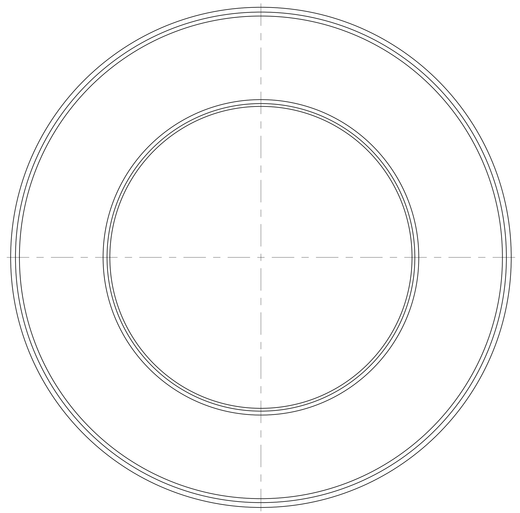
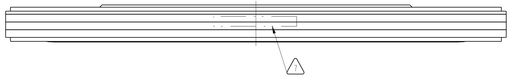
DRAWING LIST

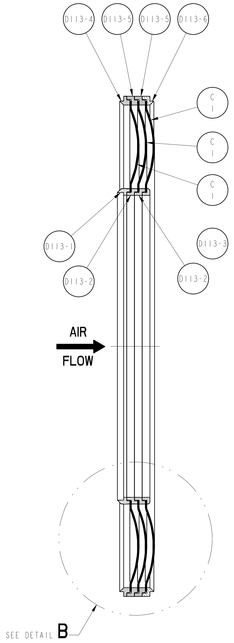
DRAWING NUMBER: DRAWING CODE	BALLOON NO	DESCRIPTION	QTY/ ASSY
G022107MD113-1		ID INLET RING	1
G022107MD113-2		ID SPACER RING	2
G022107MD113-3		ID OUTLET RING	1
G022107MD113-4		OD INLET RING	1
G022107MD113-5		OD SPACER RING	2
G022107MD113-6		OD OUTLET RING	1

COMMERCIAL PARTS LIST

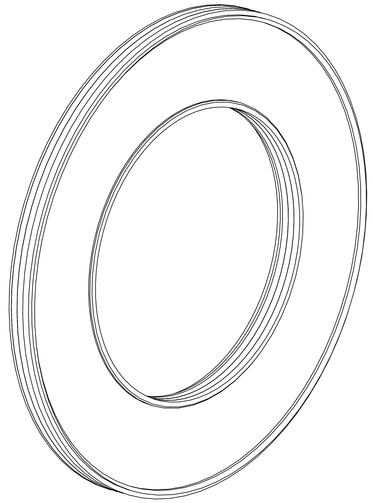
BALLOON NO	DESCRIPTION	QTY/ ASSY
1	WELDED WIRE MESH; 16 X 16 MESH X .018" WIRE DIA., TYPE 304 STAINLESS STEEL; McMASTER-CARR PART No. 85385T65	3

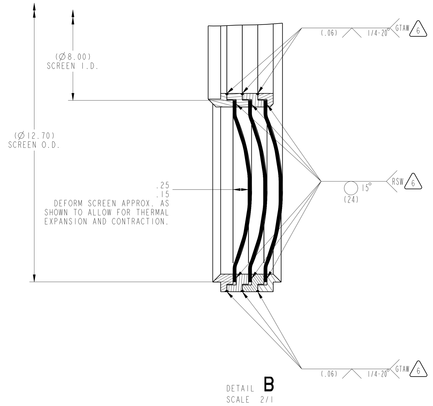






A-A





DETAIL B
SCALE 2/1

1. MATERIAL: ANNEALED TYPE 304 STAINLESS STEEL PER ASTM A-240, OR ASTM A-666 OR EQUAL, HAVING A MINIMUM YIELD STRENGTH OF 30 KSI. PROVIDE A LEGIBLE MILL CERTIFICATE, GIVING THE CHEMISTRY AND TENSILE PROPERIES, WITH THIS DRAWING NUMBER ADDED.

