

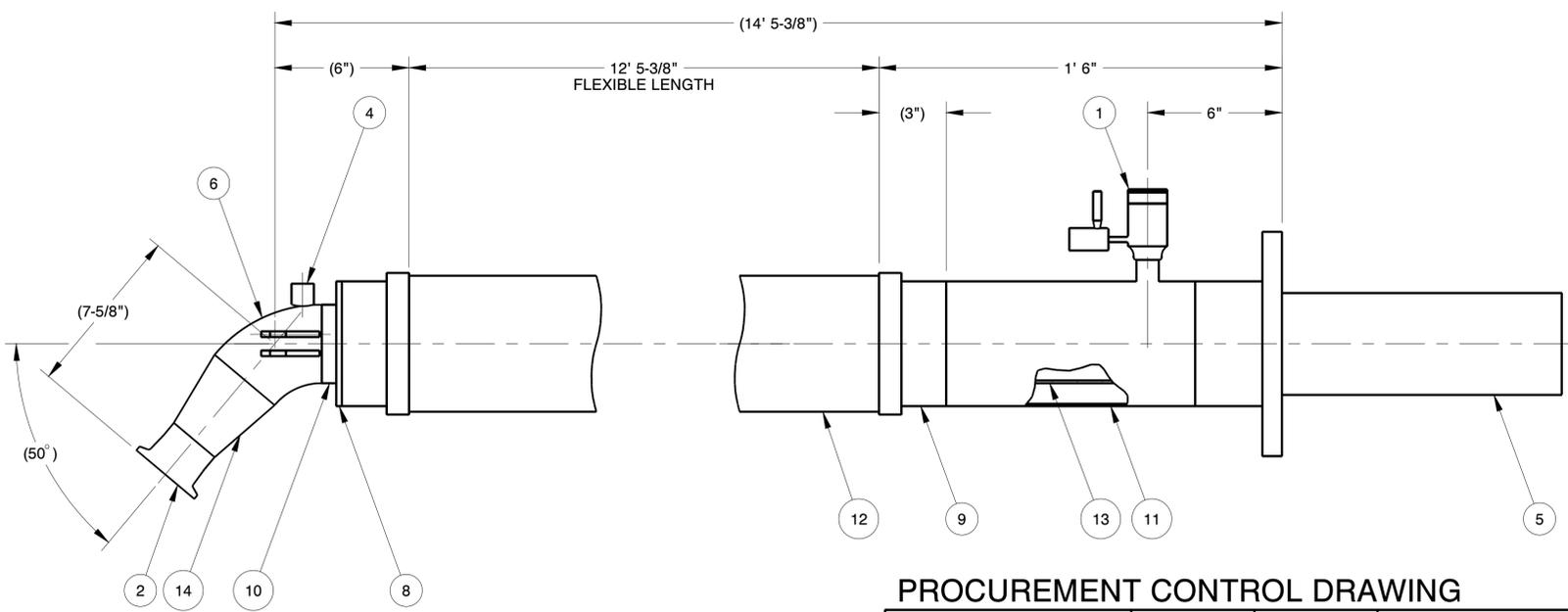
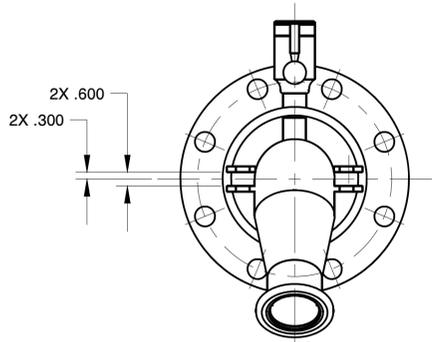
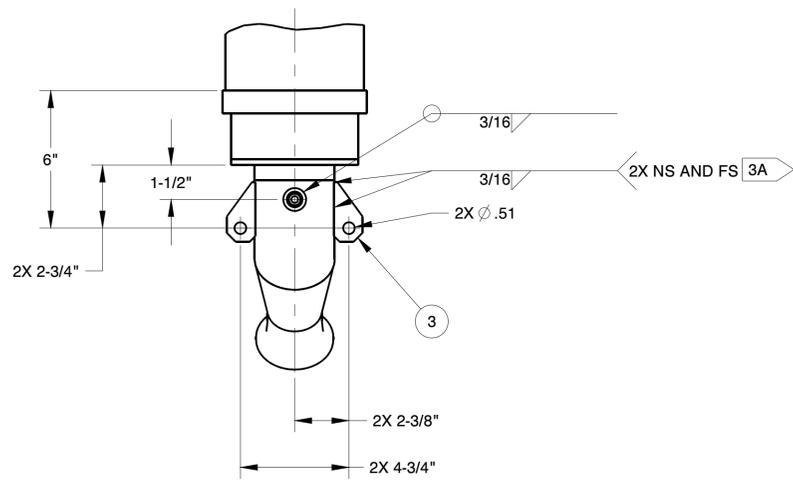
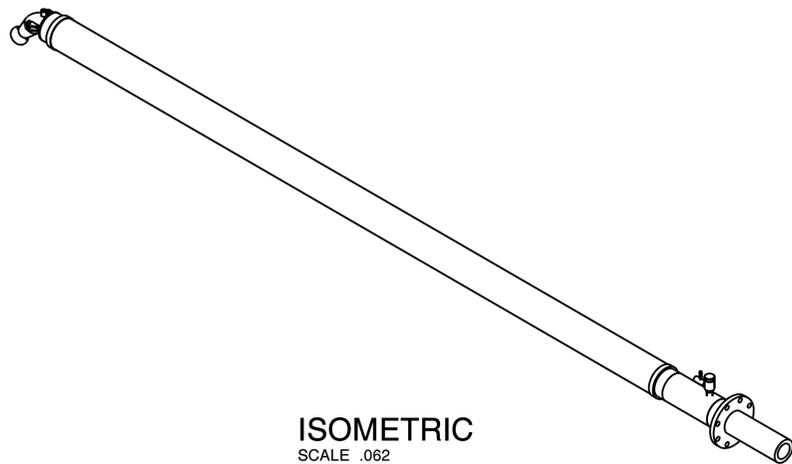
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EODR #: 1311480

