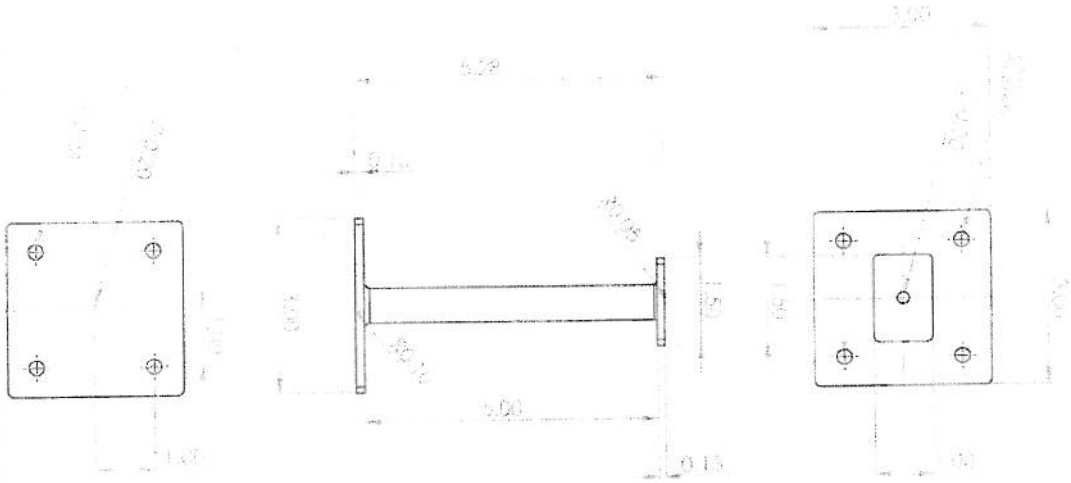
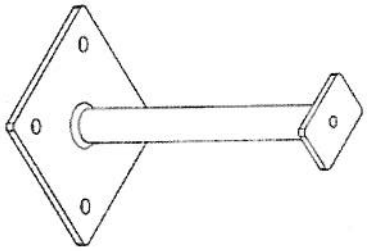