2. SEE SHEET 2 FOR ADDITIONAL MACHINING REQUIREMENTS.

3. 63 Ra ALL MACHINED SURFACES.

4. ALLOW EXCESS MATERIAL AT BORE AND OD TO ALLOW FINISH MACHINING AFTER WELDING.

5. PASSIVATE MACHINED PART PER ASTM A-967 OR EQUAL, PRIOR TO WELDING.

5 RESISTANCE SPOT WELD FIRST SCREEN TO FIRST RING. ASSEMBLE SECOND RING OVER SCREEN, APPLY PRESSURE, THEN GTAW RINGS TOGETHER. REPEAT FOR SECOND SCREEN AND THIRD SCREEN.

6 ELECTROCHEMICAL ETCH DRAWING PART NUMBER G022107MD113 ON SPECIFIED SURFACE, PER SAE-AS47B, METHOD 7A.

8. CLEAN FINISHED PART, TAG WITH THE DRAWING NUMBER, AND SEAL IN A CLEAR PLASTIC BAG. PACKAGE TO PREVENT DAMAGE DURING SHIPPING.

9. THIS SCREEN ASSEMBLY WAS DESIGNED FOR A MAXIMUM FAN AIR TEMPERATURE OF 250°F AND DELTA-P OF 5 PSI. TO ACCOMMODATE RADIAL THERMAL GROWTH, THE INNER RING IS DESIGNED TO PROVIDE A DIAMETRAL CLEARANCE OF 0.062. WITH THE AERO SYSTEMS ENGINEERING (ASE) DWG. L07188-604, "OUTER CORE - SPLIT COVER", 7.904 OD. FOR ASSEMBLY, 0.015 DIAMETRAL CLEARANCE IS PROVIDED WITH ASE DWG. L07188-004, "CHARGING STATION - CORE DUCT" 7.797 OD.

10. THE 400# AXIAL DELTA-P FORCE IS SUPPORTED BY TWO ASE PARTS, -608 NEAR THE OD AND -606 NEAR THE ID.

CHG	ZONE	DESCRIPTION	APP/DATE
A	A5 C5	REVISED WELDING CALLOUTS FOR SCREEN RING ID AND OD TO INDICATE SKIP WELDING IN LIEU OF CONTINUOUS WELDING ADDED ADDITIONAL DIMENSIONS TO VIEWS ON SHEET 2	CMG 12/17/08

REVISIONS

PRIOR TO USE VERIFY THE INTENDED PURPOSE IN PDM (-FOR- ATTRIBUTE)

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCE ON	
.X	± 0.03
.XX	± 0.01
.XXX	± 0.005
FRACTION	±
ANGULAR	± 0.50°
BREAK EDGES	-

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994

CONTRACT	NNC06BA07B
CONTRACTOR	ASRC AEROSPACE
TASK ORDER	022
DRAFTER	ASRC/C. GRIFFITHS
ENGINEER	ASRC/G. PINKAS
DESIGNER	ASRC/C. GRIFFITHS

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
JOHN H. GLENN RESEARCH CENTER
LEWIS FIELD
CLEVELAND, OHIO

DUAL-FLOW REDESIGN
NOZZLE ASSEMBLY

G022107MD100

D113 NOZZLE SCREEN ASSEMBLY

PDM REL LEVEL: Released PDM REVISION: -
PDM DATABASE:
MODEL NAME: G022107MD113_SCREEN_ASSY
CHECK FOR ANY OUTSTANDING ECO'S PRIOR TO USE

