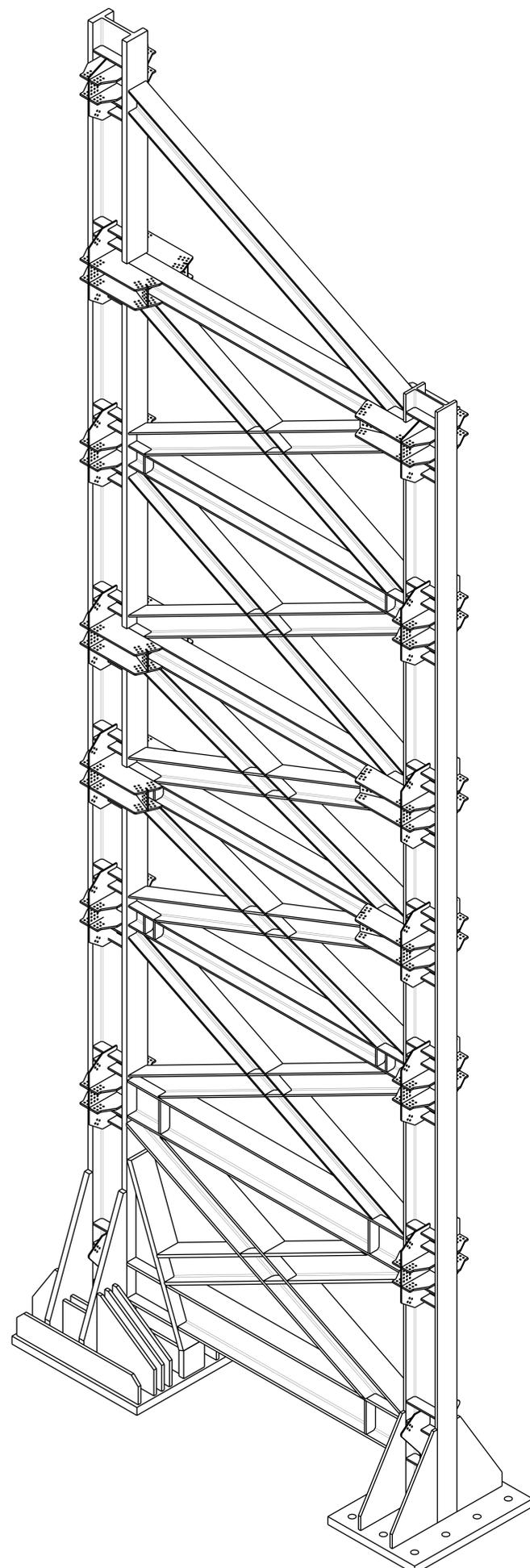


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REVISIONS			
NO.	DESCRIPTION	DATE	APPROVAL



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 07-17-14
 DATE

- UNLESS OTHERWISE SPECIFIED:
1. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
 2. $\sqrt[125]{500}$ ALL MACHINED SURFACES.
 3. DIMENSIONING AND TOLERANCING IN ACCORDANCE WITH ASME Y14.5-1994.
 4. STENCIL PART NUMBER IN THE APPROXIMATE LOCATION SHOWN USING A CONTRASTING COLOR AND 3" TALL LETTERS.
 5. PAINT ALL EXPOSED SURFACES USING THE FOLLOWING FINISH: PREPARE SURFACES, ABRASIVE CLEANING WHERE NECESSARY, THEN POLYURETHANE PRIME AND TOP COAT USING SHERWIN WILLIAMS POLANE F63. FINISH COLOR GRAY NO. 16251 PER FED-STD-595C.
- DO NOT PAINT MACHINED OR OTHER INDICATED SURFACES. DO NOT PAINT HOLES OR THREADS. AREAS DAMAGED DURING ASSEMBLY OR INSTALLATION SHALL BE TOUCHED UP AFTER DELIVERY USING BRUSH OR ROLLER ONLY. PROTECT UNPAINTED SURFACES WITH TRI-FLOW TO PREVENT CORROSION.
- SUBSTITUTIONS FOR PAINT TYPE, COLOR SHADE, OR PROTECTIVE COATING MAY BE PERMITTED WITH NASA ENGINEERING APPROVAL.
6. STENCIL PART WEIGHT "74,000 LBS" IN THE APPROXIMATE LOCATION SHOWN USING A CONTRASTING COLOR AND 3.0" TALL LETTERS.
 7. COPED JOINTS AND WELD ACCESS HOLES SHALL BE PER THE EDITION OF ANSI/AWS D1.1/D1.1M "STRUCTURAL WELDING CODE-STEEL" THAT IS CURRENT AT THE RELEASE DATE OF THIS DRAWING. NOTE THAT REQUIRED WELD ACCESS HOLES HAVE NOT BEEN SHOWN AT THE DETAIL LEVEL IN THIS DRAWING. REFER TO "WELD PREP DETAIL" DIAGRAM ON SHEET 3.
 8. STEEL WELDING DESIGN, PROCEDURES, AND NON-DESTRUCTIVE EVALUATION SHALL BE PER ANSI/AWS D1.1/D1.1M "STRUCTURAL WELDING CODE-STEEL" AND CURRENT AS OF THE RELEASE DATE OF THIS DRAWING. UTILIZE WELDING PRACTICES AND TECHNIQUES TO MINIMIZE DISTORTION. UNLESS OTHERWISE SPECIFIED, WELDS SHALL BE 100% VISUALLY INSPECTED.
 9. AFTER WELDING AND PRIOR TO FINAL MACHINING, STRESS RELIEVE PER AWS D1.1, "STRUCTURAL WELDING CODE, STEEL", AND CURRENT AS OF THE RELEASE DATE OF THIS DRAWING.
 10. STENCIL TEXT IN THE APPROXIMATE LOCATION SHOWN USING A CONTRASTING COLOR AND 3.0" TALL LETTERS.

