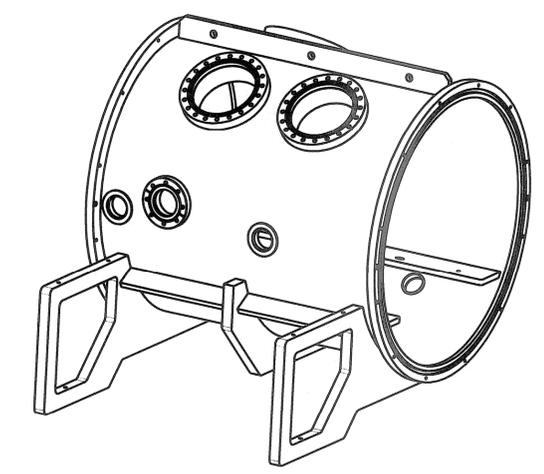
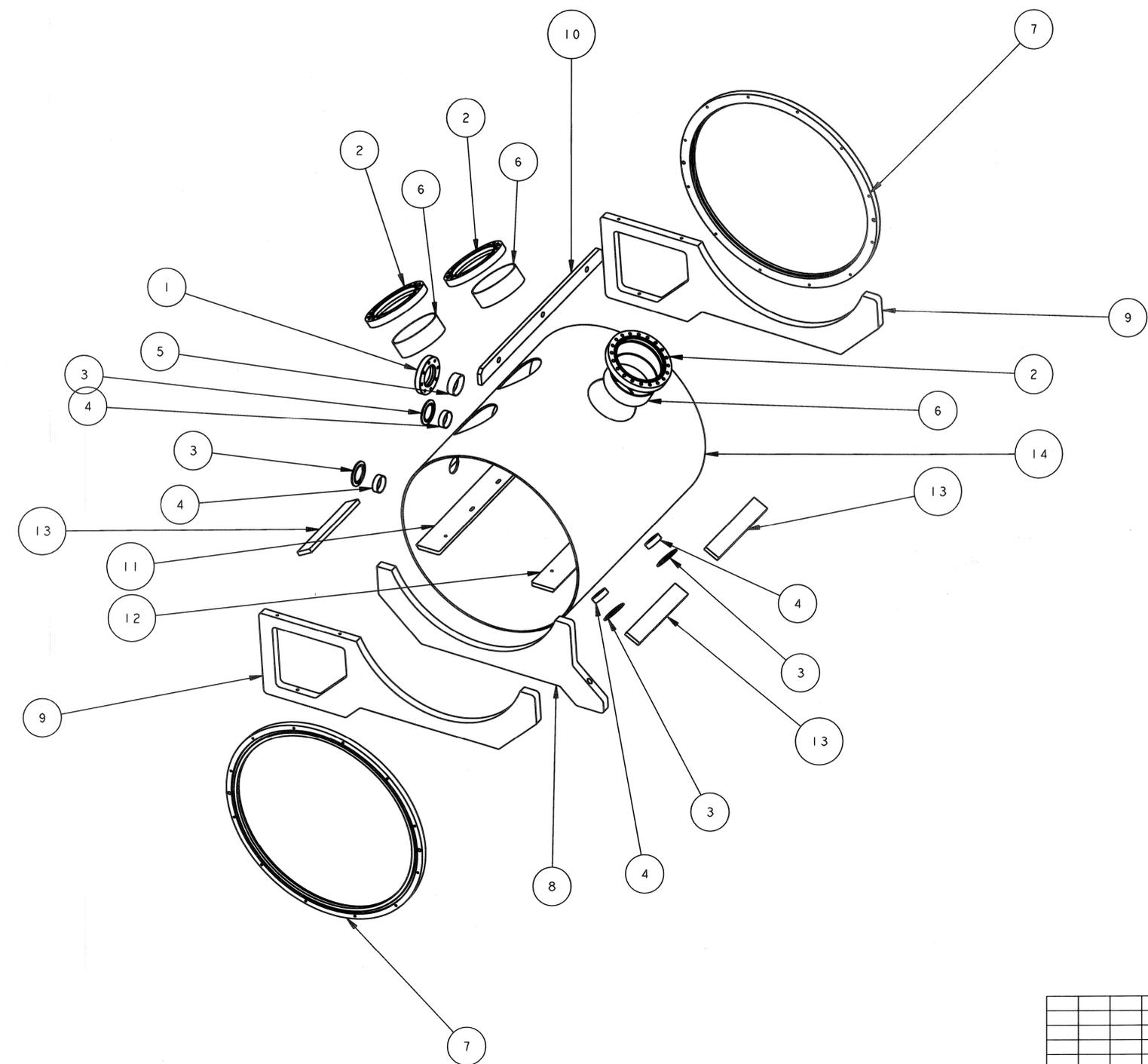


NOTES:

1. APPLICABLE STANDARDS/SPECIFICATIONS:
ASME Y14.100, ENGINEERING DRAWING PRACTICES,
MIL-STD-31000, TECHNICAL DATA PACKAGES.
2. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.
3. SURFACE ROUGHNESS SHALL BE 125 RMS OR BETTER.
4. ALL WELDING SHALL BE DONE IN ACCORDANCE TO ASME
BPVC (BOILER & PRESSURE VESSEL CODE) SECTION VIII, DIV I.
5. LEAK TEST (LT) SHALL BE PERFORMED, USING HELIUM, TO MINIMUM
VACUUM LEVEL OF 1×10^{-7} TORR AFTER WELDING.

