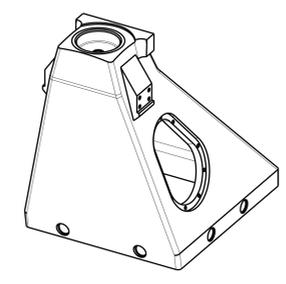
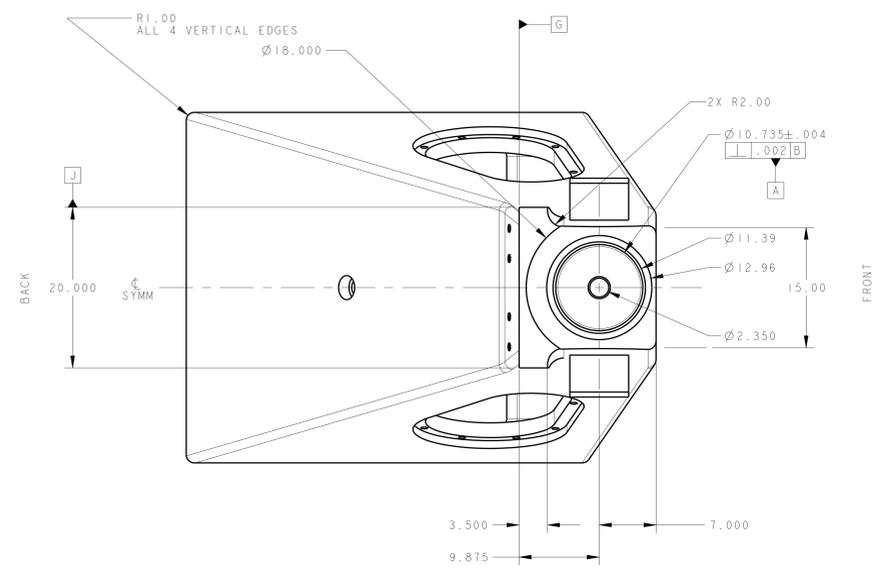


