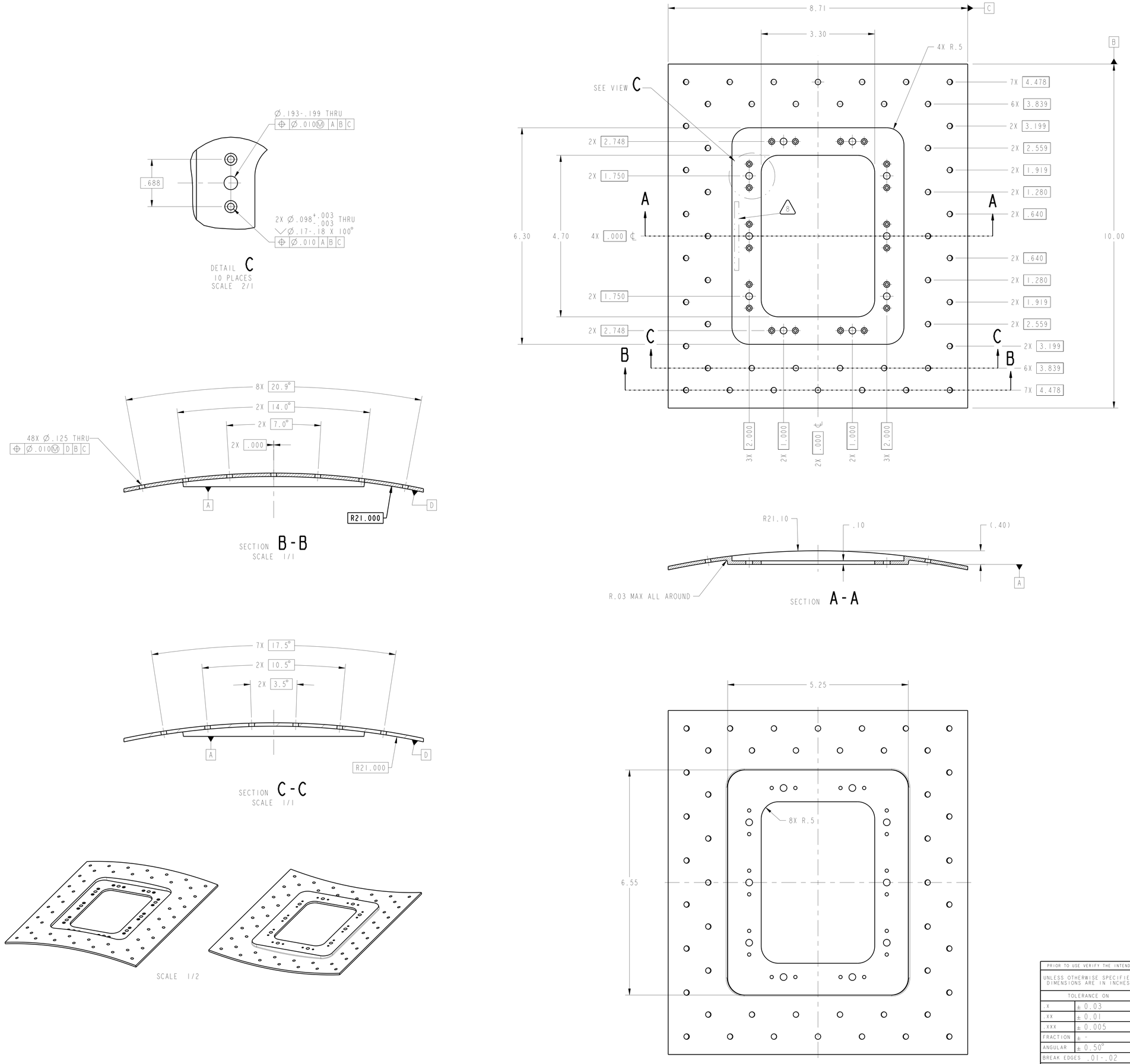

1. MATERIAL: 6061-T6 ALUMINUM.
2. CERTIFIED MATERIAL TEST REPORT WITH A TRACEABLE LOT NUMBER MUST BE PROVIDED.
3. THIS DRAWING SHALL BE USED WITH MODEL "140403MFA204_DOUBLER PLATE.stp" FOR COMPLETE PRODUCT DEFINITION.
4. 125 Ra ALL MACHINED SURFACES.
5. SURFACE TREATMENT: CHEMICAL CONVERSION COATING PER MIL-DTL-5541F WITH MATERIAL MEETING MIL-DTL-81706B, CLASS IA.
6. PRIMER PAINT PER MIL-PRF-23377K.
7. VISUALLY INSPECT PART FOR DEFECTS.
8. IDENTIFY WITH PART DRAWING NUMBER PLUS A SERIALIZED DASH NUMBER PROVIDED BY CONFIGURATION CONTROL, PER S3 VRP-02 EXAMPLE: (140403MFA204-01). USE RUBBER STAMP AND BLACK INK WITH 1/8" to 1/4" HIGH CHARACTERS, PER MIL-STD-130. LOCATE ON SPECIFIED SURFACE APPROXIMATELY AS SHOWN (ZONE C5).

CHG	ZONE	DESCRIPTION	APP/DATE

REVISIONS

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

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

CONTRACT

CONTRACTOR

TOLERANCE ON		TASK ORDER	
.X	± 0.03	DRAFTER	DEZ/ L. SPINELLI
.XX	± 0.01	ENGINEER	DER/ J. POLACK
.XXX	± 0.005	DESIGNER	DEZ/ L. SPINELLI
FRACTION	± -	DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994	
ANGULAR	± 0.50°		
BREAK EDGES	.01-.02		

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

IO DOUBLER ASSEMBLY

140403MFA203

A204 IO DOUBLER

PDM REL LEVEL: Released PDM REVISION: -

PDM DATABASE: 140403_S3_Viking_Research_Pod

MODEL NAME: 140403MFA204_DOUBLER_PLATE

CHECK FOR ANY OUTSTANDING ECO'S PRIOR TO USE

SIZE	DRAWING NUMBER	REV	BLDG	AREA
E	140403MFA204	-	4	HANGER

UNITS: INCH

SCALE:	INITIAL REL DATE	SHEET	DISCIPLINE
1/1	06/26/2014	1 OF 1	MECHANICAL

PRO/E VERSION: Wildfire 5.0

SIZE E DRAWING NUMBER 140403MFA204 REV -