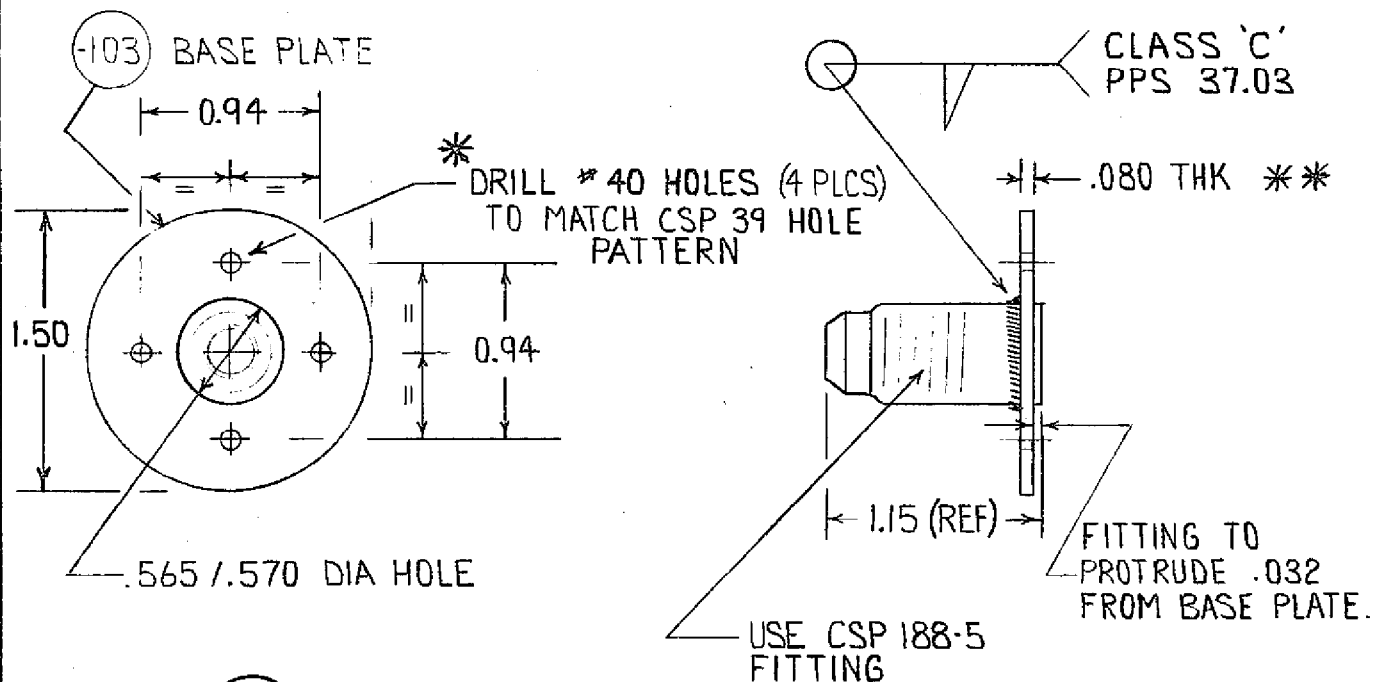




STANDARDS SHEET



-1 ASSEMBLY

NOTES

- 1 MATERIAL : BASE PLATE; 6061 SHEET OR PLATE QQ-A-250/11 T6 .080 FITTING; 6061 QQ-A-225/8 T6 (REF CSP 188-5).
- 2, HEAT TREAT NOT REQUIRED AFTER WELDING.
- 3, FINISH : AI
- 4, IF DRAIN CUP REQUIRED, USE CSP 39 (REF).

* SKIM SPOTFACE IN WELD BEAD AREA TO PROVIDE CLEARANCE FOR HEAD OF MS20470AD3 RIVET (.187 HEAD DIA). SPOTFACE FILLET RAD TO BE .031.