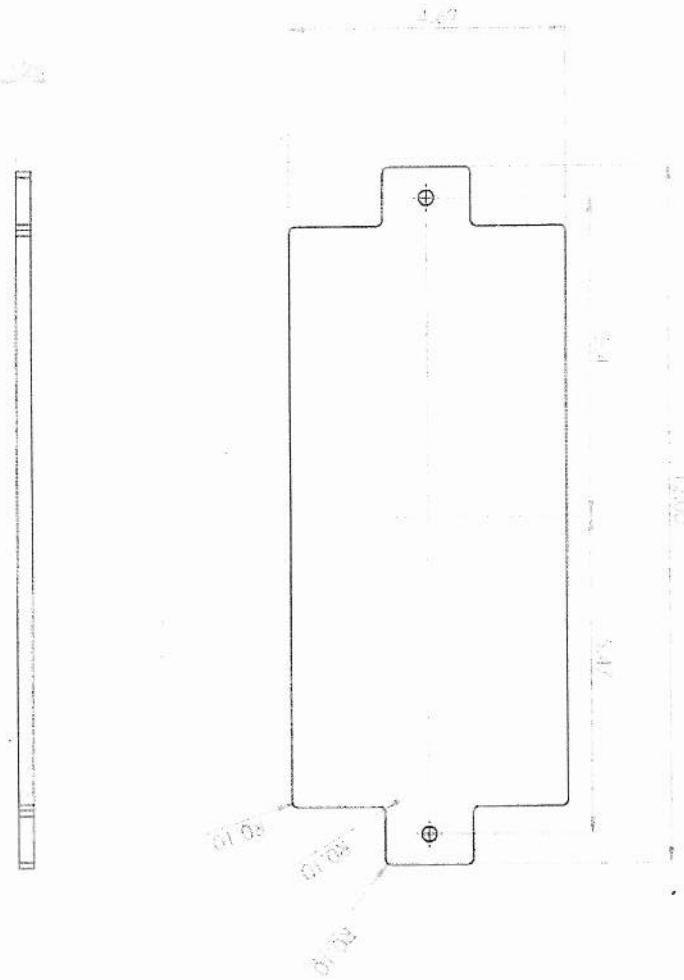


COAT USING YELLOW CHEMICAL CONVERSION COATING PER MIL-DTL-5541 TYPE1 CLASS 3

Aluminum 6061-T6

LensSupportBeam
Benny Venkatesan, NRL Code 5747
(202) 767 5941

A3

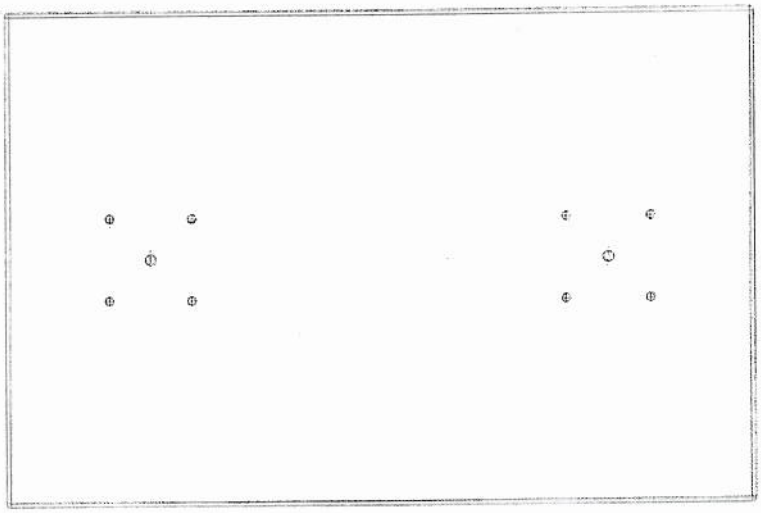


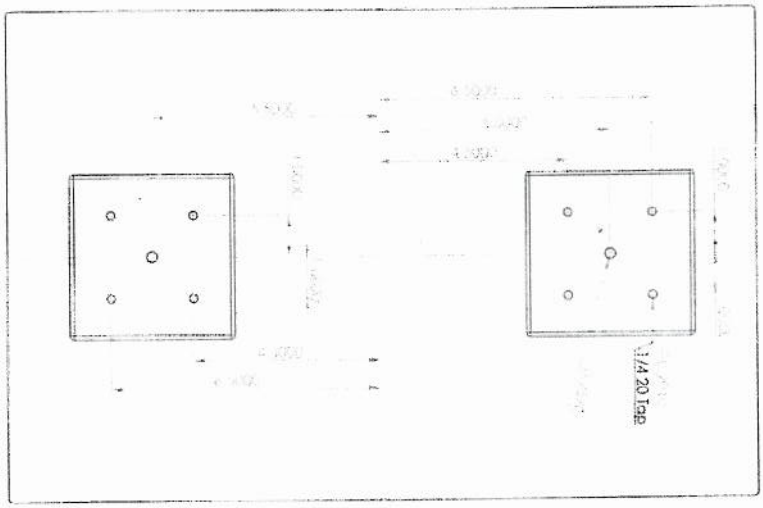
COAT USING YELLOW CHEMICAL CONVERSION
COATING PER MIL-DTL-5541 TYPE1 CLASS 3

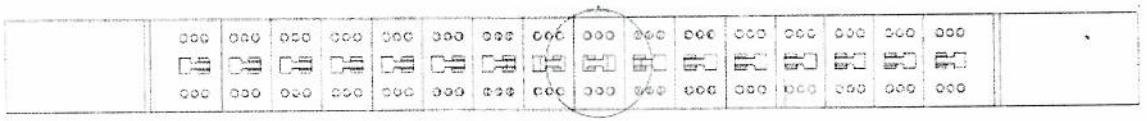
Aluminum 6061-T6

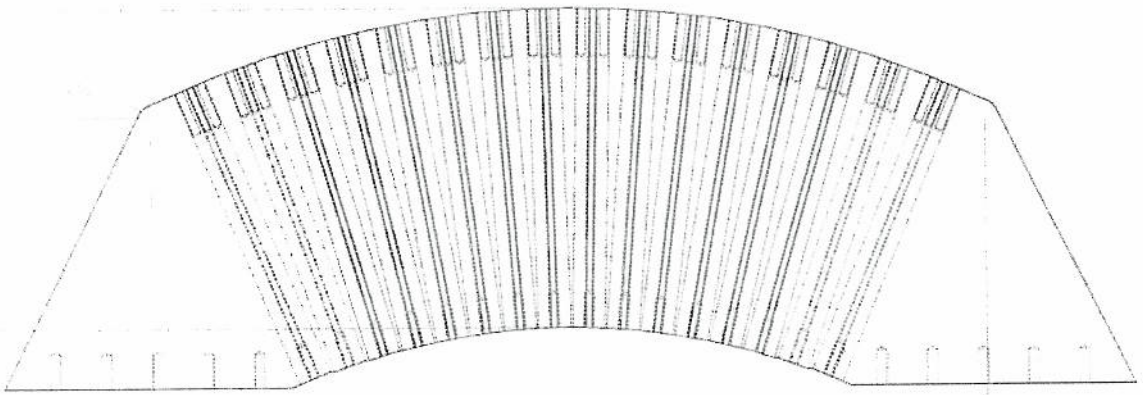
LensBaseAttachment
Benny Venkatesan, NRL Code 5747

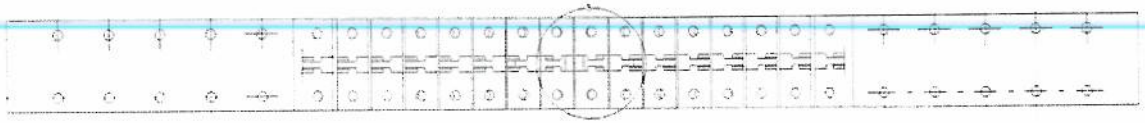
A3

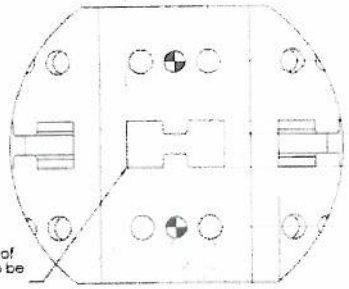



1/4 20 Tap

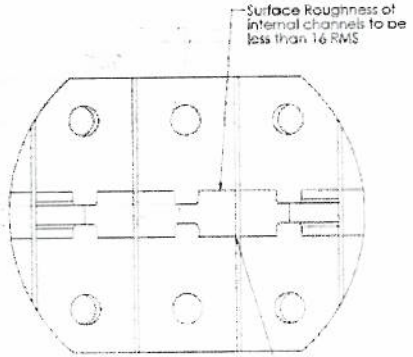








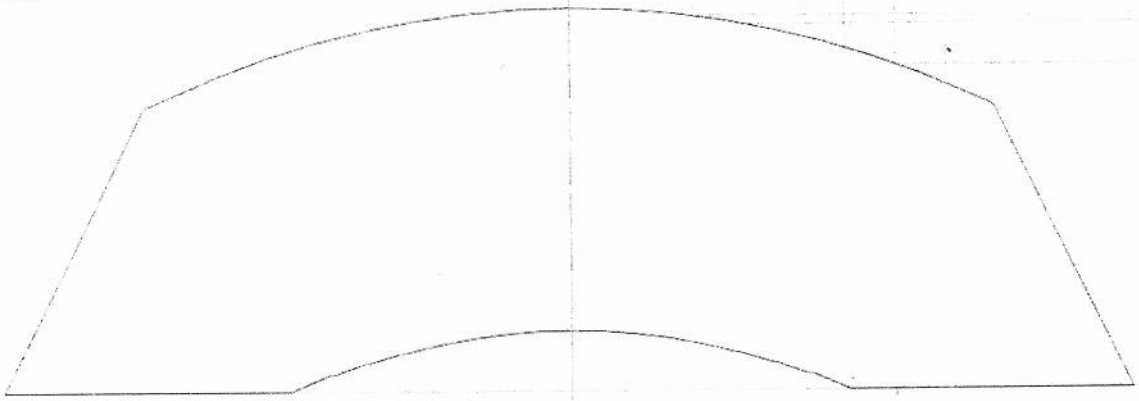
DETAIL A
(Normalized to Face)
SCALE 6 : 1