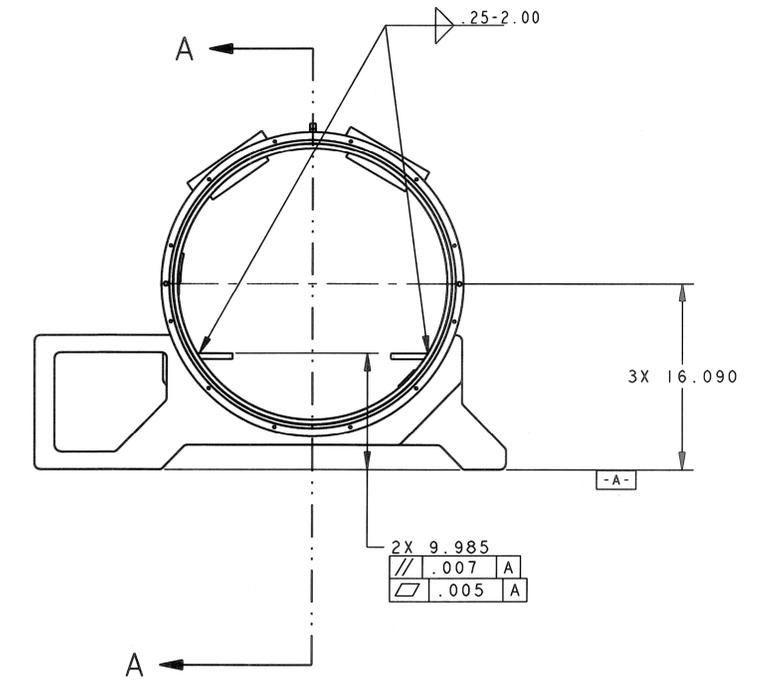
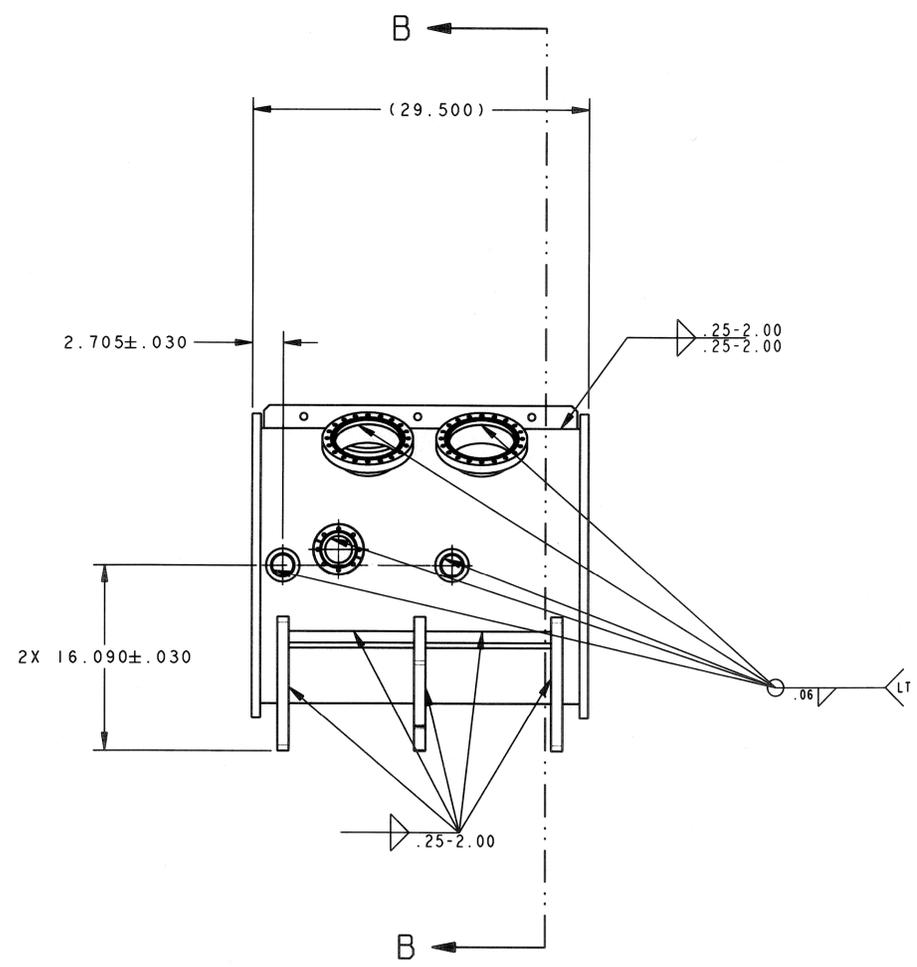
REVISION HISTORY							
ZONE	REV	DESCRIPTION	DRAWN	CHECKED	LEAD ENGR	BRANCH	DATE



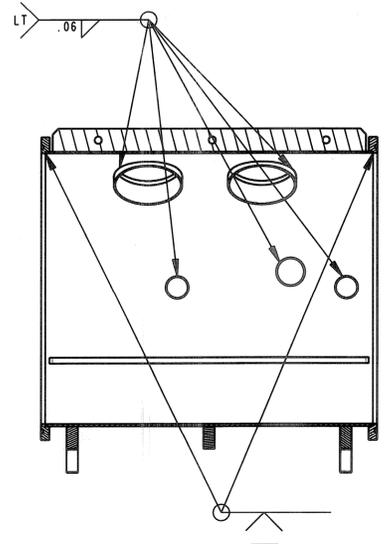
QTY REQD	CAGE CODE	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	ITEM NO.
1		1252004-001	VACUUM HOUSING CENTER	CRES 304L AMS 5511	14
4		1252004-031	SUPPORT RIBS	CRES 304L AMS 5511	13
1		1252004-015	SHELF, INTERNAL 2	CRES 304L AMS 5511	12
1		1252003-013	SHELF, INTERNAL 1	CRES 304L AMS 5511	11
1		1252004-043	RAIL, LIFT SUPPORT	CRES 304L AMS 5511	10
2		1252004-007	LEG, FRONT/REAR	CRES 304L AMS 5511	9
1		1252004-005	LEG, CENTER	CRES 304L AMS 5511	8
2		1252004-003	FRONT/REAR FLANGE	CRES 304L AMS 5511	7
3	4EJP8	480012 OR EQUIVALENT	TUBE, 6.00 X 2.0 X .065	CRES 304L	6
1	4EJP8	480008 OR EQUIVALENT	TUBE, 2.50 X 2.0 X .065	CRES 304L	5
4	4EJP8	480007 OR EQUIVALENT	TUBE, 2.00 X 2.0 X .065	CRES 304L	4
4	4EJP8	713022 OR EQUIVALENT	FLANGE, KF50	CRES 304L	3
3	4EJP8	130031 OR EQUIVALENT	FLANGE, DEL-SEAL, CF 8.00	CRES 304L	2
1	4EJP8	130021 OR EQUIVALENT	FLANGE, DEL-SEAL, CF 4.50	CRES 304L	1

PARTS LIST

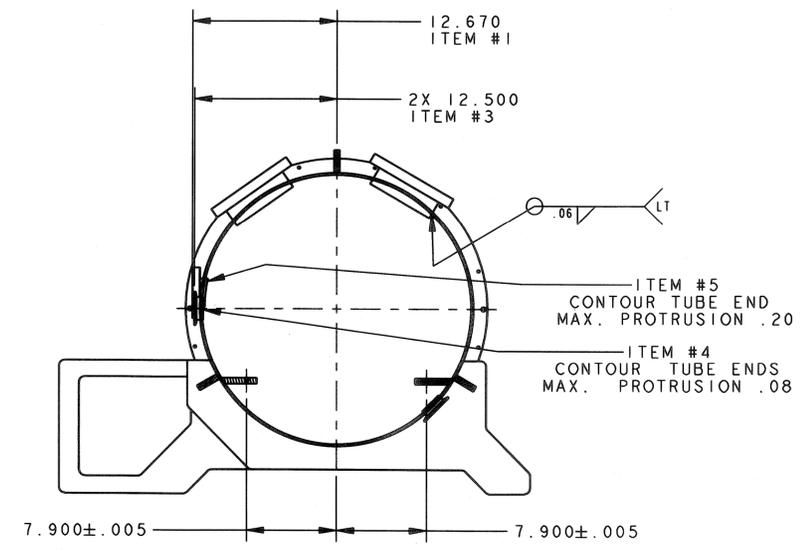
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS .XX ± .03 ANGULAR .X ± .5° XXX ± .010 DO NOT SCALE DRAWING		CONTRACT NO.		NATIONAL AERONAUTICS & SPACE ADMINISTRATION LANGLEY RESEARCH CENTER HAMPTON, VA 23681-2199	
TREATMENT		APPROVALS	DATE	TITLE	
FINISH		M. J. MCKENNEY	25-Aug-11	HOUSING CENTER SECTION VACUUM HOUSING ASSY IR CDS	
DRAWN		CHECKED	DATE	SIZE	CAGE CODE
DESIGNER		DATE	DATE	D	25305
LEAD ENGR		DATE	DATE	DWG. NO.	1252004
BRANCH		DATE	DATE	REV.	-
PART DASH NO.		APPLICATION		SCALE	1/8
-1	1	1	1252001	IR CDS	
QTY REQD PER ASSY	NEXT FINAL	NEXT ASSY	USED ON	SHEET 1 OF 10	



