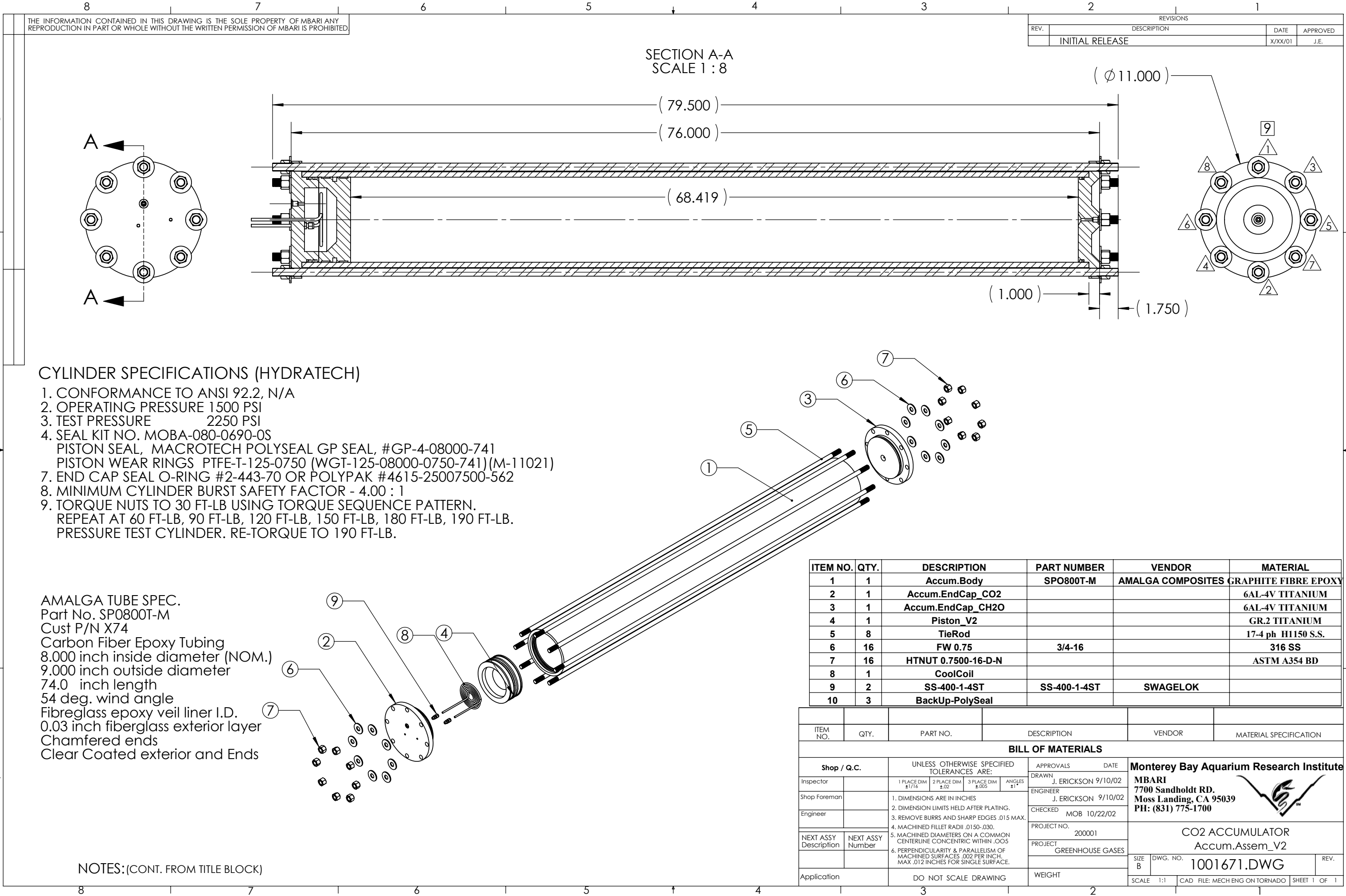
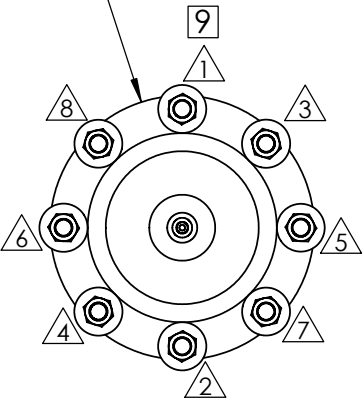
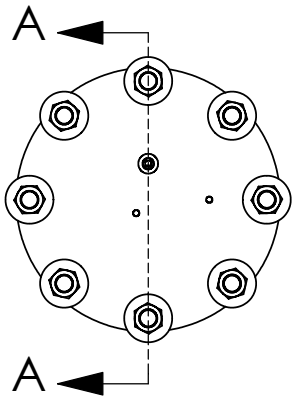