DETAIL B
(Normalized to Face)
SCALE 6 : 1

NOTES:

1. ALL MACHINED SURFACES FINISHED [illegible] UNLESS OTHERWISE SPECIFIED.
2. CLEANED TO BE FREE OF SCRATCHES, TOOLING, DEBRIS, MARKS, MANUFACTURING MARKINGS AND ALL OTHER SUCH BLEMISHES.
3. MATERIAL [illegible] PER AMS [illegible]
4. [illegible] CHEMICAL CONVERSION COATING PER MIL-DTL-5541, TYPE I, CLASS 3.
5. THE DRAWING IS A REVISED DRAWING. DIMENSIONS ARE FOR REFERENCE ONLY. TOLERANCES DEPICTED ARE FOR COMPLETE DIMENSIONAL DATA USE THE 3-D CAD MODEL PROVIDED IN THE DELIVERY FILE.
6. UNLESS NOTED OTHERWISE, ALL TOLERANCES ARE +.005 TO THE DATA PROVIDED IN THE 3-D CAD MODEL. TOLERANCES ARE APPLIED WITH RESPECT TO THE OPENING SHOWN BY THE DRAWING.



This page marks the locations of Detail A. The face on which the detail is produced should be normal to the line marking the angle of the center of the detail.

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THIS A CONVER DRAWING DERIVED FROM NAVAL CHARTS [illegible]

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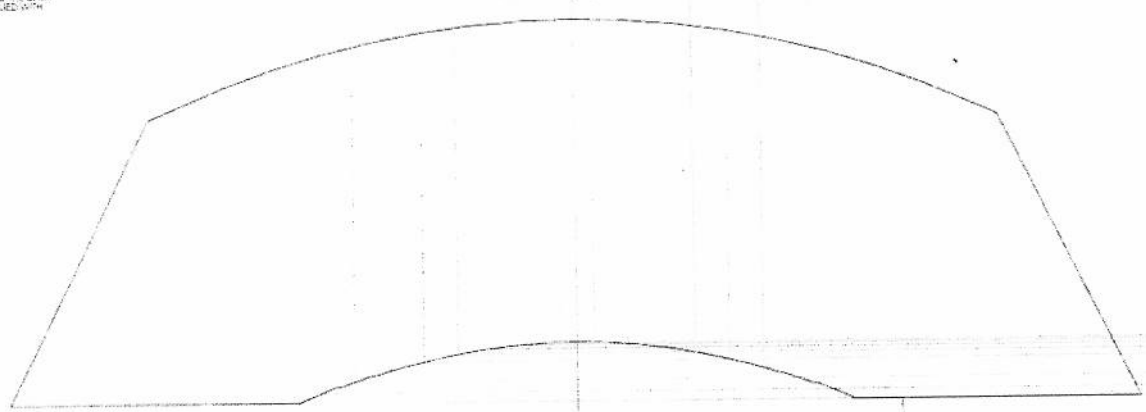
WASHINGTON, D.C. 20375-5320

D

NOTE:

1. ALL MACHINED SURFACES FINISHED [illegible] UNLESS OTHERWISE SPECIFIED.
2. SURFACES TO BE FREE OF CORRATORES, COLDES, SCRIBE MARKS, MANUFACTURING MARKS, FOR AND ALL OTHER TUCH BLEMISHES.
3. MATERIAL: [illegible] PER AMS-QQ-A-250/11
4. COATING: YELLOW CHEMICAL CONVERSION COATING PER MIL-DTL-5541 TYPE [illegible] CLASS 3.
5. THE DRAWING IS A KEYNOTE DRAWING. DIMENSIONS ARE FOR INSPECTION AND TOLERANCE DEFINITION ONLY. FOR COMPLETE DIMENSIONAL DATA, USE THE 3-D CAD MODEL PROVIDED IN THE DOCUMENT FILE.
6. UNLESS NOTED OTHERWISE, ALL TOLERANCES ARE ± 0.05 TO THE DATA PROVIDED IN THE 3-D CAD MODEL. TOLERANCES ARE APPLIED WITH RESPECT TO THE ORIGINS SHOWN IN THE DRAWING.



This page marks the locations of Detail B. The face on which the detail is produced should be normal to the line marking the angle of the center of the detail.