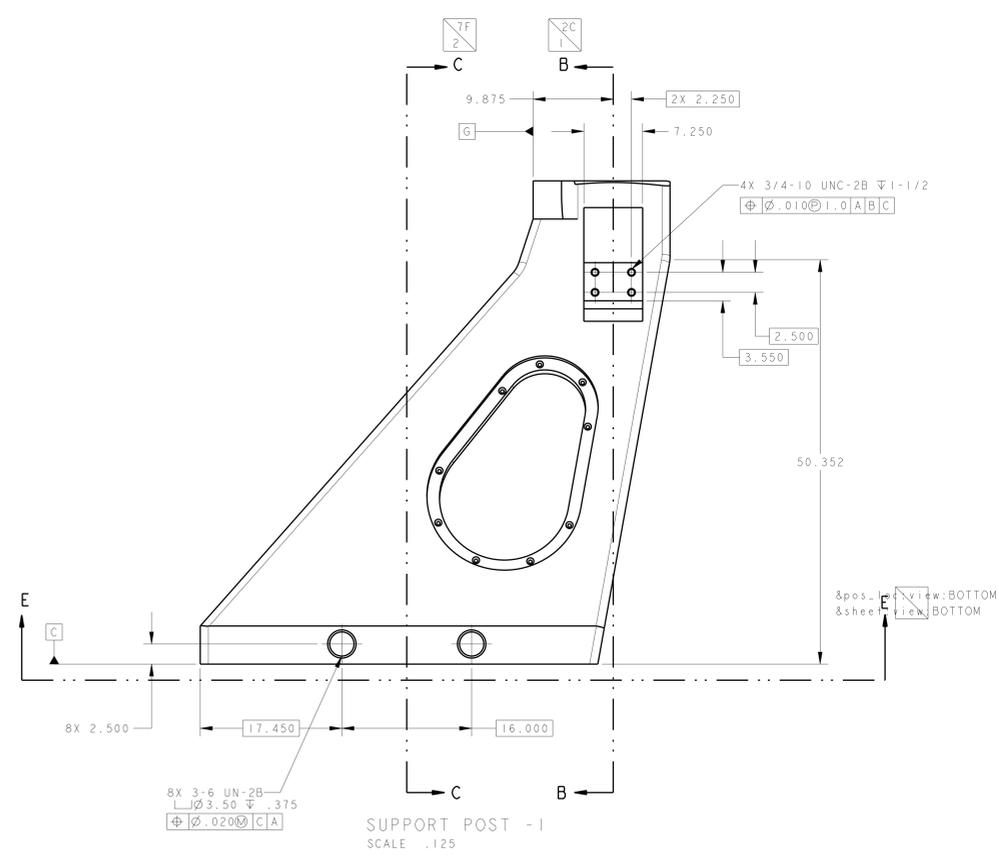
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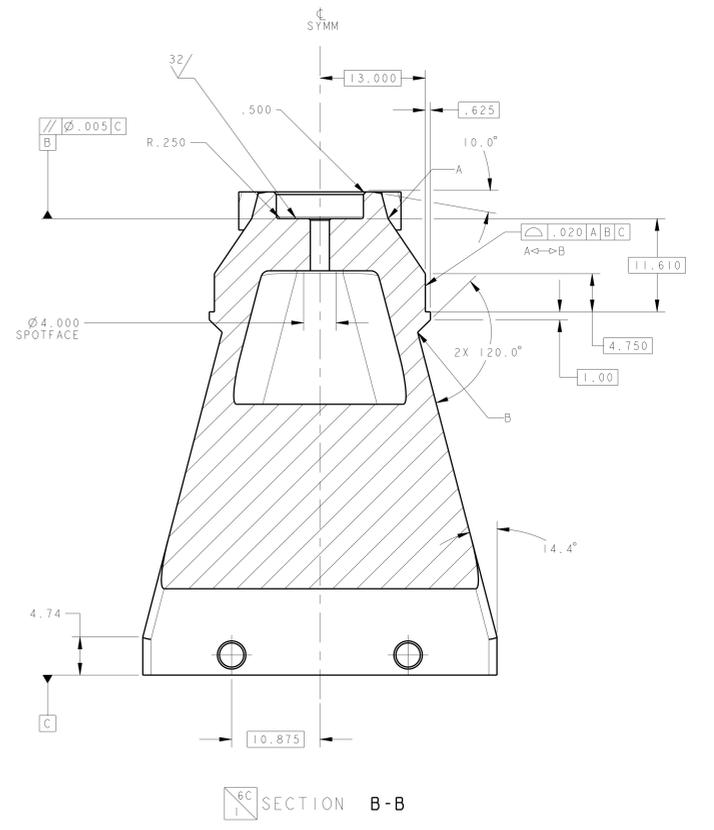
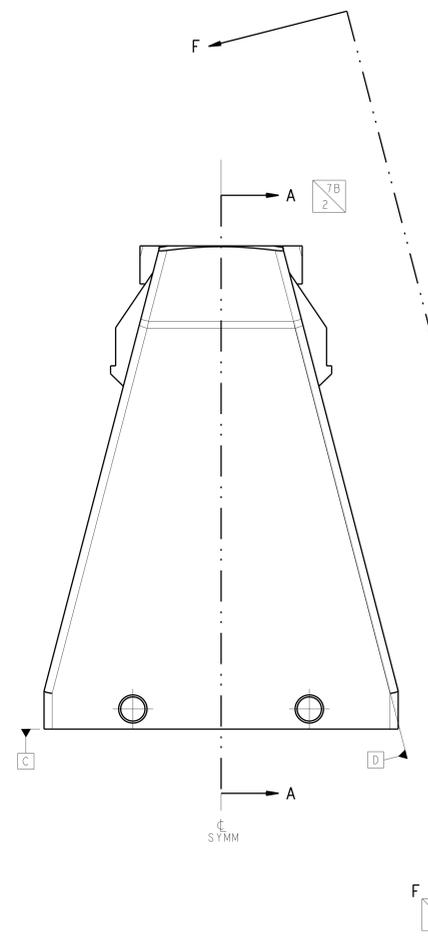
REVISION HISTORY		DATE	APPROVAL
PART NO.	ZONE	REV	