MAIN VIEW
FOR REFERENCE ONLY
NO SCALE

NO.	QTY	UNIT	DESCRIPTION	MATERIAL
33	3-8	10	112 F 90M14397-33 GUSSET PLATE, .75" STK	MATERIAL: ASTM 572 GRADE 50
32	6,7	10	6 F 90M14397-32 PLATE, .50" STK, FOR FN 3	MATERIAL: ASTM 572 GRADE 50
31	6,7	10	6 F 90M14397-31 PLATE, .50" STK, FOR FN 2	MATERIAL: ASTM 572 GRADE 50
30	5,6,8	10	16 F 90M14397-30 PLATE, .75" STK, FOR FN 2	MATERIAL: ASTM 572 GRADE 50
29	6,8	10	12 F 90M14397-29 PLATE, .75" STK, FOR FN 3	MATERIAL: ASTM 572 GRADE 50
28	4	10	2 F 90M14397-28 PLATE, .50" STK, FOR FN 3	MATERIAL: ASTM 572 GRADE 50
27	3	10	2 F 90M14397-27 PLATE, .50" STK, FOR FN 2	MATERIAL: ASTM 572 GRADE 50
26	6	10	2 F 90M14397-26 PLATE, .50" STK, FOR FN 2	MATERIAL: ASTM 572 GRADE 50
25	5	10	2 F 90M14397-25 PLATE, .50" STK, FOR FN 2	MATERIAL: ASTM 572 GRADE 50
24	7	9	2 F 90M14397-24 PLATE, .50" STK, 70-70, FOR FN 3	MATERIAL: ASTM 572 GRADE 50
23	7,8	9	4 F 90M14397-23 PLATE, .50" STK, 70-92, FOR FN 3	MATERIAL: ASTM 572 GRADE 50
22	6,8	9	4 F 90M14397-22 PLATE, .50" STK, 92-92, FOR FN 3	MATERIAL: ASTM 572 GRADE 50
21	7	9	2 F 90M14397-21 PLATE, .50" STK, 70-70, FOR FN 2	MATERIAL: ASTM 572 GRADE 50
20	7,8	9	4 F 90M14397-20 PLATE, .50" STK, 70-92, FOR FN 2	MATERIAL: ASTM 572 GRADE 50
19	6	9	4 F 90M14397-19 PLATE, .50" STK, 92-92, FOR FN 2	MATERIAL: ASTM 572 GRADE 50
18	6,7	8	12 F 90M14397-18 PLATE, .75" STK, FOR FN 3	MATERIAL: ASTM 572 GRADE 50
17	6,7	8	12 F 90M14397-17 PLATE, .75" STK, FOR FN 2	MATERIAL: ASTM 572 GRADE 50
16	4	-	AR P 90M14397-16 PLATE, .75" STK	MATERIAL: ASTM 572 GRADE 50
15	5,6,8	-	AR P 90M14397-15 PLATE, 1.00" STK	MATERIAL: ASTM 572 GRADE 50
14	3	-	AR P 90M14397-14 PLATE, 1.38" STK	MATERIAL: ASTM 572 GRADE 50
13	3	-	AR P 90M14397-13 PLATE, 2.75" STK	MATERIAL: ASTM 572 GRADE 50
12	4	-	AR P 90M14397-12 PLATE, .875" STK X 8.86" X 4.83"	MATERIAL: ASTM 572 GRADE 50
11	3	-	AR P 90M14397-11 PLATE, 1.50" STK	MATERIAL: ASTM 572 GRADE 50
10	4	-	AR P 90M14397-10 PLATE, .875" STK	MATERIAL: ASTM 572 GRADE 50
9	3,4	-	AR P 90M14397-9 PLATE, 1.38" STK	MATERIAL: ASTM 572 GRADE 50
8	3	-	AR P 90M14397-8 PLATE, 4.0", SMALL, STK	MATERIAL: ASTM 572 GRADE 50
7	3	-	AR P 90M14397-7 PLATE, 4.0", LARGE, STK	MATERIAL: ASTM 572 GRADE 50
6	2	-	AR P 90M14397-6 W 10 X 68	MATERIAL: ASTM A992
5	2	-	AR P 90M14397-5 W 12 X 152	MATERIAL: ASTM A992
4	2	-	AR P 90M14397-4 W 18 X 106	MATERIAL: ASTM A992
3	2	-	AR P 90M14397-3 W 18 X 143	MATERIAL: ASTM A992
2	2	-	AR P 90M14397-2 W 18 X 311	MATERIAL: ASTM A992
1	-	-	F 90M14397-1 MAIN TOWER WELDMENT SLS INTERTANK TEST	MATERIAL: ASTM A992

FIND NO.	CALLOUT	DETAIL	TOT	REQ'D	PART NO.	DESCRIPTION	VEND NO.	REMARKS

UNLESS OTHERWISE SPECIFIED	
FRACTIONS	DECIMALS
$\frac{1}{16}$ $\frac{1}{8}$ $\frac{1}{4}$.06 .12 .25
$\frac{1}{32}$ $\frac{1}{16}$ $\frac{1}{8}$.03 .06 .12
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MAIN TOWER
WELDMENT
SLS INTERTANK TEST