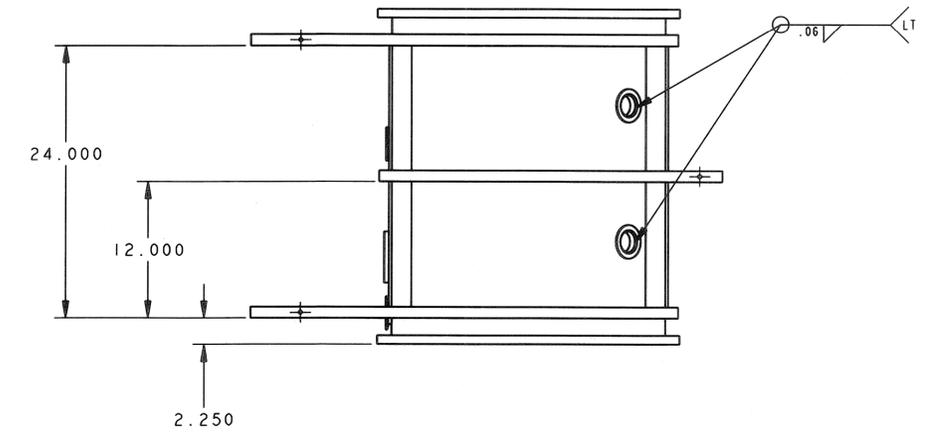
2X 9.985		
// .007	A	
/ .005	A	



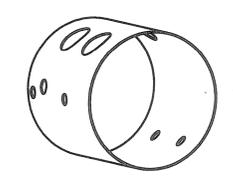
SECTION A-A



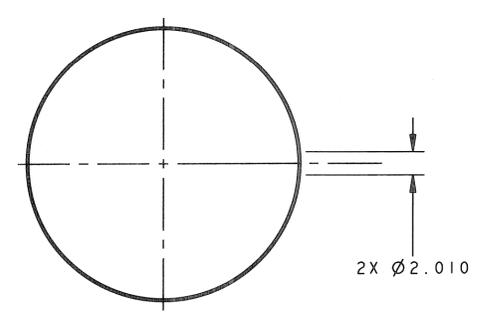
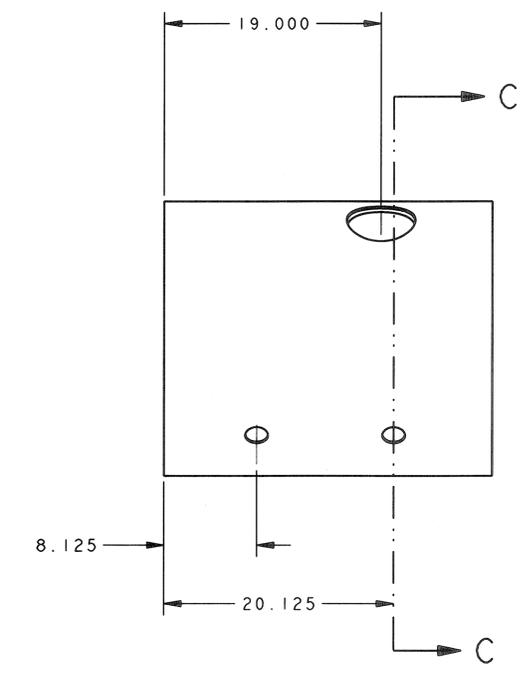
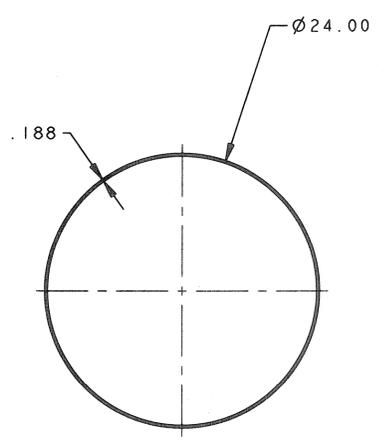
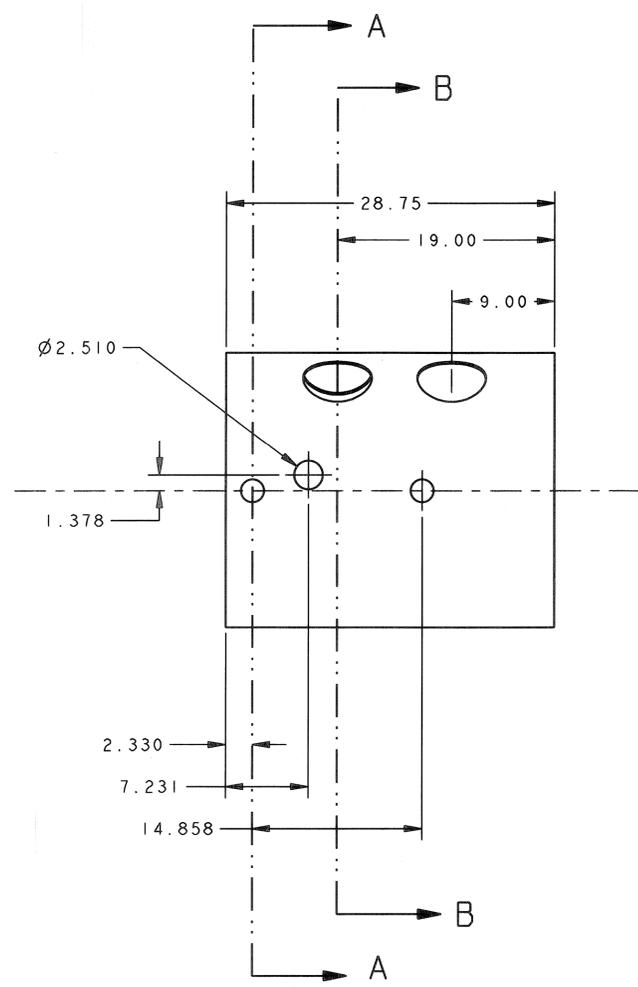
SECTION B-B



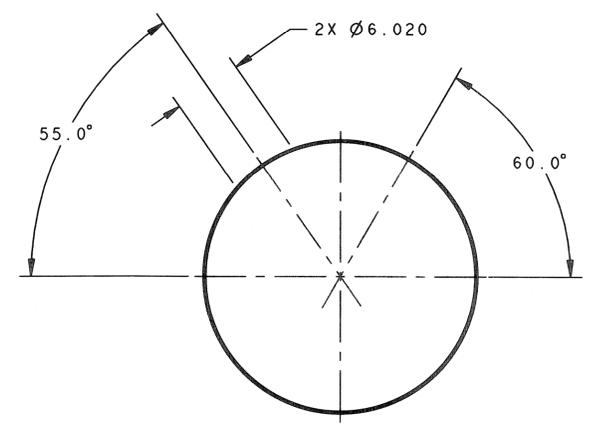
- NOTES:
1. APPLICABLE STANDARDS/SPECIFICATIONS:
ASME Y14.100, ENGINEERING DRAWING PRACTICES,
MIL-STD-31000, TECHNICAL DATA PACKAGES.
 2. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.
 3. SURFACE ROUGHNESS SHALL BE 125 RMS OR BETTER.