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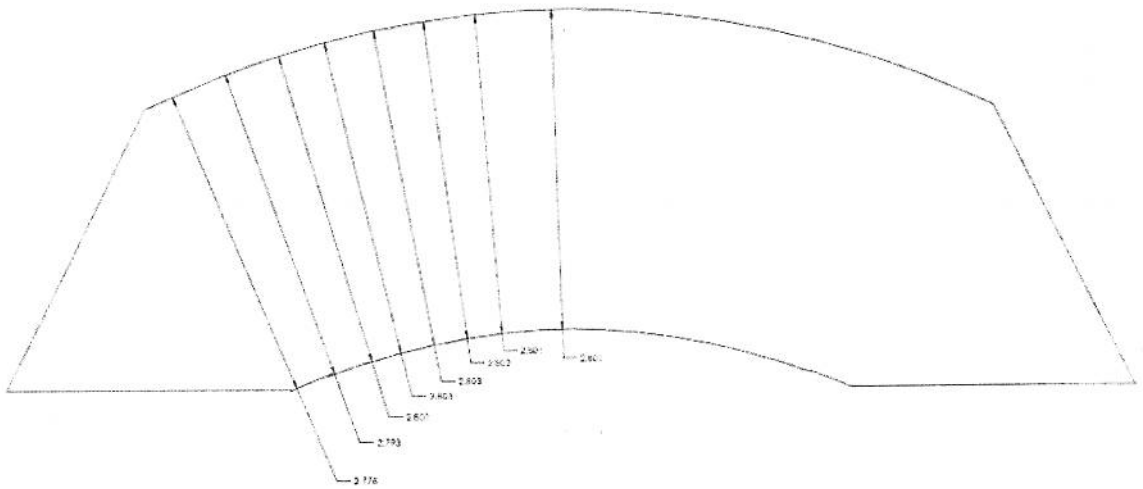
[illegible]
[illegible]

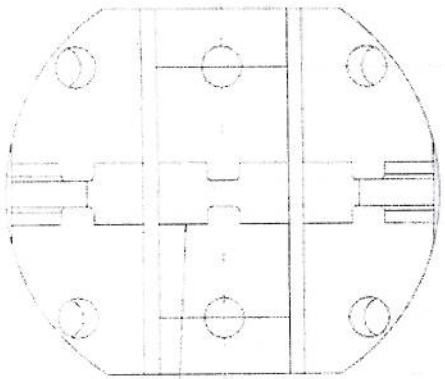
D

SCALE 1 | PROJECT | SHEET [illegible]



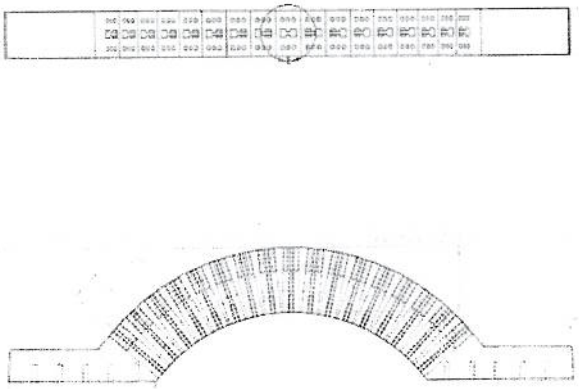
Channel length is critical; measure from the centerline of detail A to the centerline of detail B

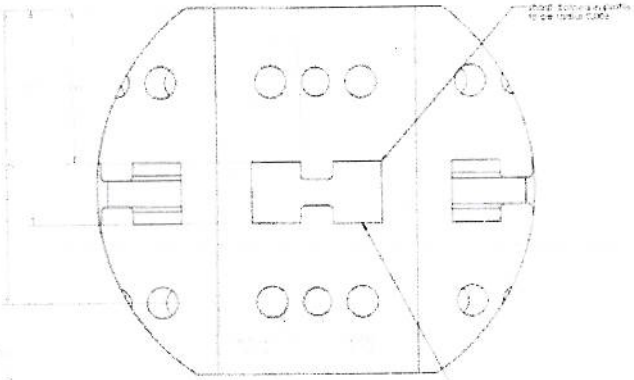
All tolerances on this page must be unidirectional



