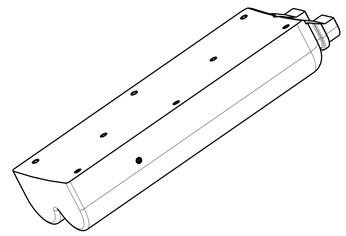
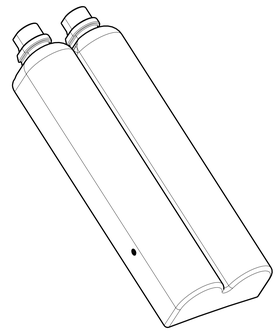
COMMERCIAL PARTS LIST

BALLOON NO	DESCRIPTION	QTY/ ASSY	
C1	INSERT, SCREW-THREAD, LOCKING, KEY LOCKED, HEAVY DUTY, MS51831-109(L), (MATERIAL: TYPE 302/303 STAINLESS STEEL), (FOR .750-10 FASTENER)	8	6
C2	.750-10 UNC-3A X 1.00 LG, HEX SOCKET, SELF LOCKING, SET SCREW, McMASTER-CARR NUMBER 91385A934 (OR EQUIVALENT)	4	8

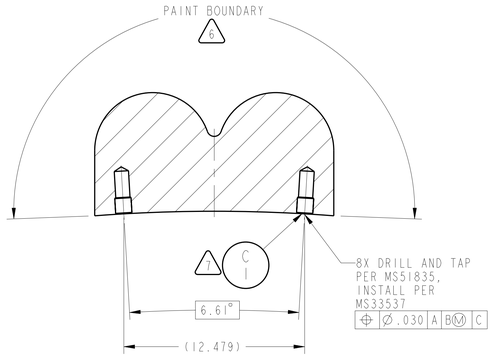


SCALE 1/8

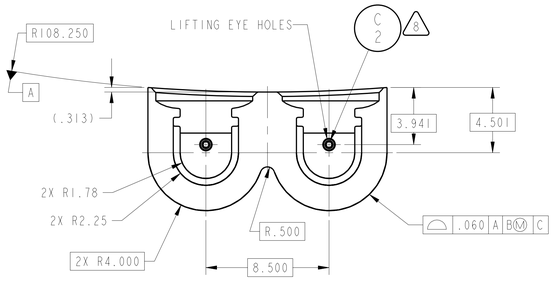


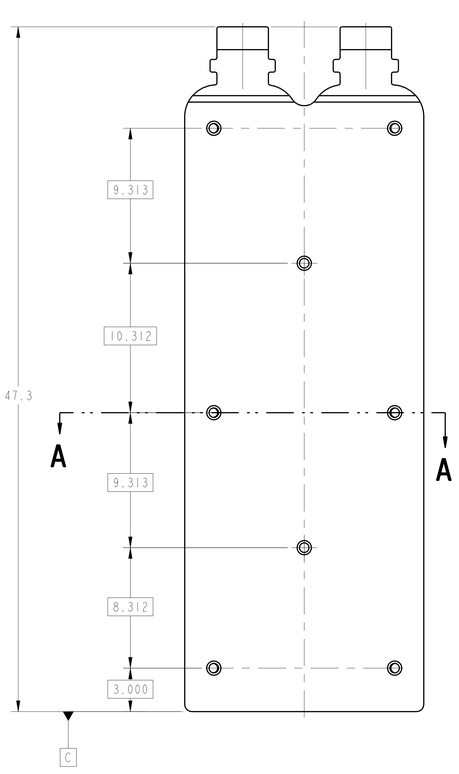
SCALE 1/8

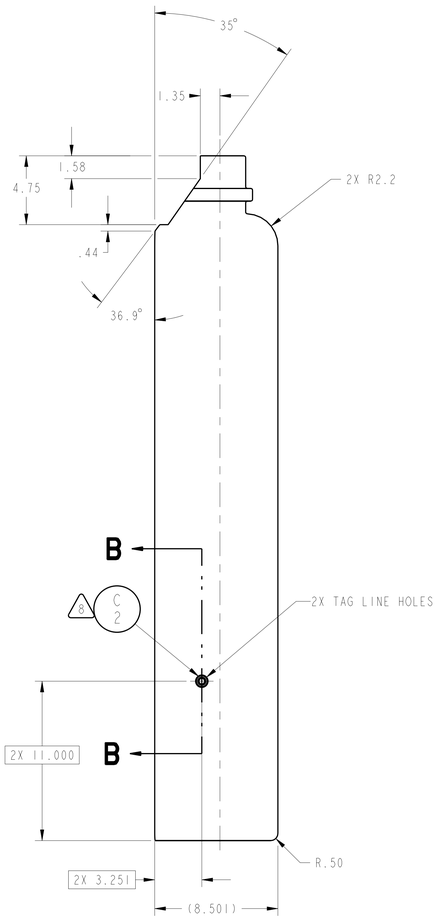
1. MATERIAL: 6061-T651 ALUMINUM PER SAE-AMS-QQ-A-250/11. CERTIFICATE OF CONFORMANCE REQUIRED.
2. 125 Ra ALL MACHINED SURFACES.
3. ELECTRONIC PART FILE TO BE PROVIDED.
4. IDENTIFY PART BY ENGRAVING DRAWING PART NUMBER 060213MFA798 ON SPECIFIED SURFACE PER SAE-AS478, METHOD 3 (ZONE B3).
5. SURFACE TREATMENT PER MIL-C-5541E, CLASS 3. USE IRIDITE 14.2 OR REQUESTER APPROVED EQUAL PER MIL-DTL-81706B, CLASS 1A, FORM II, METHOD B OR C AS APPLICABLE. SPOT TOUCH UP BY METHOD B.
6. EXTERNAL SURFACES WITHIN INDICATED PAINT BOUNDARY: COAT WITH NATIONAL COATINGS AcryShield HIGH REFLECTIVE A590 (WHITE) TOPCOAT FOLLOWING MANUFACTURERS SUGGESTED APPLICATION PROCEDURE. THE COATING THICKNESS SHALL BE 6-10 MILS (DRY).
7. INSTALL ITEM C1 (LOCKING INSERTS) AFTER SURFACE TREATMENT.
8. FASTENERS ARE TO BE INSTALLED AFTER PROTUBERANCE INSTALLATION.
9. APROXIMATE WEIGHT 494 LBS.