SIZE	DRAWING NUMBER	REV	BLDG	AREA
R	G022107MD113	A	140	DOME

SCALE	INITIAL REL DATE	SHEET	DISCIPLINE
1/1	11/16/08	1 of 2	MECHANICAL

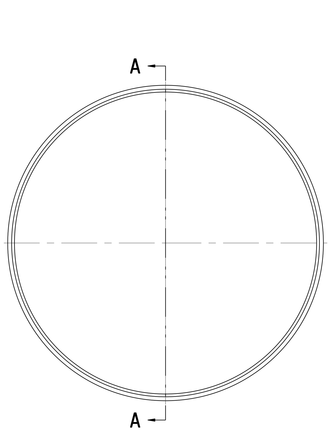
UNITS: INCH

PRO/E VERSION: Wildfire 2.0

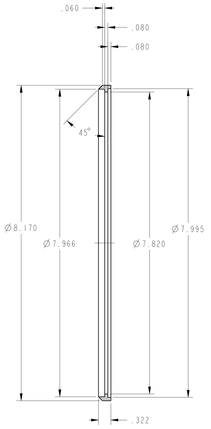
DRAWING NUMBER	REV	SHT
G022107MD113	-	1

R G022107MD113 REV: -

NAME:CHCGRFI OBJECT:G022107MD113_SCREEN_ASSY_1 DATE:16-Dec-08 08:00



0113-1 ID INLET RING



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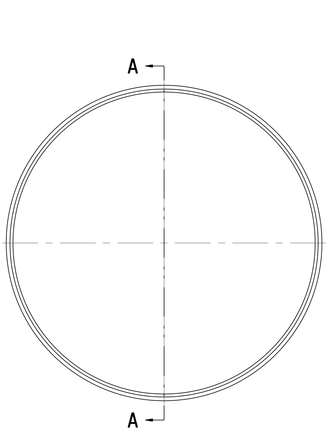
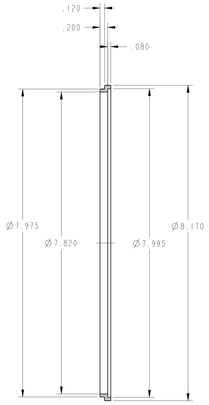


0113-2 ID SPACER RING
2 REQUIRED



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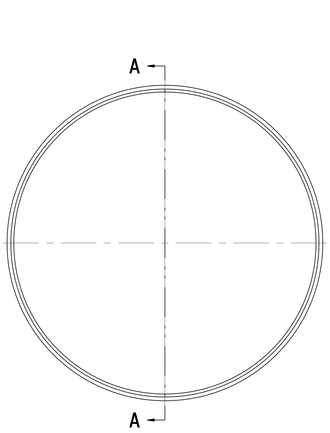
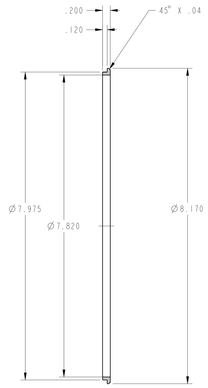


0113-3 ID OUTLET RING



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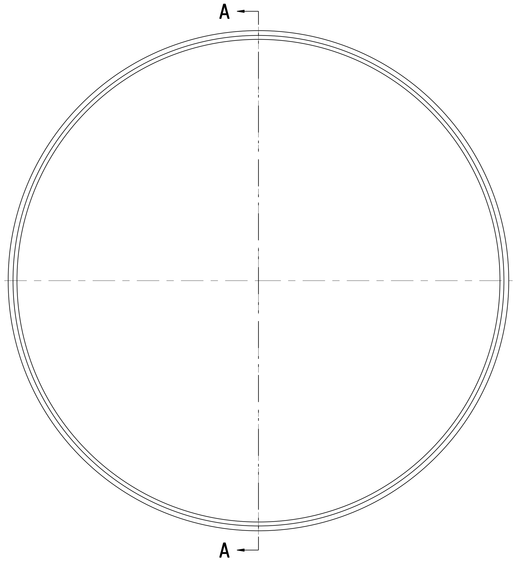
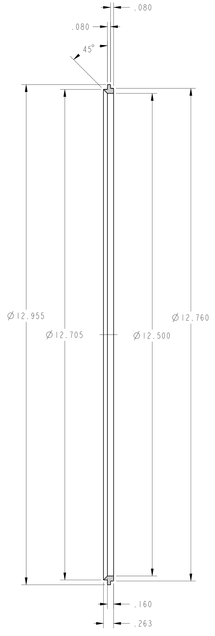


