DO NOT BREAK THRU (BOTH SIDES); C-BORE Ø.250 ± .11 WAS Ø.219 ± .11; ADDED NOTE 10; MAT'L WAS 1100 ALUM; SHT #2 ADDED 63RMS SURFACE FINISH TO R.420 CYLINDRICAL CAVITIES	KMK	03/06/00	BCT024744
C	CHANGED NOTE 7, ELECTROPOLISH SPECIFICATION WAS 1055-B-DE-0.0015.	MTS	08/31/00	BCT025955
D	NOTE #7 SPECIFICATION WAS #1055-B-DE-0.0020	KMK	01/11/00	BCT026809
E	NOTE #8 WAS; PLUG ALL TAPPED HOLES FROM ELECTROPOLISH; TO NOTE #7 ADDED REFERENCE TO ULTRASONIC CLEANING AND RINSE WITH DEIONIZED WATER	KMK	05/10/00	BCT027755

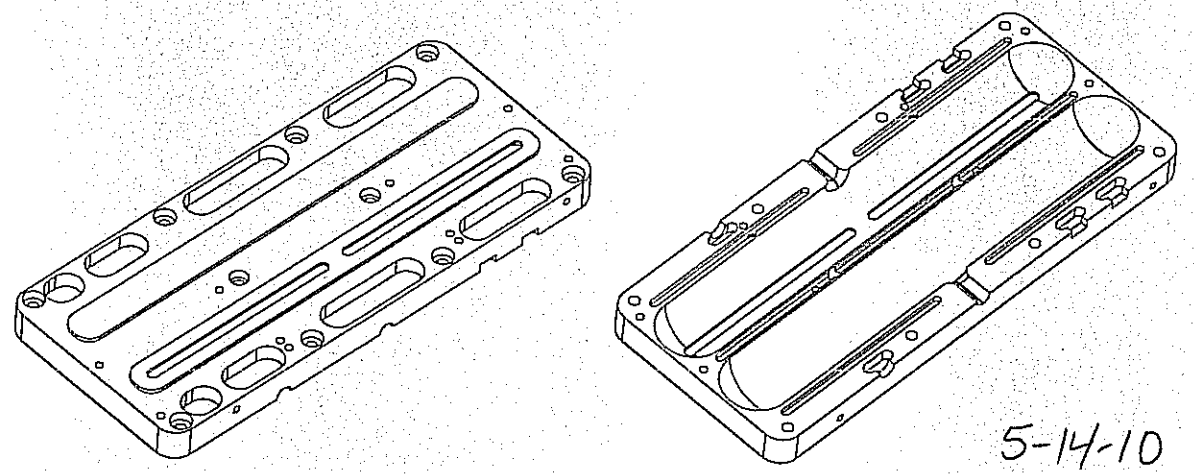
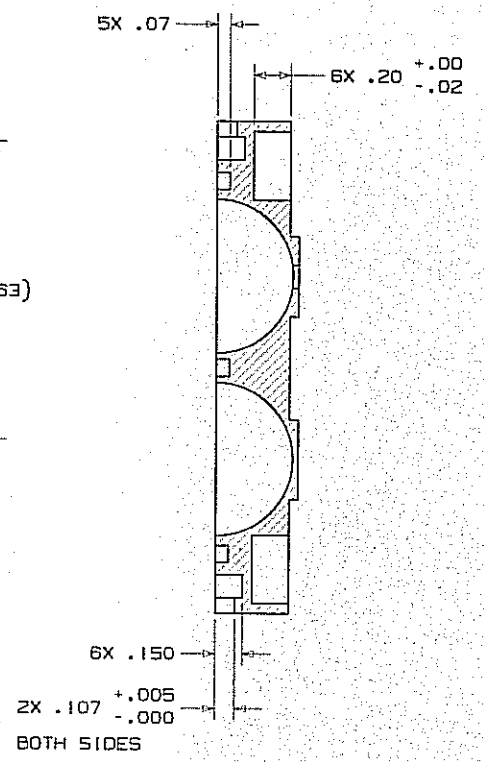
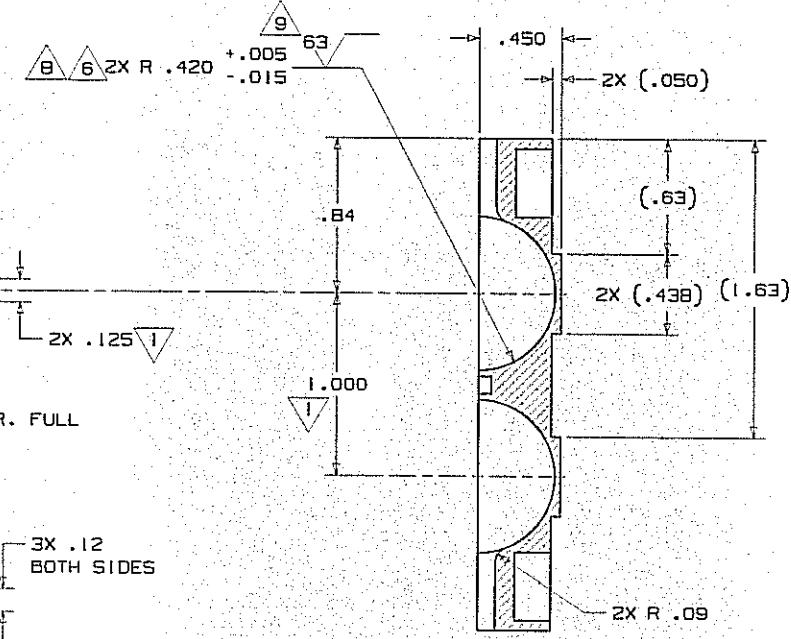
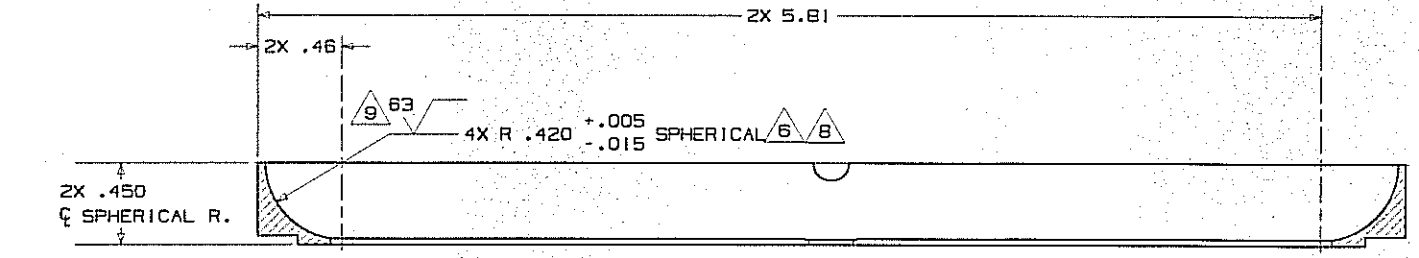
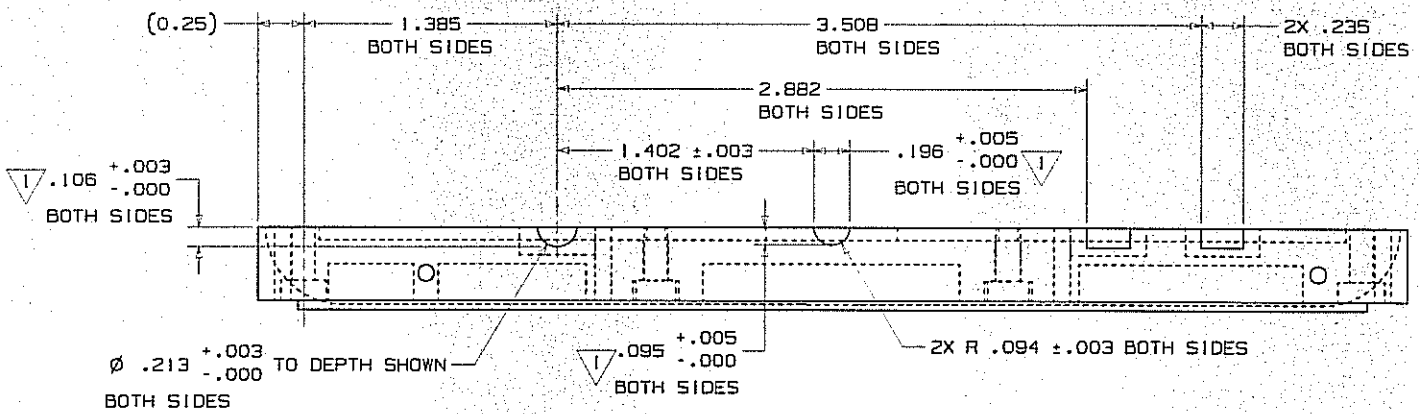
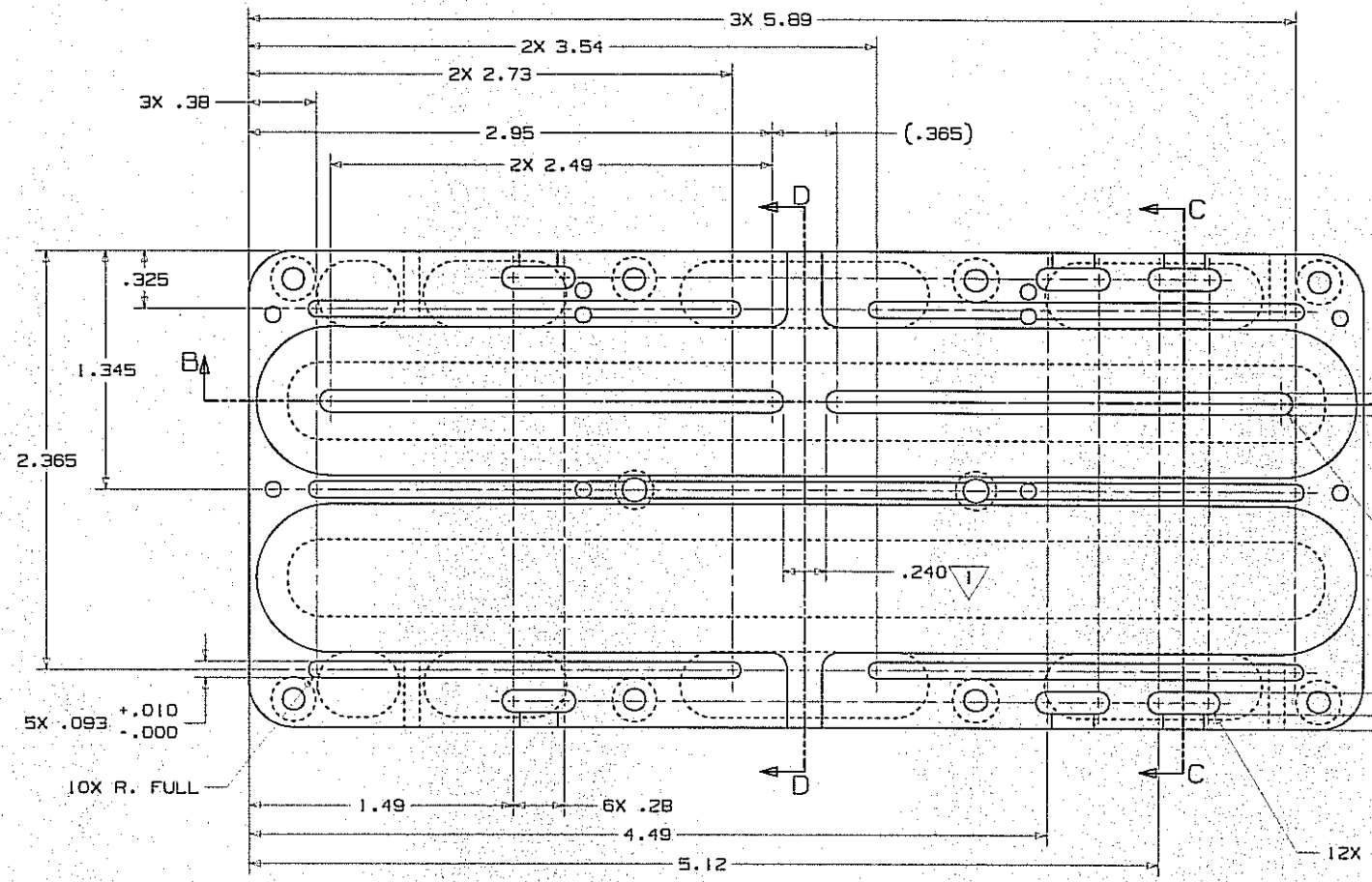
allow .002 Mat removal per side for electro polish