SUPPORT POST ISOMETRIC
SCALE .063



SUPPORT POST - I
SCALE .125



NOTE: ASSOCIATED NOTES LOCATED ON SHEET 3
ASSOCIATED PARTS LIST LOCATED ON SHEET 3

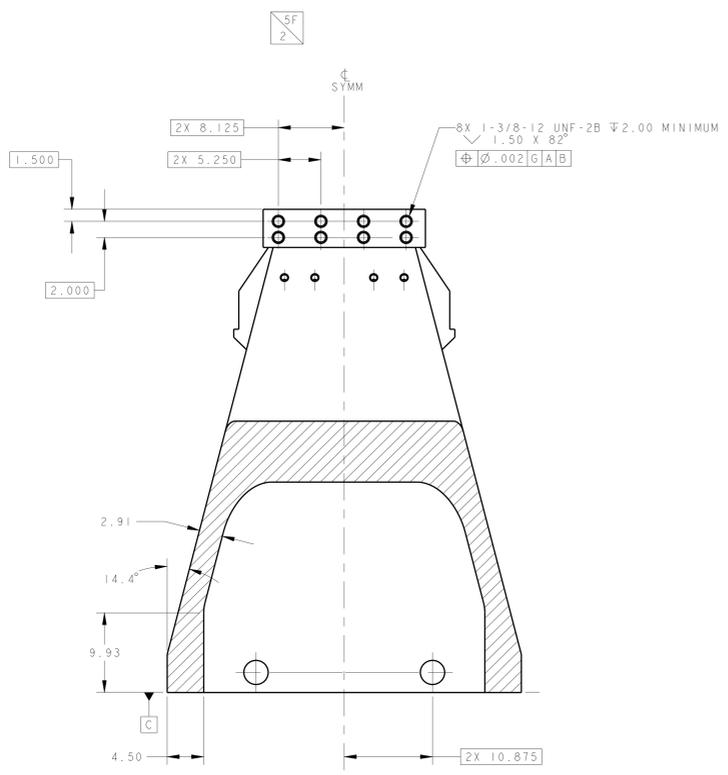
CAD MAINTAINED CHANGES SHALL BE INCORPORATED ONLY BY THE DESIGN ACTIVITY.		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994. TOLERANCES ON:		ORIGINAL DATE OF DRAWING (YY/MM/DD)		JOHN F. KENNEDY SPACE CENTER, NASA KENNEDY SPACE CENTER, FLORIDA	
SOFTWARE	PRO/ENGINEER	FRACTIONS	DECIMALS	ANGLES	DRAWN	CHECKED	DATE
FILENAME	T19M0600001	±1/16	1 PL ±.060 1 PL ±.1		J. PORTA	J. SMITH	
MATERIAL	T19M0600001	2 PL ±.030	3 PL ±.010		J. PORTA	J. SMITH	
HEAT TREATMENT	NEXT ASSY USED ON	THIRD ANGLE PROJECTION			APPROVED		
FINAL PROTECTIVE FINISH	APPLICATION				A. LITTLEFIELD		
				SCALE	NOTED	DWG NO.	REV
				E	22264	719M0600001	1
				SCALE	NOTED	UNIT WEIGHT	SHEET 1 OF 3
				ENGINEERING IN WORK - REVISION CONTROLLED DOCUMENT VALID DATE IN RISC EXAMS PRIOR TO USE			

ITAR CATEGORY IV
SENSITIVE BUT UNCLASSIFIED (SBU)

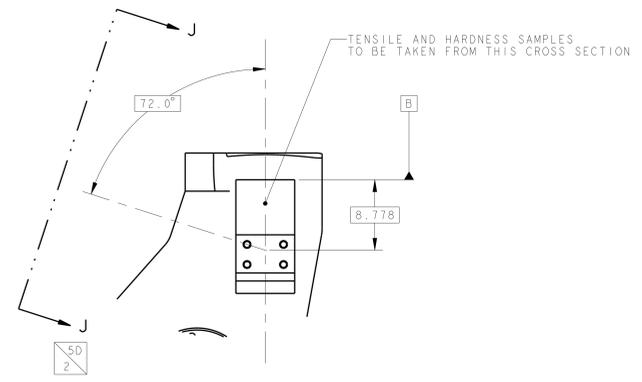
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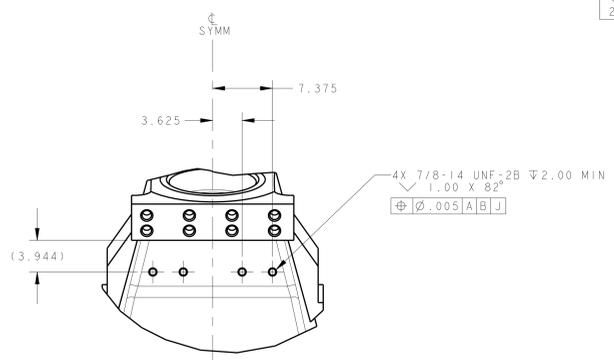
REVISION HISTORY			
PART NO.	ZONE	REV	APPROVAL



