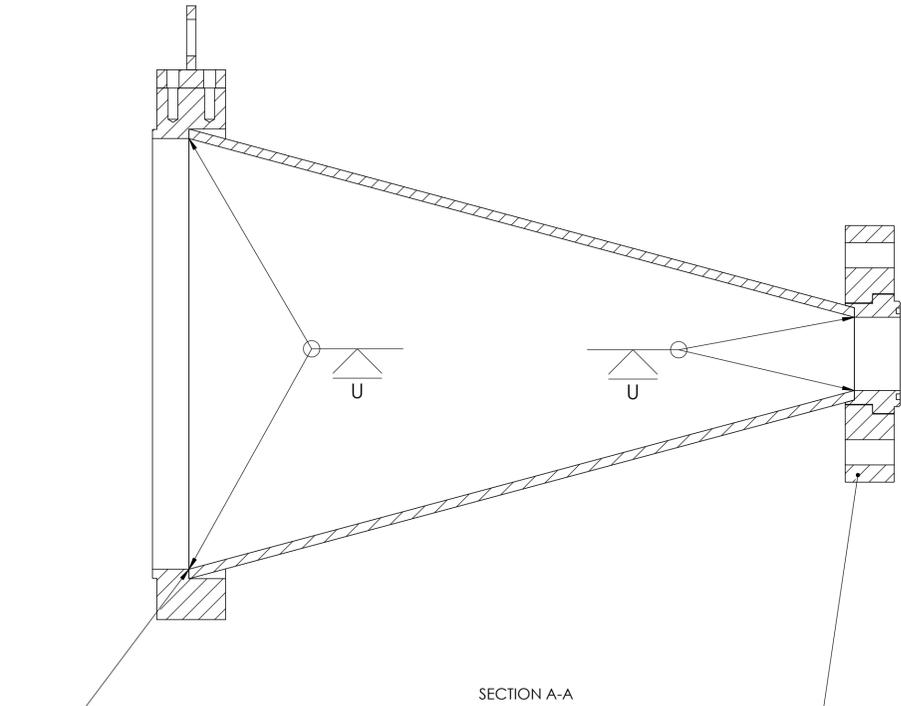
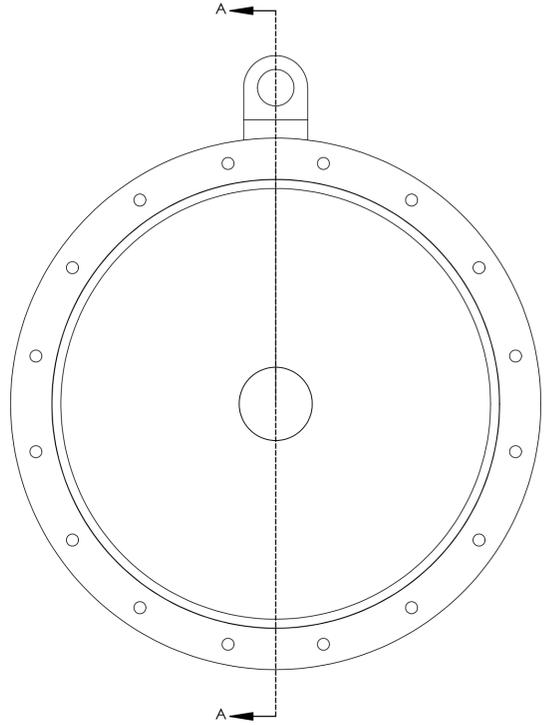
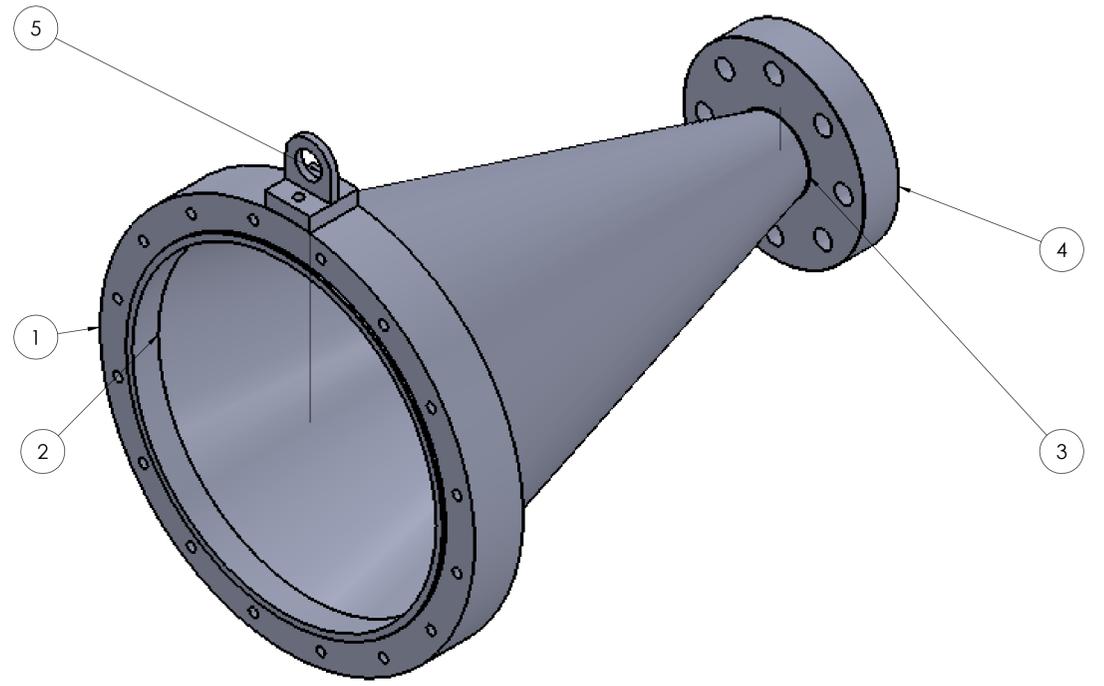