5-14-10

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TOLERANCES AND SYMBOLS PER ASME Y14.5-1994 DIMENSIONS SPECIFIED ARE AFTER FINISH		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		10011 Dettling Avenue Lakeview, California 90215-4440 USA	
.XX ± 0.04 .XXX ± 0.010 .XXXX ± 0.005 .0000 ± 0.0020		ANGLES ± 1° SURF. FINISH 125RMS		MATERIAL 1100-H112 ALUMINUM	
ORIGINATOR		DATE		TITLE INT. CHAMBER, FEMALE 1100 ALUM.	
SIZE D12:1	SCALE 1:1	DRW. KLIMEK	DATE 02/22/00	PART NO. 777073-678	REV E 1/2

UNIGRAPHICS



5-14-10 408

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TOLERANCES AND SYMBOLS: DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE AFTER ADDITIVE FINISH.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.	
.XX .0.04 .XXX .0.010 .XXXX .0.005 .XXXXX .0.0020	HOLES $\pm 1^\circ$ SURF. FINISH	MATERIAL ORIGINATOR DATE	
SIZE D 2:1	SCALE 1:1	DESIGNED BY K. KLIMEK	DATE 07/22/00
PART NO. 777073-678		REV E 2/2	

INT. CHAMBER, FEMALE  
1100 ALUM.