Surface Roughness of internal channels to be less than 16 RMS

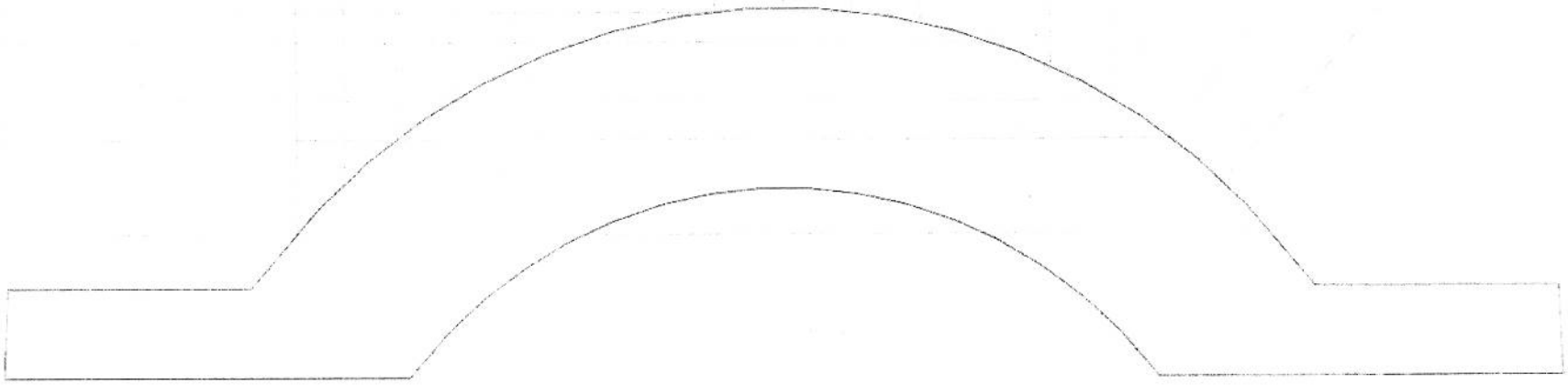
DETAIL A
SCALE 8 : 1





Surface Roughness of internal channels to be less than 16 RMS

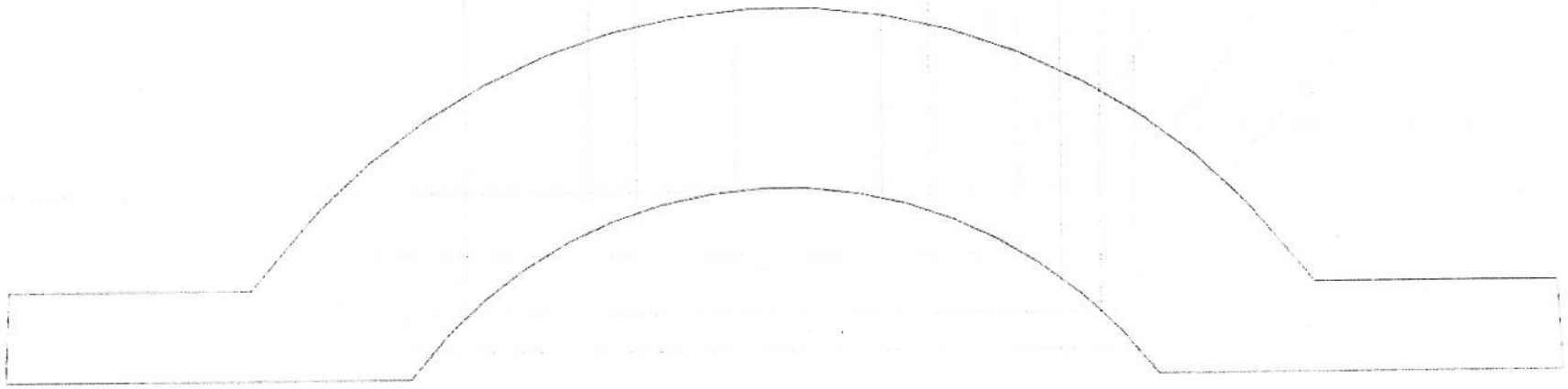
DETAIL B
SCALE 8 : 1



This page marks the locations of Detail B. The face on which the detail is produced should be normal to the line marking the angle of the center of the detail.

NOTES:

1. ALL MACHINED SURFACES FINISHED 125 RMS OTHERWISE SPECIFIED.
2. SURFACES TO BE FREE OF SCRATCHES, GOUGES, CORROSION MARKS, DENTS AND MARKS WITH ALL OTHER SUCH BLEMISHES.
3. MATERIAL: 304 STEEL PER AMS-QQ-A-250/11
4. CONDITIONS: NO CHEMICAL CONVERSION COATING PER MIL-DTL-5541 TYPE II CLASS 3
5. THIS DRAWING IS A 2D INTERPRETATION. DIMENSIONS ARE FOR REFERENCE PURPOSES ONLY. FOR A COMPLETE DIMENSIONAL DATA SET REFER TO THE 3D CAD MODEL PROVIDED IN THE DOCUMENT FILE.
6. UNLESS NOTED OTHERWISE, ALL TOLERANCES ARE +/-0.05 TO THE DATA PROVIDED IN THE 3D CAD MODEL. TOLERANCES ARE APPLIED WITH PRIORITY TO THE DESIGN SHOWN ON THE DRAWING.



This page marks the locations of Detail A. The face on which the detail is produced should be normal to the line marking the angle of the center of the detail.