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	24in_flange	24in blank flange	1
2	36in_cone	36in Cone	1
3	4in_flange_rotatable_A	4in blank flange rotatable-A	1
4	4in_flange_rotatable_B	4in blank flange rotatable-B	1
5	29in_flange_hook	29in flange hook	1



Interior diameter welds must be ground smooth, without any abrupt protrusions or divots, and continuous to form a seal. The surface finish should be consistent with the surrounding surfaces.

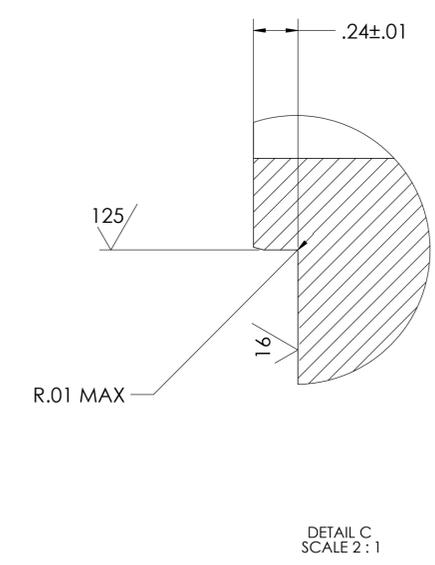
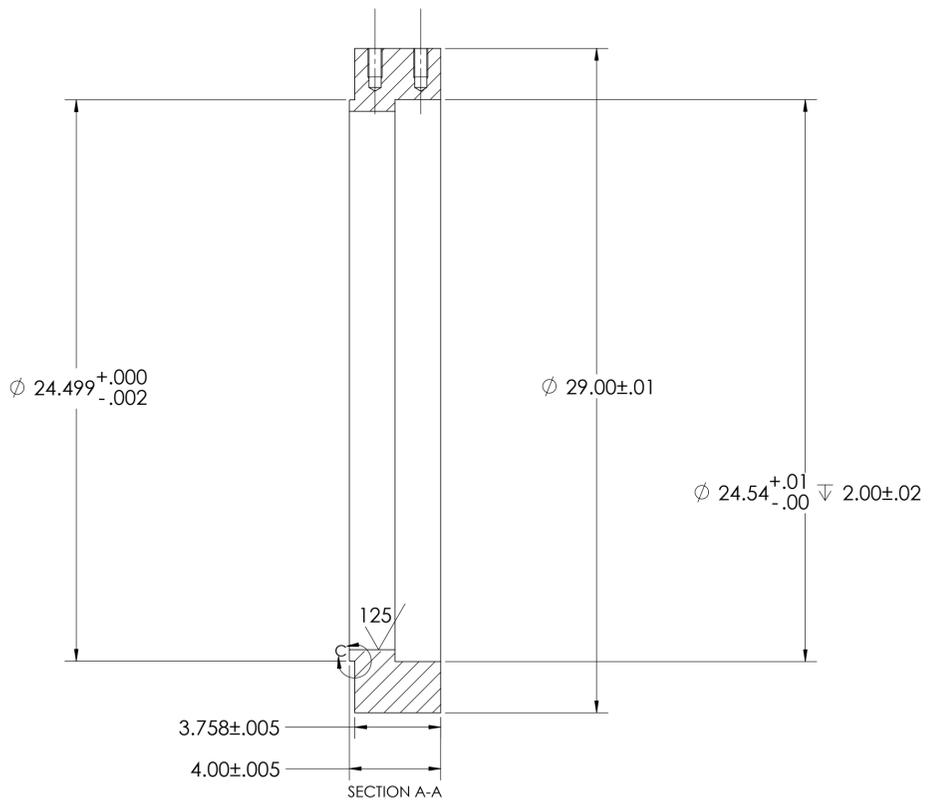
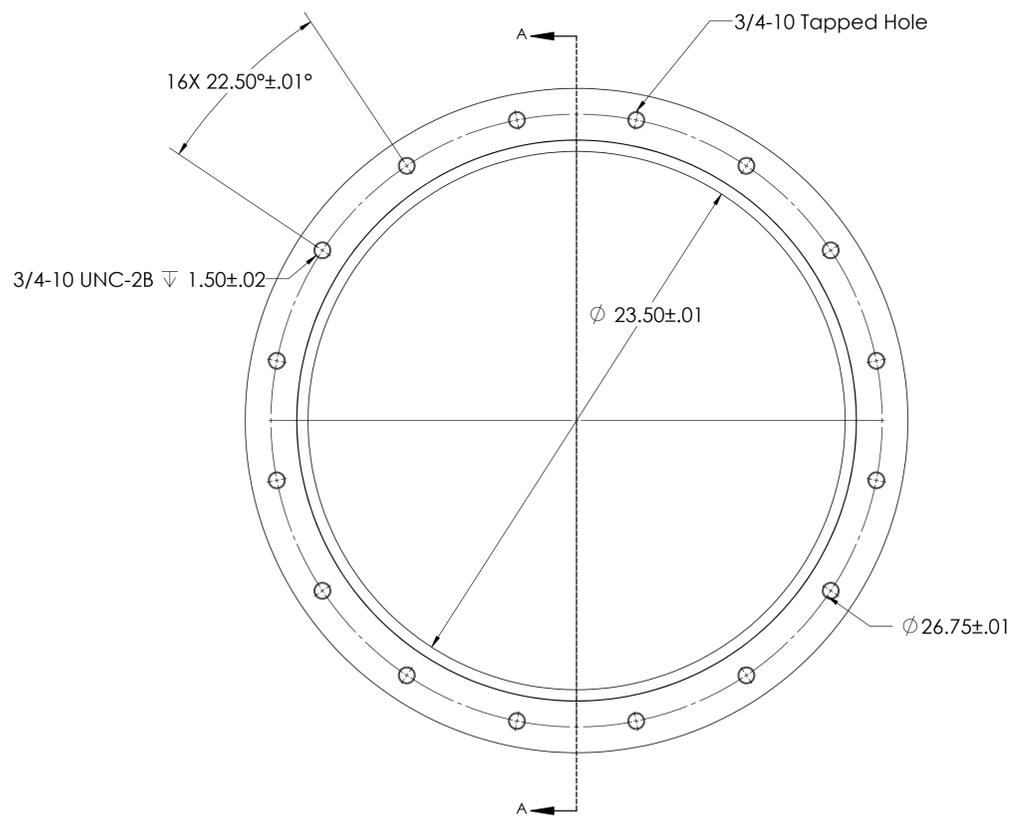
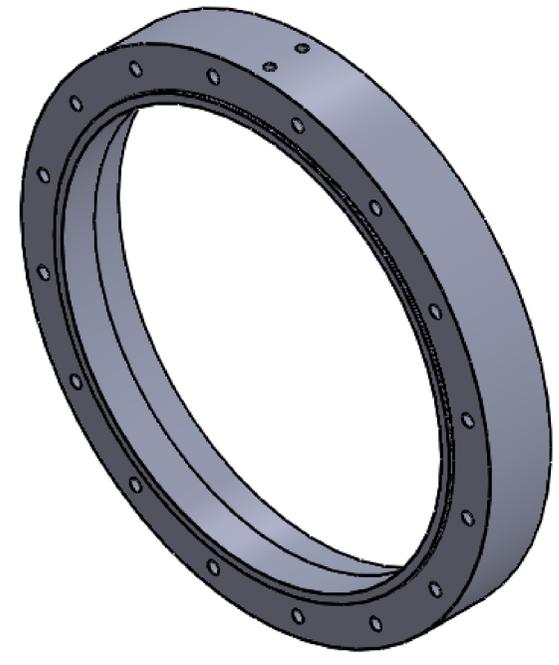
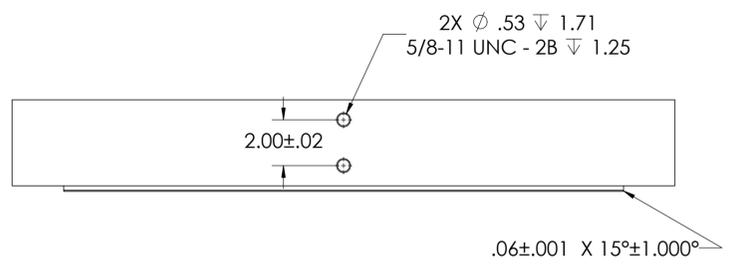
Item #4 must be placed prior to welding items #3 and #2 together.



- Material for the assembly is 304L stainless steel.
- Certified Material Test Report (CMTR) certifications are required for all pressure boundary material and must demonstrate Code specification compliance.
- This assembly is used in a high vacuum system.
- Helium Leak testing is required and the leak rate must not be greater than 2.0E-09 Std Atm cc/sec He.
- Finished assembly inspection is required and conformance documentation is required.
- All machining and inspection processes and procedures must be approved by the NASA Pressure Systems Safety department prior to starting work. Provide ASME Section IX WPS, WPQ, PQR and welder certifications to NASA for review and approval prior to starting fabrication.
- All welding shall comply fully with ASME Section IX and shall only be performed by an ASME Code U or PP Stamp holder in full compliance with their ASME QA Program except U or PP Stamping, which is not required.
- All full penetration welds shall be fully examined by radiography (RT) as per ASME Section V, with acceptance criteria per ASME Section VIII, Div-1.
- All welds shall be examined by VT and MT or PT methods as per ASME Section V, with acceptance criteria as per ASME Section VIII.
- Hydrostatic pressure test the completed assembly to 600 PSI