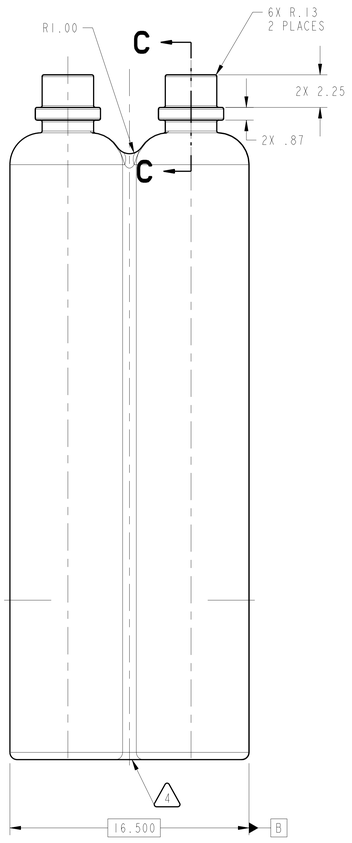


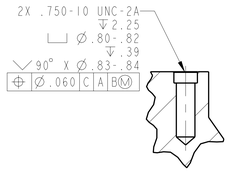
SECTION **A-A**



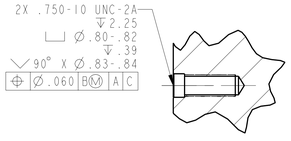








SECTION **C-C**
SCALE 1/2
LIFTING EYE HOLES
(SET SCREW NOT SHOWN)



SECTION **B-B**
SCALE 1/2
TAG LINE HOLES
(SET SCREW NOT SHOWN)

DATE / INITIAL	ECR	DEV	WAV	ECR IMPLEMENTED / QA SIGNATURE/DATE

RELEASED BY AIX USS CMO ON 5/7/08 FOR PRPCUREMENT USE
DO NOT COPY

CHG	ZONE	DESCRIPTION	APP/DATE
		REVISIONS	

PRIOR TO USE VERIFY THE INTENDED PURPOSE IN PDM ("FOR" ATTRIBUTE)

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

CONTRACT -
CONTRACTOR -
TASK ORDER

TOLERANCE ON			
X	± 0.03	DRAFTER	DEZ/D. DRAGONY
.XX	± 0.01	ENGINEER	DES/J. HUNTER
.XXX	± 0.005	DESIGNER	DEZ/D. DRAGONY
FRACTION	± -		
ANGULAR	± 0.50°		
BREAK EDGES	.01-.02		

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994

PDM REL LEVEL: Released PDM REVISION: -
PDM DATABASE:
MODEL NAME: 060213MFA798_ULLAGE_PROTUB
CHECK FOR ANY OUTSTANDING ECO'S PRIOR TO USE

????	SINGLE PART DRAWING
????-?	CHARTED PART DRAWING
C ?	COMMERCIAL PART
E ?	EXISTING PART

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
JOHN H. GLENN RESEARCH CENTER
LEWIS FIELD
CLEVELAND, OHIO

US-1 SEGMENT ASSEMBLY
060213MFA300

A798 ULLAGE PROTUBERANCE

SIZE	DRAWING NUMBER	REV	BLDG	AREA
E	060213MFA798	-	50	HI BAY

UNITS: INCH

SCALE:	INITIAL REL DATE	SHEET	DISCIPLINE
1/4 AND NOTED	03/05/2008	1 OF 1	MECHANICAL

PRO/E VERSION: Wildfire 2.0

SIZE E DRAWING NUMBER 060213MFA798 REV -

NAME/USER: OBSCF\060213MFA798_ULLAGE_PROTUB DATE:04-MAR-08 13:13:00