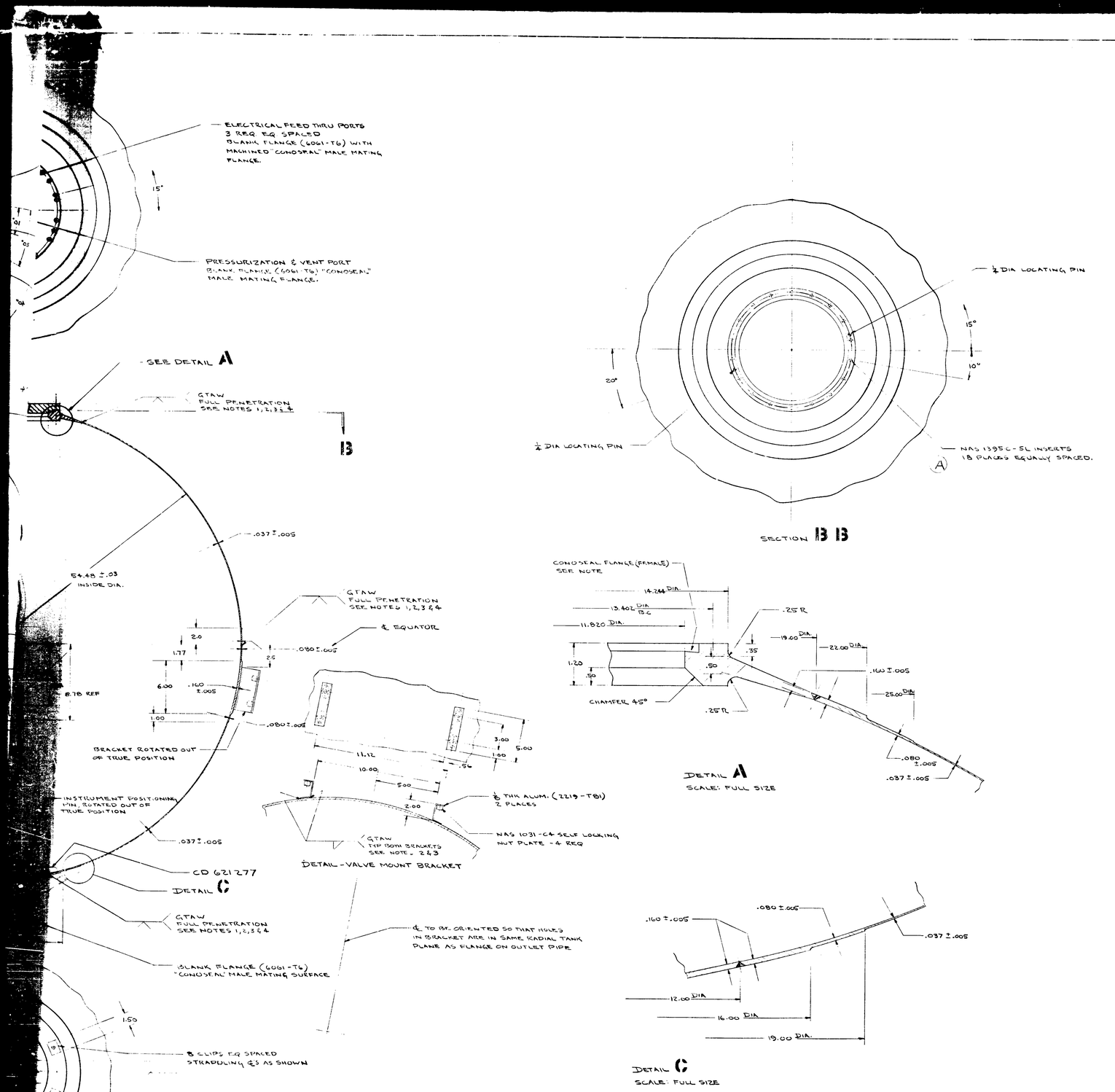

GENERAL NOTES

1. FULL PENETRATION WELDS SHOULD BE GROUND FLUSH ON THE INSIDE.
2. WELD PER MIL W-8604.
3. 100% RADIOGRAPHIC INSPECT PER MIL R 45774 STANDARD II.
4. DYE PENETRANT INSPECT ALL WELDS PER MIL I-6866.
5. ONLY EXTERNAL TANK SURFACES SHALL BE TREATED.
6. SURFACE TREAT PER MIL C-5541 A TYPE 1, GRADE C, CLASS 3 (IRIDITE 4.2 OR APPROVED.
7. TANK DESIGN PRESSURES.
   - MAX WORKING PRESS. - 50 PSIG
   - PROOF PRESS. - 75 PSIG
   - BURST PRESS. - 100 PSIG
8. ALL THREADED INSERTS TO BE INSTALLED PRIOR TO FINISH MACHINING OF CONOSEAL GROOVES.
9. DIMENSIONS OF ALL CONOSEAL GROOVES SHALL BE DETERMINED BY AEROQUIP CORPORATION - MARMON DIVISION 11214 EXPOSITION BLVD. LOS ANGELES, CALIFORNIA 90064
10. APPLY ZINC CHROMATE PER MIL P-8585 TO THREADED INSERTS, INSTALL WHILE PRIMER IS STILL WET. WIPE OFF EXCESS PRIMER WITH CLEAN CLOTH.

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CAUTION
THIS DRAWING IS PRINTED AT REDUCED SIZE
USE GRAPHIC SCALE
UNLESS APPLICABLE

CHANGE NO.	REVISION	DATE	CK. APP.
A	REPOSITION ED BOLT HOLES ON TANK DOOR (WAS 1 HOLE)	2-25-70	KID

SCALE ±℄ AS NOTED	REFERENCE	INITIAL	DATE
UNLESS OTHERWISE SPECIFIED	MAT'L	DR.	
	2219-T	CK.	W.J.S. 2-11-70
.X DIM. SHOP TOLT ± .06	ALUM ALLOY	ENGR.	KID 2-2-70
.XX DIM. SHOP TOLT ± .03		ENGR.	
.XXX DIM. SHOP TOLT ± .005		ENGR.	
ANGULAR DIM. SHOP TOLT ± .5°	SAFETY APPROVAL	ENGR.	W.H.A. 2-25-70
___ DIM. SHOP TOLT ±		ENGR.	
		ENGR.	
		ENGR.	
	PROJECT ENGR. DATE	ENGR.	Jay Jones 2/11/70

TANK ASSEMBLY - METHANE

RESEARCH PROPULSION MODULE

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
LEWIS RESEARCH CENTER
CLEVELAND, OHIO

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