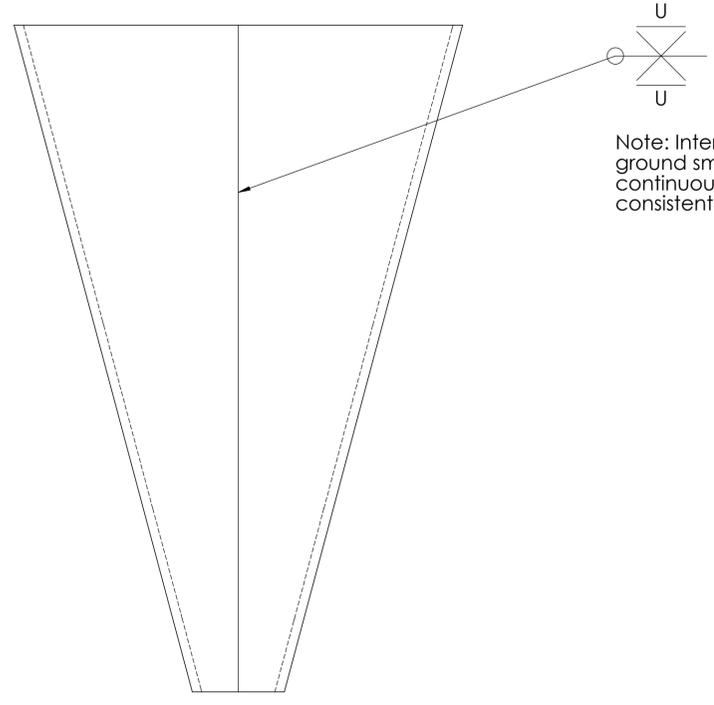
All ASTM Type 304L Stainless Steel material must conform to ASTM A240, SA240 & AMS 5511

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES (UNLESS OTHERWISE NOTED): ANGLES: ±0.5 FRACTIONS: ±1/64	
DECIMALS: .XX±0.01 .XXX±0.001		DIA. ON SAME AXIS CONCENTRIC TO .002 T.I.R.	
BREAK SHARP CORNERS AT .005 MAX		ALL DIMENSIONS AND TOLERANCES APPLY AFTER FINISH TREATMENT	
ALL MACHINED SURFACES TO BE: 125 EXCEPT WHERE NOTED		DO NOT SCALE DRAWING	
PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS NASA SENSITIVE TECHNOLOGY. IT IS THE SOLE PROPERTY OF NASA AND NOT TO BE DISTRIBUTED OR REPRODUCED IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NASA.		REVISIONS DRAWN: T. Longson DATE: 5/10/13 DESIGNED: T. Longson DATE: 4/10/13 CHECKED: R. Martinez DATE: 6/5/13 FACILITY MGR: M. McLaughlin DATE: 6/5/13 REQUESTER: B. Cruden DATE: 5/20/13 QA/QA: DATE:	
MATERIAL: ASTM Type 304L Stainless Steel SIZE: D CAGE CODE: 25307 SCALE: 1:5		AMES RESEARCH CENTER Moffett Field, California N229-ELECTRIC ARC SHOCK TUBE (EAST) FACILITY 24 INCH LDST 36in Cone Assembly INDEX DATE: SHEET 1 of 6 FILE NAME:	