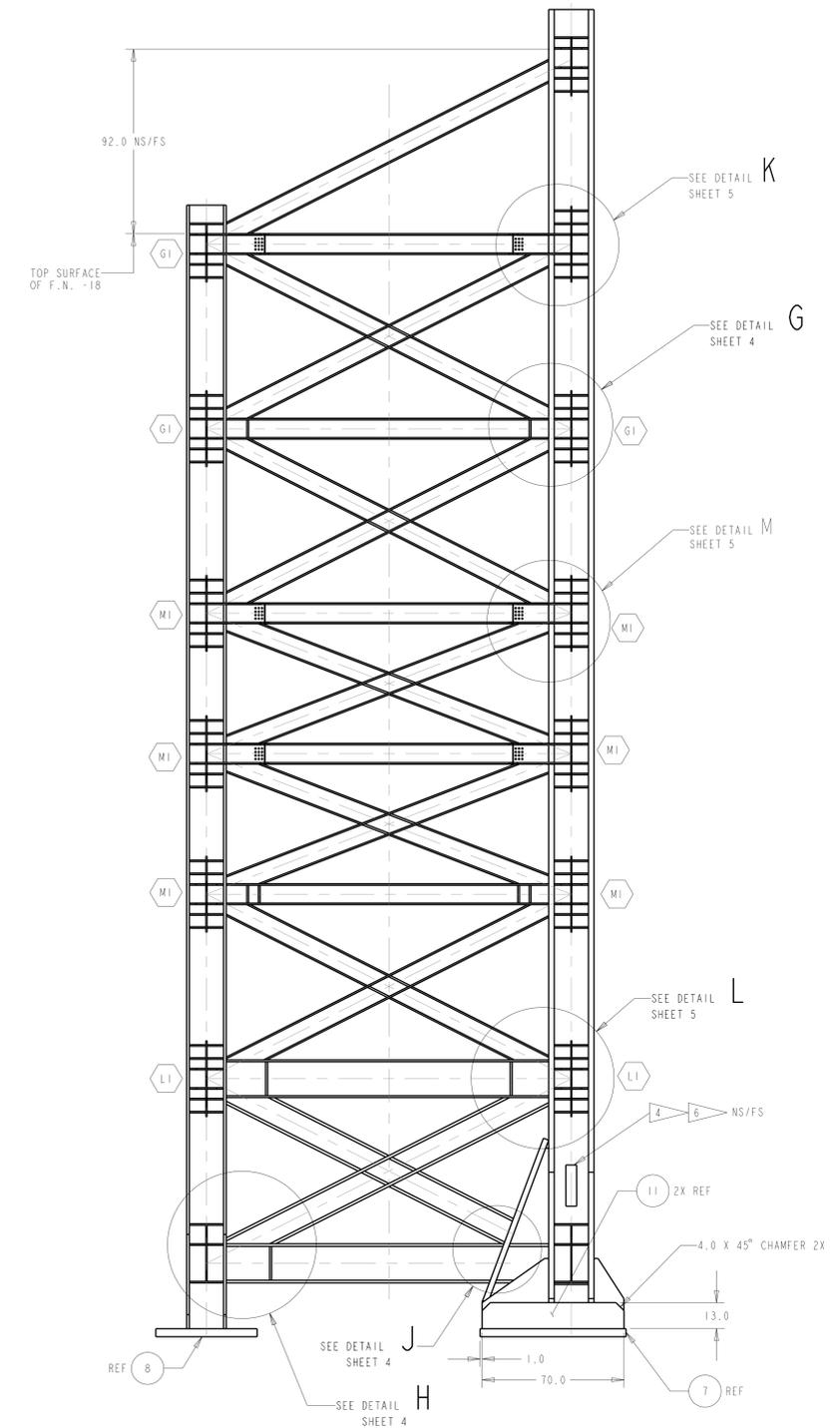
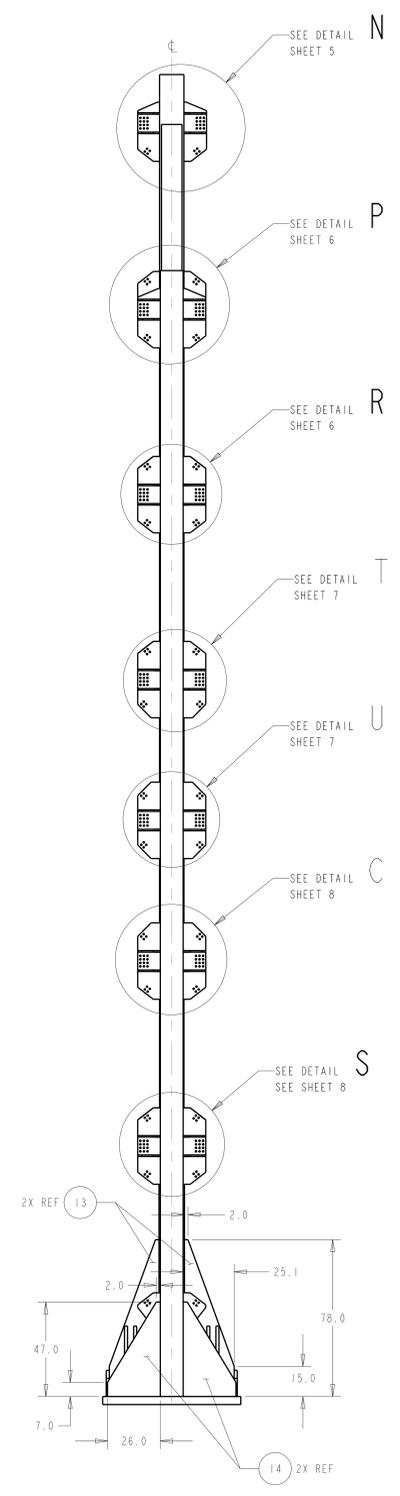
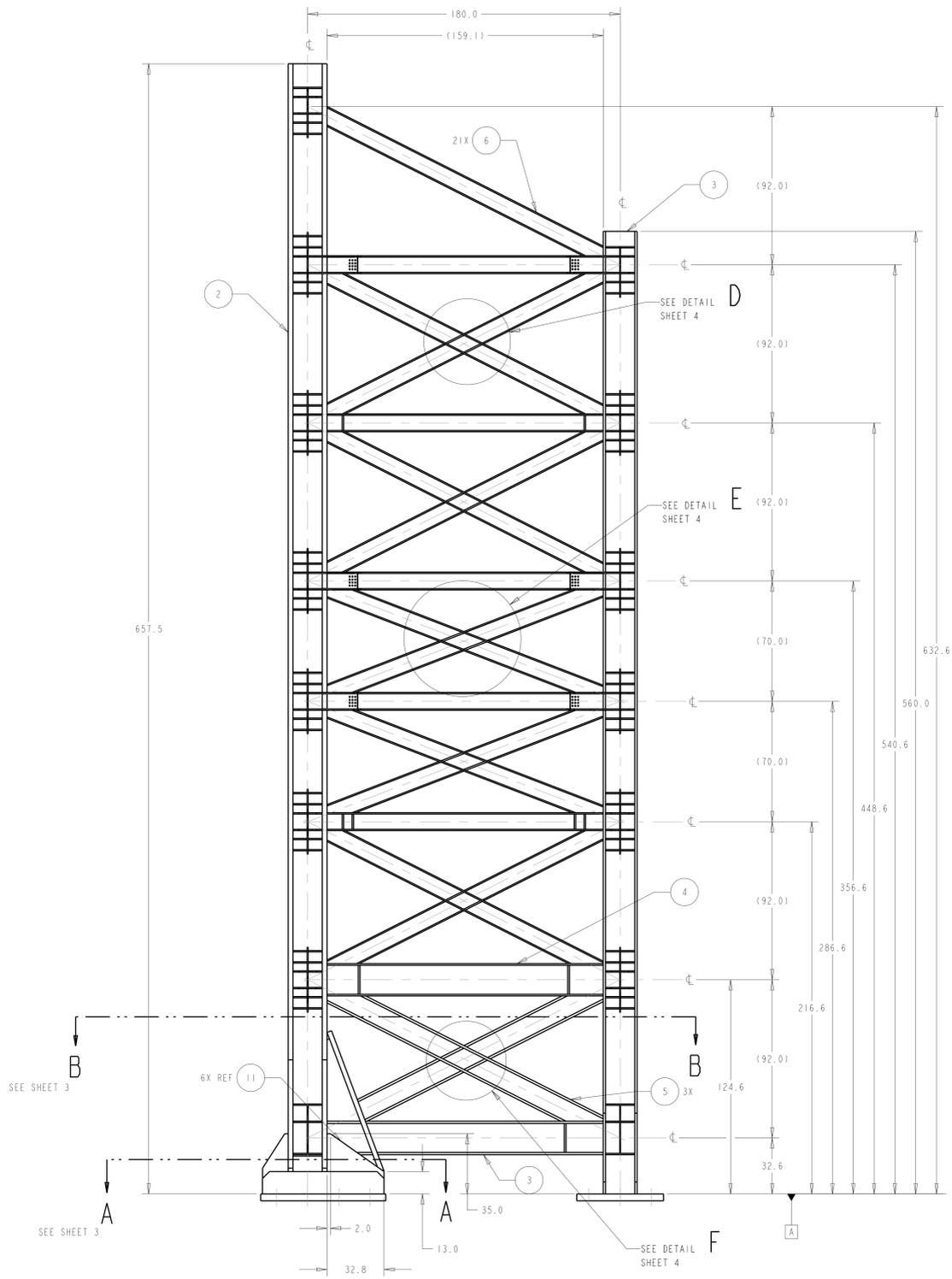
SPECIAL TEST EQUIPMENT
DESIGN BRANCH - ETSO
GEORGE C. MARSHALL
SPACE FLIGHT CENTER
NATIONAL AERONAUTICS
AND SPACE ADMINISTRATION
Huntsville, Alabama

