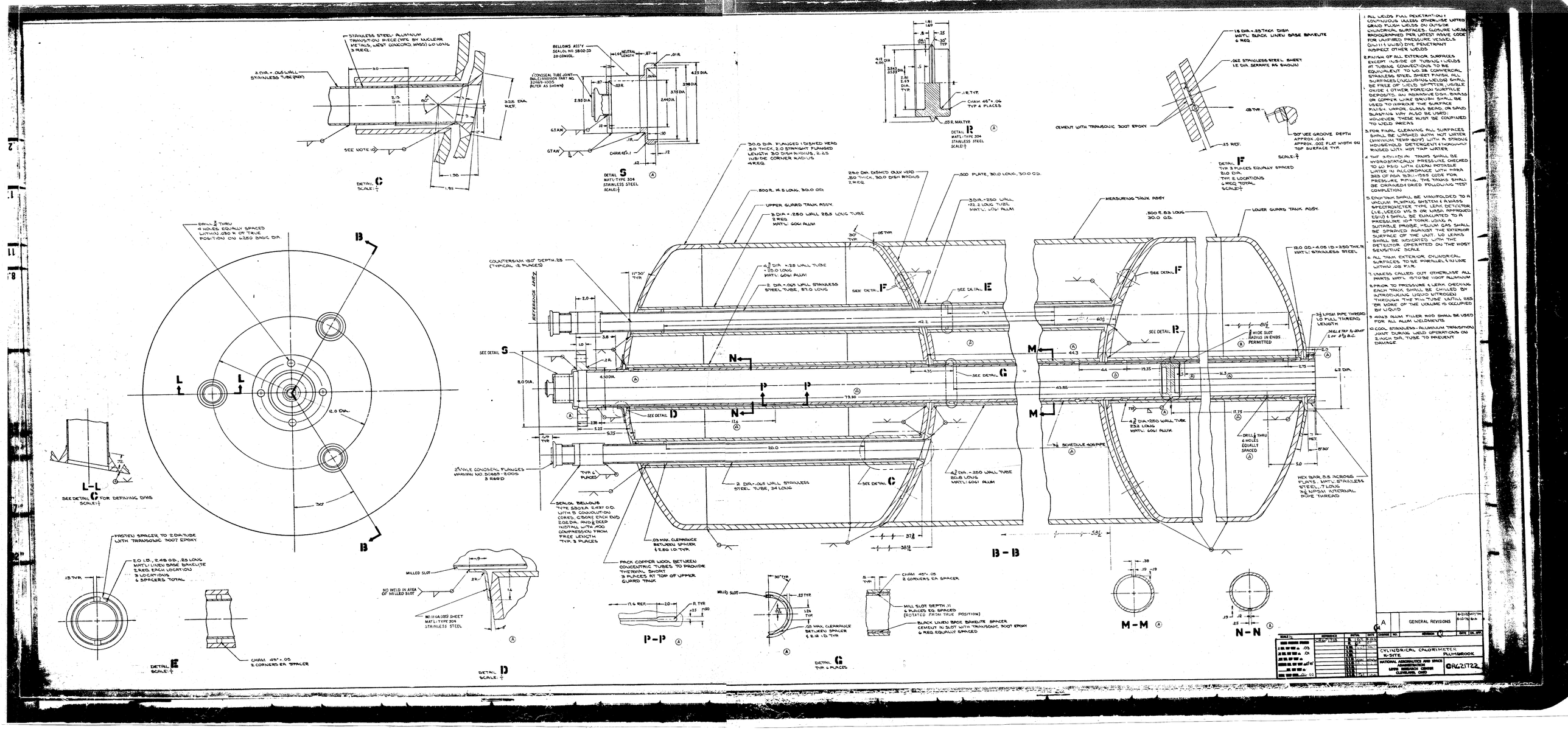

1. ALL WELDS FULL PENETRATION CONTINUOUS UNLESS OTHERWISE NOTED GRIND FLUSH WELDS ON OUTSIDE CYLINDRICAL SURFACES. CLOSURE WELDS RADIOGRAPHED PER LATEST ASME CODE FOR UNFIRED PRESSURE VESSELS (PAR 1-5 UW51) DYE PENETRANT INSPECT OTHER WELDS
2. FINISH OF ALL EXTERIOR SURFACES EXCEPT INSIDE OF TUBING I.D.S AT TUBING CONNECTIONS TO BE EQUIVALENT TO NO. 2B COMMERCIAL STAINLESS STEEL SHEET FINISH. ALL SURFACES (INCLUDING WELDS) SHALL BE FREE OF LOOSE SCALE, VISIBLE OXIDE (OTHER FOREIGN SURFACE DEPOSITS. AN ABRASIVE DISK, BRASS OR COPPER LINK BRUSH SHALL BE USED TO IMPROVE THE SURFACE FINISH. VAPOR GLASS BEAD, OR SAND BLASTING MAY ALSO BE USED; HOWEVER THESE MUST BE CONFINED TO WELD AREAS
3. FOR FINAL CLEANING ALL SURFACES SHALL BE FLUSHED WITH HOT WATER (MINIMUM TEMP 160°F) WITH A STRONG HOUSEHOLD DETERGENT THOROUGHLY RINSED WITH HOT TAP WATER
4. THE WINDING TANKS SHALL BE HYDROSTATICALLY PRESSURE CHECKED TO 60 PSIG WITH CLEAN POTABLE WATER IN ACCORDANCE WITH PARA 303 OF ASA B31.1-1955 CODE FOR PRESSURE PIPING. THE TANKS SHALL BE DRAINED & DRIED FOLLOWING TEST COMPLETION)
5. EACH TANK SHALL BE MANIFOLDED TO A VACUUM PUMPING SYSTEM & MASS SPECTROMETER TYPE LEAK DETECTOR (i.e. VEECO MS 9 OR MASA APPROVED EQUIV) & SHALL BE EVACUATED TO A PRESSURE OF TORR USING A SUITABLE PROBE, HELIUM GAS SHALL BE SPRAYED AGAINST THE EXTERIOR SURFACE OF THE UNIT. LO LEAKS SHALL BE INDICATED WITH THE DETECTOR OPERATED ON THE MOST SENSITIVE SCALE
6. ALL TANK EXTERIOR CYLINDRICAL SURFACES TO BE PARALLEL TO LINE WITHIN .05 T.I.R.
7. UNLESS CALLED OUT OTHERWISE ALL PARTS MATL TO BE 1100 ALUMINUM
8. PRIOR TO PRESSURE & LEAK CHECKING EACH TANK SHALL BE CHILLED BY INTRODUCING LIQUID NITROGEN THROUGH THE FILL TUBE UNTIL 2/3 OR MORE OF THE VOLUME IS OCCUPIED BY LIQUID
9. 4043 ALUM FILLER ROD SHALL BE USED FOR ALL ALUM WELDMENTS
10. COOL STAINLESS - ALUMINUM TRANSITION JOINT DURING WELD OPERATIONS ON 2 INCH DIA. TUBE TO PREVENT DAMAGE

REVISIONS				
ZONE	REFERENCE	BY	DATE	CHANGE NO.
A	GENERAL REVISIONS		4-21-61 5-10-61	

SCALE: 1/2	REFERENCE DRAWINGS	INITIAL	DATE	APPROVALS
	C60P1718			DRAWN
				CHECKED
				ENGR.
				PROJ. ENGR.
				PROJ. MGR.
				QUAL. MGR.

CYLINDRICAL CALORIMETER
K-SITE
PLAINBROOK

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
LEWIS RESEARCH CENTER
CLEVELAND, OHIO

CR62172