

D

C

B

A

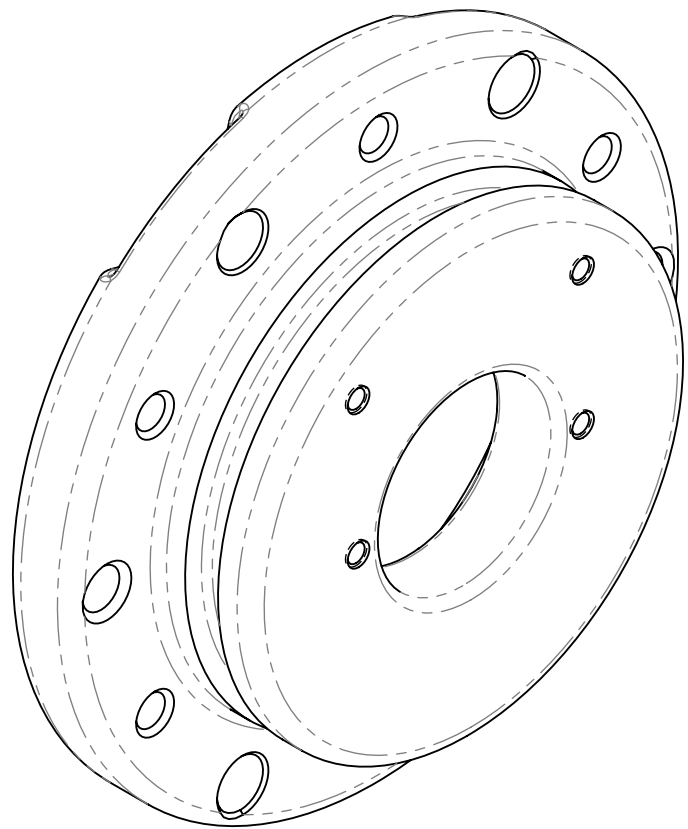
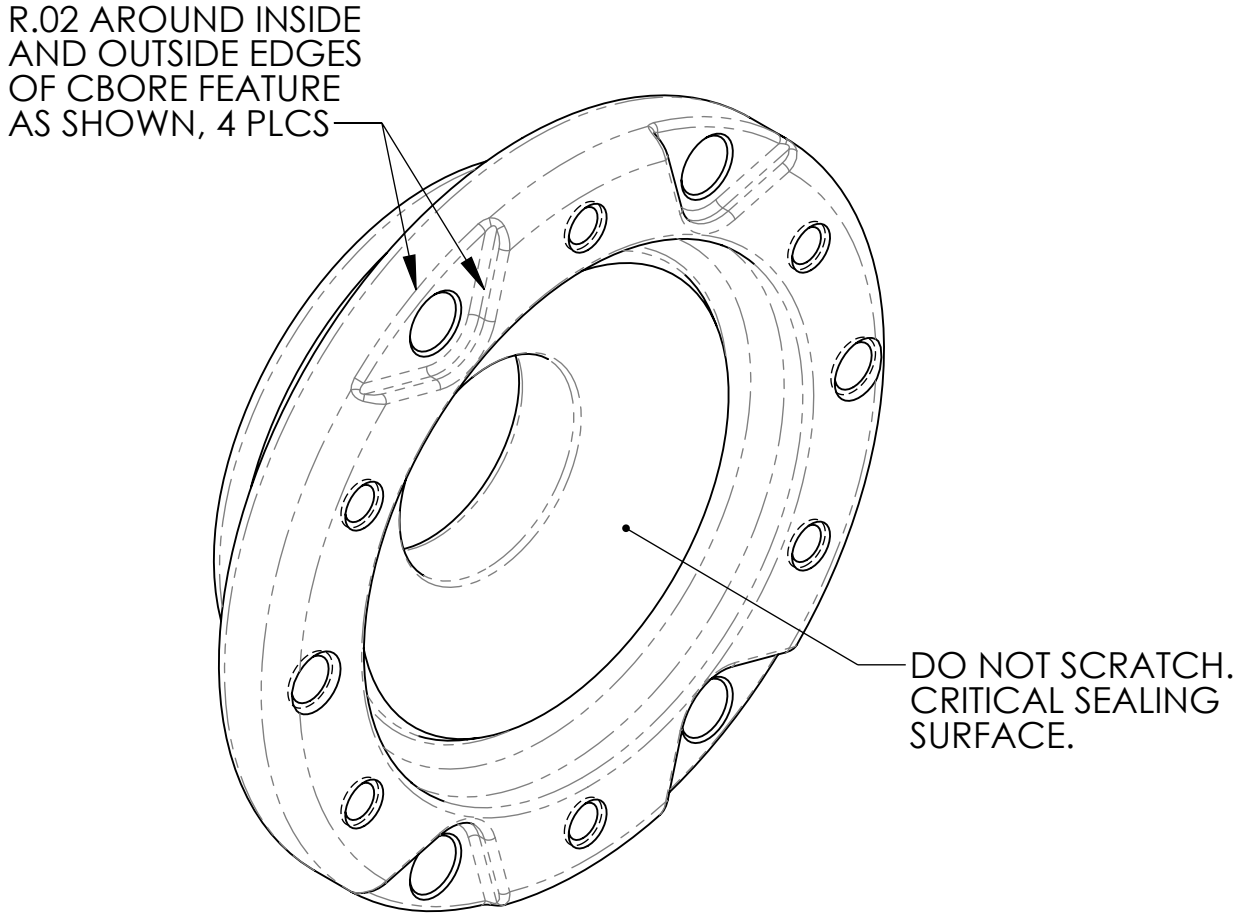
D

