

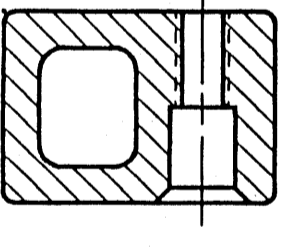
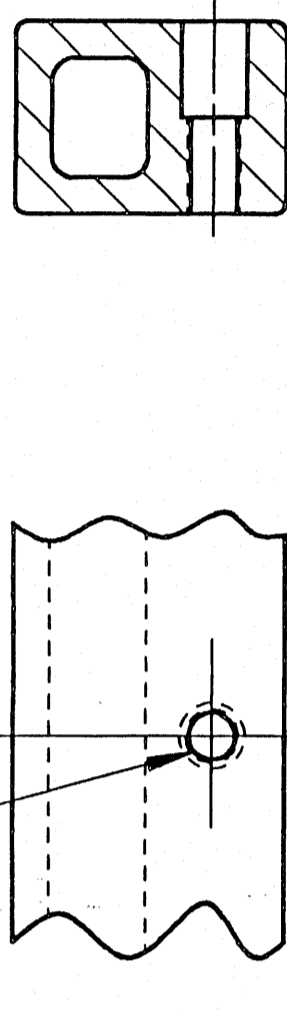
ITEM/POD	Part Number	Material/Parts Call-Out
	24A0801B	COOLING TUBE EXTRUSION

#31 (0.120/3.05) THRU (SPECIAL TAP DRILL SIZE)  
 #6 (.138/3.5)-32UNF-2C TAP THRU  
 C'BORE #18(0.170/4.31) x .25/6.35 DEEP, FAR SIDE.