** MIN. FLANGE THICKNESS .080 AFTER SPOTFACE

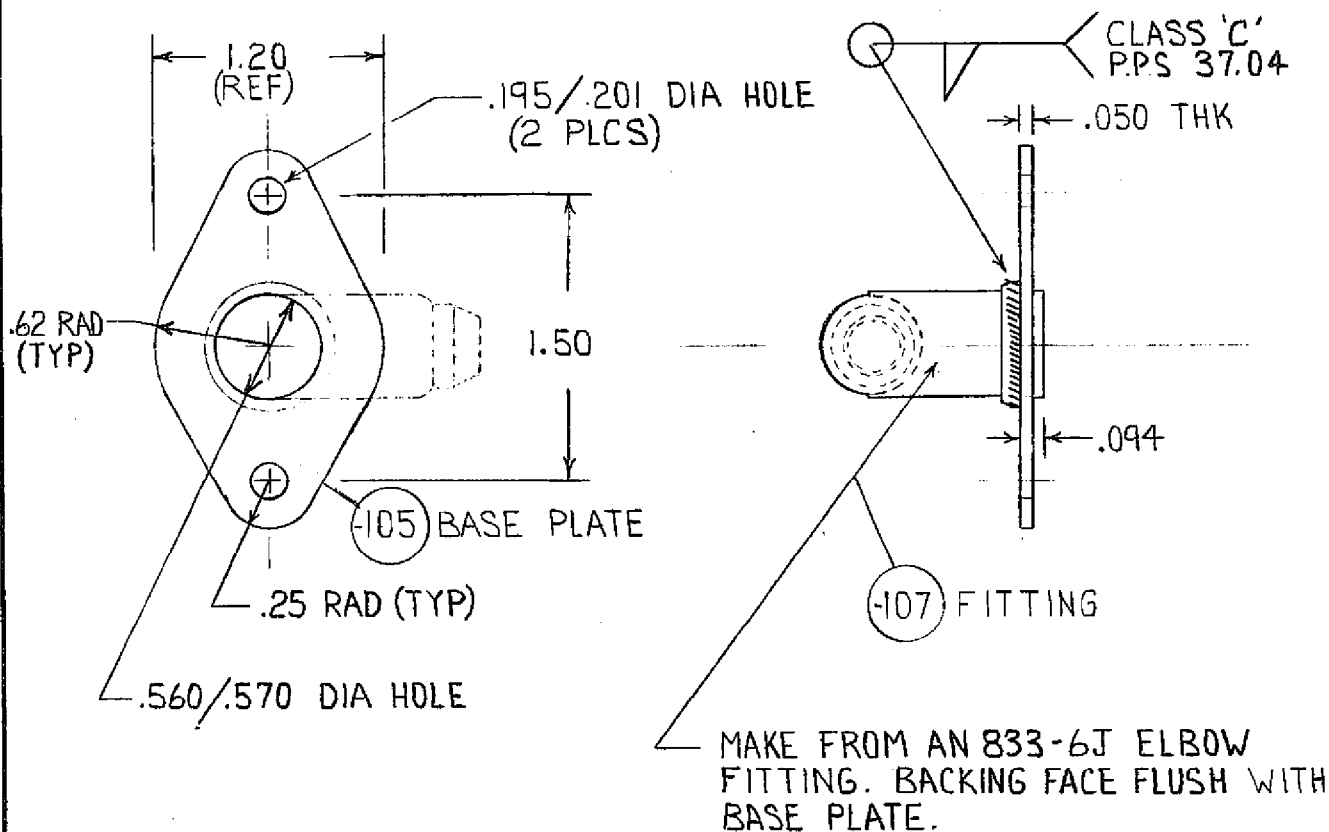
DRAWN	M. ROSSO	CLASSIFICATION	STANDARD
CHECKED	KROMKAMP	FITTING - DRAIN	CSP 394
STRESSED	W26		
APPROVED	CHRAUNY		

20.2.84

(A) SPOTFACE NOTE ADDED

18.V.88

STANDARDS SHEET



(2) ASSEMBLY

NOTES

- 1, MATERIAL : BASE PLATE ; 321 SHEET, MIL-S-6721 ANNEALED .050 FITTING; AN833-6J, (304 CRES REF)
- 2, PASSIVATE TO PPS 31.05 BEFORE WELDING.
- 3, AFTER WELDING ANNEAL TO P.P.S. 30.10

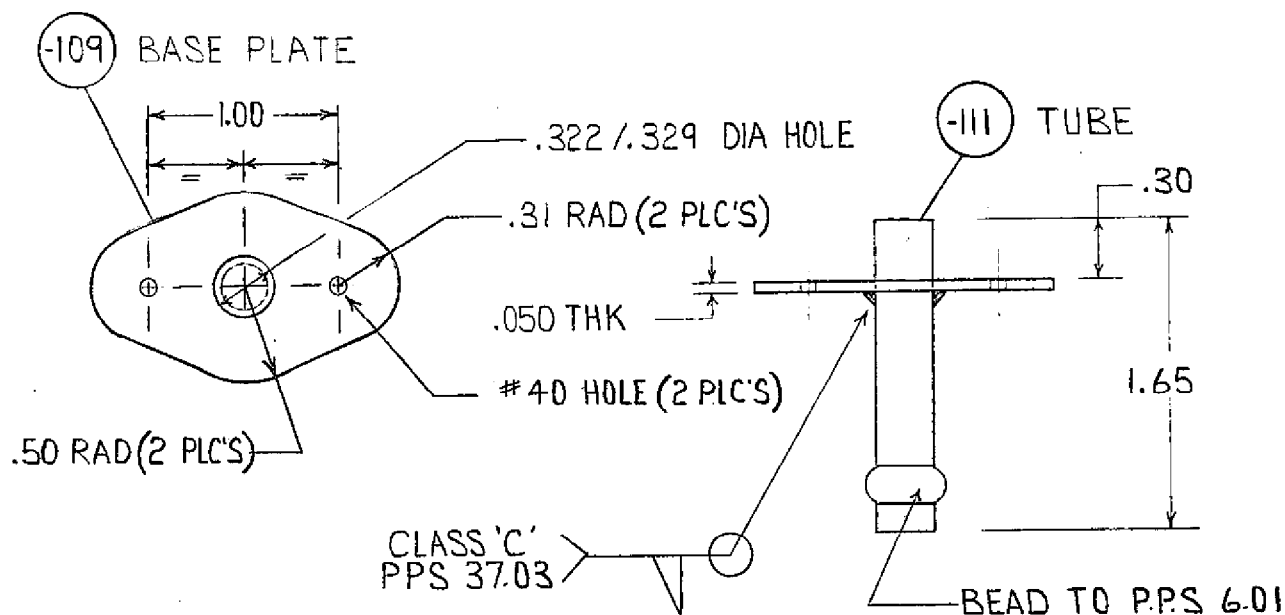
NOTE 3 ADDED 6 MAR 84 M.ROSSO

(A)