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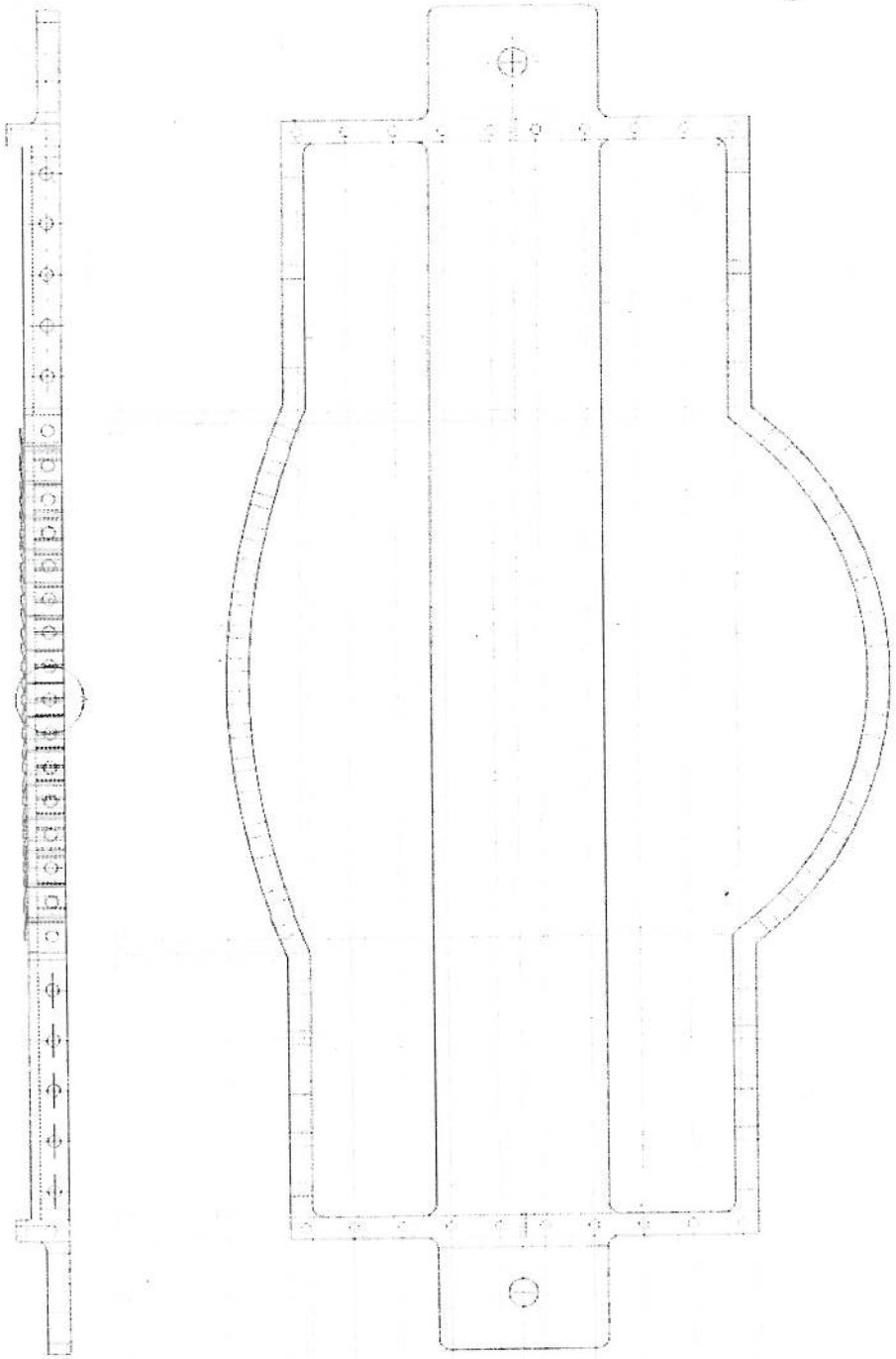
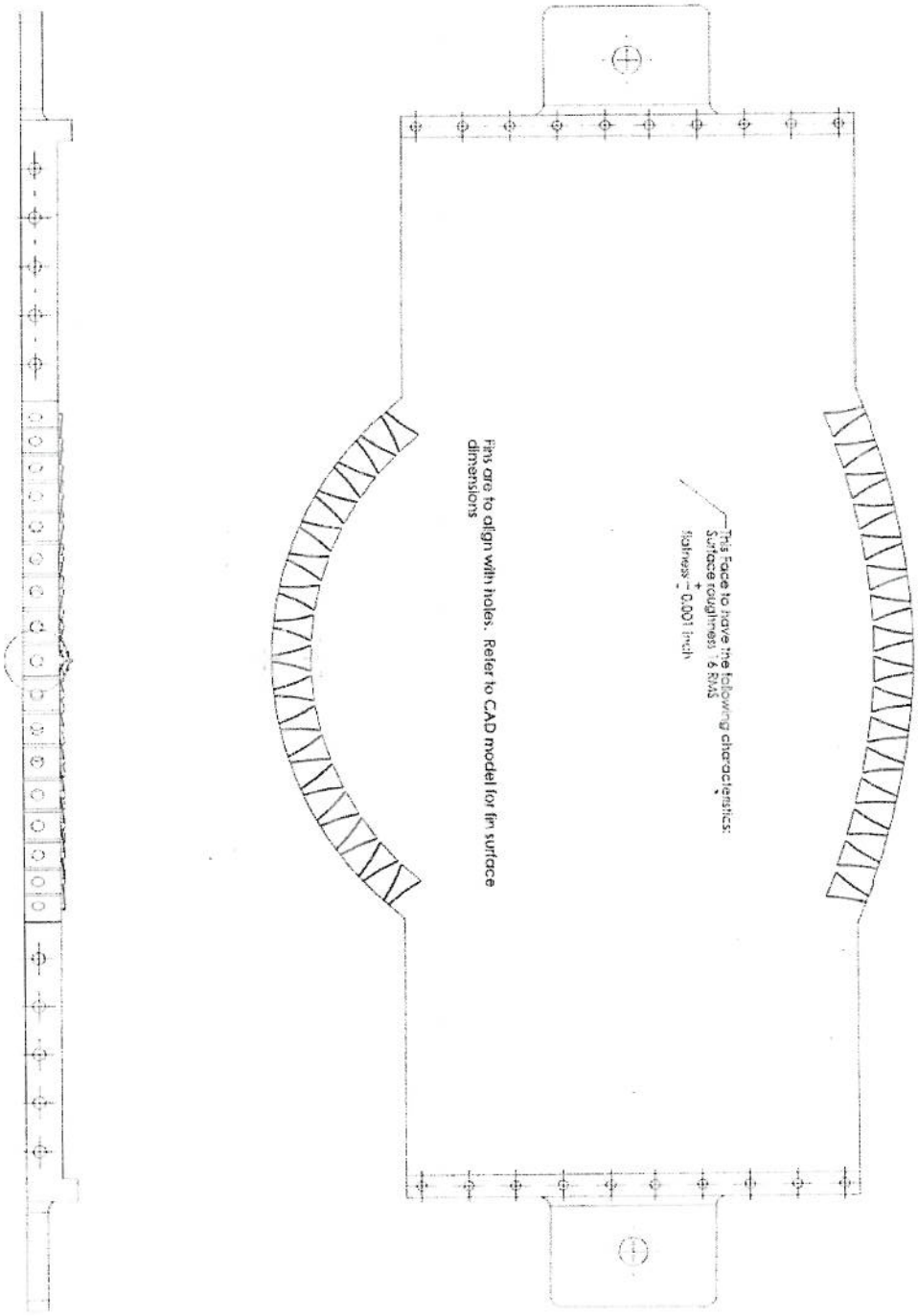
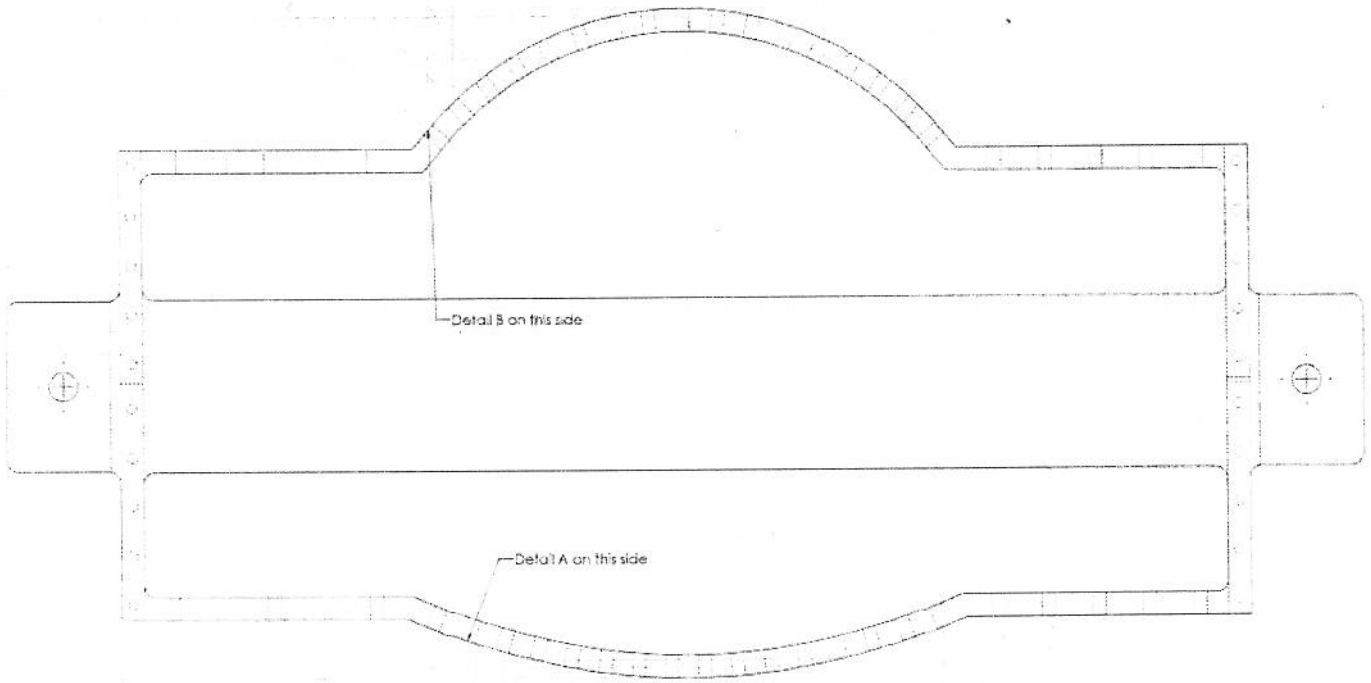
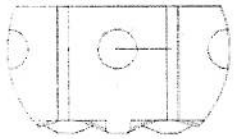
D