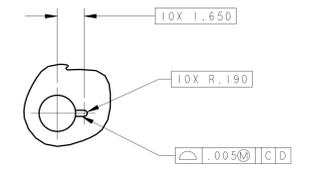
SECTION C-C
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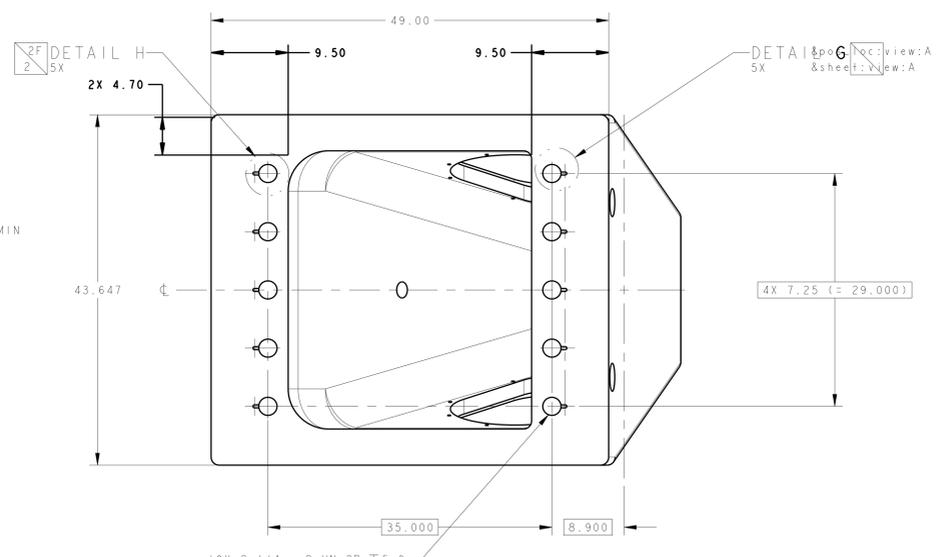
SECTION D-D
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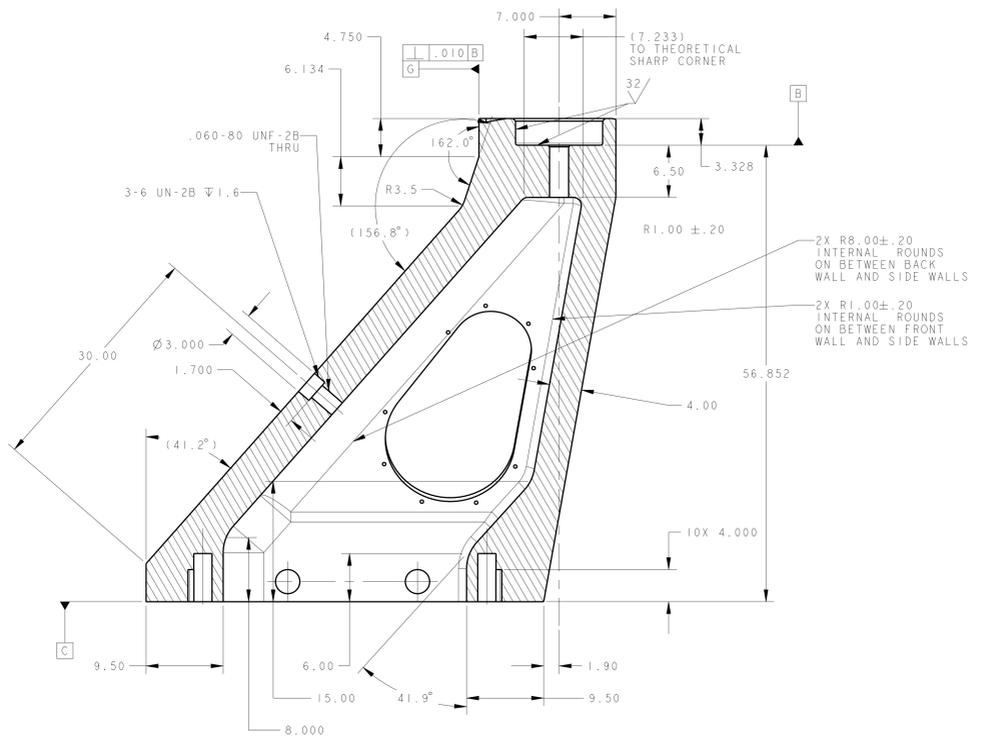
VIEW J-J
SCALE .125