DRAWN	M.ROSSO	CLASSIFICATION	STANDARD
CHECKED	KROMKAMP	FITTING - DRAIN	CSP 394
STRESSED	MUSG		
APPROVED	SCHREIBER		

20.2.84

STANDARDS SHEET



-3 ASSEMBLY

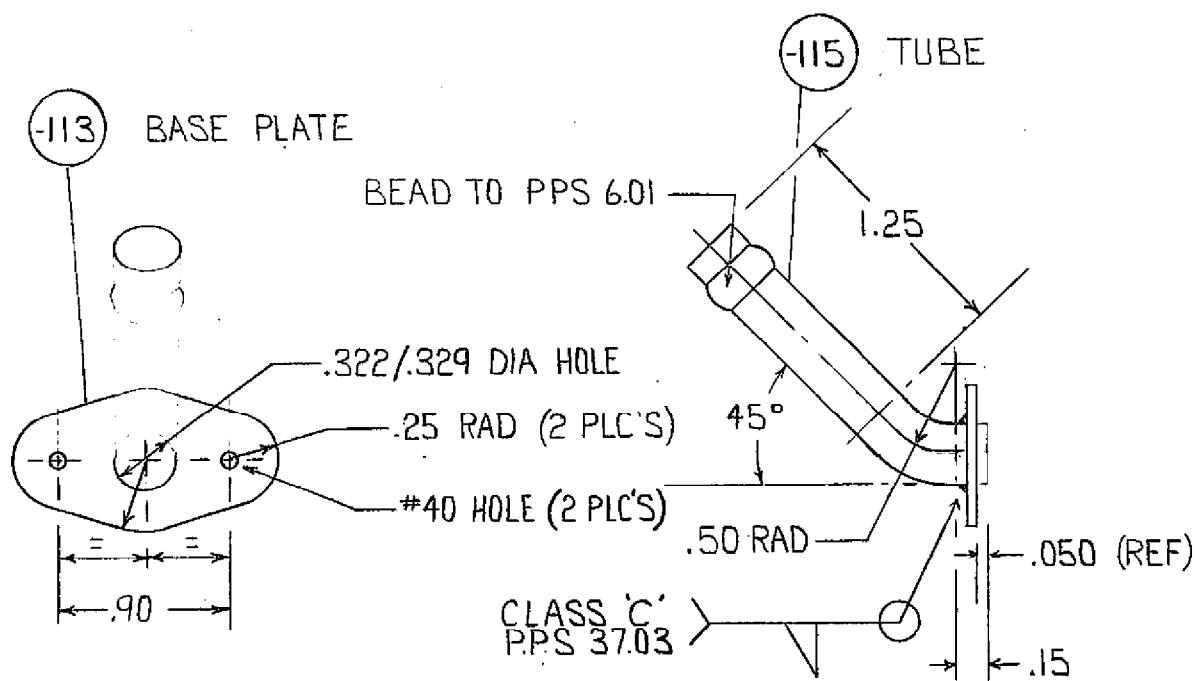
NOTES

- 1, MATERIAL; BASE PLATE: .050 AL ALLOY 5052 QQ-A-250/8 H32 OR H34. TUBE: .312 X .035 AL ALLOY 5052 WW-T-700/4 TEMPER 'O'.
- 2, HEAT TREAT NOT REQUIRED AFTER WELDING.
- 3, FINISH; CI ONLY

DRAWN	M.ROSSO	CLASSIFICATION	STANDARD
CHECKED	<i>K. K. K.</i>	FITTING - DRAIN	CSP 394
STRESSED	<i>M. Walt</i>		
APPROVER	<i>SCHATTNER</i>		

20 2.84

STANDARDS SHEET



4 ASSEMBLY

NOTES

- 1 MATERIAL : BASE PLATE; .050 AL ALLOY 5052 QQ-A-250/8 H32 OR H34
TUBE; .312 % X .035 AL ALLOY 5052 WW-T-700/4 TEMPER 'O'
- 2 HEAT TREAT NOT REQUIRED AFTER WELDING.
- 3 FINISH : CI ONLY.

DRAWN	M. ROSSO	CLASSIFICATION	STANDARD
CHECKED	<i>Kenn King</i>	FITTING - DRAIN	CSP 394
STRESSED	<i>m. Elliott</i>		
APPROVED	<i>SCHWARTZ</i>		

20.2.84