C

B

A

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
	A	ANODIZE THICKNESS AND SEALCOAT SPECIFICATION. ADJUSTED TOLERANCES OF CRITICAL SURFACES.	5/7/2024	TSG

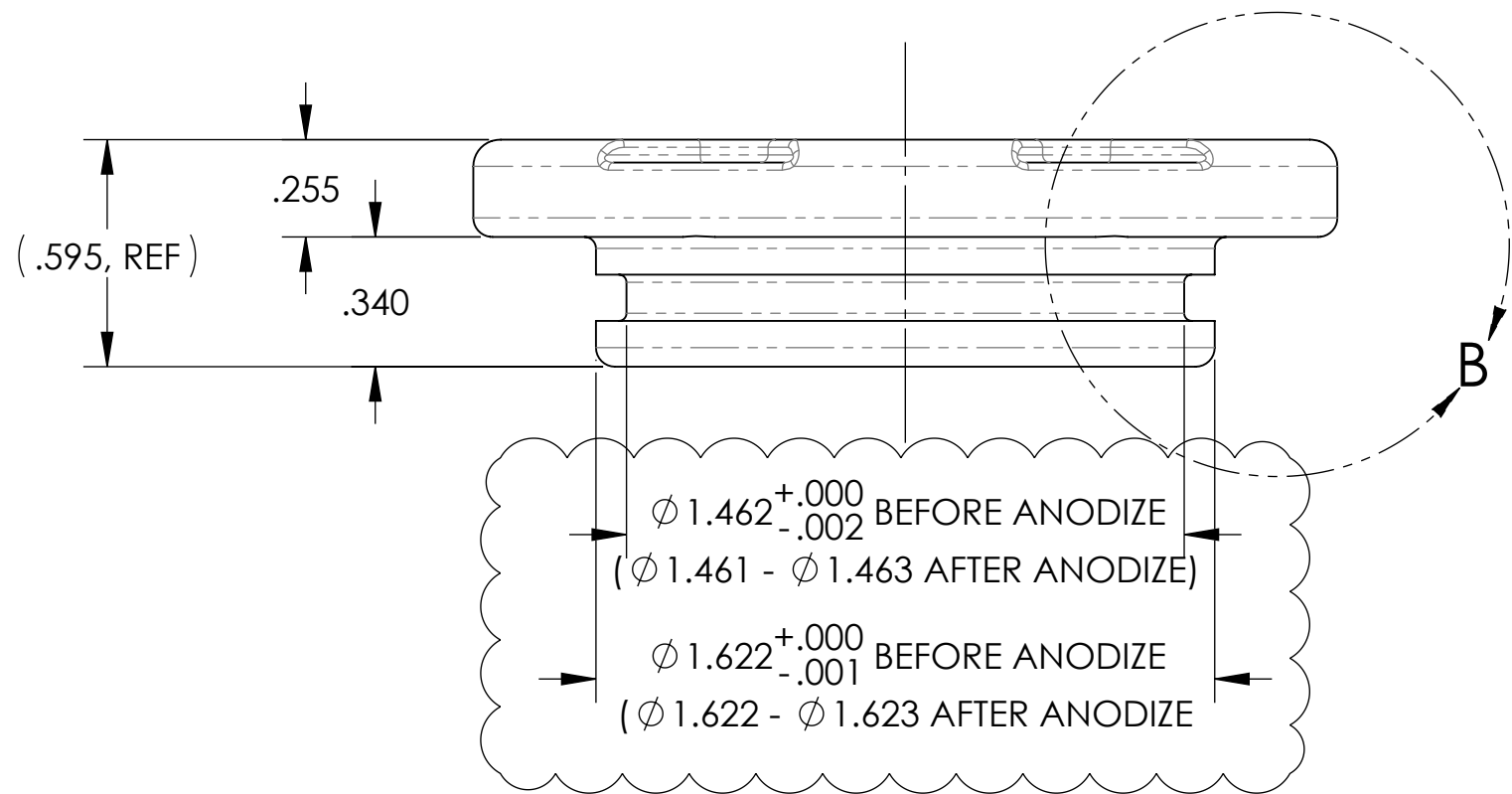


4X $\varnothing$.170 THRU ALL
✓ $\varnothing$.19 X 90°, BOTH SIDES
□ $\varnothing$.29 ∇ .06
LOCATED ON $\varnothing$ 2.000 BCD,
SPACED AS SHOWN

