

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 | SIZE | |
|------------------------|----------|---------|
| | 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 GAMBRO BCT.
- 5 ▽ INDICATES KEY DIMENSION OR SURFACE(S) TO BE CHECKED BY INCOMING O.C..
- 6 SECONDARY SURFACE FINISH:

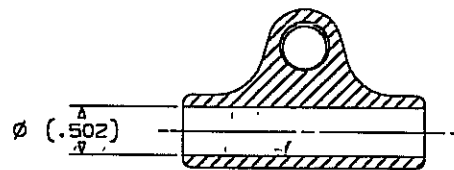
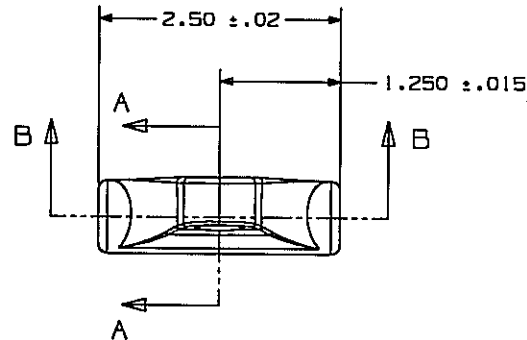
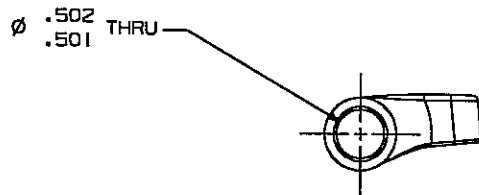
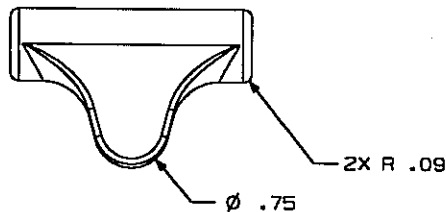
ALL EXTERIOR SURFACES (MARKED BY NOTE 7, 8 AND 9) TO BE POLISHED & ALUMINUM OXIDE GRIT BLASTED TO AN ACCEPTABLE (APPROVED BY GAMBRO BCT) FINISH FOR ELECTROPOLISHING.

⚠ CAST SURFACE VISUAL SEVERITY LEVEL AA.

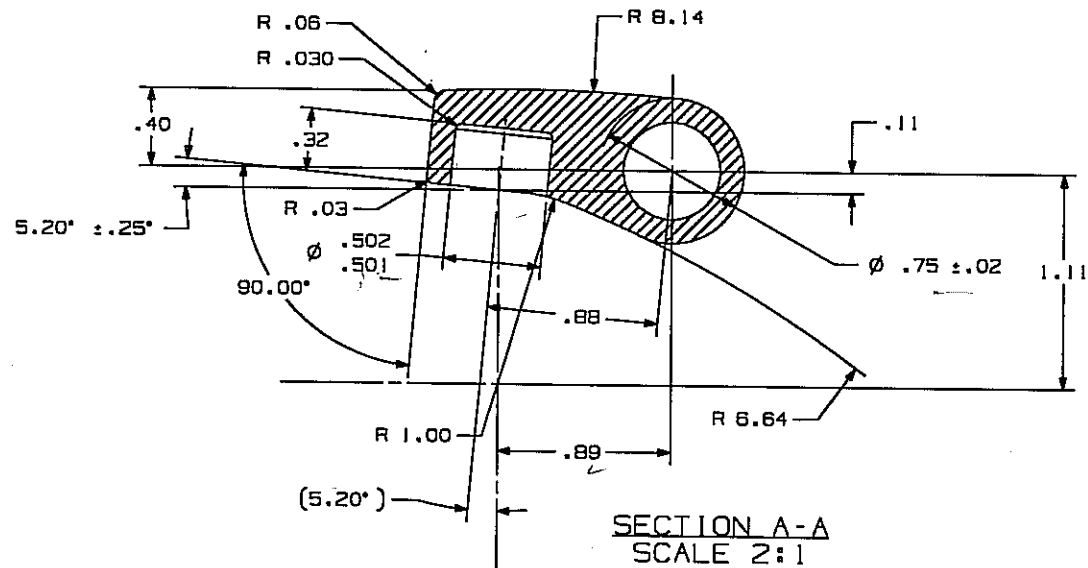
⚠ CAST SURFACE VISUAL SEVERITY LEVEL A.

