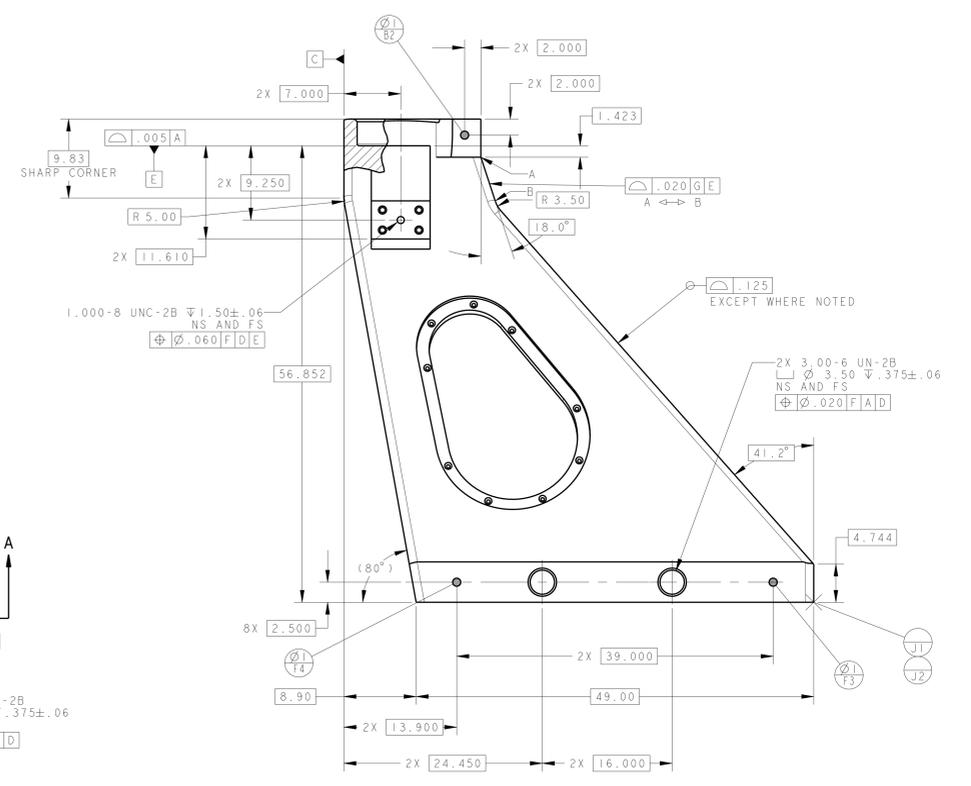
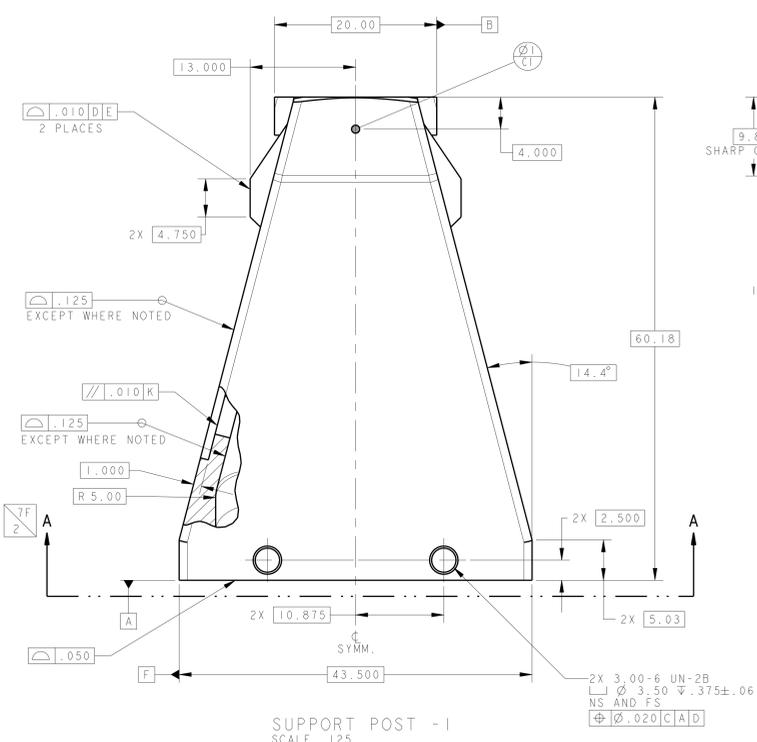
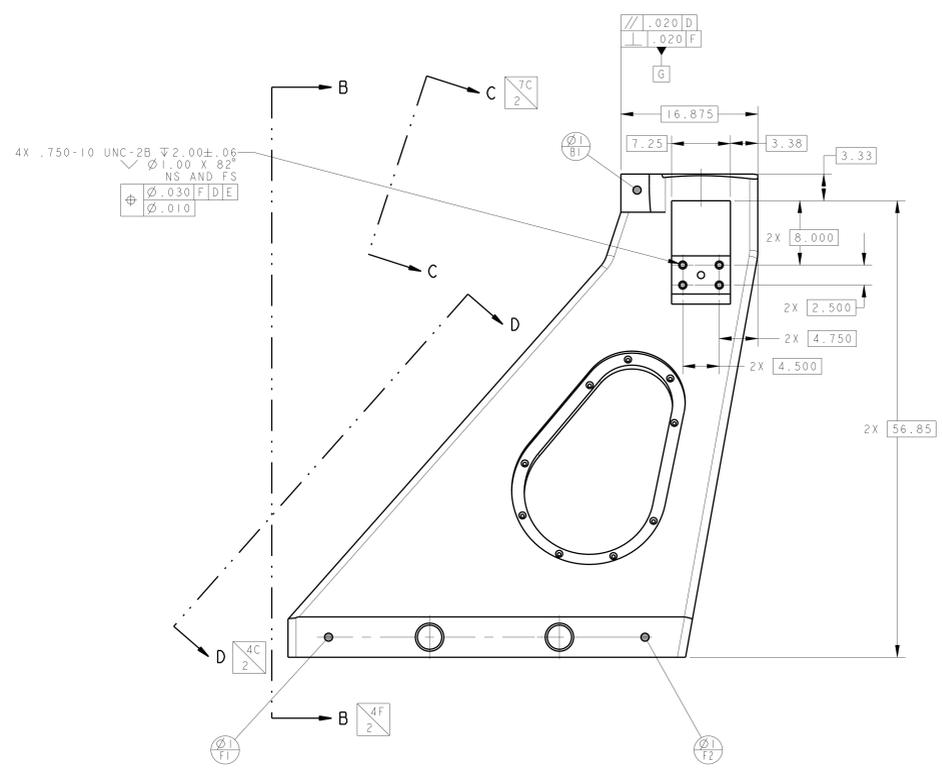