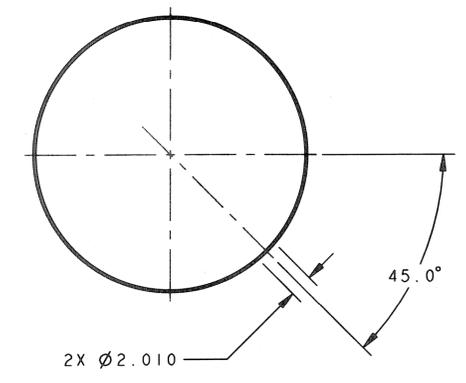
SCALE 1/16



SECTION A-A



SECTION B-B

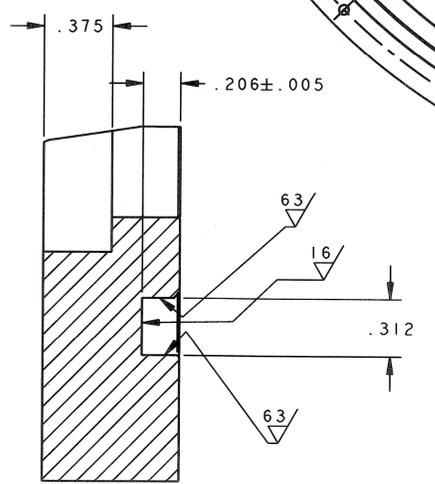
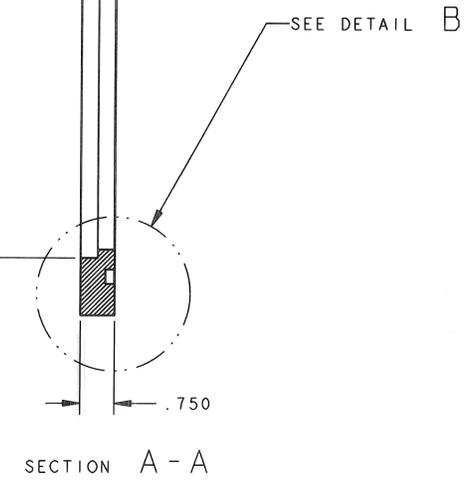
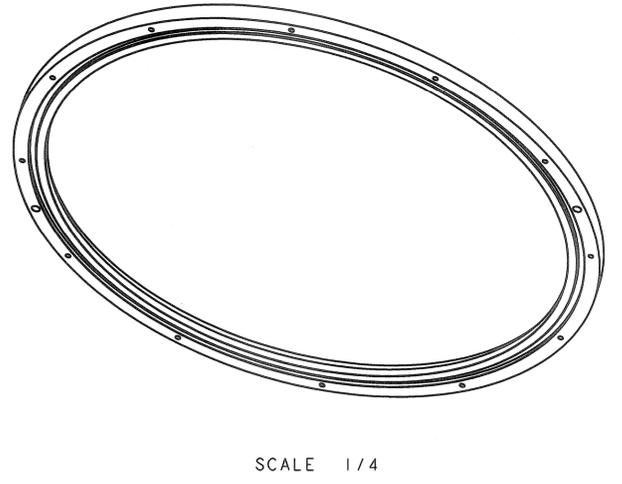
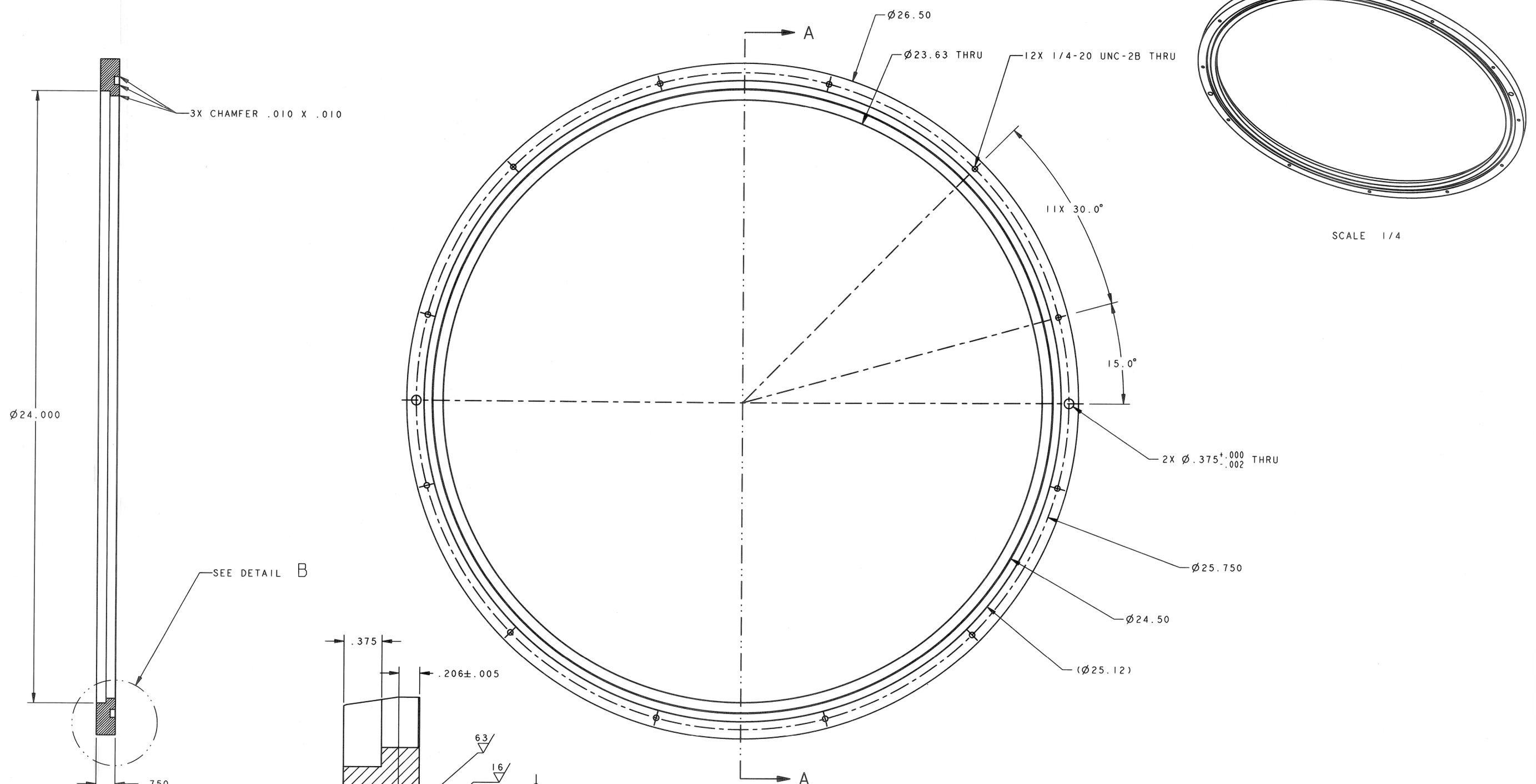


SECTION C-C

PART -001

I		1252004-001	VACUUM HOUSING CENTER	CRES 304L AMS 5511	I
QTY REQD	CAGE CODE	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	ITEM NO.
PARTS LIST					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS .03 .XX ± .03 .XXX ± .010 DO NOT SCALE DRAWING.			CONTRACT NO. NATIONAL AERONAUTICS & SPACE ADMINISTRATION LANGLEY RESEARCH CENTER HAMPTON, VA 23681-2199		
TREATMENT		APPROVALS	DATE	TITLE	
FINISH		M. J. MCKENNEY	24-Aug-11	VACUUM HOUSING CENTER, VACUUM HOUSING ASSY, IR CDS	
SIMILAR TO		CHECKED LA19357C	2011/01/06	SIZE CAGE CODE DWG. NO.	
SPECIAL MARKING SYM		DESIGNER		D 25305 1252004	
PART DASH NO.	NEXT FINAL	NEXT ASSY	USED ON	SCALE 1/8	SHEET 3 OF 10
-001	I	I	1252004 IR-CDS		

- NOTES:
1. APPLICABLE STANDARDS/SPECIFICATIONS:
ASME Y14.100, ENGINEERING DRAWING PRACTICES,
MIL-STD-31000, TECHNICAL DATA PACKAGES.
 2. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.
 3. SURFACE ROUGHNESS SHALL BE 125 RMS OR BETTER.