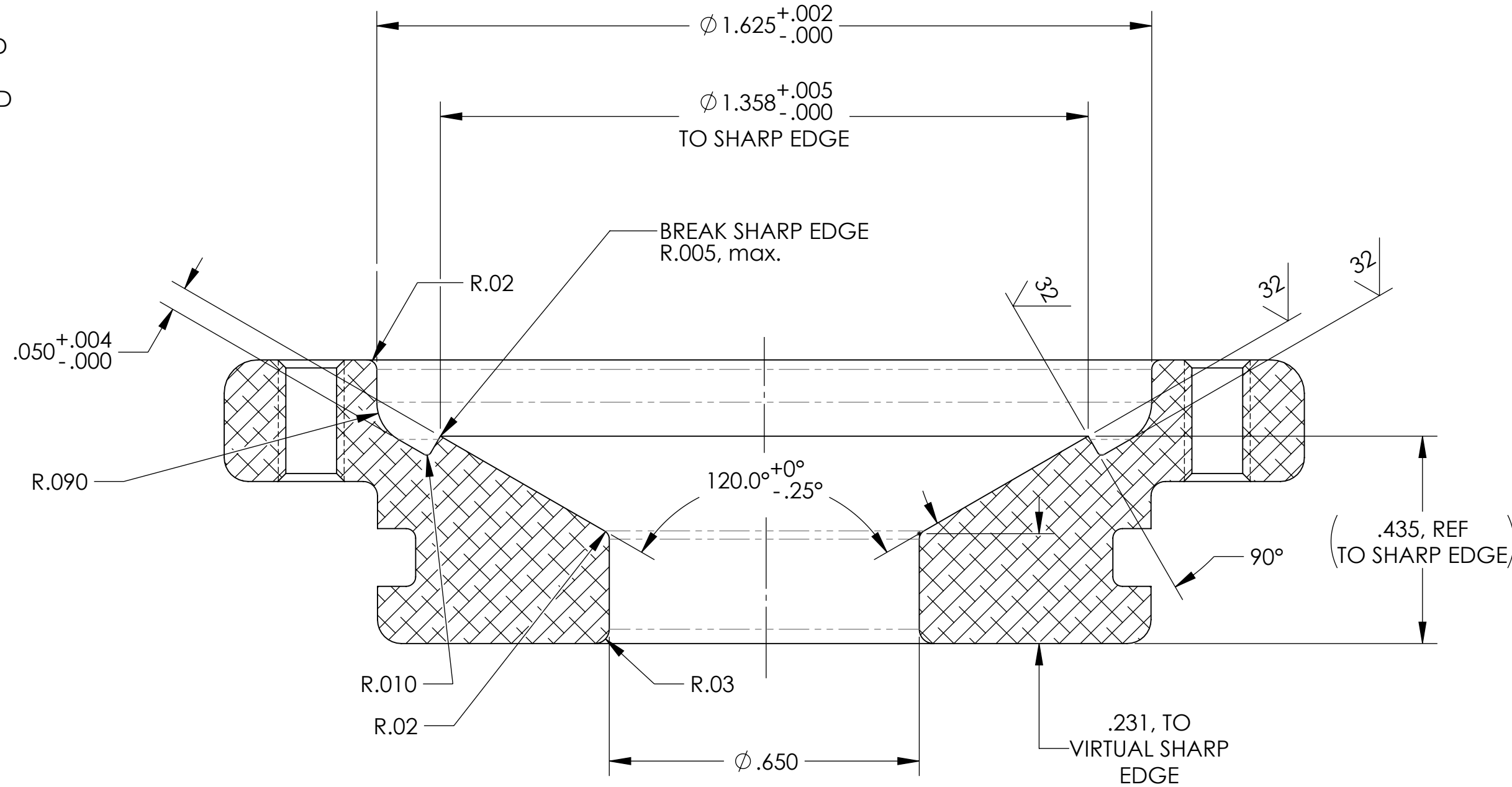
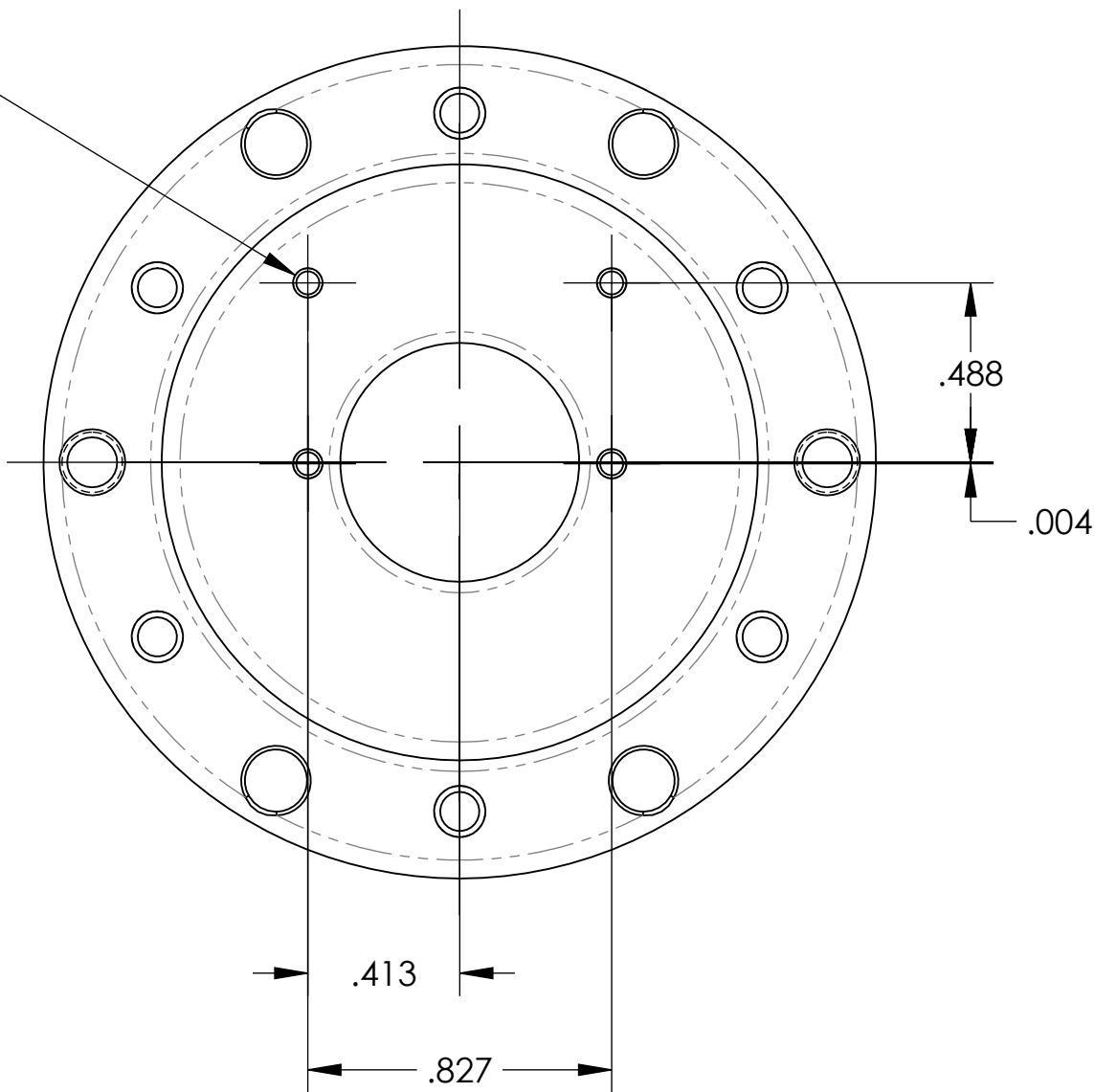
6X $\varnothing$.11 THRU ALL
6-32 UNC - 2B THRU ALL
✓ $\varnothing$.14 X 90°, BOTH SIDES
LOCATED ON $\varnothing$ 1.900 BCD,
SPACED AS SHOWN.
OVERTAP FOR ANODIZE BUILDUP,
HOLES MUST BE PLATED.
SEE NOTE 7.