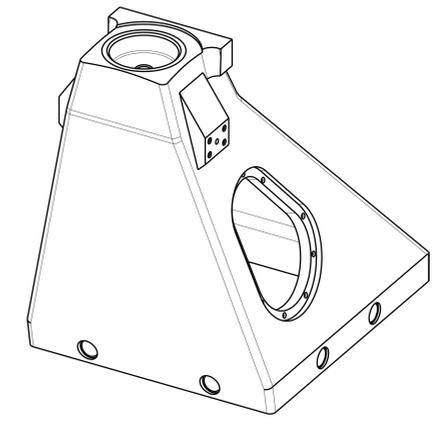
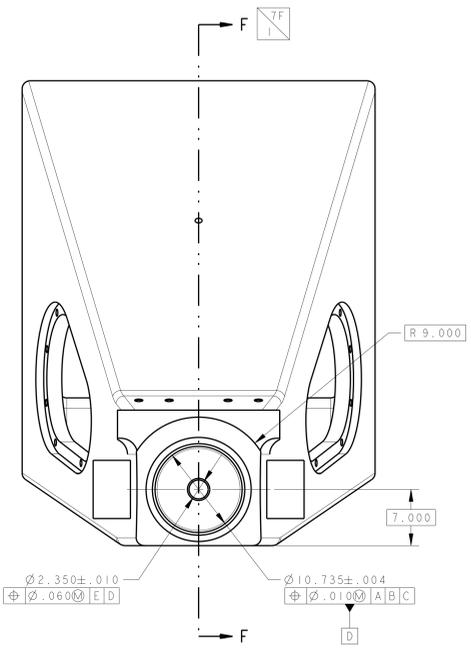
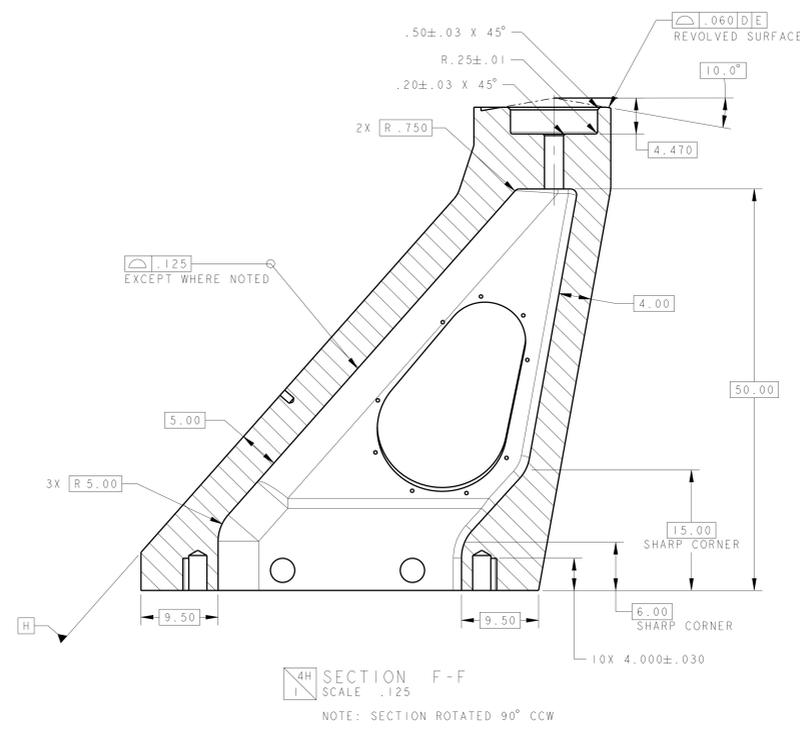