EAR 99 NLR

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVAL

- NOTES:
- GENERAL
- 1A. INTERPRET THIS DRAWING PER ASME Y14.5-2009.
  - 1B. THIS DRAWING PROVIDES THE PHYSICAL DIMENSIONS AND PARTS LIST FOR PIPE SPOOL ASSEMBLY. REFER TO PROCUREMENT SPECIFICATION K0000146599 FOR TECHNICAL, FABRICATION, TEST AND INSPECTION REQUIREMENTS.
  - 1C. PIPE SPOOL REFERENCE DESIGNATOR NUMBER IS 4190.
  - 1D. REMOVE SCALE AND BURRS AND BREAK SHARP CORNERS AND EDGES.
- MACHINING
- 2A. UNLESS OTHERWISE SPECIFIED, ALL MACHINED SURFACES SHALL BE 125 MICRO-INCHES OR BETTER.
  - 2B. UNLESS OTHERWISE SPECIFIED, ALL MACHINED SURFACES SHALL BE 32 MICRO-INCHES OR BETTER.
- WELDING
- 3A. STAINLESS STEEL WELDING SHALL BE PERFORMED IN ACCORDANCE WITH NASA-SPEC-5004A. DUE TO FINAL PROFILE OF FORGING, JOINT MAY RESULT IN A MAX ROOT OPENING OF 5/16. INCREASE FILLET WELD SIZE AND PROVIDE SUITABLE BACKING AS REQUIRED PER AWS D1.1 PARA. 5.22.1.



QTY	FIND NO OR ITEM NO	DESCRIPTION
1	14	REDUCER, CONCENTRIC, B16.9, SCHED 10
1	13	PIPE 3 NPS, SCHED 10, ASTM A312
AR	12	FLEX HOSE 3X5, VACUUM JACKETED
AR	11	PIPE 5 NPS, SCHED 10, ASTM A312
AR	10	PIPE 3 NPS, SCHED 10, ASTM A312
1	9	8X10 PIPE TO HOSE TRANSITION
1	8	3X5 CLOSURE RING
1	7	8X10 PIPE TO HOSE TRANSITION
1	6	3", 50 DEG ELBOW, LONG, ASME B16.9, SCHED 10, ASTM A403
1	5	BAYONET, MALE, 3X5
1	4	PORT 3 NPS
4	3	PLATE
1	2	FLANGE 2 NPS
1	1	ASSEMBLY, VACUUM VALVE