DETAIL G (SHOWN)
DETAIL H (OPPOSITE)
SCALE .250



VIEW: E-E
SCALE .125



SECTION A-A
SCALE .125

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SIZE	SCALE	CODE	DWG NO.	REV
E	22264		719M060001	A
SCALE	NOTED	UNIT	WEIGHT	SHEET 2 OF 3

DRAWING NUMBER: 719M060001 SHEET 2 OF 3

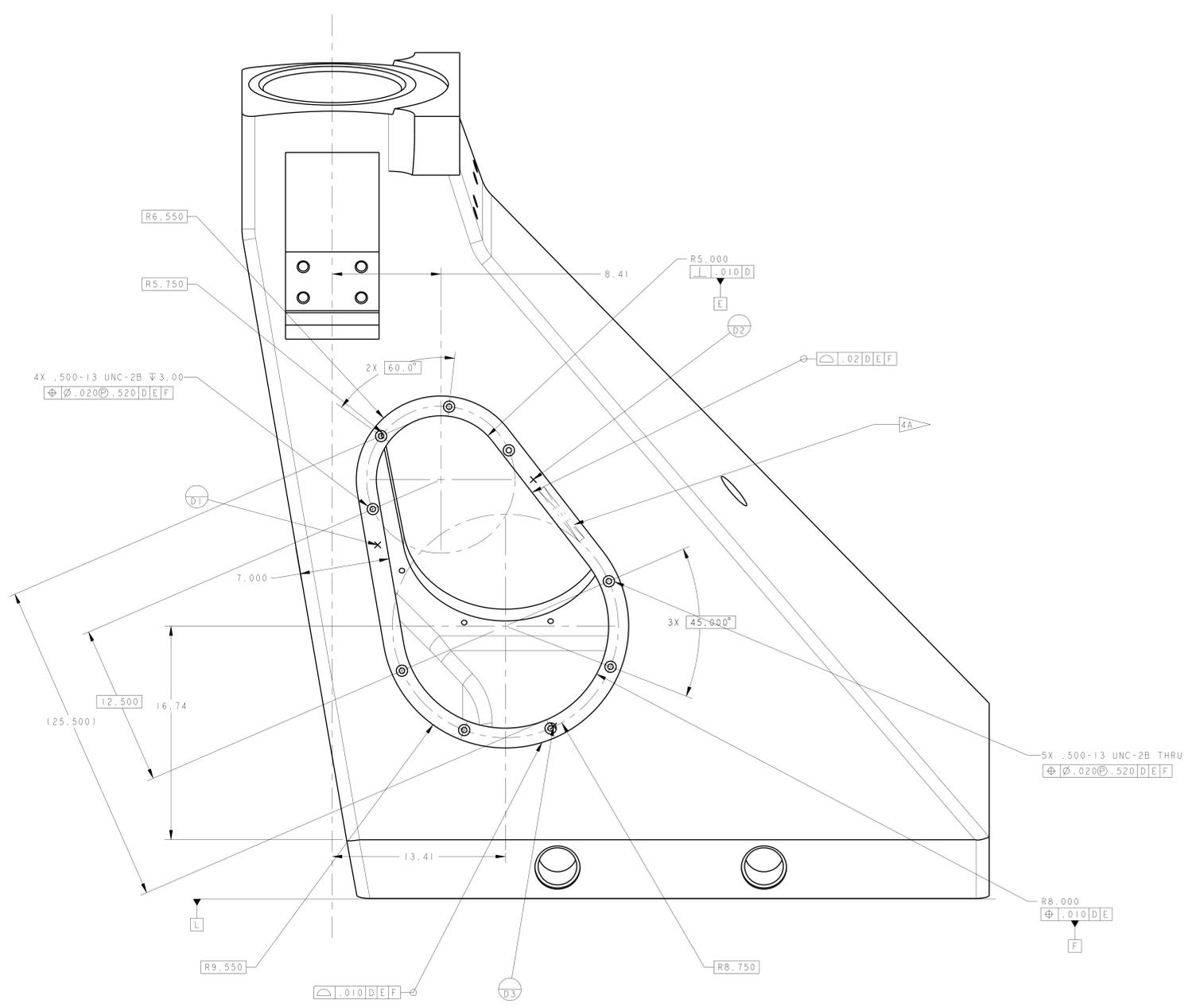
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REVISION HISTORY					
PART NO.	ZONE	REV	DESCRIPTION	DATE	APPROVAL