$\phi .0107 \pm .0025$  A B C

#6 (.138)-32UNF-2C TAP THRU  
 C'BORE #18(0.170/4.32) x .25/6.35 DEEP  
 C'SINK 0.25/6.25 x 82°

$\phi .0107 \pm .0025$  A B C

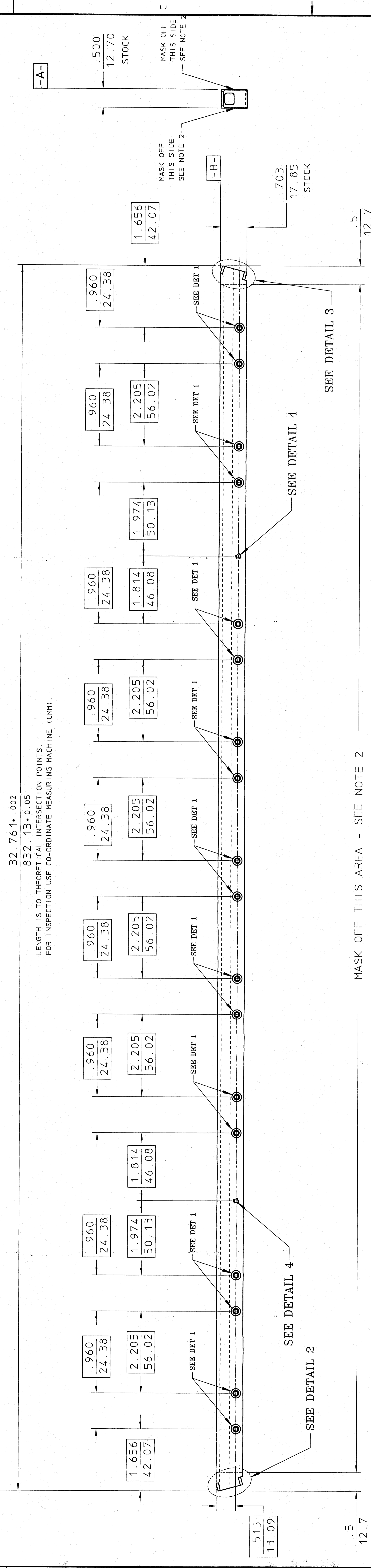


**DETAIL 1**  
 SCALE 2:1  
 18 PLACES

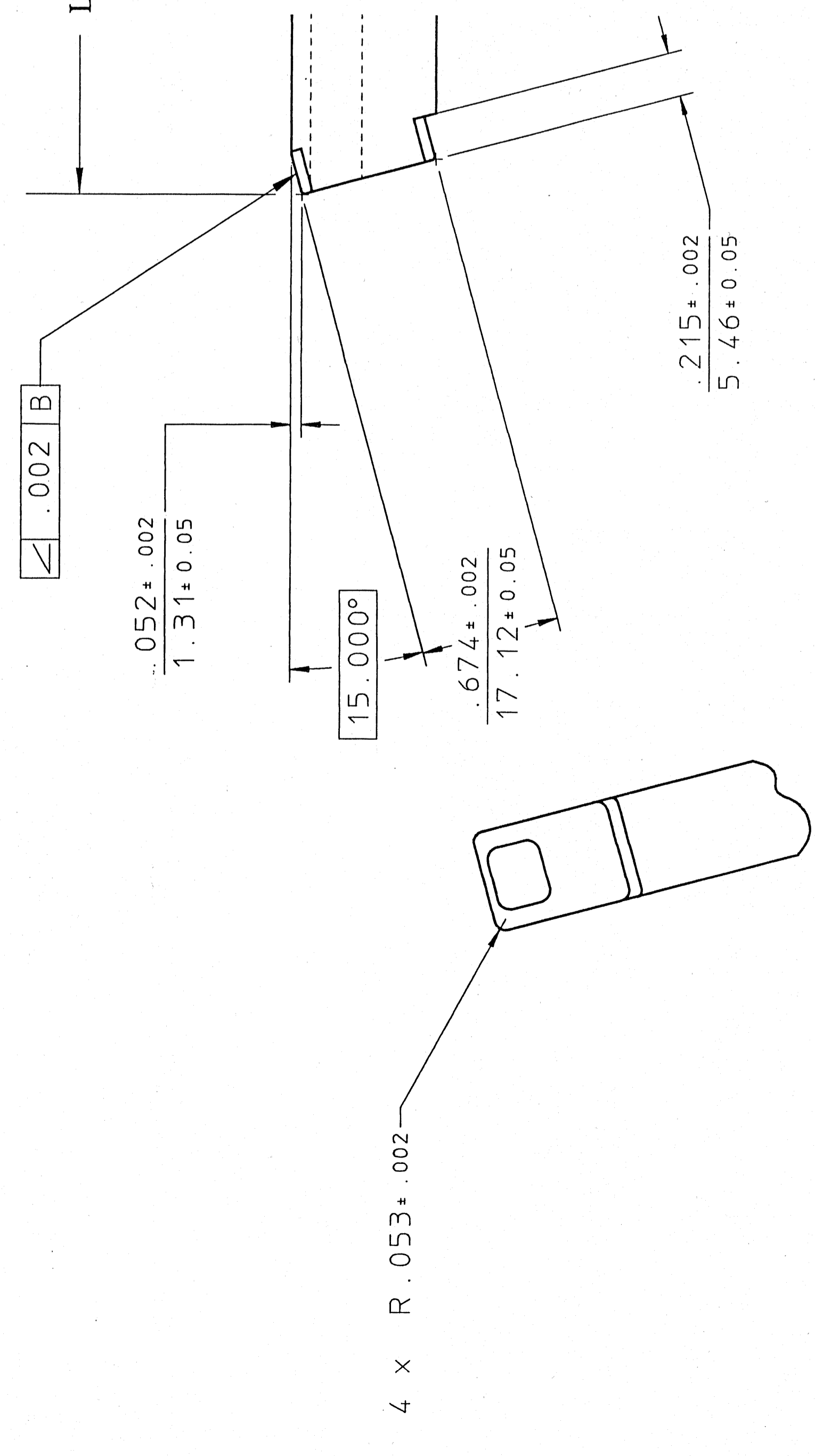
**DETAIL 4**  
 SCALE 2:1  
 2 PLACES

DATUM REFERENCE PLANE -C- IS THE INTERSECTION POINT OF THE 15° INCLINED SURFACE AND THE SURFACE AT 90° TO IT. USE CO-ORDINATE MEASURING MACHINE TO ESTABLISH AFTER MACHINING