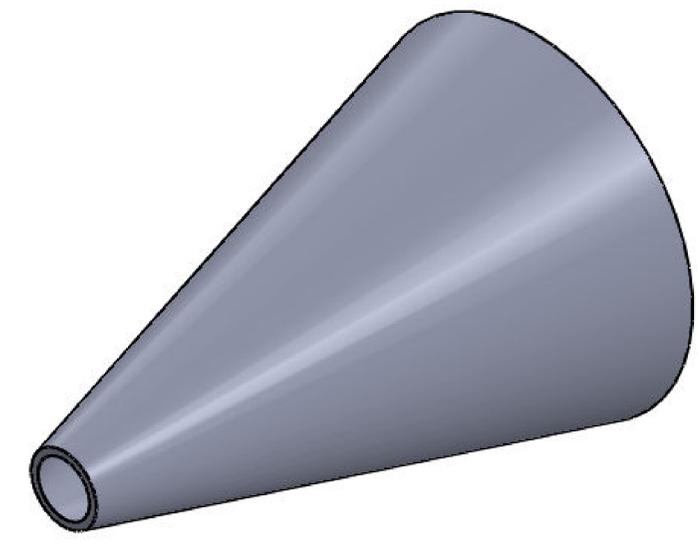


ASTM Type 304L Stainless Steel

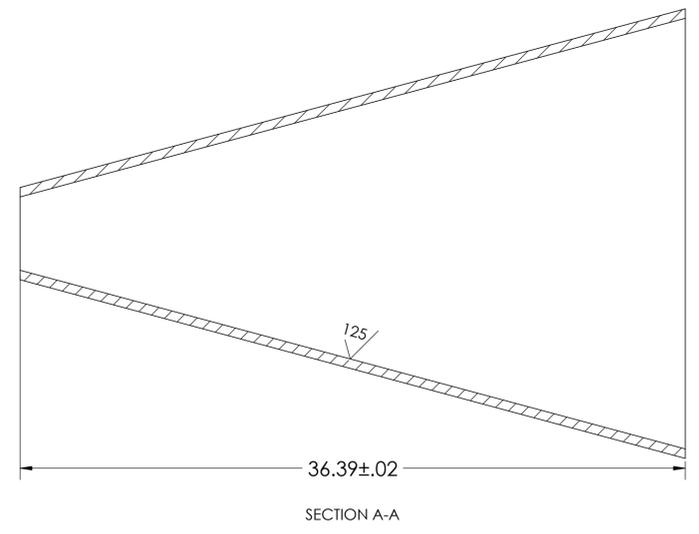
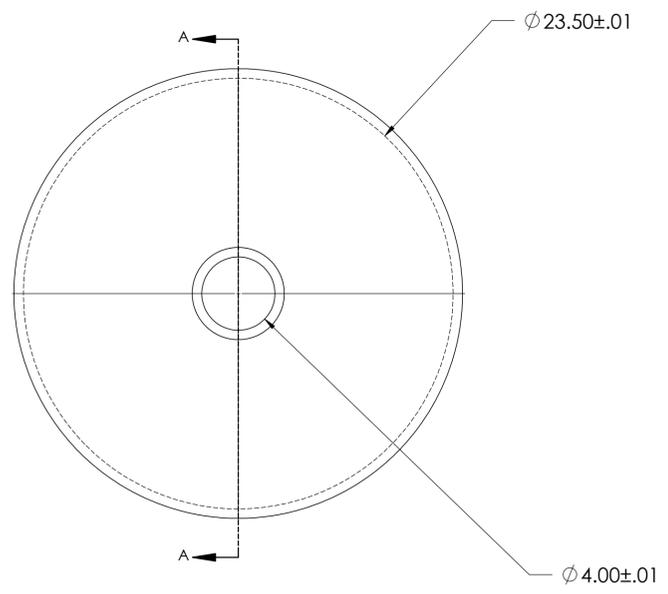
SHEET 2: 24in flange			
SEE SHEET 1 FOR REVISIONS			
SIZE D	CAGE CODE 25307	A	REV 1
SCALE 2:1	INDEX DATE	SHEET 2 OF 2	
FILE NAME:			