2X $\varnothing$.136 THRU ALL
8-32 UNC - 2B THRU ALL
✓ $\varnothing$.18 X 90°, BOTH SIDES
LOCATED ON $\varnothing$ 2.000 BCD,
SPACED AS SHOWN.
OVERTAP FOR ANODIZE BUILDUP,
HOLES MUST BE PLATED.
SEE NOTE 7.

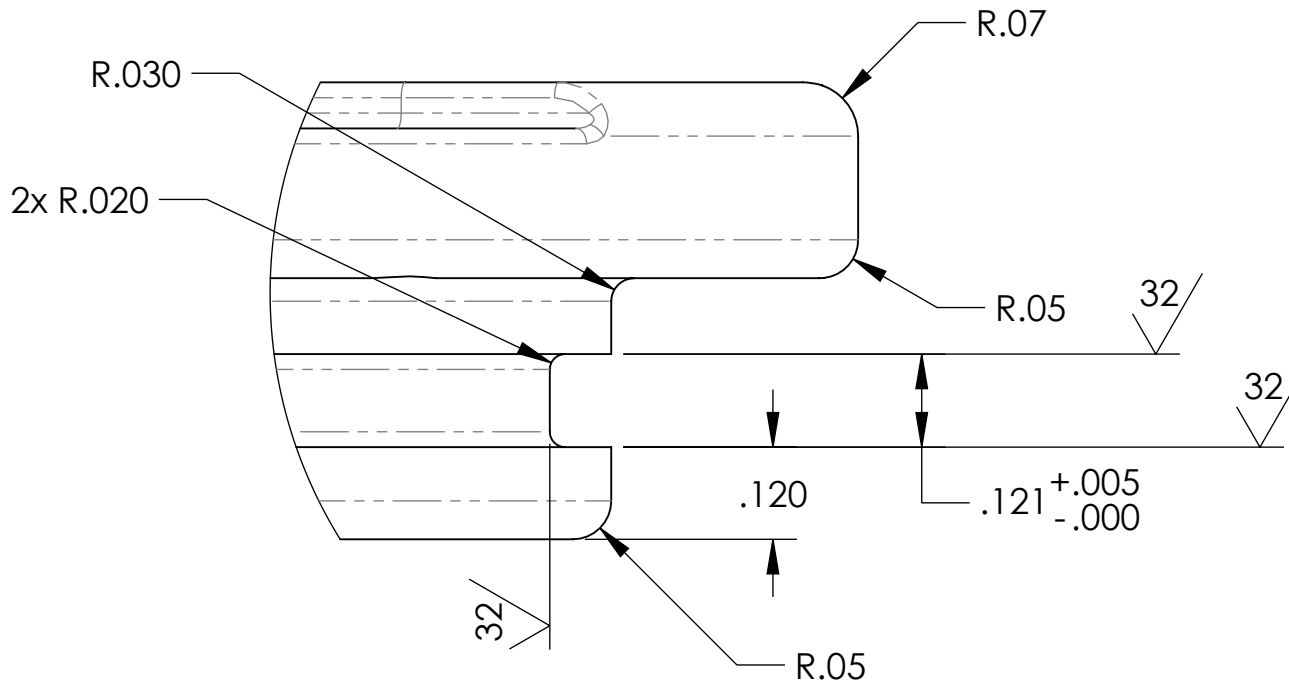
DO NOT SCRATCH.
CRITICAL SEALING
SURFACE.