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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	INITIAL RELEASE	X/XX/01	J.E.

SECTION A-A
SCALE 1 : 8



CYLINDER SPECIFICATIONS (HYDRATECH)

1. CONFORMANCE TO ANSI 92.2, N/A
2. OPERATING PRESSURE 1500 PSI
3. TEST PRESSURE 2250 PSI
4. SEAL KIT NO. MOBA-080-0690-0S
PISTON SEAL, MACROTECH POLYSEAL GP SEAL, #GP-4-08000-741
PISTON WEAR RINGS PTFE-T-125-0750 (WGT-125-08000-0750-741)(M-11021)
7. END CAP SEAL O-RING #2-443-70 OR POLYPAK #4615-25007500-562
8. MINIMUM CYLINDER BURST SAFETY FACTOR - 4.00 : 1
9. TORQUE NUTS TO 30 FT-LB USING TORQUE SEQUENCE PATTERN.
REPEAT AT 60 FT-LB, 90 FT-LB, 120 FT-LB, 150 FT-LB, 180 FT-LB, 190 FT-LB.
PRESSURE TEST CYLINDER. RE-TORQUE TO 190 FT-LB.

AMALGA TUBE SPEC.
Part No. SP0800T-M
Cust P/N X74
Carbon Fiber Epoxy Tubing
8.000 inch inside diameter (NOM.)
9.000 inch outside diameter
74.0 inch length
54 deg. wind angle
Fibreglass epoxy veil liner I.D.
0.03 inch fiberglass exterior layer
Chamfered ends
Clear Coated exterior and Ends

ITEM NO.	QTY.	DESCRIPTION	PART NUMBER	VENDOR	MATERIAL
1	1	Accum.Body	SPO800T-M	AMALGA COMPOSITES	GRAPHITE FIBRE EPOXY
2	1	Accum.EndCap_CO2			6AL-4V TITANIUM
3	1	Accum.EndCap_CH2O			6AL-4V TITANIUM
4	1	Piston_V2			GR.2 TITANIUM
5	8	TieRod			17-4 ph H1150 S.S.
6	16	FW 0.75	3/4-16		316 SS
7	16	HTNUT 0.7500-16-D-N			ASTM A354 BD
8	1	CoolCoil			
9	2	SS-400-1-4ST	SS-400-1-4ST	SWAGELOK	
10	3	BackUp-PolySeal			

ITEM NO.	QTY.	PART NO.	DESCRIPTION	VENDOR	MATERIAL SPECIFICATION
BILL OF MATERIALS					
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		APPROVALS	DATE
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	DRAWN	J. ERICKSON 9/10/02
Shop Foreman		3 PLACE DIM ±.005	ANGLES ±1°	ENGINEER	J. ERICKSON 9/10/02
Engineer		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.			
NEXT ASSY Description	NEXT ASSY Number	PROJECT NO. 200001			
		PROJECT GREENHOUSE GASES			
Application		DO NOT SCALE DRAWING		WEIGHT	
				SIZE B	DWG. NO. 1001671.DWG
				SCALE 1:1	REV.
				CAD FILE: MECH ENG ON TORNADO	SHEET 1 OF 1

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CO2 ACCUMULATOR
Accum.Assem_V2

NOTES:(CONT. FROM TITLE BLOCK)