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REVISION HISTORY		DATE	APPROVAL
PART NO.	ZONE	REV	



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) 13/01/23	JOHN F. KENNEDY SPACE CENTER, NASA KENNEDY SPACE CENTER, FLORIDA
SOFTWARE PRO/ENGINEER		FRACTIONS DECIMALS ANGLES	STRT/END TOLERANCE	
FILENAME T19M0600001		±1/16 1 PL ±.060 1 PL ±.1	ENTER/EXIT CHECKER	
MATERIAL T19M0600001 SLS ML		2 PL ±.030 3 PL ±.010	ENTER/EXIT CHECKER	
HEAT TREATMENT		THIRD ANGLE PROJECTION	ENTER/EXIT CHECKER	
FINAL PROTECTIVE FINISH			ENTER/EXIT CHECKER	
	NEXT ASSY USED ON		APPROVED	
	APPLICATION		J. PORTA	
			A. LITTLEFIELD	
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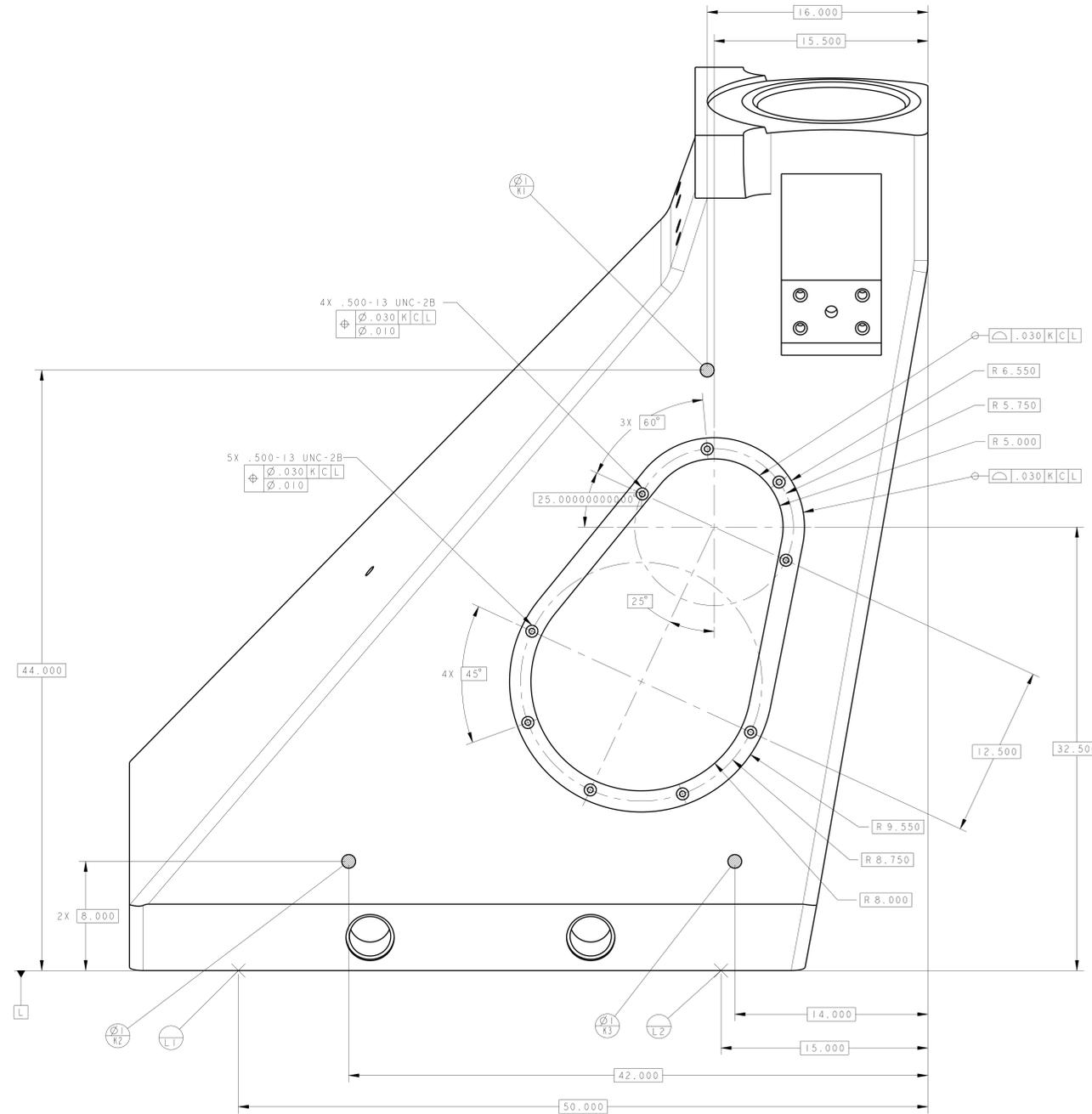
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REVISION HISTORY					
PART NO.	ZONE	REV	DESCRIPTION	DATE	APPROVAL