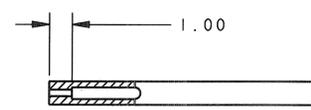
DETAIL B
SCALE 2/1

-003		FRONT/REAR FLANGE		CRES 304L AMS 5511		1	
QTY REQD	CAGE CODE	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION		MATERIAL SPECIFICATION	ITEM NO.	
PARTS LIST							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.				CONTRACT NO.			
TOLERANCES				APPROVALS			
DECIMALS .XX ± .03				DATE			
ANGULAR .X ± .5°				DRAWN			
XXX ± .010				CHECKED			
DO NOT SCALE DRAWING.				DATE			
TREATMENT				DRAWN			
FINISH				CHECKED			
SIMILAR TO				DATE			
SPECIAL MARKING SYM				DRAWN			
LEAD ENGR.				DATE			
BRANCH				DATE			
APPLICATION				TITLE			
NATIONAL AERONAUTICS & SPACE ADMINISTRATION LANGLEY RESEARCH CENTER HAMPTON, VA 23681-2199				FRONT/REAR FLANGE, VACUUM HOUSING ASSY, IR CDS			
PART DASH NO.		NEXT FINAL		NEXT ASSY.		USED ON	
-003		2		2		1252004-1	
QTY REQD PER ASSY		NEXT FINAL		NEXT ASSY.		USED ON	
2		2		2		1252004-1	
APPLICATION		NEXT FINAL		NEXT ASSY.		USED ON	
IR CDS		2		2		1252004-1	
SCALE 1/2		CAGE CODE		DWG. NO.		REV.	
1/2		25305		1252004		-	
SHEET		4		OF		10	

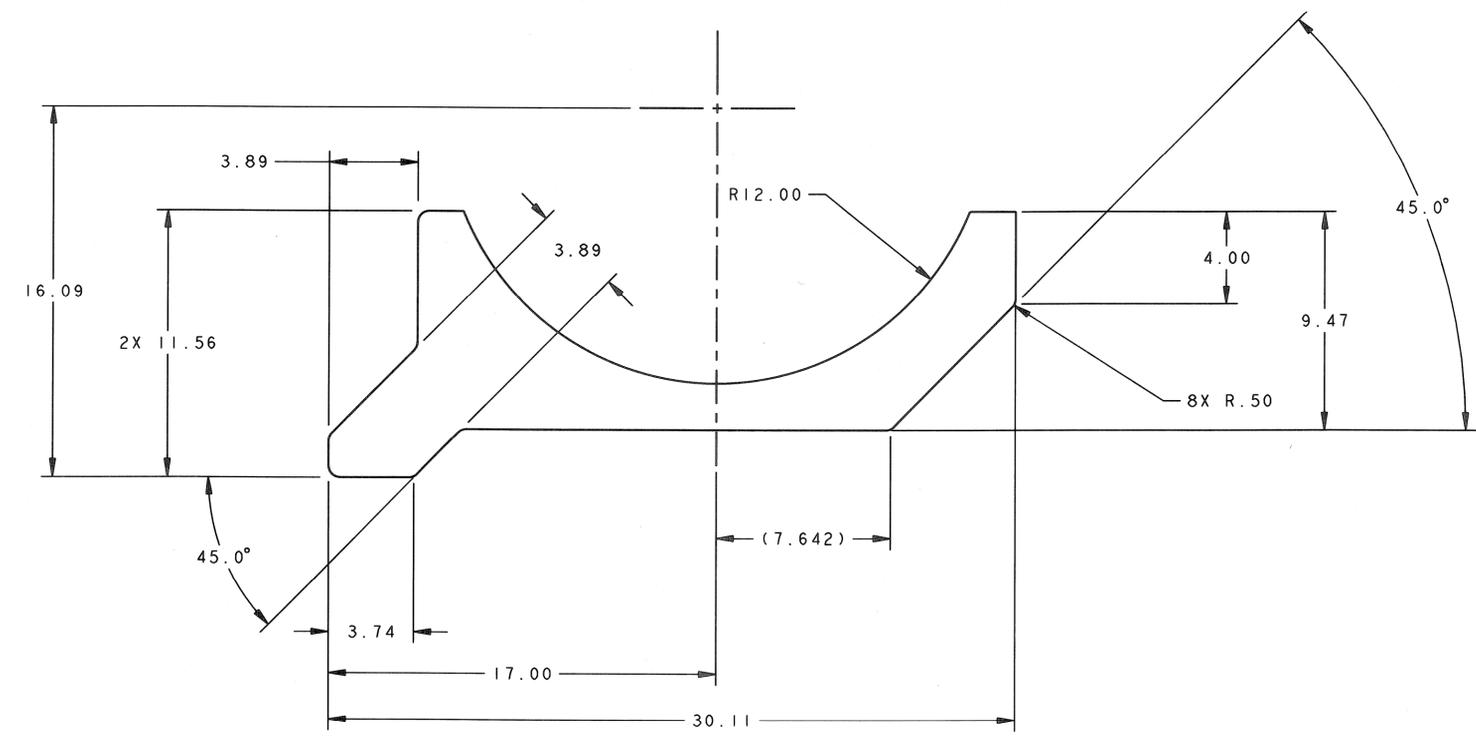
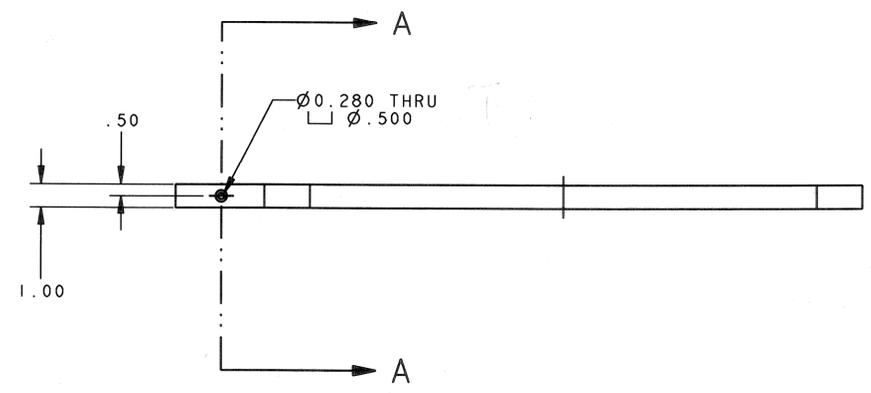
- NOTES:
1. APPLICABLE STANDARDS/SPECIFICATIONS:
ASME Y14.100, ENGINEERING DRAWING PRACTICES,
MIL-STD-31000, TECHNICAL DATA PACKAGES.
 2. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.
 3. SURFACE ROUGHNESS SHALL BE 125 RMS OR BETTER.



