



**NOTES:**

- 1. MANIFOLD IS TO BE ASSEMBLED AS SHOWN AND ALUMINUM HOT DIP BRAZED. A .005" GAP IS PROVIDED AT ALL BRAZE JOINTS FOR BRAZE FILLER MATERIAL.
- 2. BRAZE VENDOR TO SUPPLY ANY FIXTURE REQUIRED.
- 3. Ø.125 HOLES IN THE SIDES (IN THE PLANE OF REFERENCE SURFACE -E- AND -F- OF THE (ITEM 7&8) U-TUBES ARE FOR THE PURPOSE OF DRAINING AND CLEARING THE INSIDE OF THE MANIFOLD AFTER BRAZING, AND MUST BE SEALED PERMANENTLY BEFORE PRESSURE TESTING
- 4. COMPLETED MANIFOLD HAS ONLY 4 OPENINGS: THE TWO 1/2 NPT'S IN THE HEADER PORTS AND THE TWO 1/8 NPT'S IN THE DRAIN PORTS
- 5. MANIFOLD MUST BE TESTED WITH WATER AT 30 PSI FOR 1 HR. AND BE LEAKFREE.
- 6. TACKWELDING FOR FIXTURING, DRAIN HOLE CLOSE-OFF, AND LEAK REPAIR IS PERMISSIBLE.
- 7. ALL DIMENSIONS APPLY IN THE RESTRAINED CONDITION.

2 15	S.H.M.S. #4-4OUNC-2A x .63 LG. ST STL
20 14	S.H.M.S. #4-4OUNC-2A x .38 LG. ST STL
10 13	S.H.M.S. #4-4OUNC-2A x .25 LG. ST STL
6 12	24A0971 THERMAL WELL BUTTON
6 11	24A3521 PIN
4 10	24A0961 COOLING TUBE ENDCAP, RIGHT
5 9	24A0951 COOLING TUBE ENDCAP, LEFT
10 8	24A3513 U-TUBE, #2 HALF
10 7	24A0823 U-TUBE, #1 HALF
1 6	24A0933 HEADER DRAIN, LEFT
1 5	24A0924 HEADER DRAIN, RIGHT
1 4	24A0594 HEADER PORT, RIGHT
1 3	24A0584 HEADER PORT, LEFT
1 2	24A3674 HEADER TUBES, LEFT AND RIGHT
1 1	24A0816 COOLING TUBES, OUTER SECTOR

REV	DATE	BY	CHK	DESCRIPTION
1	11/14/67	M	J	ISSUED FOR FAB
2	11/22/67	M	J	REVISION: 1. SHOWN AS 24A1015

UNLESS OTHERWISE SPECIFIED: SHOP DIMENSIONS TO VENDOR  
 S.H.M.S. #4-4OUNC-2A x .63 LG. ST STL  
 S.H.M.S. #4-4OUNC-2A x .38 LG. ST STL  
 S.H.M.S. #4-4OUNC-2A x .25 LG. ST STL

DESCRIPTION  
 LAWRENCE BERKELEY LABORATORY  
 UNIVERSITY OF CALIFORNIA, BERKELEY  
 BHEL STAR-TFC  
 OUTER SECTOR ASSEMBLY  
 COOLING MANIFOLD BRAZE ASSEMBLY  
 PART NO. 24A1015  
 REVISION DATE 11/22/67 BY M

REVISIONS  
 DATE 11/22/67  
 BY M  
 CHANGES

SCALE 1:1  
 5 PLACES AS SHOWN  
 4 PLACES-HYPER IMAGE

VIEW A-A  
 PORTS MUST LINE UP

BRZE IN PLACE IN COUNTERBORE

16 TUBES  
 Ø .010 | A | B | E | F

22.269 REF