- NOTES:
- GENERAL
- 1A. INTERPRET THIS DRAWING PER ASME Y14.5M-2004.
 - 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 150KSI MINIMUM, WITH A MINIMUM ELONGATION AT FAILURE OF 10%.
 - 2B. UNLESS OTHERWISE SPECIFIED, ALL CAST SURFACES SHALL BE 500 MICRO-INCHES OR BETTER.
- MACHINING
- 3A. UNLESS OTHERWISE SPECIFIED, ALL MACHINED SURFACES SHALL BE 125 MICRO-INCHES OR BETTER.
 - 3B. UNLESS OTHERWISE SPECIFIED, ALL UNDIMENSIONED MACHINED INSIDE RADII .030 MAXIMUM.
 - 3C. ALL UNDIMENSIONED EXTERNAL RADII SHALL BE 1.000±.125.
- MARKING
- 4A. CAST PART NUMBER 719M0600001-1 AND SERIAL NUMBER USING 1.0 INCH HIGH CHARACTERS PER THE GENERAL REQUIREMENTS (PARAGRAPH 3.1) AND QUALITY ASSURANCE PROVISIONS (PARAGRAPH 4) OF KSC-STD-E-0015, APPROXIMATELY WHERE SHOWN.
- FINISH
- 5A. ALL SURFACES EXCEPT THREADED HOLES AND THE SOCKET AT THE TOP OF THE CASTING (10.735 DIAMETER HOLE) SHALL BE PREPARED AND PAINTED AS FOLLOWS: ABRASIVE BLAST PER SSPC-SPI10. 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.



46 VIEW E-E
SCALE .250

NOTE: OPPOSITE SIDE DOOR-OPENING HIDDEN FOR CLARITY.
MIRRORED VIEW APPLIES TO OPPOSITE SIDE DOOR-OPENING.

STYL	SCALE	CODE	DWG NO	REV
E	NOTED		719M0600001	3

ASSY DASH NO AND NO REG	ZONE	FIG NO OF FIG 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		8502.5

PARTS LIST

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