90M14397

DATE: 05-06-14

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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL



FIND NO. 1 3
SCALE 0.031

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07-17-14
DATE

MAIN TOWER WELDMENT SLS INTERTANK TEST

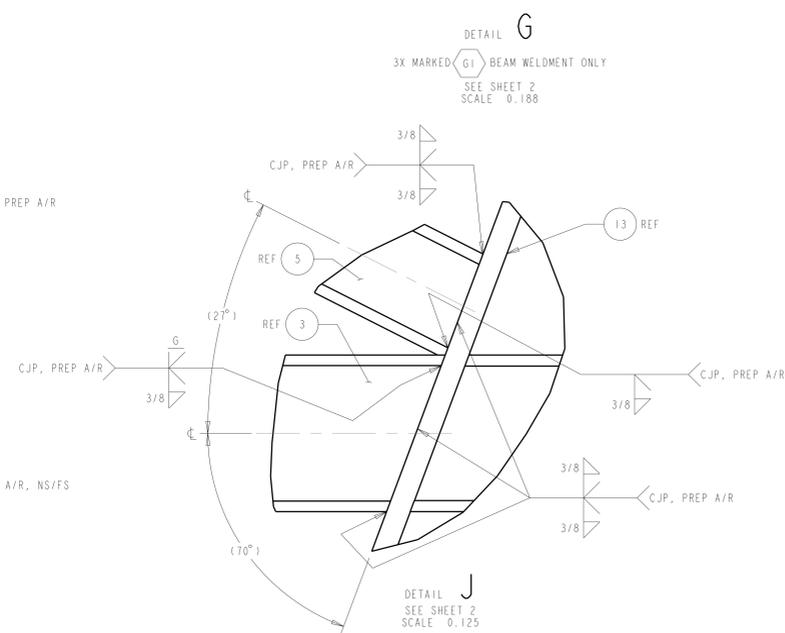
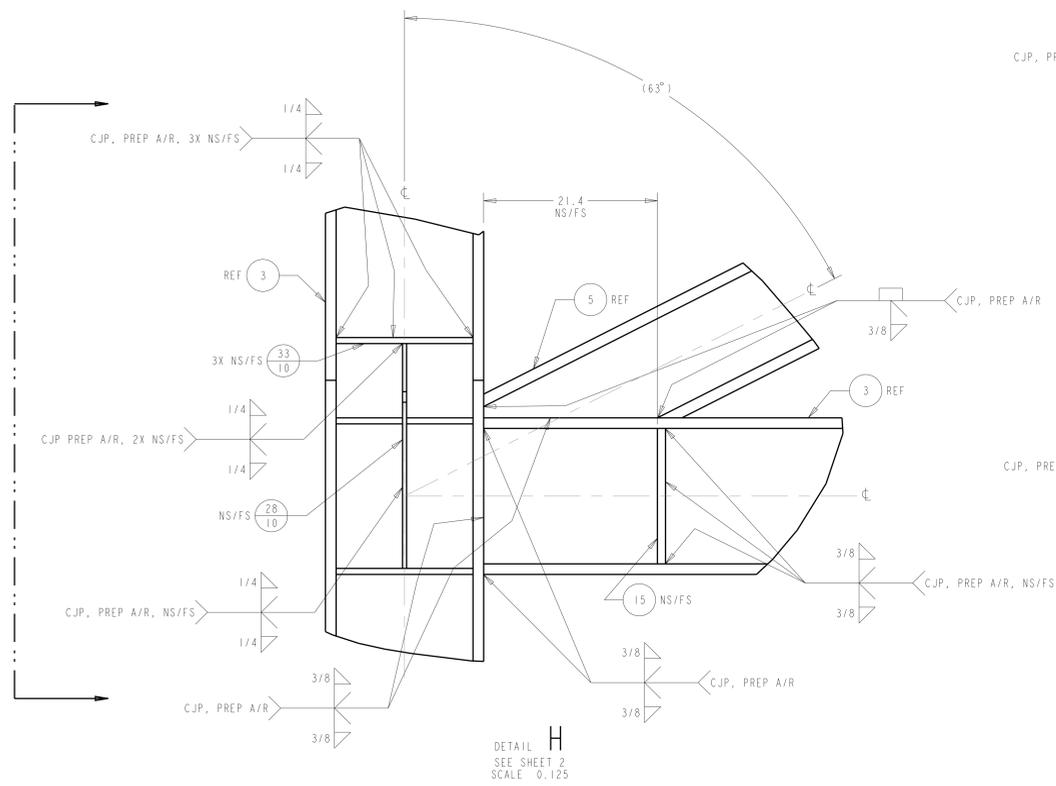