PROCUREMENT CONTROL DRAWING

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED ONLY BY THE DESIGN ACTIVITY.		UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES. INTERPRET DIM AND TOL PER ASME Y14.5-2009. TOLERANCES ON:	
SOFTWARE	CREO PARAMETRIC 2.0	FRACTIONS	DECIMALS
FILENAME	K0000065262D	± 1/16	1 PL ±.1
MATERIAL	SST		2 PL ±.03
HEAT TREATMENT	NONE		3 PL ±.010
FINAL PROTECTIVE FINISH	NONE		
DRAFTSMAN	J. A. STAGI	THIRD ANGLE PROJECTION	
ENGINEER	D. C. STANIFER		
ENGINEER	W. C. PATRICK		
ENGINEER	J. K. TUCKERMAN	ENGINEER	V. J. WARD
ENGINEER	C. T. OCONNOR	ENGINEER	T. O. ADAMS
ENGINEER	A. C. LITTLEFIELD	ENGINEER	A. C. LITTLEFIELD

ORIGINAL DATE OF DRAWING (YY/MM/DD)		2013/03/19	
DRAFTSMAN	CHECKER	DRAFTSMAN	CHECKER
D. C. STANIFER	J. A. STAGI	D. C. STANIFER	J. A. STAGI
ENGINEER	CHECKER	ENGINEER	CHECKER
W. C. PATRICK	L. C. KAYLOR	ENGINEER	STRESS
ENGINEER	J. K. TUCKERMAN	ENGINEER	V. J. WARD
ENGINEER	C. T. OCONNOR	ENGINEER	T. O. ADAMS
ENGINEER	A. C. LITTLEFIELD	ENGINEER	A. C. LITTLEFIELD

JOHN F. KENNEDY SPACE CENTER, NASA KENNEDY SPACE CENTER, FLORIDA			
<b>FLEX HOSE, LO2 FILL AND DRAIN, FORWARD</b>			
SIZE	CAGE CODE	DWG NO	REV
D	22264	K000065262	-
SCALE	UNIT WEIGHT	SHEET	OF
.250	125.81	1	2

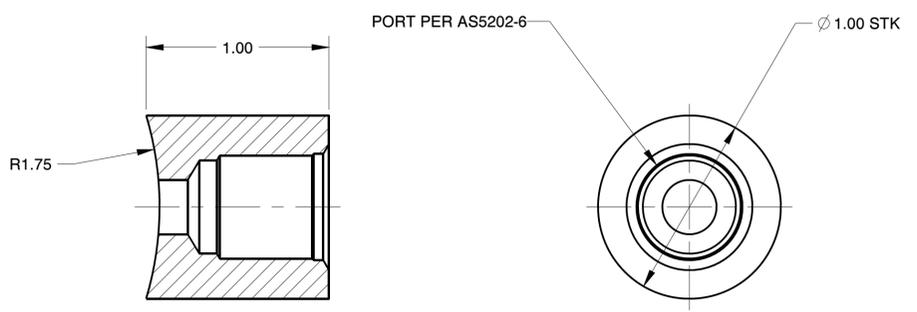
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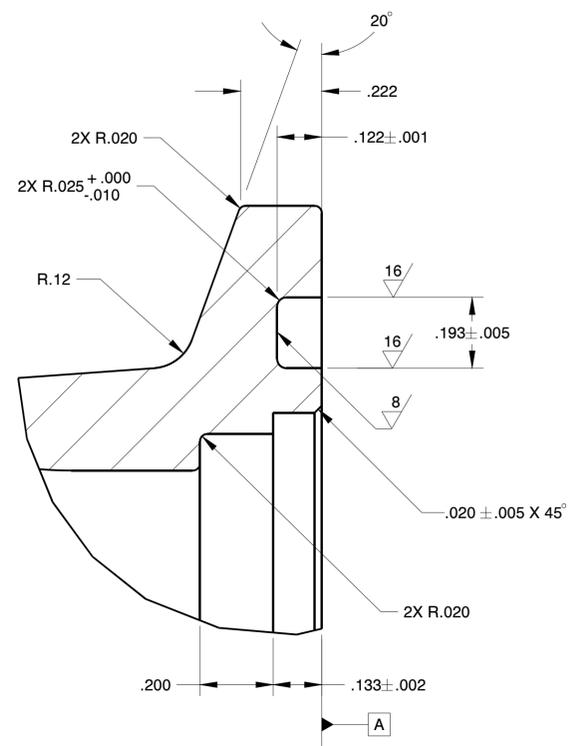
EDDR #: 1311480

