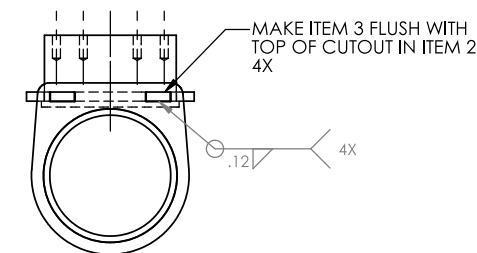
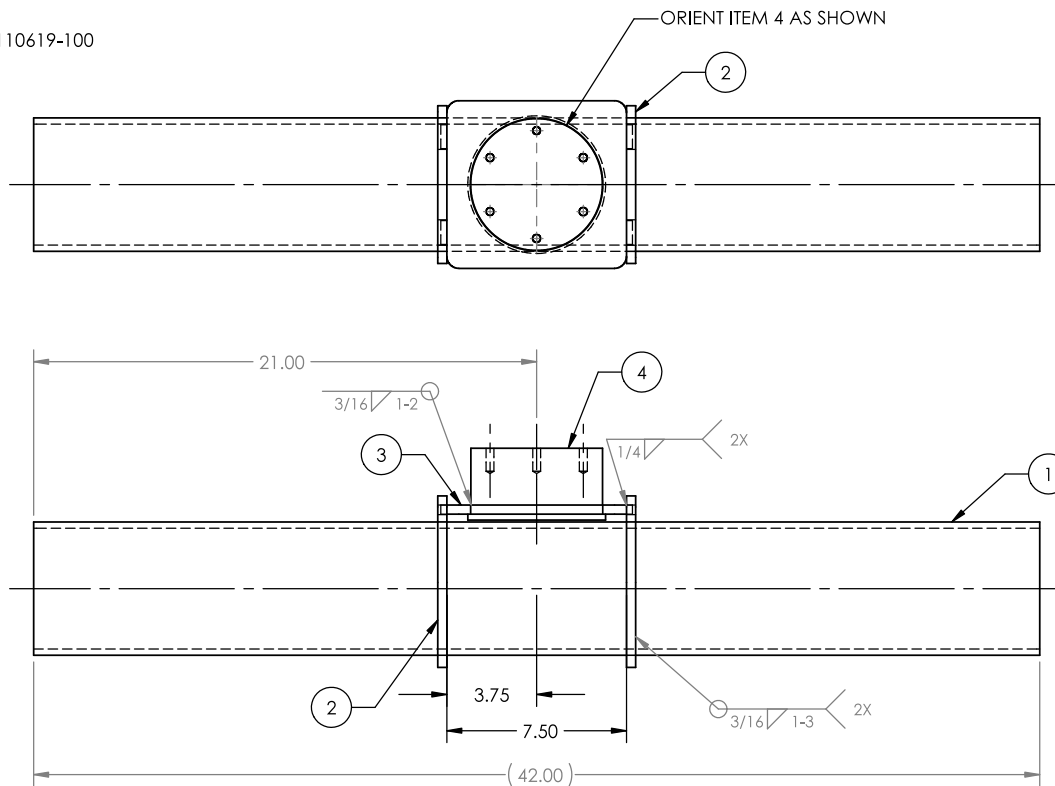


UNLESS OTHERWISE SPECIFIED:

- 1 ALL COMPONENTS SHALL BE THOROUGHLY CLEANED OF DIRT, OIL, AND GREASE PRIOR TO ANY WELDING.
- 2 ALL WELDS SHALL BE GAS TUNGSTEN ARC (ARGON GAS SHIELD) IAW AWS C5.5. FILLER MATERIAL SHALL BE COMMERCIAL PURE TITANIUM ROD, GRADE 1, ERTI-1 IAW ANSI AWS A5.16.
- 3 WELDS SHALL BE VISUALLY INSPECTED IAW ANSI/AWS D1.1 PARA. 9.25 BEFORE AND AFTER APPLICATION OF DYE PENETRANT. DYE PENETRANT SHALL BE OF A NON-CLORINATED HYDROCARBON TYPE AND SHALL BE APPLIED IAW ANSI/AWS B1.10-86, SECTION 3.2.
- 4 IDENTIFY WITH PART NUMBER 110619-100 AND REVISION LETTER.



4	110623-001 A	INTERFACE ROUND BAR	1
3	110622-001 A	CENTER ANCHOR TOP PLATE	1
2	110621-001 A	CENTER ANCHOR PLATE	2
1	110620-001 A	BACKBONE HORIZONTAL TUBE	1
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.

DO NOT SCALE DRAWING
INTERPRET DIMENSIONS AND
TOLERANCES IAW ASME Y14.5M-1994
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
ANGULAR ± .5°
FRACTION ± 1/8
DECIMAL .XX ± .03
XXX ± .015
HOLES < Ø .500 +.006
- .001
SURFACE 125/10
ROUGHNESS
BREAK EDGES .005-.020
CHAMFER OR RADIUS
FILLET RADII .015 MAX

110598	40008/MARS
NEXT ASSY	USED ON
APPLICATION	

CONTRACT NO.		APPROVALS		DATE		PARTS LIST			
MATERIAL		DRAWN	WHYTE	10 26 04		 SUBASSY BACKBONE LIFT TUBE			
		CHECKED							
FINISH		ISSUED	XXXXXX	XX XXX XX					
						SIZE	CAGE CODE	DWG NO.	REV.
						C	6T914	110619	A
		ORIG RELEASE		XX XXX XX		SCALE	1:4	REF: NONE	SHEET 1 OF 1

SOLIDWORKS FILE: 110619-100 A