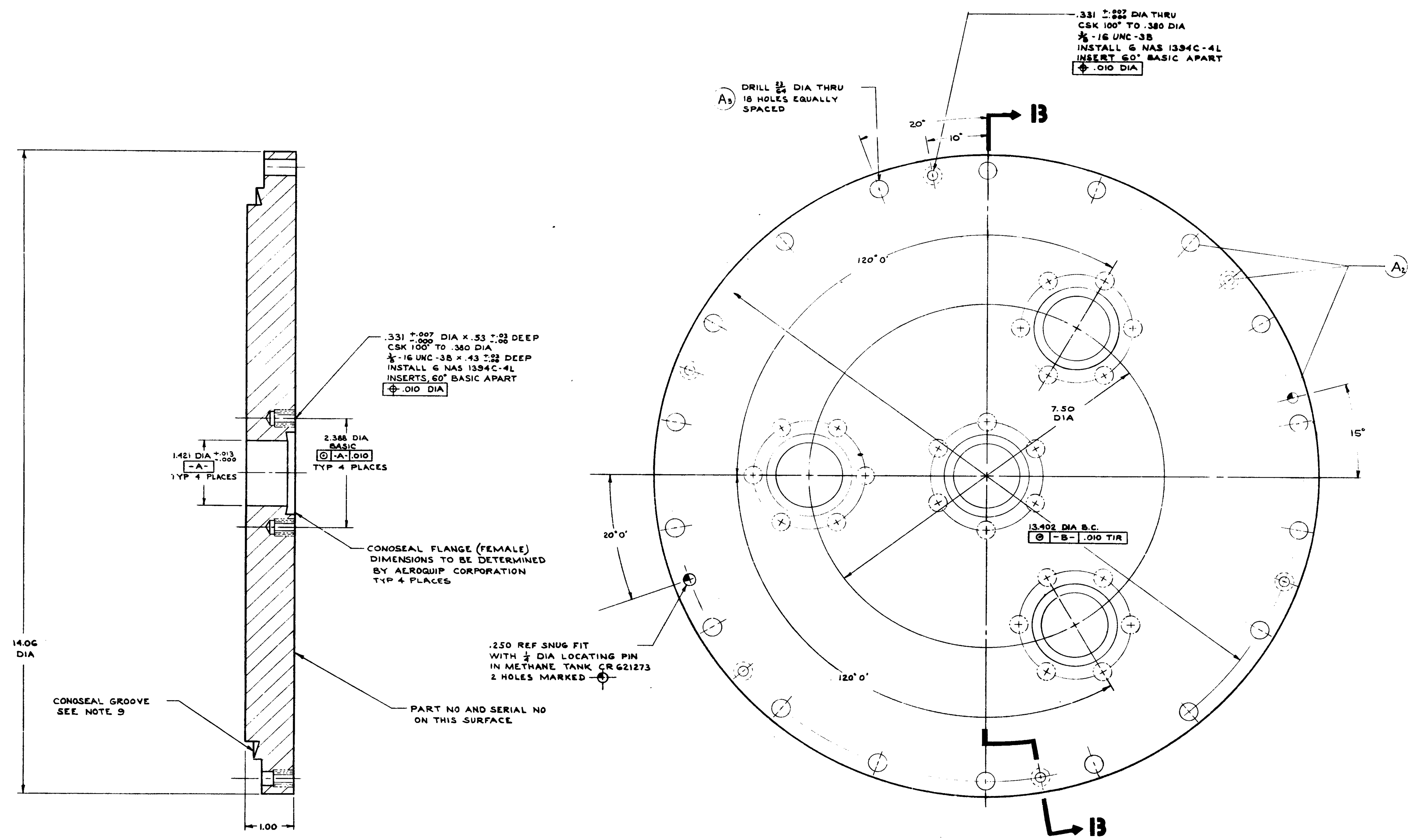

B-B

1. ULTRASONIC INSPECT PER MIL-U-81055 QUALITY LEVEL II PRIOR TO ANY FABRICATION PROCESSES.
2. FLUORESCENT PENETRANT INSPECT PER MIL-I-6866 B, AMEND 1, TYPE 1, METHOD B BEFORE SURFACE TREATMENT. PENETRANT LIQUID SHALL BE MAGNAFLUX CORPORATION "ZYGLO-PENTREX ZL-22" OR APPROVED. (NO CRACKS ALLOWED)
3. CLEAN ALL SURFACES WITH TRICHLOROETHANE PER FEDERAL SPECIFICATION O-T-620, THEN DRY.
4. SURFACE TREAT PER MIL-C-5541A, TYPE 1, GRADE C, CLASS 3, (IRIDITE 14.2 OR APPROVED.)
5. PART NO. AND SERIAL NO. SHALL BE APPLIED BY THE MONODE ELECTROLYTE PROCESS, OR OTHER ACCEPTABLE ELECTRO-CHEMICAL-ETCHING PROCESS. NUMBERS AND LETTERS SHALL BE .1 HIGH. IMPRESSION MARKING OF PART, NOT PERMITTED.
6. 125 ALL OVER UNLESS OTHERWISE SPECIFIED.
7. ALL THREADED INSERTS TO BE INSTALLED PRIOR TO FINISH MACHINING OF CONOSEAL GROOVES.
8. APPLY ZINC CHROMATE PER MIL-P-8585 TO THREADED INSERTS, INSTALL WHILE PRIMER IS STILL WET. WIPE OFF EXCESS PRIMER WITH CLEAN CLOTH.
9. GROOVE TO BE SUITABLE FOR "CONOSEAL 50887-1200A" GASKET. PRODUCT OF AEROQUIP CORPORATION/MARMAN DIVISION REF CATALOG 819 B. FINISH TO BE ALODYNE IN GROOVE. (A1)

CF 621274

CHANGE	NO.	REVISION	DATE	APP.
A	3	18 HOLES WAS 12 HOLES	5-25-70	KID
	2	REPOSITIONED HOLES & SPACING		
	1	B WAS A		

SCALE: 1/1

.XX ± .03
.XXX ± .010

INITIAL	DATE
L.J.A.	2-10-70
KID	3-2-70

DOOR - CRYOGENIC TANK METHANE

TANK ASSEMBLY - METHANE CR 621273

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
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CLEVELAND, OHIO

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