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

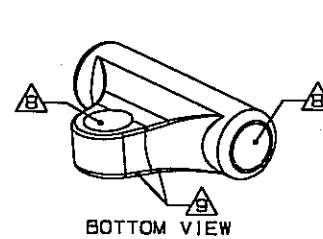
will be done in next Assy



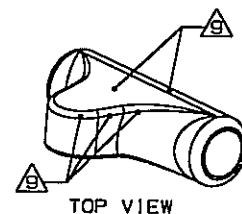
SECTION B-B



SECTION A-A
SCALE 2:1



BOTTOM VIEW



TOP VIEW

ALL OTHER SURFACES NOT MARKED BY ⚠ OR ⚠

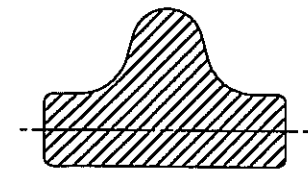
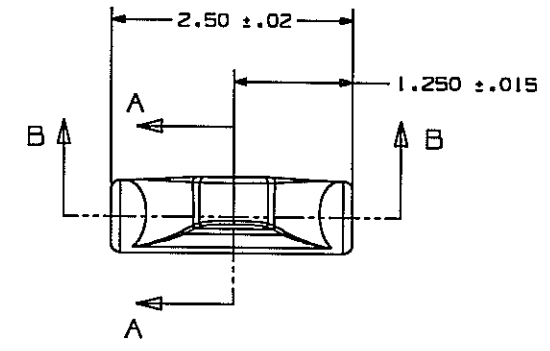
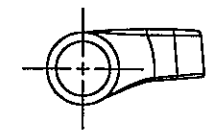
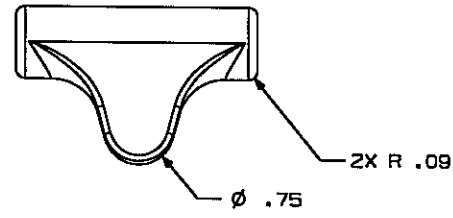
7-27-09 40B

800	1	EA	777094-442	TEE, CAST
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION
BILL OF REFERENCE				
THESE DIMENSIONS AND SPECIFICATIONS ARE THE PROPERTY OF GAMBRO BCT, INC. AND SHALL NOT BE REPRODUCED, COPIED, OR USED FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF GAMBRO BCT, INC.				
TOLERANCES AND FINISHES UNLESS OTHERWISE SPECIFIED ARE:		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		
.XX ± .1		ANGLES		
.XX ± .02		± .5°		
.XXX ± .010		SURF. FINISH		
.XXXX ± .0050		SEE NOTES		
MATERIAL		304 STAINLESS STEEL		
ORIGINATOR		C HAKE		
DATE		1/2/97		
DRAWN		C HAKE		
DATE		1/2/97		
PART NO.		777096-679		
REV		B 1/1		

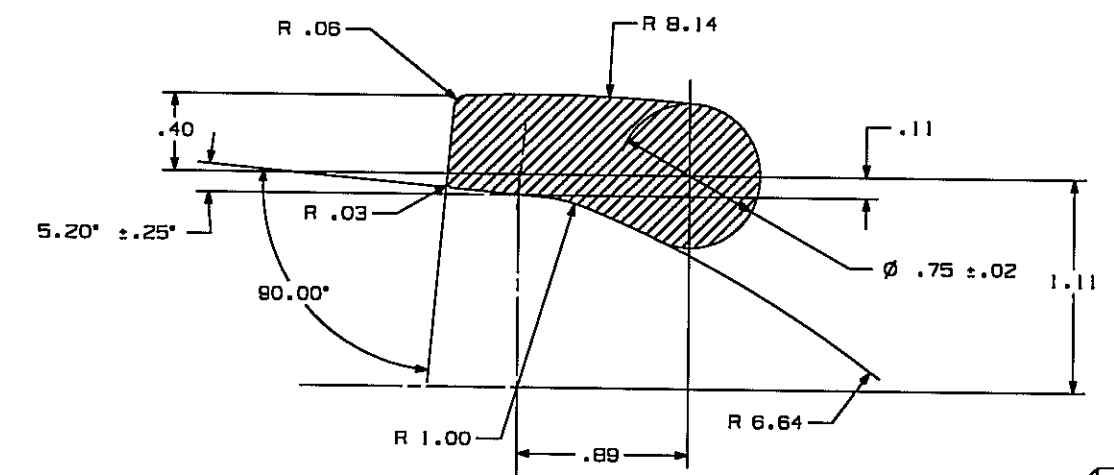
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- | TYPE OF DEFECT | LEVEL AA | LEVEL A |
|------------------------|----------|---------|
| NEGATIVES | | |
| MAX LENGTH..... | .020 | .035 |
| MAX DEPTH..... | .015 | .030 |
| POSITIVES | | |
| MAX LENGTH..... | .010 | .025 |
| MAX HEIGHT..... | .010 | .020 |
| NONFILL..... | .010 | .020 |
| MISMATCH, PARTING LINE | | |
| MAX HEIGHT..... | .005 | .010 |
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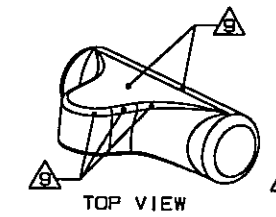
- △ CAST SURFACE VISUAL SEVERITY LEVEL AA.
- △ CAST SURFACE VISUAL SEVERITY LEVEL A.
- △ CAST SURFACE VISUAL SEVERITY LEVEL AA, EXCEPT NO PARTING LINES, WITNESS LINES, GRINDING MARKS OR NONUNIFORMITY IN THE SURFACE.



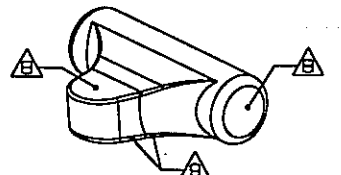
SECTION B-B



SECTION A-A
SCALE 2:1



TOP VIEW



BOTTOM VIEW

ALL OTHER SURFACES NOT MARKED BY △ OR ▽

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	INITIAL RELEASE, CREATED FROM 777096-679.	AR	11/07/08	BCT018198

TOLERANCES AND SURFACE FINISH DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
±.1	ANGLES	MATERIAL	
±.02	±.5°	304 STAINLESS STEEL	
±.010	SURF. FINISH	ORIGINATOR	
±.0050	SEE NOTES	AMIR ROOM1	
DATE	DATE	DATE	
7-27-09	408	7-27-09	