SCALE 1/8



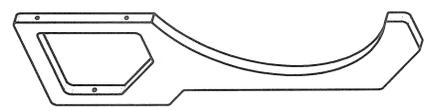
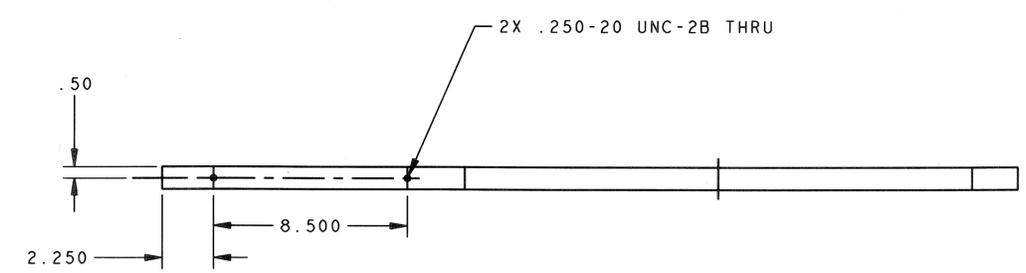
SECTION A-A



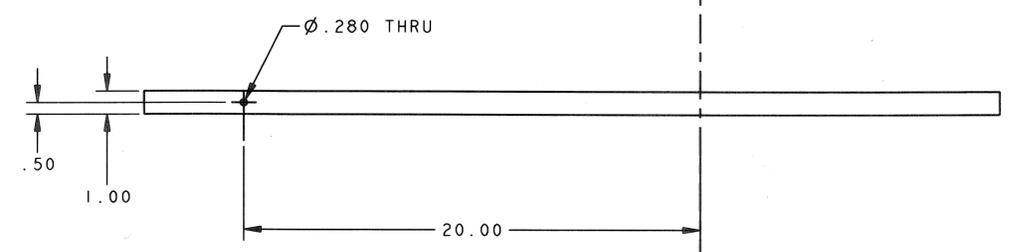
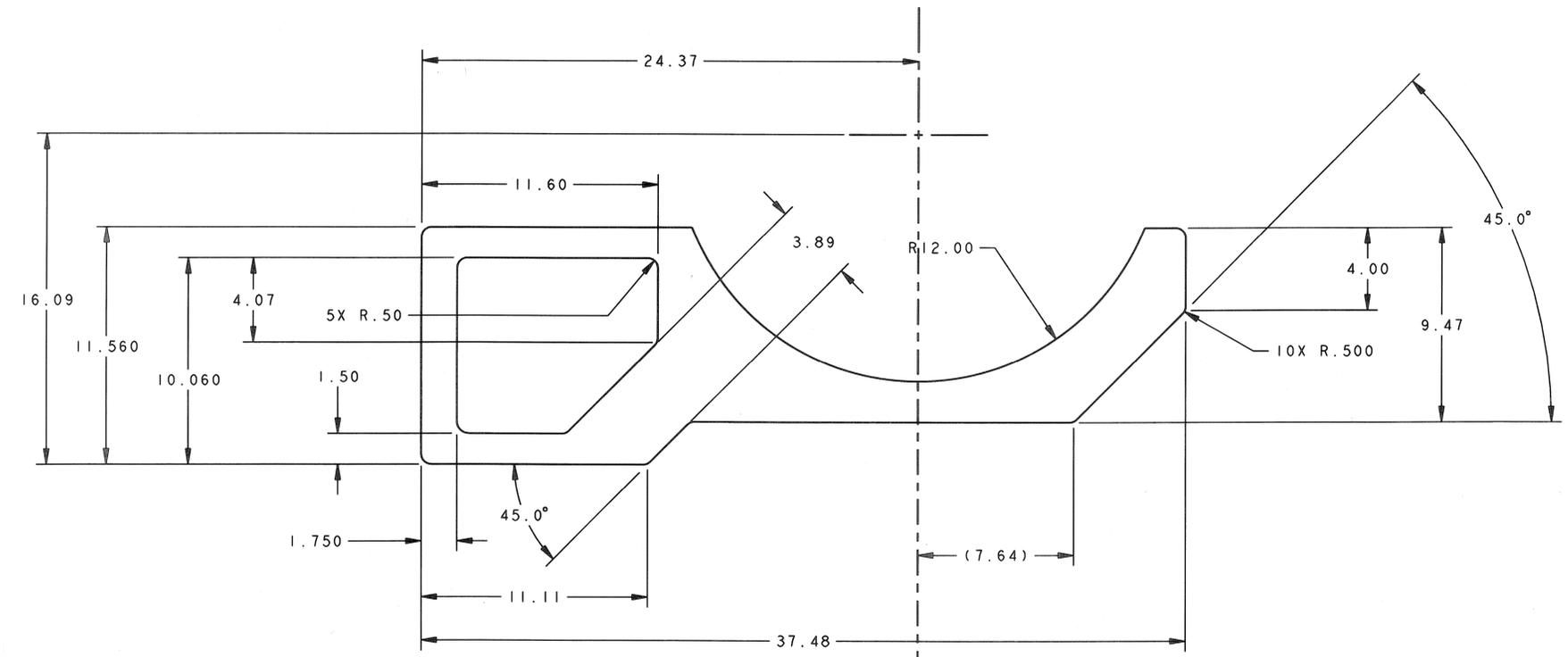
		-005	LEG, CENTER		CRES 304L AMS 5511	1
QTY RECD	CAGE CODE	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION		MATERIAL SPECIFICATION	ITEM NO.
PARTS LIST						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.			CONTRACT NO.		NATIONAL AERONAUTICS & SPACE ADMINISTRATION LANGLEY RESEARCH CENTER HAMPTON, VA 23681-2199	
TOLERANCES			APPROVALS	DATE	TITLE	
DECIMALS .XX ± .03			M. J. MCKENNEY	24-Aug-11	LEG, CENTER, VACUUM HOUSING ASSY, IR CDS	
ANGULAR .X ± .5°						
XXX ± .010			CHECKED LA18354		SIZE CAGE CODE DWG. NO.	
DO NOT SCALE DRAWING.			DESIGNER		D 25305 1252004	
FINISH			LEAD ENGR.		SCALE 1/4	
SIMILAR TO			BRANCH		SHEET 5 OF 10	
PART DASH NO.	NEXT FINAL	NEXT ASSY	USED ON	APPLICATION		
-005	1	1	1252004-1	IR CDS		

ZONE		REV	DESCRIPTION	DATE	APPROVED

- NOTES:
1. APPLICABLE STANDARDS/SPECIFICATIONS:
ASME Y14.100, ENGINEERING DRAWING PRACTICES,
MIL-STD-31000, TECHNICAL DATA PACKAGES.
 2. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.
 3. SURFACE ROUGHNESS SHALL BE 125 RMS OR BETTER.