NOTES:

- GENERAL
- 1A. INTERPRET THIS DRAWING PER ASME Y14.5M-1994.
 - 1B. PERFECT ORIENTATION, COAXIALITY, OR SYMMETRY AT MMC FOR INTERRELATED FEATURES IS REQUIRED UNLESS SEPARATE TOLERANCES ARE SHOWN AT THE FEATURE. GENERAL DRAWING TOLERANCE DOES NOT APPLY TO IMPLIED 90° ANGLES.
 - 1C. REMOVE SCALE AND BURRS AND BREAK SHARP CORNERS AND EDGES.
- MATERIALS
- 2A. MATERIAL SHALL BE AISI 4320 CAST STEEL IN ACCORDANCE WITH SAE-AMS-2175, CLASS 1, GRADE B. ULTIMATE TENSILE STRENGTH SHALL BE IN THE RANGE OF 150-200 KSI.
- MACHINING
- 3A. UNLESS OTHERWISE SPECIFIED, ALL MACHINED SURFACES SHALL BE 125 MICRO-INCHES OR BETTER.
 - 3B. UNLESS OTHERWISE SPECIFIED, ALL UNDIMENSIONED MACHINED INSIDE RADII .010 MAXIMUM.
- MARKING
- 4A. STENCIL 719M0300001-1 USING .50 INCH HIGH CHARACTERS PER THE GENERAL REQUIREMENTS (PARAGRAPH 3.1) AND QUALITY ASSURANCE PROVISIONS (PARAGRAPH 4) OF KSC-STD-E-0015, APPROXIMATELY WHERE SHOWN. STENCIL PAINT SHALL BE A COMMERCIALY AVAILABLE SPRAY LACQUER (KRYLON INDUSTRIAL SPARVAR LACQUER PAINTS OR EQUAL). TEXT COLOR SHALL BE THAT CLOSEST TO WHITE, NO. 17925 PER FED-STD-595
- FINISH
- 5A. ALL SURFACES EXCEPT THREADED HOLES AND THE SOCKET AT THE TOP OF THE CASTING (10.735 DIAMTER HOLE) SHALL BE PREPARED AND PAINTED AS FOLLOWS: ABRASIVE BLAST PER SSPC-SPI0. REMOVE ABRASIVE RESIDUE. CLEAN AND DRY SURFACES. APPLY A 4-6 MIL DRY FILM THICKNESS INORGANIC ZINC (10Z) COATING (CONFORMING TO PARAGRAPH 4.1.2.1 OF NASA-STD-5008) FROM THE APPROVED PRODUCTS LIST OF NASA-STD-5008 APPENDIX A. THE PREPARATION OF THE METALS AND THE APPLICATION AND THICKNESS OF THE COATING SHALL BE IN COMPLIANCE WITH THE MANUFACTURER'S RECOMMENDATIONS. NACE CERTIFIED COATING INSPECTION REQUIRED.



ASSY DASH NO AND NO REG	ZONE	FIG NO OF VIEW NO	REF CODE	PART OR STOCK NO	DESCRIPTION	STOCK SIZE	MATERIAL SPEC	FINISH CODE	UNIT WT
				719M0600001-1	SUPPORT POST	61 X 58 X 43	AISI 4320 STEEL		8478.8

PARTS LIST

SCALE	NOTED	UNIT WEIGHT	SHEET 3 OF 3
ENGINEERING In Work	REVISION CONTROLLED DOCUMENT	VALID DATE IN KSC EXAMS PRIOR TO USE	

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