EAR 99 NLR

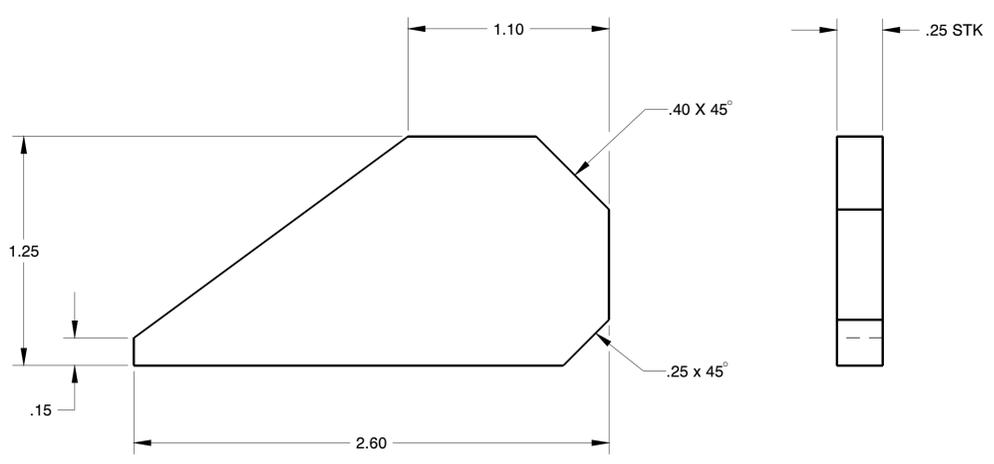
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVAL



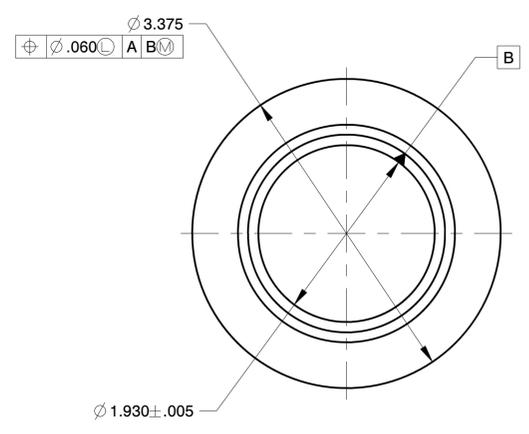
④ PORT



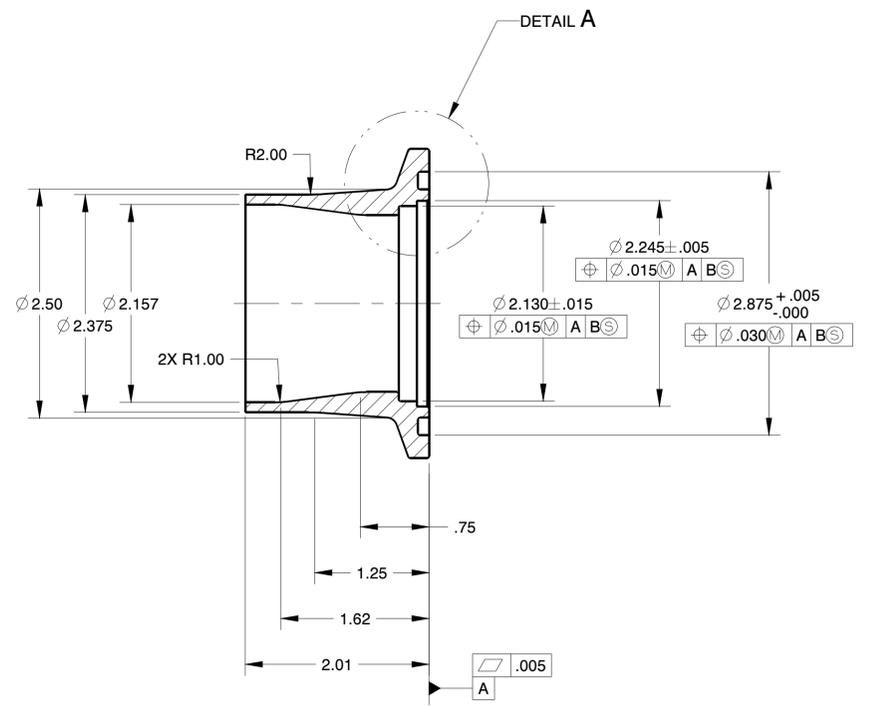
DETAIL A  
SCALE 4.000



③ PLATE



②B FLANGE



SIZE	CAGE CODE	DWG NO	REV
D	22264	K000065262	-
SCALE	1.000	UNIT WEIGHT	125.81
		SHEET	2 OF 2