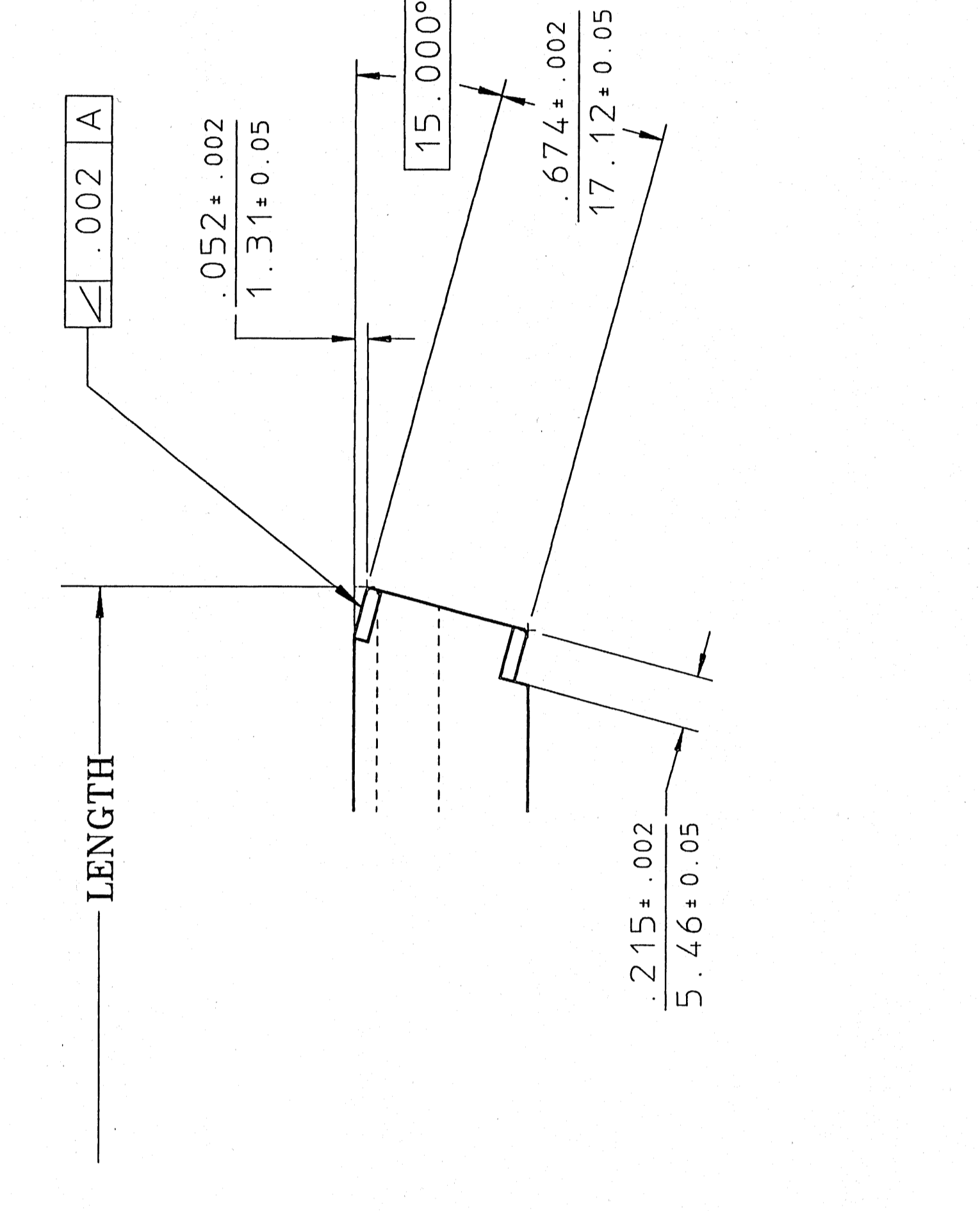
LENGTH IS TO THEORETICAL INTERSECTION POINTS. FOR INSPECTION USE CO-ORDINATE MEASURING MACHINE (CMM).



MASK OFF THIS AREA - SEE NOTE 2



**DETAIL 2**  
 SCALE 2:1



**DETAIL 3**  
 SCALE 2:1

- NOTES:
1. DECREASE PARTS AFTER MACHINING
  2. AFTER PARTS HAVE BEEN MANUFACTURED AND INSPECTED:
    - A. MASK OFF AREAS INDICATED.
    - B. CLEAN PARTS BY THE PHOSPHORIC ACID ANODIZING METHOD (ASTM D3933-80) EXCEPT FOR MASKED OFF AREAS
    - C. COAT WITHIN 4 hrs WITH DEXTER-HYSOL PRIMER HEA 9210 B EXCEPT FOR MASKED OFF AREAS

REV	DATE	BY	CHK	APP	DESCRIPTION
A	95-04-14	NEW LOGO, METRIC DIMS, CORR.			DETAIL 2 DIMS
B					CHANGES
C					
D					
E					
F					
G					
H					
I					
J					
K					
L					
M					
N					
O					
P					
Q					
R					
S					
T					
U					
V					
W					
X					
Y					
Z					

REV	DATE	BY	CHK	APP	DESCRIPTION
A	95-04-14	NEW LOGO, METRIC DIMS, CORR.			DETAIL 2 DIMS
B					CHANGES
C					
D					
E					
F					
G					
H					
I					
J					
K					
L					
M					
N					
O					
P					
Q					
R					
S					
T					
U					
V					
W					
X					
Y					
Z					