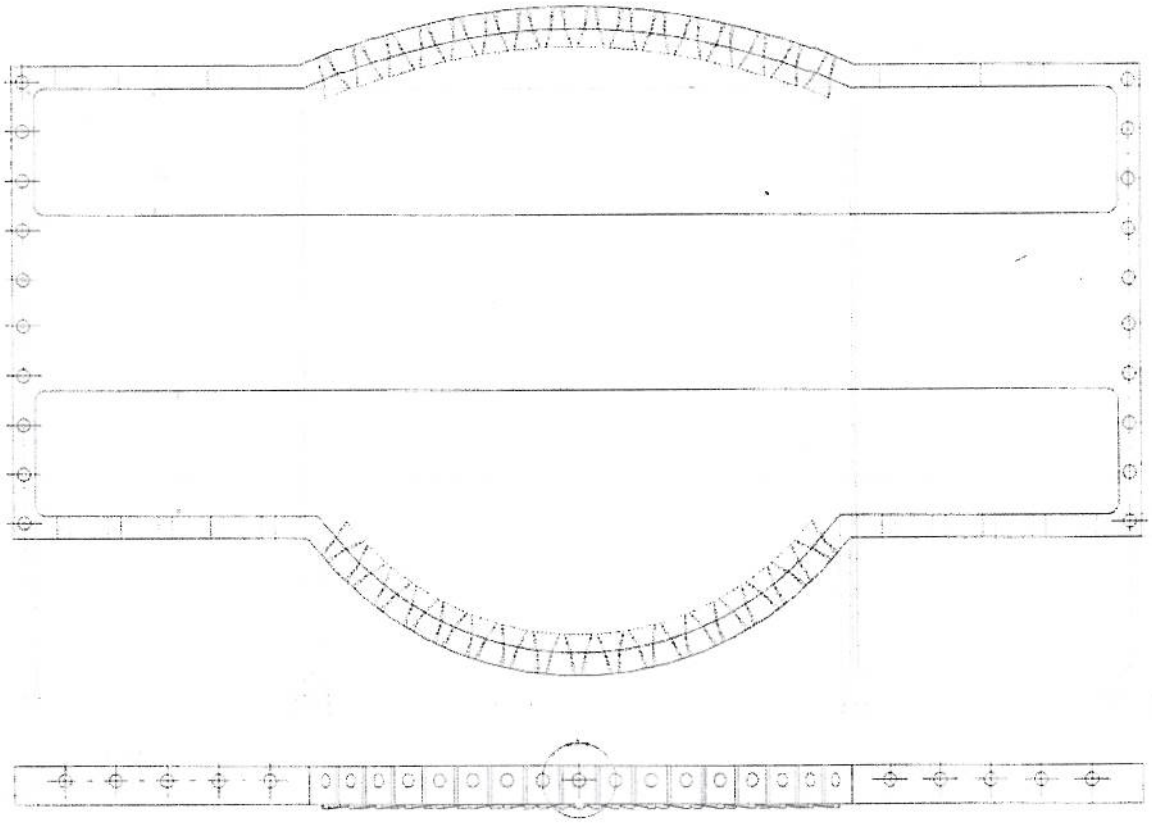

This face to have the following characteristics:
Surface roughness 8 RMS
flatness ± 0.001 inch
Fins are to align with holes. Refer to CAD model for fin surface dimensions

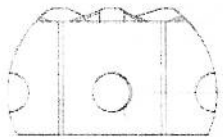
Reference Details A and B from the previous pages
Locate these details as indicated on this drawing.
Detail profiles should be normal to the angles shown