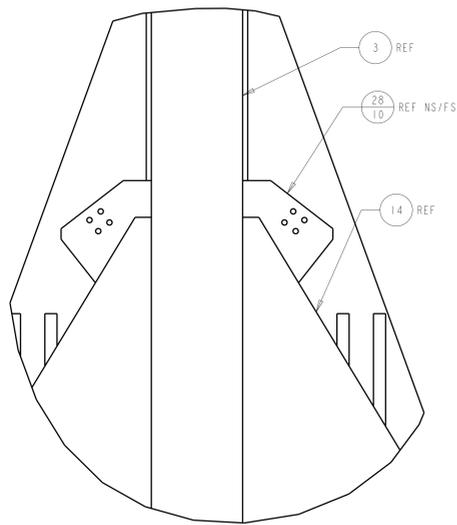
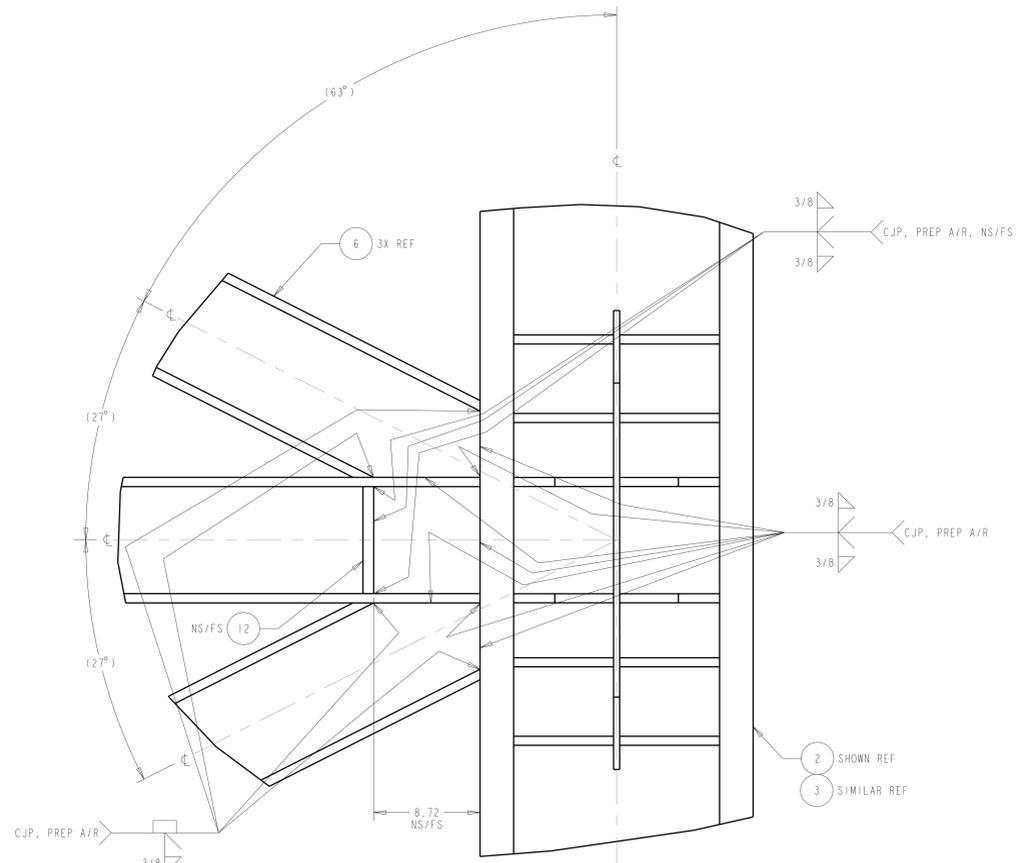
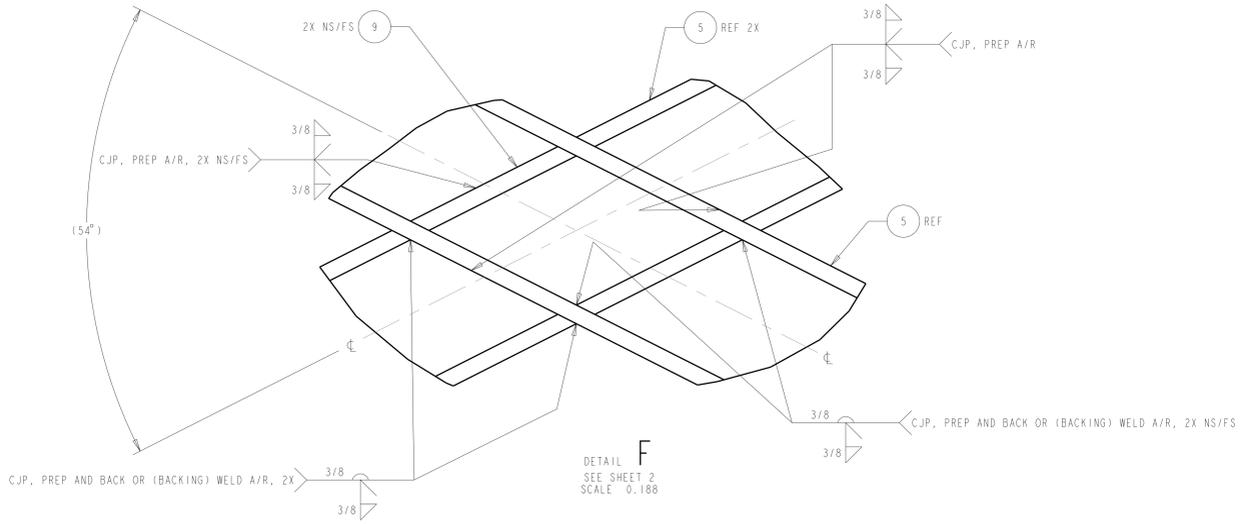
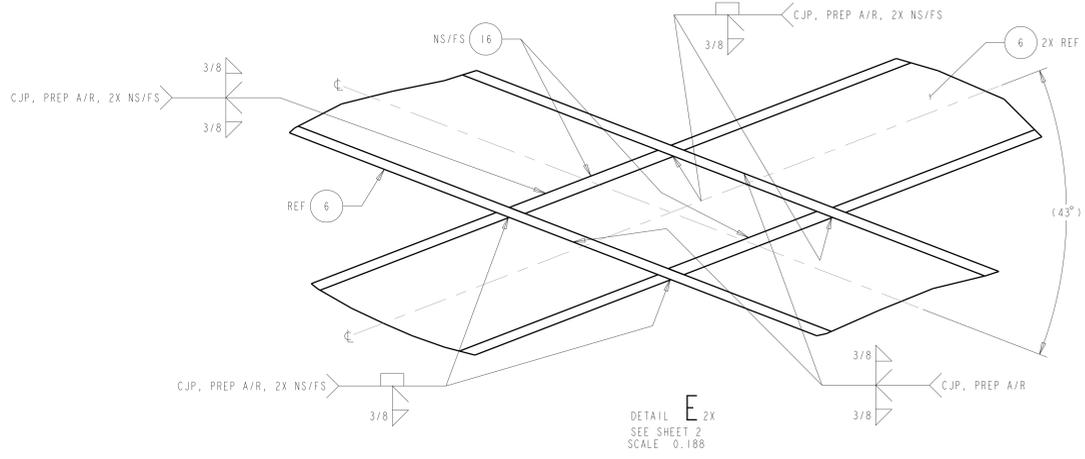
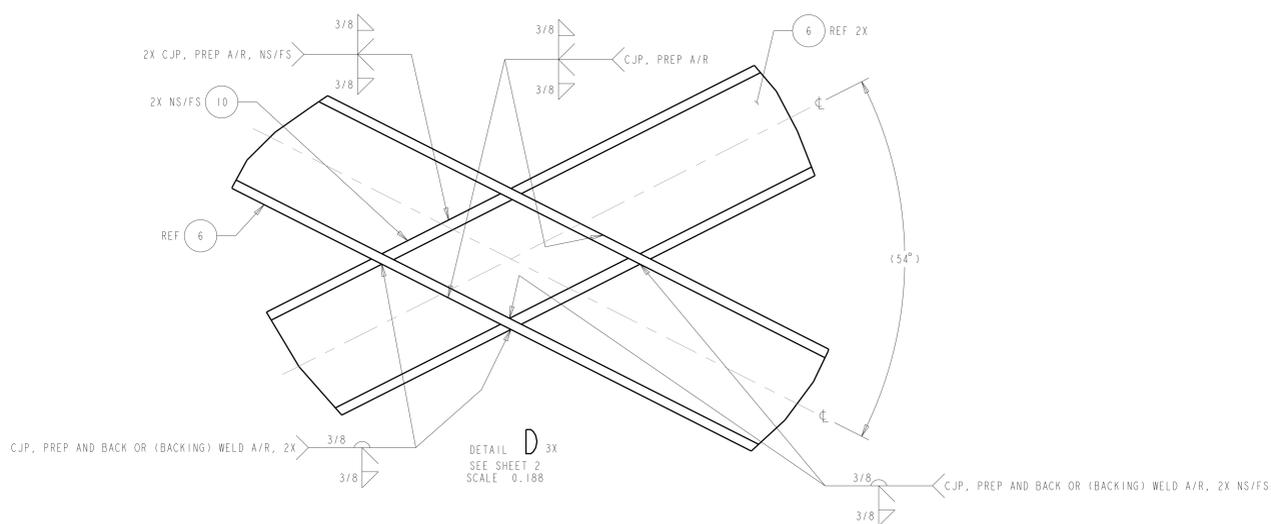
SPECIAL TEST EQUIPMENT DESIGN BRANCH - ET50
GEORGE C. MARSHALL SPACE FLIGHT CENTER
NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
HOUSTON, TEXAS