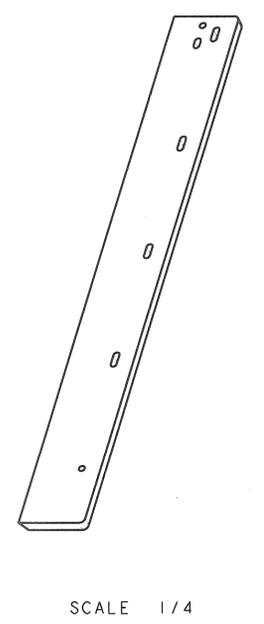
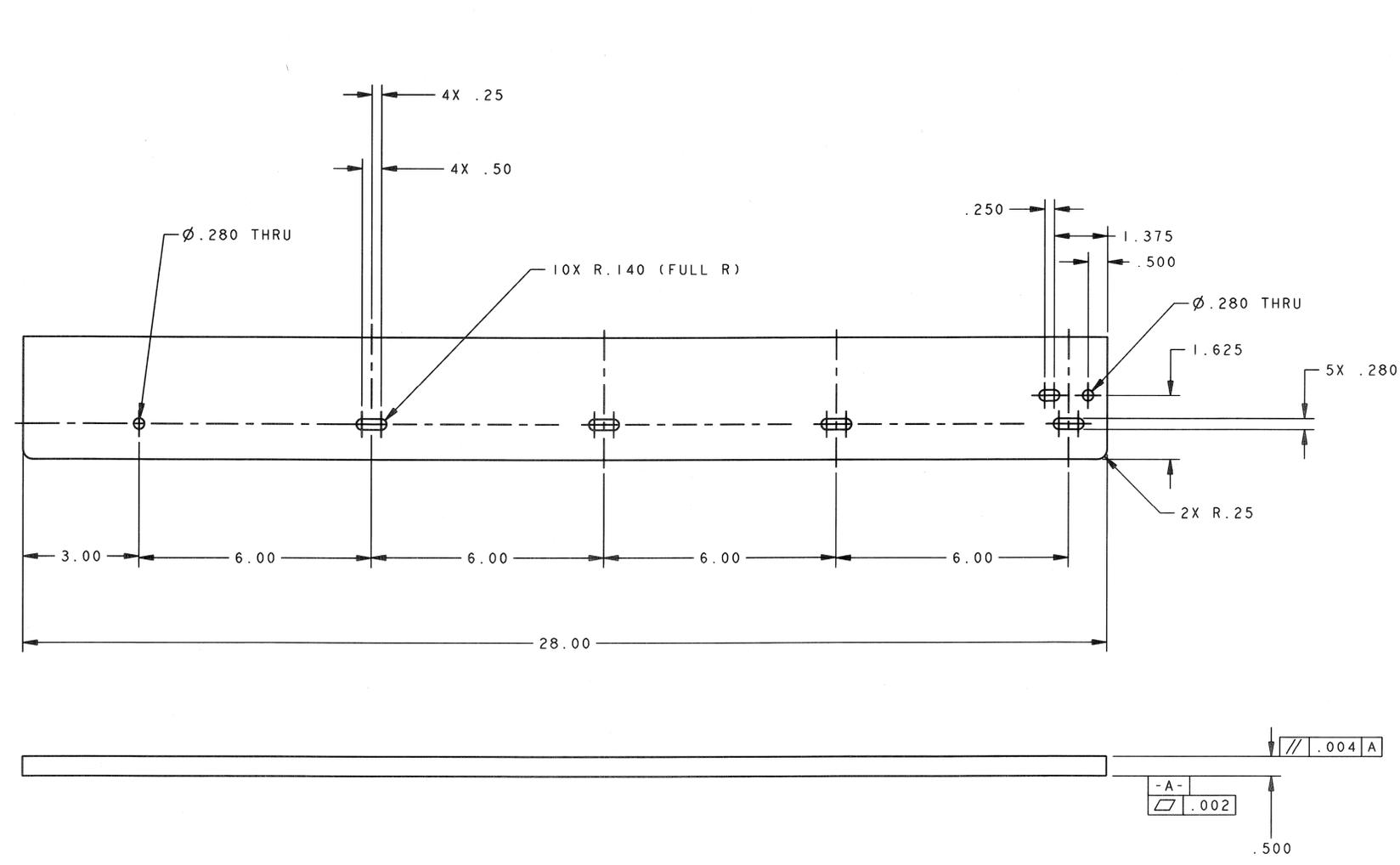
SCALE 1/8



-007	LEG FRONT/REAR	CRES 304L AMS 511	1
QTY REQD	CAGE CODE	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION
			MATERIAL SPECIFICATION

PARTS LIST			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.		CONTRACT NO.	
TOLERANCES		NATIONAL AERONAUTICS & SPACE ADMINISTRATION	
DECIMALS	ANGULAR	LANGLEY RESEARCH CENTER	
.XX ± .03	.X ± .5°	HAMPTON, VA 23681-2199	
.XXX ± .010			
DO NOT SCALE DRAWING.			
TREATMENT	APPROVALS	DATE	TITLE
FINISH	M. J. MCKENNEY	24-Aug-11	LEG, FRONT/REAR,
	CHECKED LA18354		VACUUM HOUSING ASSEMBLY,
	DESIGNER		IR CDS
	LEAD ENGR		
	BRANCH		
PART DASH NO.	QTY REQD PER ASSY	APPLICATION	SIZE CAGE CODE DWG. NO.
-007	2 2	1252004-1 IR-CDS	D 25305 1252004
			SCALE 1/4
			SHEET 6 OF 10

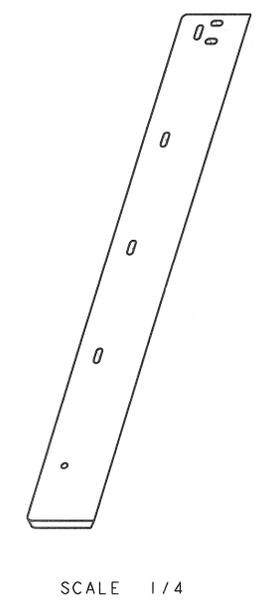
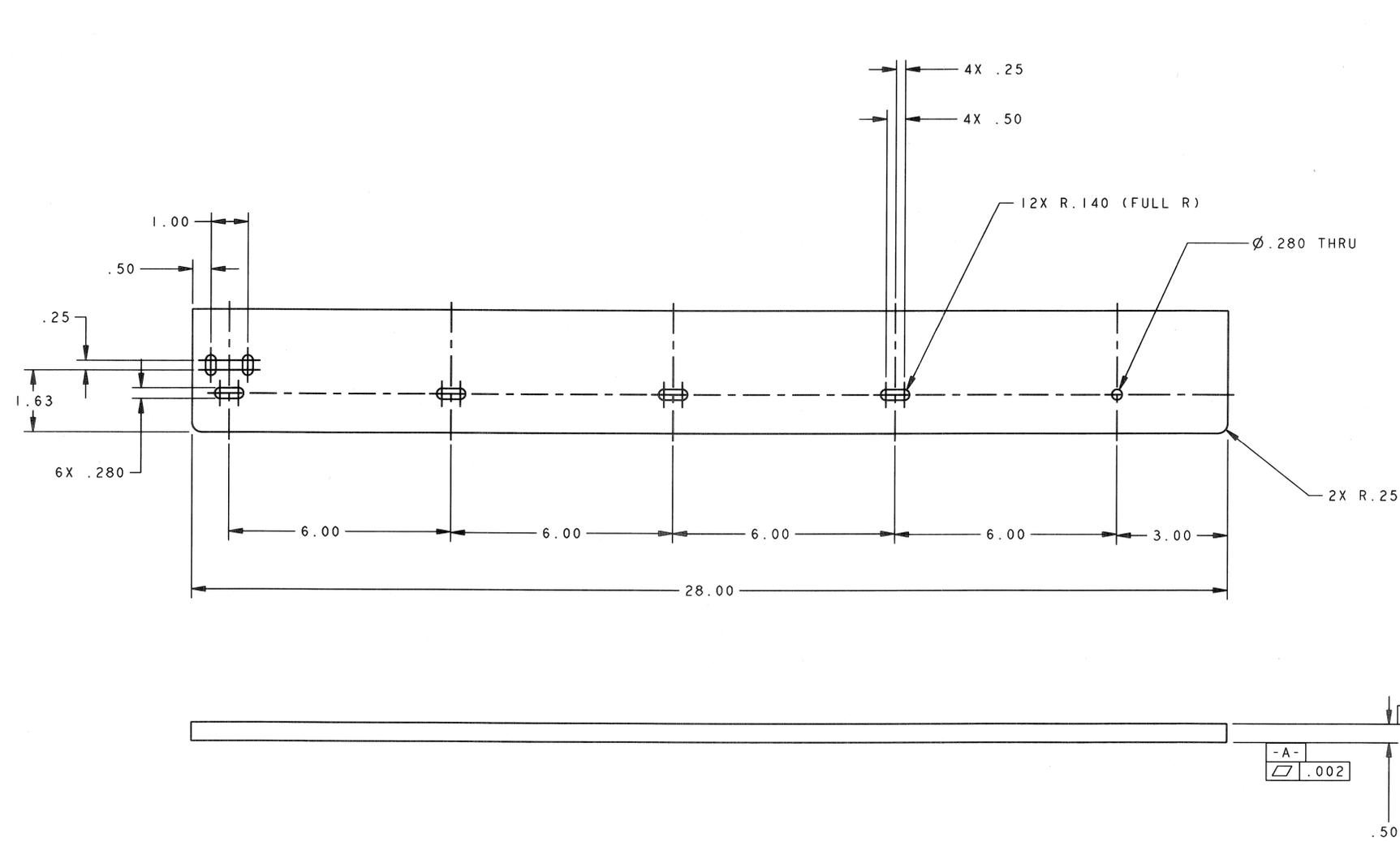
- NOTES:
1. APPLICABLE STANDARDS/SPECIFICATIONS:
ASME Y14.100, ENGINEERING DRAWING PRACTICES,
MIL-STD-31000, TECHNICAL DATA PACKAGES.
 2. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.
 3. SURFACE ROUGHNESS SHALL BE 125 RMS OR BETTER.



