CLASSIFICATION OF CHARACTERISTICS (DOD-STD-2101)	
CRITICAL-	NONE
MAJOR-	5
MINOR-	ALL OTHER CHARACTERISTICS

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL

CAD MAINTAINED, CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY

NOTES:

1. INTERPRET DRAWING IN ACCORDANCE WITH ASME Y14.5M-1994 AND ASME Y14.100-2000 WITH APPENDICES B, C, D, AND E.

(M101) 2. MAKE FROM 10551422.

3. UNLESS OTHERWISE SPECIFIED, REMOVE BURRS, BREAK SHARP EDGES .005-.020. FILLETS .020 MAX.

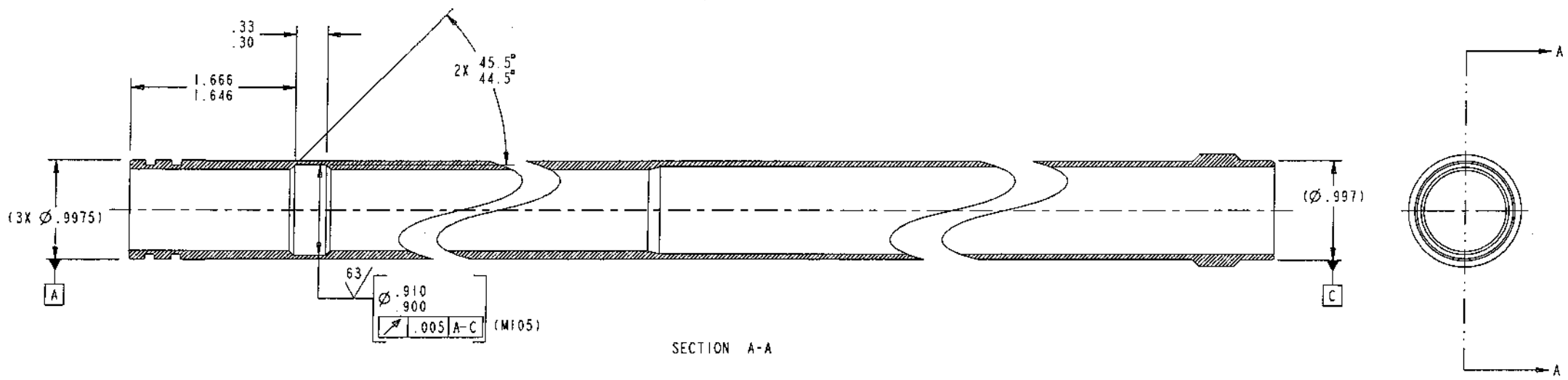
(M102) 4. AFTER SLOT IS MACHINED STRIP CADMIUM PLATING AND REPLATE IN ACCORDANCE WITH SAE AMS QQ-P-416A, TYPE II, CLASS 3. ALL SURFACES, REGARDLESS OF CONFIGURATION, SHALL HAVE A MINIMUM PLATING THICKNESS OF .0001 INCH. SURFACES ON THE OUTER DIAMETER THAT CAN BE TOUCHED BY A .75 INCH DIAMETER BALL, AND ON THE INNER DIAMETER FOR THE FIRST THREE INCHES FROM BOTH ENDS, SHALL MEET PLATING THINCKNESS REQUIREMENTS OF SAE AMS QQ-P-416A, TYPE II, CLASS 3.

5. DIMENSIONAL LIMITS APPLY AFTER PLATING.

(M103) 6. ITEM SHALL WITHSTAND AN INTERNAL HYDROSTATIC PRESSURE OF 11,000 PSI MINIMUM FOR 15 SECONDS MINIMUM WITHOUT LEAKAGE, PERMANENT DEFORMATION OR FRACTURE. TEST SHALL APPLY TO EACH COMPONENT IN LOT.

(M104) 7. AFTER HYDROSTATIC TESTING, MAGNETIC PARTICLE INSPECT IN ACCORDANCE WITH ASTM E 1444-01a USING WET FLOURESCENT PARTICLES IN A CONTINUOUS METHOD WITH DC CURRENT. ACCEPTABLE PARTS SHALL PASS THE REQUIRMENTS OF MIL-STD-1907, WITH NO DEFECTS EXCEEDING ONE-HALF THE MAXIMUM SIZE SPECIFED IN TABLE I, GRADE A.

8. UNLESS OTHERWISE SPECIFIED, SURFACE ROUGHNESS MUST BE 125 OR BETTER.



SECTION A-A

ALTERED ITEM DRAWING

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512-174-0110	DL11820361
NEXT ASSY	USED ON
APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
GENERAL TOLERANCES
XX DECIMALS ± —
XXX DECIMALS ± —
ANGLES ± —

MATERIAL: 2

DO NOT SCALE DRAWING

INDIAN HEAD DIVISION
NAVAL SURFACE WARFARE CENTER
INDIAN HEAD, MD 20640-5035

ENGINEER		
ENGINEER		4/29/03
CHECKED		4/29/03
DRAWN		4/29/03
APPROVED FOR USNC/IH		DATE 4/30/03

DEPARTMENT OF THE NAVY
NAVAL SURFACE WARFARE CENTER
INDIAN HEAD, MARYLAND 20640-5035

TUBE, BOOSTER-MODIFIED

SIZE	CAGE CODE	DRAWING NUMBER
D	14083	512-174-0091
SCALE: NONE		SHEET 1 OF 1