90M14397

REVISION SEE SHT 1
E 2 10

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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL

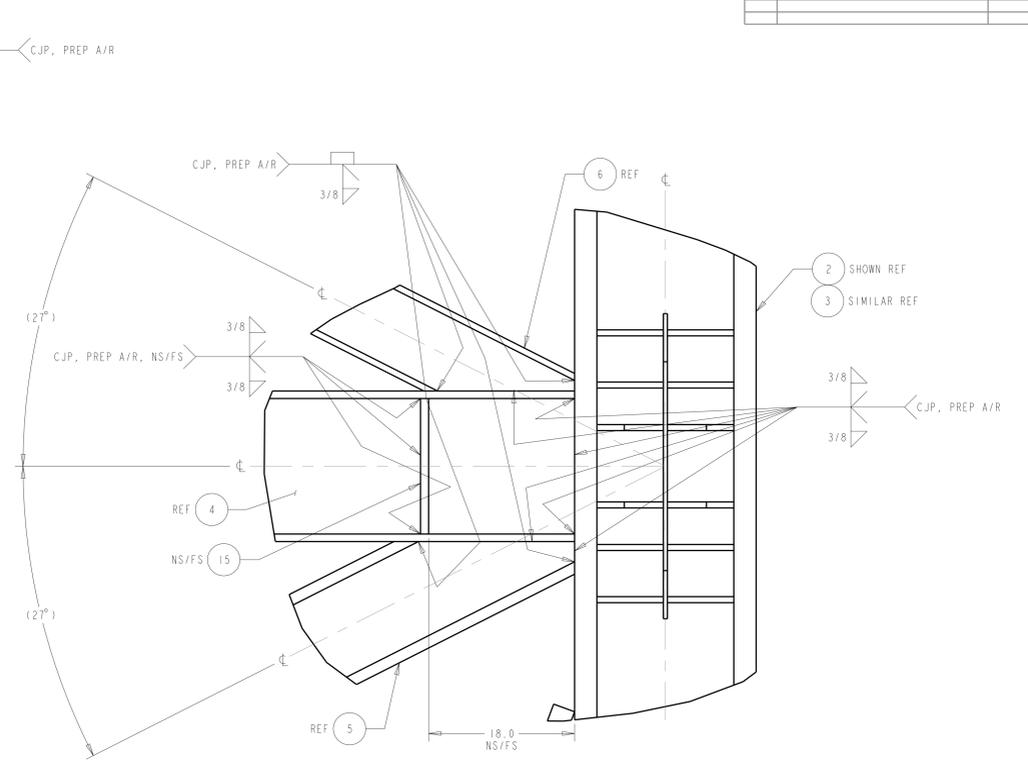
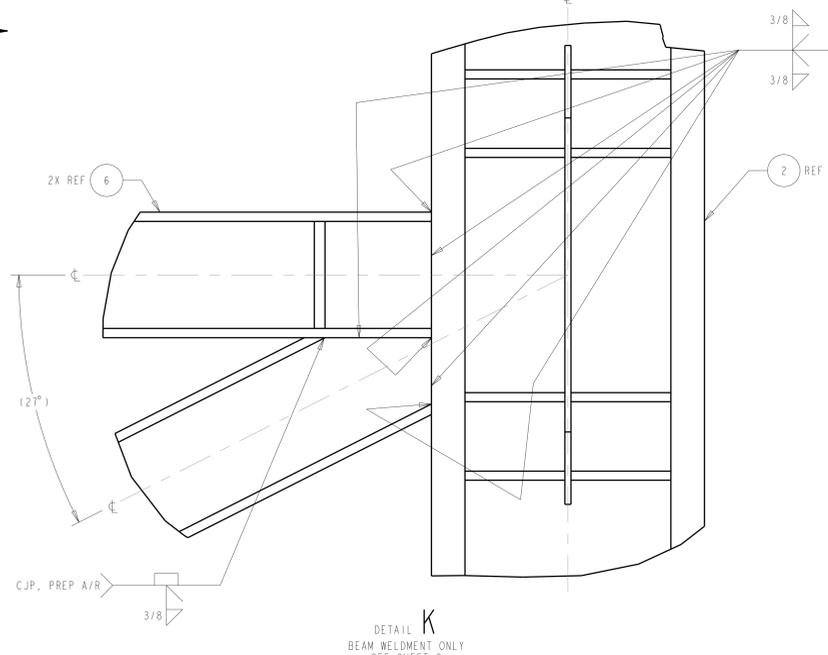
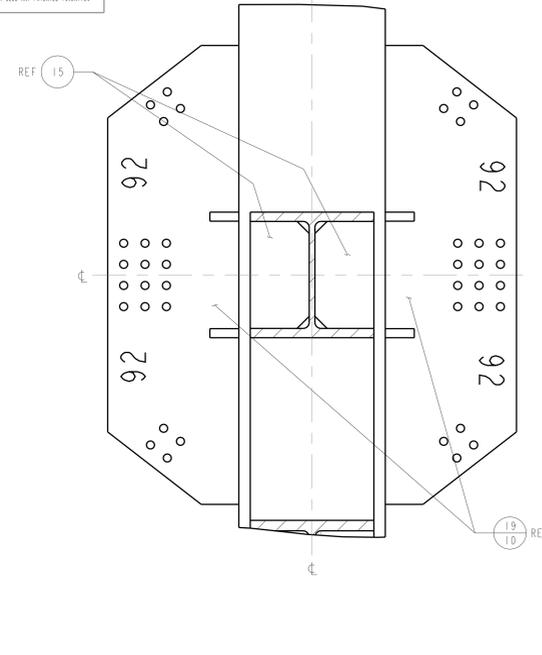


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MAIN TOWER WELDMENT SLS INTERTANK TEST		SPECIAL TEST EQUIPMENT DESIGN BRANCH - ET50 GEORGE C. MARSHALL SPACE FLIGHT CENTER NATIONAL AERONAUTICS AND SPACE ADMINISTRATION HUNTSVILLE, ALABAMA	
APPROVED FOR PUBLIC RELEASE; DISTRIBUTION IS UNLIMITED		90M14397	REVISION SEE SHIT 1
DATE	SCALE	REV	BY
07-17-14	0.125	4	10

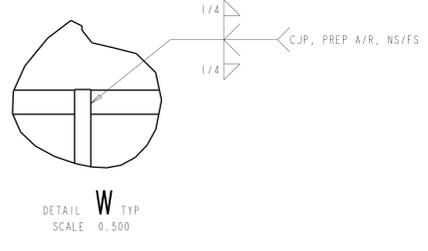
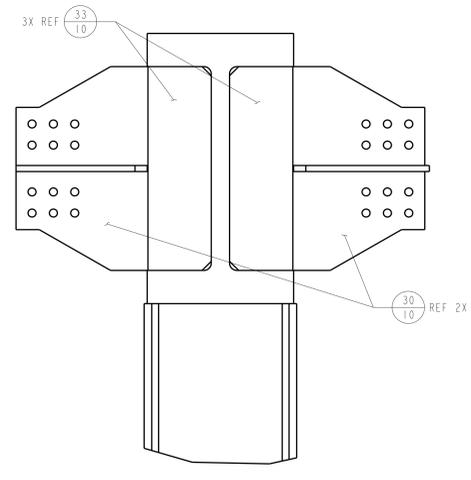
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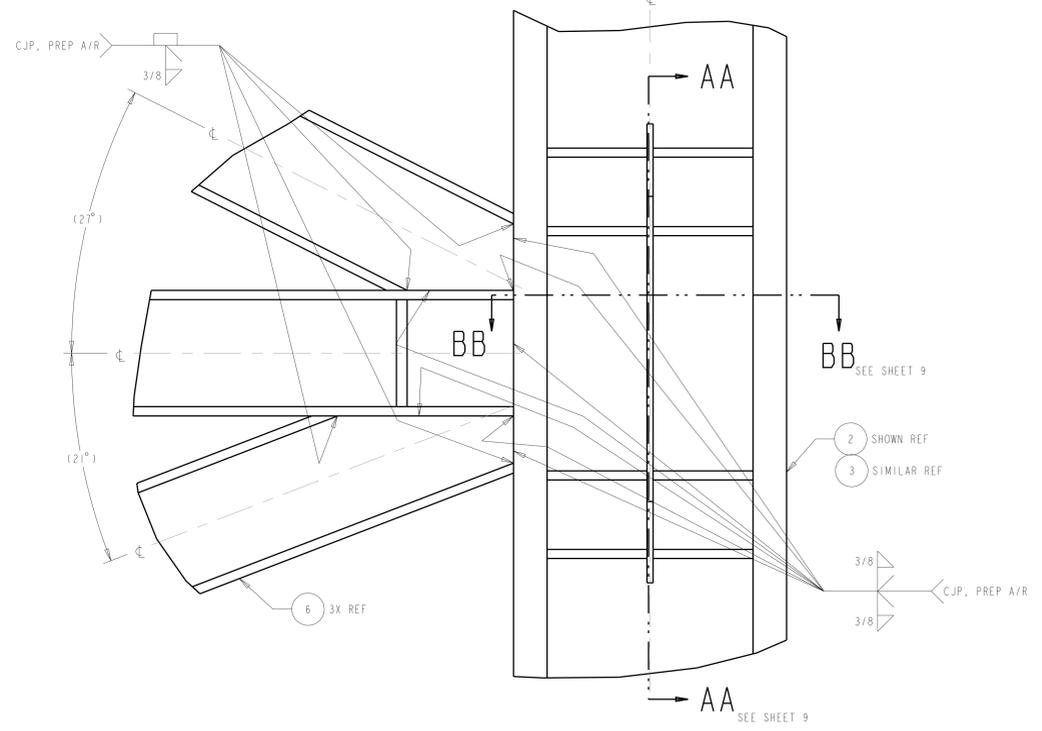