WELD PREPARATION (R11.813)

-013		SHELF, INTERNAL I		CRES 304L AMS 5511		1	
QTY REQD	CAGE CODE	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION		MATERIAL SPECIFICATION		ITEM NO.
PARTS LIST							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS .XX ± .03 ANGULAR .X ± .5 .XXX ± .010 DO NOT SCALE DRAWING.				CONTRACT NO.			
DRAWN M. J. MCKENNEY				DATE 24-Aug-11			
CHECKED [Signature]				DESIGNER [Signature]			
FINISH				LEAD ENGR [Signature]			
SIMILAR TO				SPECIAL MARKING SYM			
PART DASH NO.				BRANCH			
NEXT FINAL		NEXT ASSY		USED ON		APPLICATION	
-013	1	1	1252004-1	IR CDS			
NATIONAL AERONAUTICS & SPACE ADMINISTRATION LANGLEY RESEARCH CENTER HAMPTON, VA 23681-2199		TITLE SHELF, INTERNAL I, VACUUM HOUSING ASSY, IR CDS					
SIZE	CAGE CODE	DWG. NO.	REV.				
D	25305	1252004	-				
SCALE	1/2	CALC. BY	ACT. BY	SHEET		7 OF 10	

- NOTES:
1. APPLICABLE STANDARDS/SPECIFICATIONS:
ASME Y14.100, ENGINEERING DRAWING PRACTICES,
MIL-STD-31000, TECHNICAL DATA PACKAGES.
 2. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.
 3. SURFACE ROUGHNESS SHALL BE 125 RMS OR BETTER.

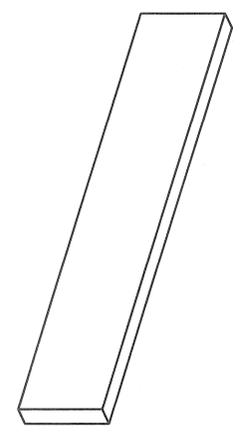
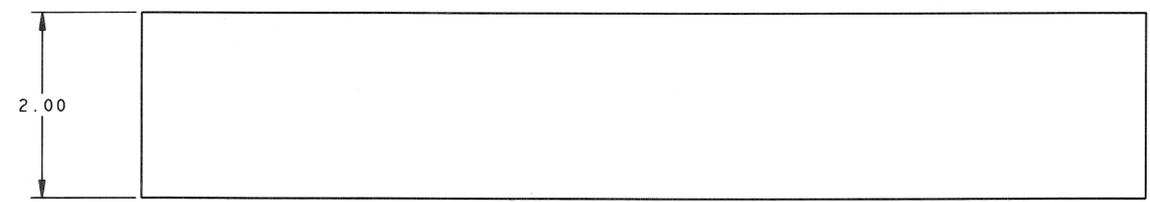


WELD PREPARATION (R11.813)

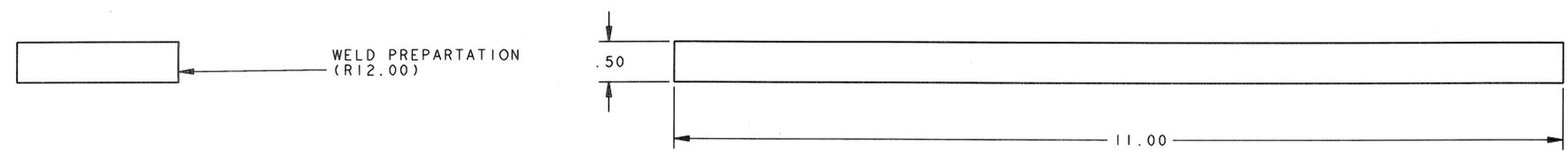
-015		SHELF, INTERNAL 2		CRES 304L AMS 5511		1	
QTY REQD	CAGE CODE	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION		MATERIAL SPECIFICATION		ITEM NO.
PARTS LIST							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS .03 XX ± .03 XXX ± .010 DO NOT SCALE DRAWING.				CONTRACT NO.			
TREATMENT				APPROVALS		DATE	
FINISH				DRAWN M. J. MCKENNEY		24-Aug-11	
SIMILAR TO				CHECKED LA18357c		30/09/06	
SPECIAL MARKING STR				DESIGNER			
APPLICATION				LEAD ENGR.			
BRANCH				TITLE		NATIONAL AERONAUTICS & SPACE ADMINISTRATION LANGLEY RESEARCH CENTER HAMPTON, VA 23681-2199	
PART DASH NO.				SIZE		CAGE CODE	
NEXT FINAL				D		25305	
NEXT ASSY				DWG. NO.		1252004	
USED ON				SCALE		1/2	
QTY REQD PER ASSY				SHEET		8 OF 10	

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

- NOTES:
1. APPLICABLE STANDARDS/SPECIFICATIONS:
ASME Y14.100, ENGINEERING DRAWING PRACTICES,
MIL-STD-31000, TECHNICAL DATA PACKAGES.
 2. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.
 3. SURFACE ROUGHNESS SHALL BE 125 RMS OR BETTER.



SCALE 1/2



-031		SUPPORT RIBS		CRES 304L AMS 5511		1	
QTY RECD	CAGE CODE	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION		MATERIAL SPECIFICATION	ITEM NO.	
PARTS LIST							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS .XX ± .03 ANGULAR .X ± .5° .XXX ± .010 DO NOT SCALE DRAWING.				CONTRACT NO.		NATIONAL AERONAUTICS & SPACE ADMINISTRATION LANGLEY RESEARCH CENTER HAMPTON, VA 23681-2199	
TREATMENT		APPROVALS		DATE		TITLE	
FINISH		DRAWN M. J. MCKENNEY		24-Aug-11		SUPPORT RIBS, VACUUM HOUSING ASSY, IR CDS	
SIMILAR TO		CHECKED L. Rossy		20/09/06		SIZE CAGE CODE DWG. NO.	
-031		4		4		D 25305 1252004	
PART DASH NO.		NEXT FINAL		NEXT ASSY		USED ON	
QTY RECD PER ASSY		APPLICATION		LEAD ENGR.		REV. -	
				BRANCH		SCALE 1/1 SHEET 9 OF 10	