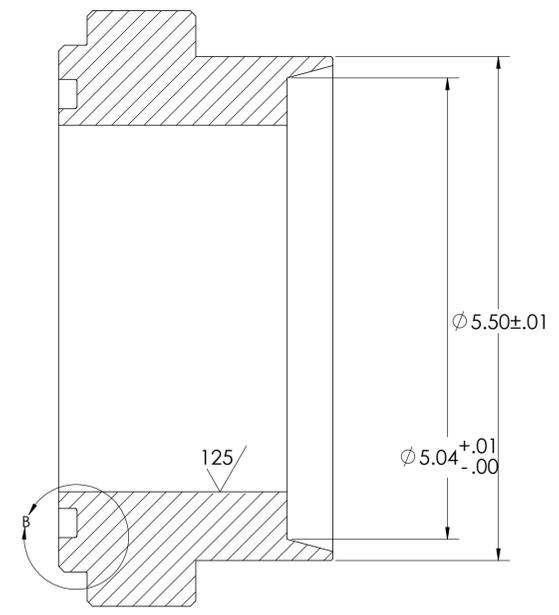
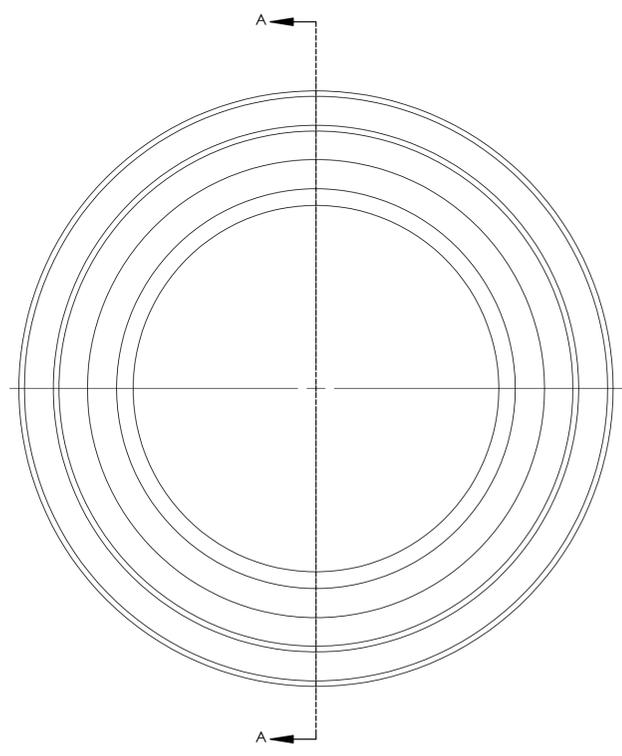
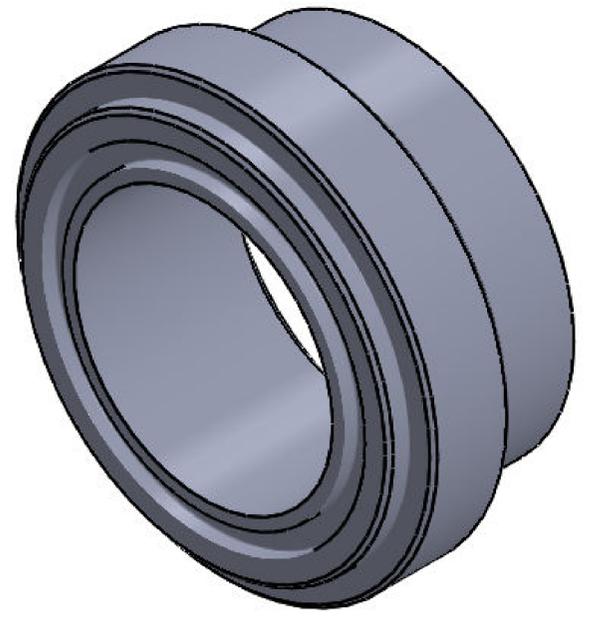
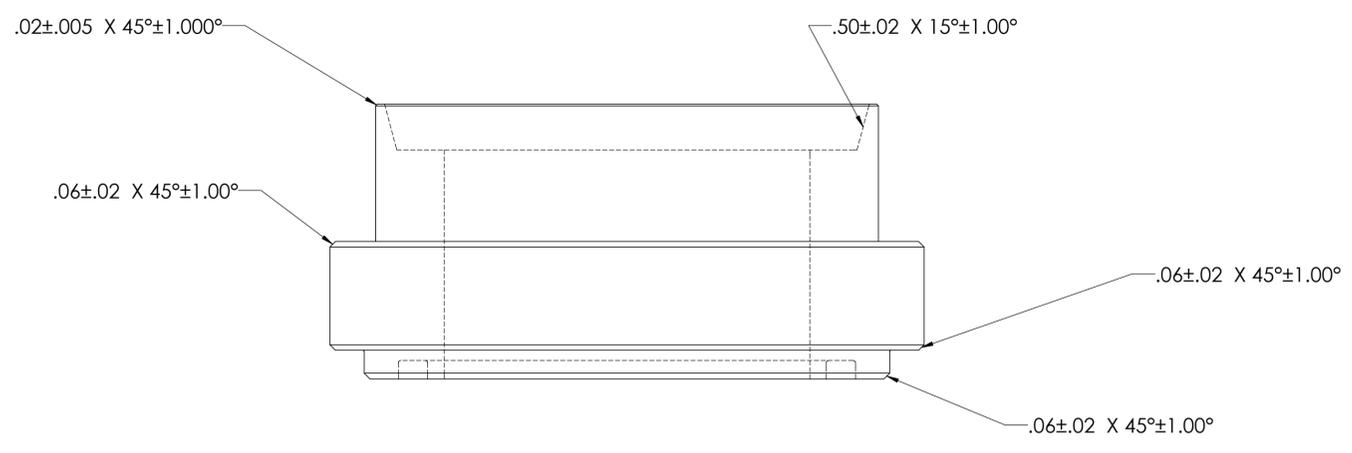
Note: Interior diameter of any adjoining welds must be ground smooth, free of any protrusions or divots, and continuous to form a seal. The surface finish must be consistent with that of the surrounding surfaces.



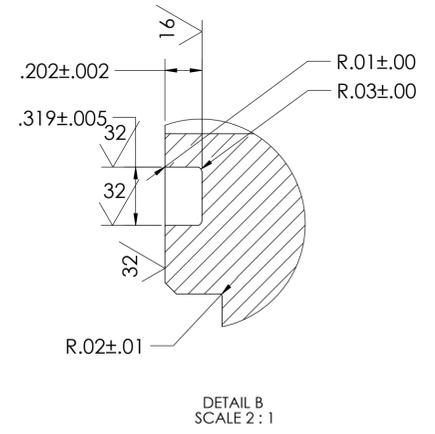
ASTM Type 304L Stainless Steel



SHEET 3: 36in Cone			
SIZE D	CAGE CODE 25307	A	REV -
SCALE 1:5	INDEX DATE	SHEET 3 OF 6	
FILE NAME:			