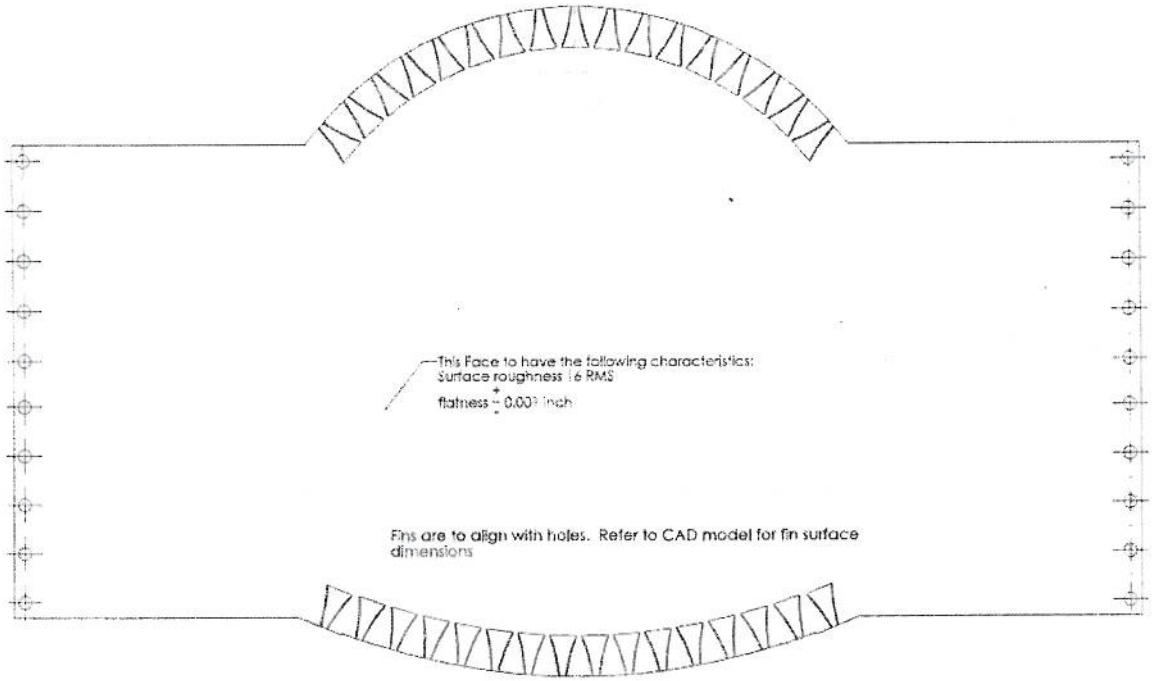


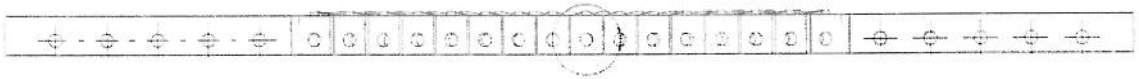
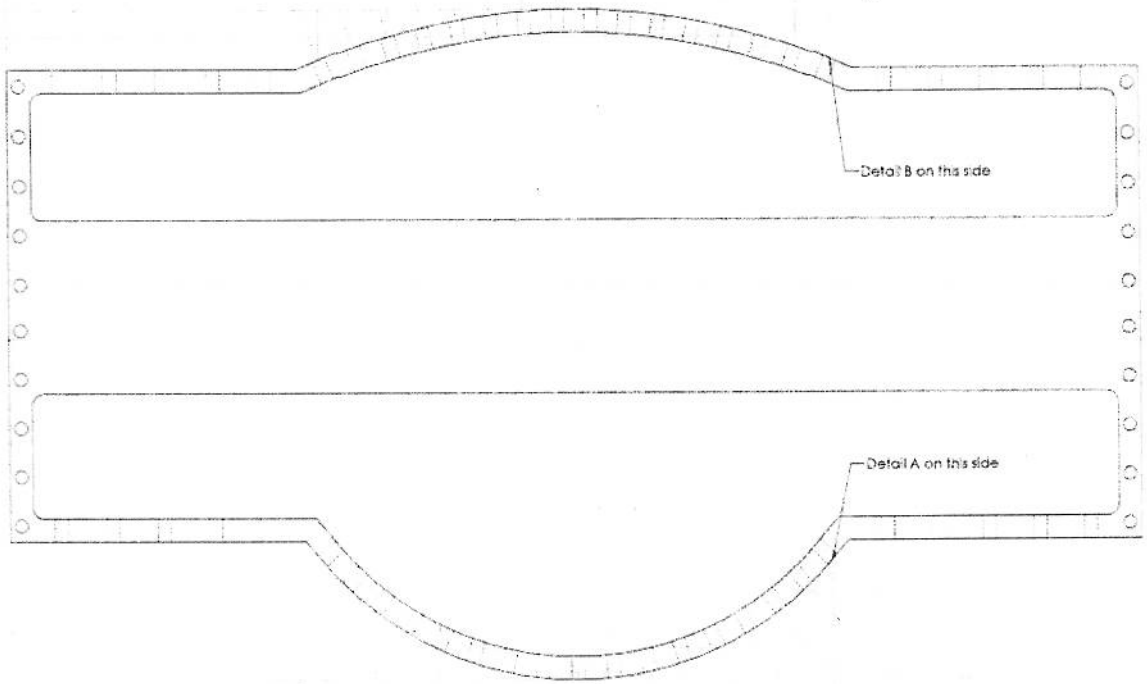
DETAIL A
SCALE 6 : 1





DETAIL B
SCALE 6 : 1





Reference Details A and B from the previous pages.
Locate these details as indicated on this drawing.
Detail profiles should be normal to the angles shown.