DETAIL K
BEAM WELDMENT ONLY
SEE SHEET 2
SOME COMPONENTS NOT SHOWN FOR CLARIFICATION
SCALE 0.188

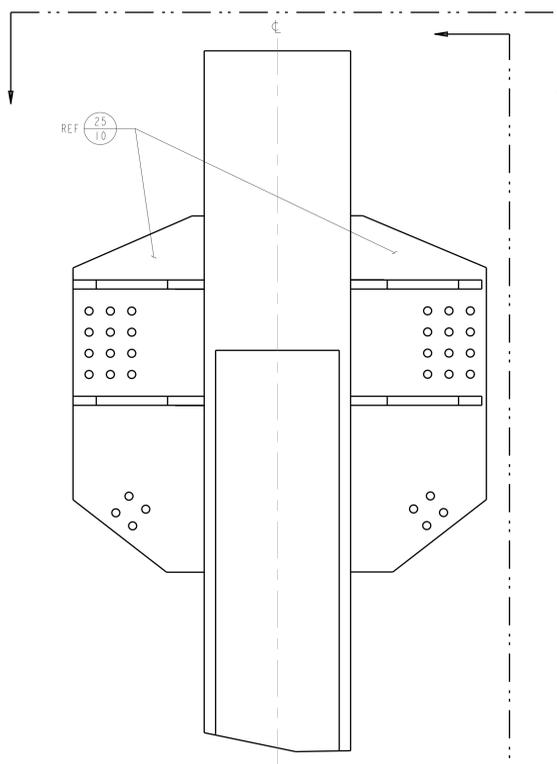
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SEE SHEET 2
SCALE 0.125



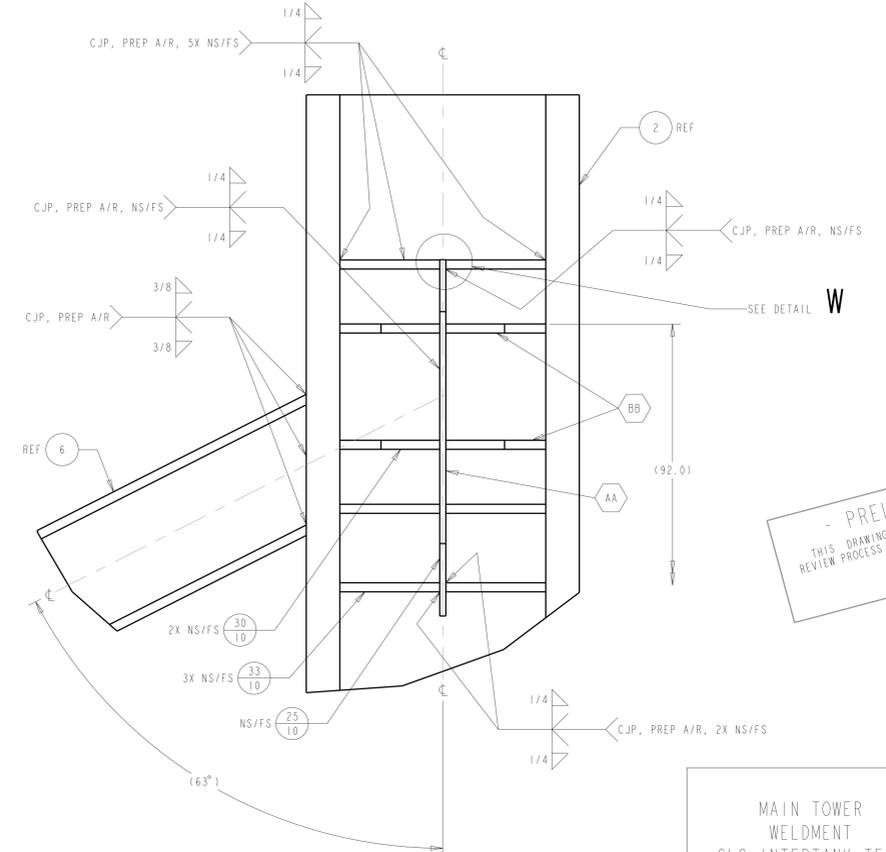
DETAIL W TYP
SCALE 0.500



DETAIL M
6X MARKED M1 BEAM WELDMENT ONLY
SEE SHEET 2
SOME COMPONENTS NOT SHOWN FOR CLARIFICATION
SCALE 0.188



DETAIL N
SEE SHEET 2
SCALE 0.188



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MAIN TOWER
WELDMENT
SLS INTERTANK TEST

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SEE
SHEET 1
E 5 10

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