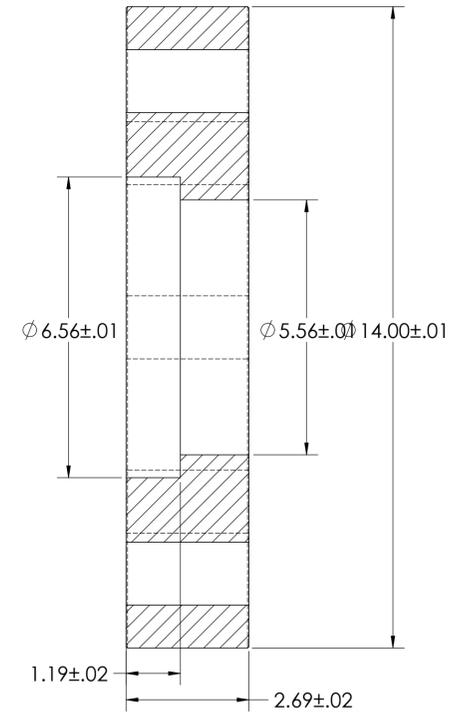
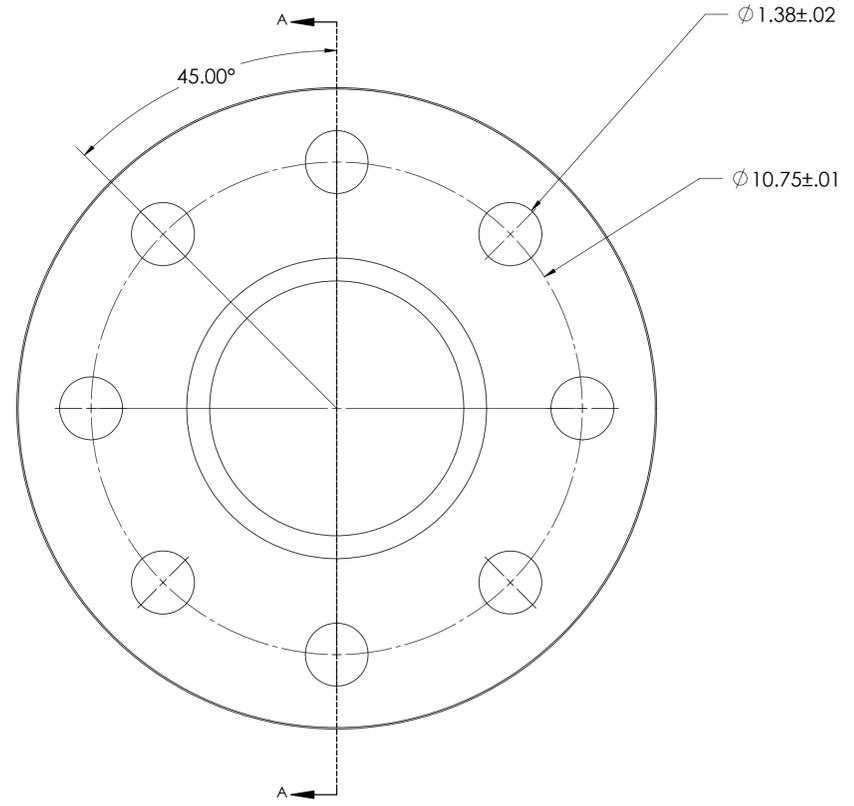
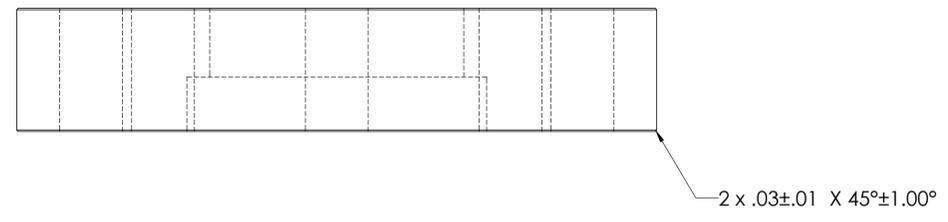
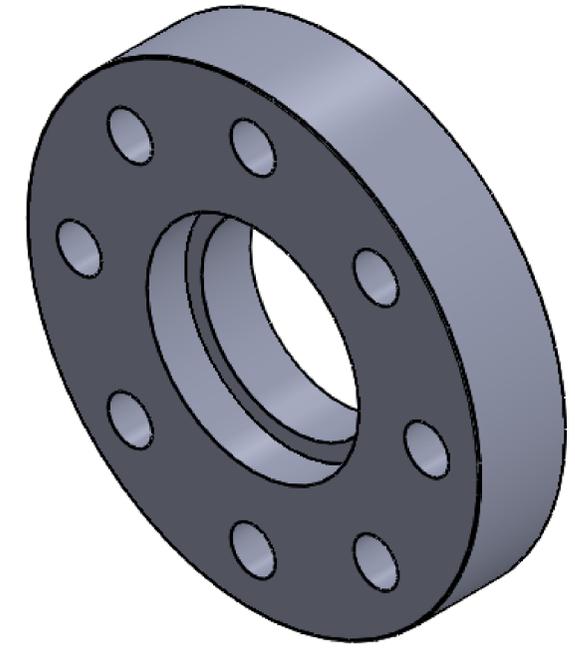
SECTION A-A



