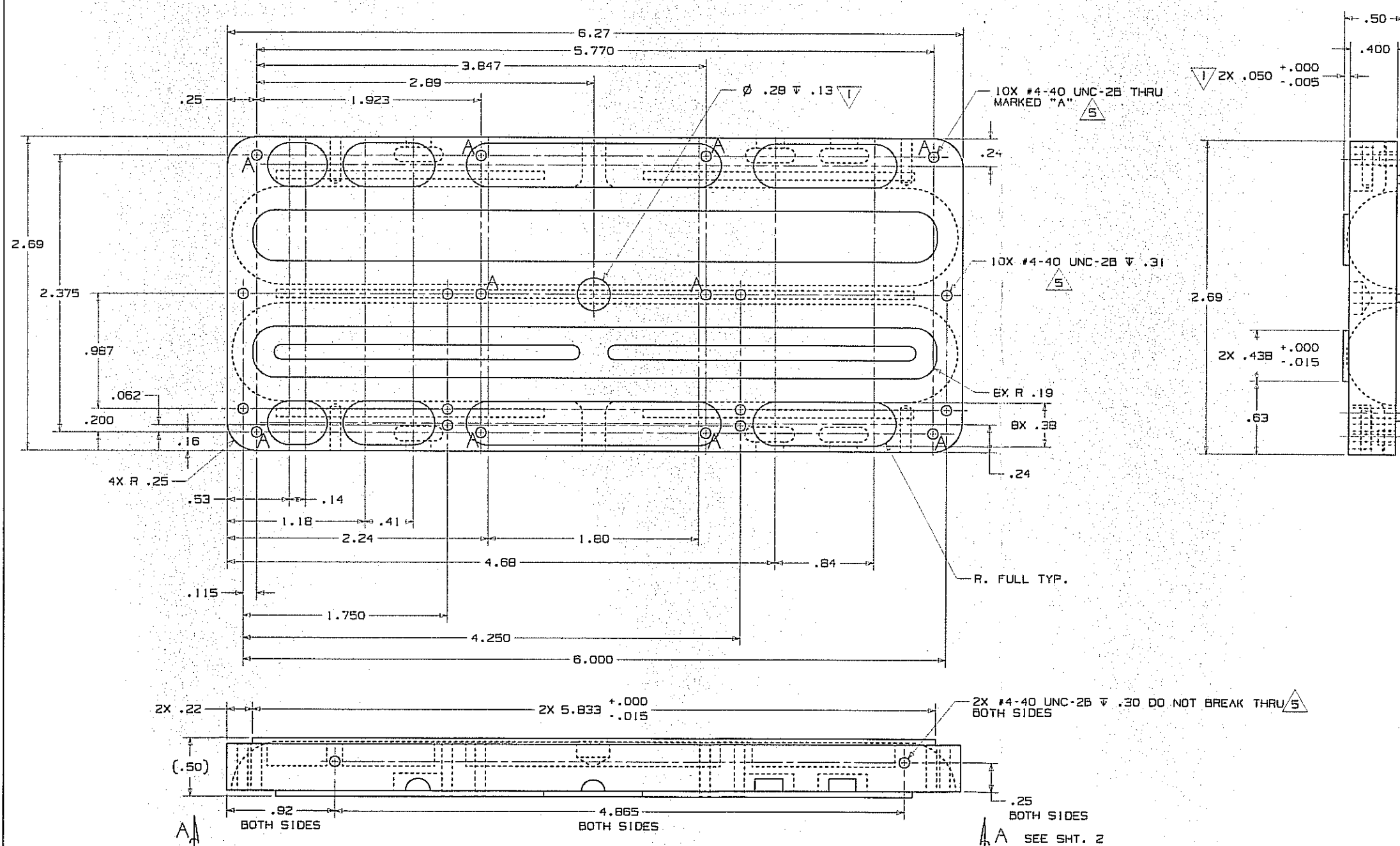


NOTES

- 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 NOTED 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	11/26/08	BCT024005
B	ADDED NOTE 10; MAT'L WAS 1100 ALUM; SHT #2 ADDED 63RMS SURFACE FINISH TO R.420 CYLINDRICAL CAVITIES	KMK	03/08/09	BCT024744
C	CHANGED NOTE 7, ELECTROPOLISHING SPECIFICATION WAS 1055-B-DE-0.0015.	MTS	08/31/09	BCT025955
D	NOTE #7 SPECIFICATION WAS #1055-B-DE-0.0020	KMK	01/14/10	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	05/10/10	BCT027755



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TOLERANCES AND DIMENSIONS UNLESS OTHERWISE SPECIFIED: FRACTIONS: .XX ±.01 DECIMALS: .XXX ±.005 ANGLES: ±1° SURF. FINISH: 125RMS DIMENSIONS ARE TO UNLESS OTHERWISE SPECIFIED		MATERIAL: 1100-H112 ALUMINUM ORIGINATOR: KL (MEK) DATE: 07/22/08	
TITLE: INT. CHAMBER, MALE 1100 ALUM.		PART NO: 777073-677 REV: E SHEET: 1/2	

UNIGRAPHICS