4X $\varnothing$.063 ∇ .18
M2X0.4 - 2B ∇ .13
✓ $\varnothing$.08 X 90°, NEAR SIDE
USE HOLES TO HOLD PART
DURING PLATING PROCESSES.
HOLES NOT USED FOR HOLDING
PART MUST BE MASKED.
SEE NOTE 7.



SECTION A-A
SCALE 4 : 1
O-RING GLAND:
2-028, BUNA-N, 70a



DETAIL B
SCALE 4 : 1
O-RING GLAND:
2-127, BUNA-N, 70a

- NOTES:
- REMOVE ALL BURRS AND SHARP EDGES R.02 OR .02 X 45° CHAMFER.
 - UNLESS OTHERWISE SPECIFIED SURFACE ROUGHNESS IS 63 MICROINCHES OR FINER.
 - MATERIAL: ALUMINUM, 6061-T6 AS PER ASTM B209. MINIMUM YIELD STRENGTH OF 35,000 PSI. PROVIDE MILL CERTS FOR APPROVAL PRIOR TO MACHINING.
 - DIAMETERS SHARING A COMMON AXIS TO BE CONCENTRIC WITHIN .002" T.I.R.
 - DIMENSIONS APPLY BEFORE ANODIZE, EXCEPT WHERE NOTED.
 - FINISH: HARD CLEAR ANODIZE IAW MIL-A-8625 TYPE III, CLASS 1 (.001 THICK). TEFLON SEAL COAT.
 - DURING PLATING PROCESSES, HOLD AND RACK PART USING M2 TAPPED HOLES ONLY, AS INDICATED. EXTRA M2 HOLES NOT USED FOR HOLDING PART MUST BE MASKED. ALL OTHER SURFACES TO BE PLATED WITH NO VOIDS. TAKE SPECIAL CARE TO REMOVE AIR BUBBLES FROM #6-32 AND #8-32 TAPPED HOLES TO ENSURE PLATING.

APPROVAL	DATE	PROPRIETARY AND CONFIDENTIAL		COMPUTER FILE NAME	
DESIGN T.GREGORY	2024-04	THIS INFORMATION IS NOT TO BE DUPLICATED OR DISTRIBUTED WITHOUT THE WRITTEN CONSENT OF GREGORY DESIGNS, LLC		GD-MB-0006-OAK 1500 VIEWPORT HOUSING-REV-A	
DRAWING T.GREGORY	2024-04-05			GD-MB-0006-OAK 1500 VIEWPORT HOUSING-REV-A	
CHECKED		UNLESS OTHERWISE SPECIFIED:		DRAWING MODEL	
D		DIMENSIONS ARE IN INCHES.			
THIRD ANGLE PROJECTION		TOLERANCES:			
		FRACTIONAL: 1/164			
		ANGULAR: MATCH .25°			
		ONE PLACE DECIMAL: .01			
		TWO PLACE DECIMAL: .005			
		THREE PLACE DECIMAL: .0005			
		GREGORY DESIGNS, LLC			
		OAK 1500 VIEWPORT HOUSING			
		GD-MB-0006			
		SCALE: 2:1			
		REV: A			
		SHEET 1 OF 1			