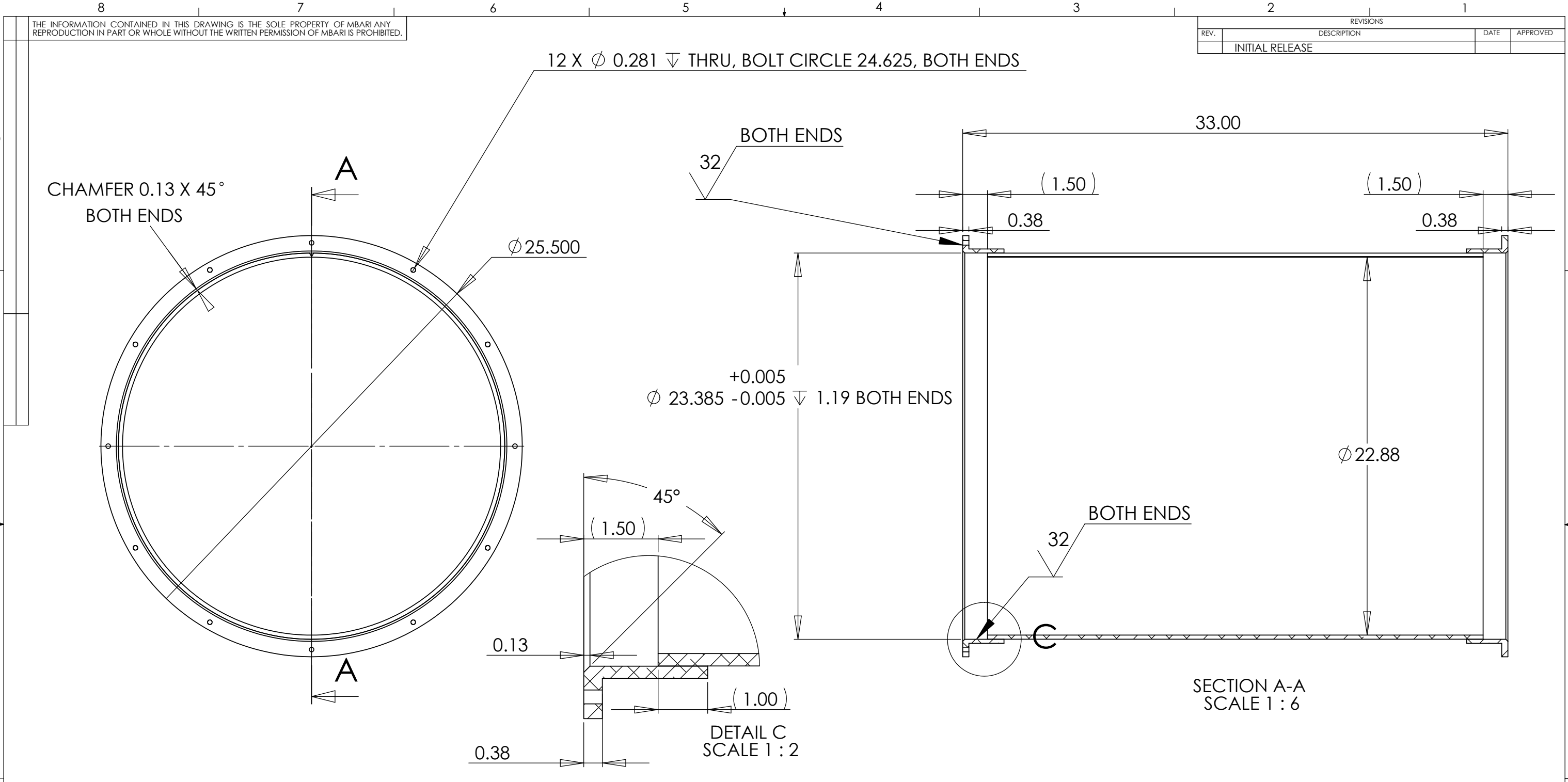




MANUFACTURING PROCEDURE:

1. FINISH MACHINING WILL ONLY TAKE PLACE AFTER WELDING AND HEAT TREAT SEE DRAWING #1003026
2. WELDENT WILL BE INSPECTED DIMENSIONALLY BEFORE ANODIZE, REPORT REQUIRED
3. HARD ANODIZE AS PER MIL-A-8625, TYPE 3, CLASS 1CLEAR WITH DIACHROMATE SEAL, SURFACE BUILD UP .0006 to .0008
4. WELDEMENT WILL BE INSPECTED DIMENSIONALLY AFTER ANODIZE, REPORT REQUIRED
5. **DIMENTION LIMITS WILL BE HELD AFTER ANODIZING SEE NOTE # 2.**

BILL OF MATERIALS									
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:				APPROVALS		DATE	
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	DRAWN	L. BIRD	02/08/06	
Shop Foreman		1. DIMENSIONS ARE IN INCHES 2. DIMENSION LIMITS HELD AFTER PLATING. 3. REMOVE BURRS AND SHARP EDGES .015 MAX. 4. MACHINED FILLET RADII .0150-.030. 5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005 6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.				ENGINEER			
Engineer						CHECKED			
NEXT ASSY Description	NEXT ASSY Number					PROJECT NO.	900312		
						PROJECT	ESP		
Application		DO NOT SCALE DRAWING				WEIGHT			
						SIZE B	DWG. NO.	1003024DWG	REV.
						SCALE 1:20	CAD FILE: MECH ENG ON TORNADO	SHEET 1 OF 1	

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SHALLOW WATER HOUSING