

NOTES:

1 DIMENSIONS NOT SPECIFIED ON THE DRAWING ARE CONTAINED IN THE DATABASE FOR THIS PART NUMBER AND REVISION.

2 RAW CAST SURFACE FINISH TO BE 125 OR BETTER. CASTING TO BE FREE OF FLASH AND BURRS.

CAST SURFACE VISUAL SEVERITY LEVELS:

TYPE OF DEFECT	LEVEL AA	LEVEL A
NEGATIVES		
MAX LENGTH.....	.020	.035
MAX DEPTH.....	.015	.030
POSITIVES		
MAX LENGTH.....	.010	.025
MAX HEIGHT.....	.010	.020
NONFILL.....	.010	.020
MISMATCH, PARTING LINE		
MAX HEIGHT.....	.005	.010

3 WELD REPAIR: COSMETIC WELD RESTORATION IS PERMITTED IN ACCORDANCE WITH EITHER MIL-STD-2219 OR MIL-W-8604.

4 TOOLING CHANGES AFTER APPROVED FIRST ARTICLE INSPECTION REQUIRE APPROVAL FROM CARIDIANBCT.

5 ▽ INDICATES KEY DIMENSION OR SURFACE(S) TO BE CHECKED BY INCOMING O.C..

6 SECONDARY SURFACE FINISH:

ALL EXTERIOR SURFACES (MARKED BY NOTE 7, 8 AND 9) TO BE POLISHED & ALUMINUM OXIDE GRIT BLASTED TO AN ACCEPTABLE (APPROVED BY CARIDIANBCT) FINISH FOR ELECTROPOLISHING.

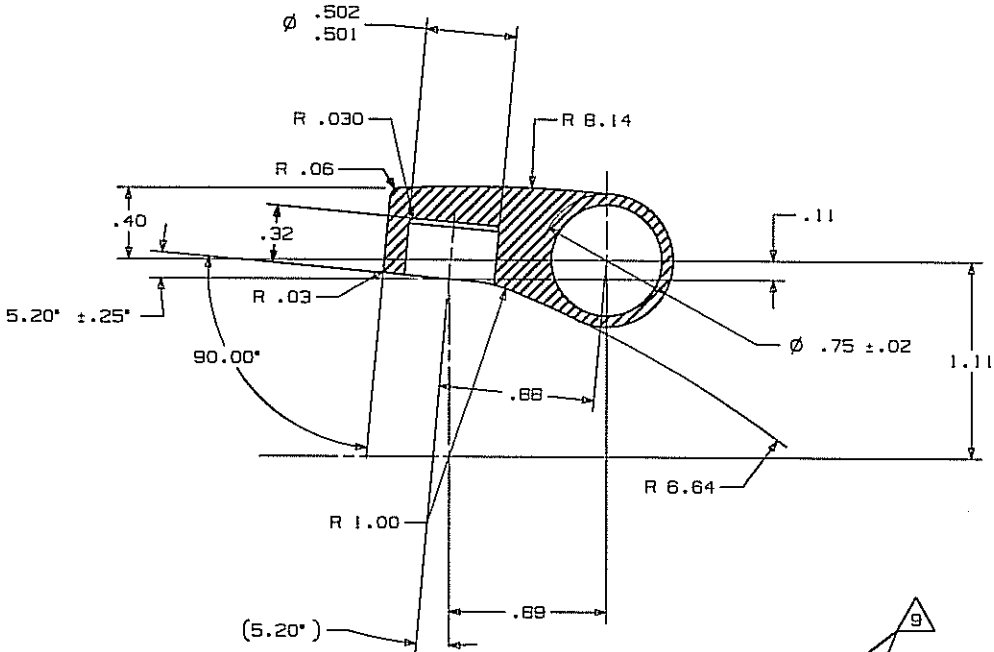
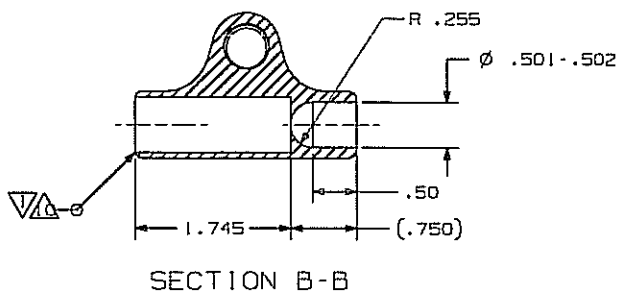
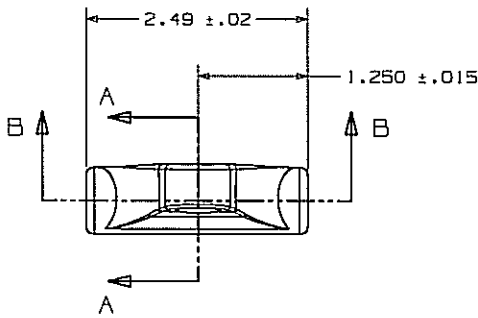
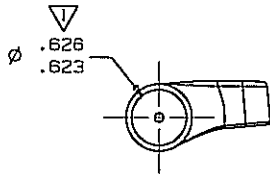
will be finished in next Assy.

△ CAST SURFACE VISUAL SEVERITY LEVEL AA.

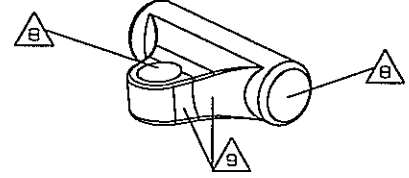
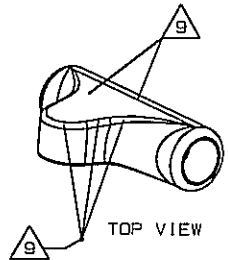
△ CAST SURFACE VISUAL SEVERITY LEVEL A.

△ CAST SURFACE VISUAL SEVERITY LEVEL AA, EXCEPT NO PARTING LINES, WITNESS LINES, GRINDING MARKS OR NONUNIFORMITY IN THE SURFACE.

△ BREAK ALL SHARP EDGES .030 MIN.



SECTION A-A
SCALE 2:1



ALL OTHER SURFACES NOT MARKED BY △ OR ▽

TOP VIEW
BOTTOM VIEW

9-9-09 408

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	ORIGINAL RELEASE, SIMILAR TO 777096-679	DG	07/25/04	BCT017385
B	Removed Cobe name, Added BOR, Chgd .510 & .501/.515 Dim to .501/.502	MY	03/19/08	BCT025811

800	I	EA	777094-442	TEE, CAST
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION
BILL OF REFERENCE				
THESE DIMENSIONS AND SPECIFICATIONS ARE THE PROPERTY OF CARIDIANBCT, INC. AND SHALL NOT BE REPRODUCED, COPIED, OR USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF CARIDIANBCT, INC.				
TOLERANCES AND FINISHES UNLESS OTHERWISE SPECIFIED: FRACTIONS DECIMALS ANGLES SURF. FINISH SEE NOTES		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED MATERIAL 304 STAINLESS STEEL ORIGINATOR DATE		
SIZE SCALE FULL SCALE ONLY		TITLE TEE, CAST, OPTIA MODIFIED PART NO. 777094-198 REV B 1/1		

CAD GENERATED DWG
UG DWG