ASTM Type 304L Stainless Steel

SHEET 4: 4in flange rotatable-A

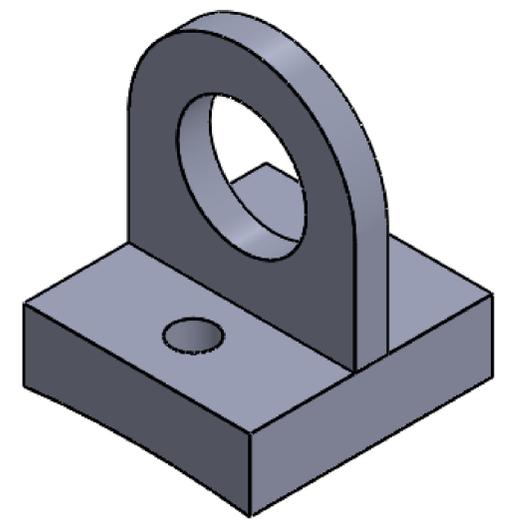
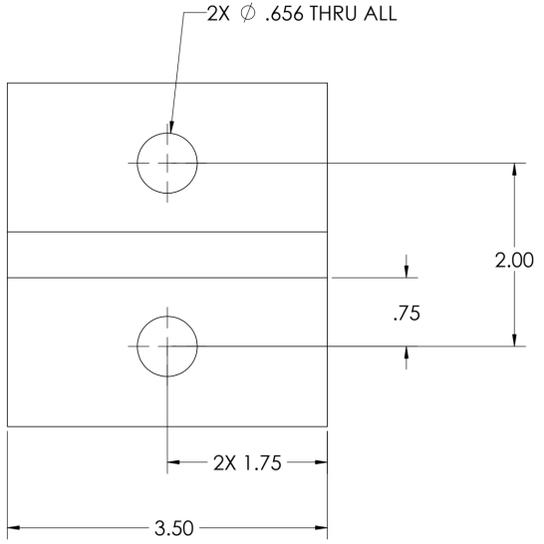
SIZE D	CAGE CODE 25307	REV A	INDEX DATE	REV -
SCALE 1:1	FILE NAME:			SHEET 4 OF 6



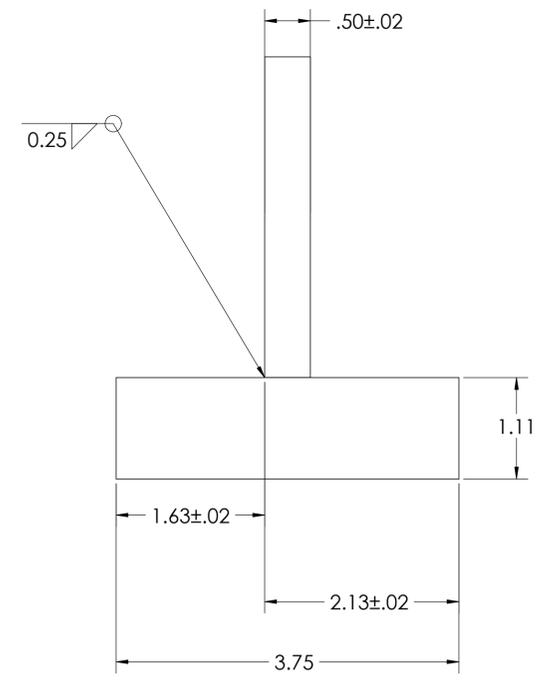
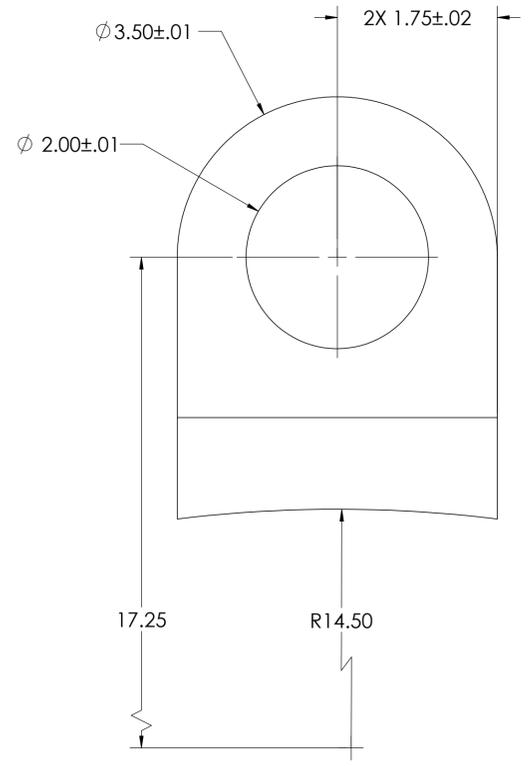
SECTION A-A

ASTM Type 304L Stainless Steel

SHEET 5: 4in flange rotatable-B			
SIZE D	CAGE CODE 25307	A	REV -
SCALE 1:2	INDEX DATE	FILE NAME:	SHEET 5 OF 6



ASTM Type 304L Stainless Steel



SHEET 6: 29in Flange Hook

SIZE D	CAGE CODE 25307	A	329-1300-M1	REV -
SCALE 1:1	INDEX DATE	FILE NAME:	SHEET 6 OF 6	