0113-4 OD INLET RING



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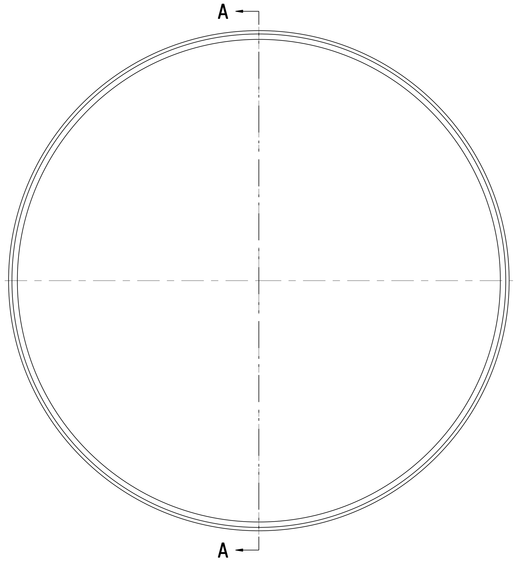
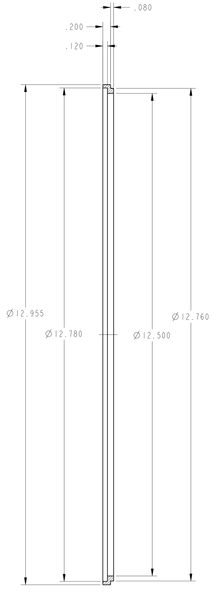


0113-5 OD SPACER RING
2 REQUIRED



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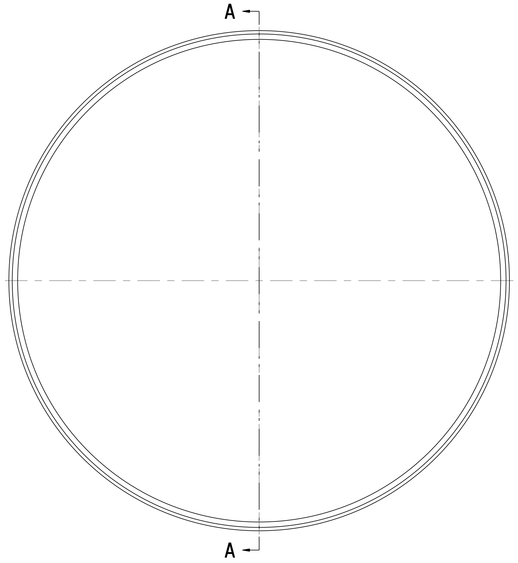
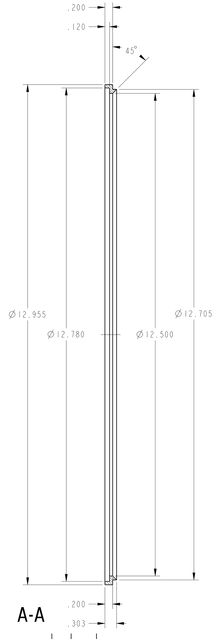


0113-6 OD OUTLET RING



A-A

DRAWING NUMBER	REV	SHT
G022107MD113	-	2

CHG	ZONE	DESCRIPTION	APP/DATE
		REVISIONS	

SIZE	DRAWING NUMBER	REV	BLDG	AREA
R	G022107MD113	A	LAS	DOME
SCALE: N/A	INITIAL REL DATE: 11/6/08	SHEET: 2 of 2	UNITS: INCH	DISCIPLINE: MECHANICAL

PRO/E VERSION: Wildfire 2.0

R G022107MD113 REV: -

NAME:CHOUBRI, OBEYDA@SYNAPTICS,INC@N_LOCBRN_ARY_2 DATE:04-Dec-08@09:31