10.13 MAX

10.04 ±.03 BSC LENGTH FOR -1

THREADED HOLE -E-

.310 ±.001 3 PLACES FOR -1 & -11

.056 +.003 -.002 WALL REF EXCEPT AT WELDS & REINFORCED AR

.185 REF TYP ALL THREADED BOSSES

.656 ±.005 INSIDE SPHERICAL R REF

19.21 DIA MAX OVER WELD BEAD

.80 DIA MAX OVER WELD BEAD

.63 R TRUE TYP ALL THREADED BOSSES REF

.185 REF TYP ALL THREADED BOSSES

.95 REF TYP ALL THREADED BOSSES

90° REF

10.75 REF FOR -1

.25 DIA

9.00 DIA REF AT THREADED BOSSES AND ADJACENT TO WELD BEAD

.38 DIA REF

1.500 GAGE DIA

1.228 ±.020 FOR -1

.75 MIN /61

.250 +.005 -.000 DIA X .012 WALL FOR LENGTH -C-

.420-6-4AN UNION REQD FOR -11

.002 MAX CORNER BREAK FOR -1 TYP BOTH TUBES

HOLE -D-

ALIGN SERIBE LINES WITHIN .060 PRIOR TO WELD

.19 R REF

1.45 MAX DIA REF

4.00 ±.02 FOR -1

.85 MIN FOR -1

.001 H

80-2960034-1 SHAFT 1 REQD FOR -1 224TB GRADE A LOCKING COMPOUND

.250 +.005 -.000 DIA X .012 WALL FOR LENGTH -H-

TANK - WELDMENT 1 REQD FOR -1

TANK - MACHINED REQD FOR -1

.001 C

.001-1 SUPPORT ASSY, PROPELLANT REQD FOR -21

53 REMOTE FILL MOUNTING FOR -21

VIEW M
SCALE: 2/1

PMD S FITTING REF

1.00 MAX

9.906 FOR -1 & -11

2.00 R REF, 2 PLACES FOR BOSSES

.18 REF, 4 PLACES TYP ALL THREADED BOSSES

9.906 FOR -1 & -11

.812 REF

.18 REF, 2 PLACES

1.10 MAX

.185 DIA REF

.18-E .310

.1812 HEX REF

.420-6-4AN UNION REQD FOR -1

9.906 FOR -1 & -11

30° ±.5° 2 PLACES

.5152 ±.015 2 PLACES FOR -1, -11

VIEW E - K

.6119 DIA x DEPTH SHOWN .3750 - 24 UNJF-3B x .310 MIN DEEP COMPLETE THREAD THREADS PER MIL-S-8879 FOR BOSS .5-.515 DIA

.01 R MIN

.062

VIEW A
SCALE 2/1

.885 MAX

.01 R MIN

.14° 2 PLACES REF TYP ALL THREADED BOSSES

.09 R, 2 PLACES REF TYP ALL THREADED BOSSES

.080, 2 PLACES REF TYP ALL THREADED

.2577 DIA x DEPTH SHOWN .2496 FOR .420-6-4AN .2515 DIA TAP USING HELI-COIL TAP 21193-4 NF OR A .250 MIN FULL THREAD DEPTH INSTALL HELI-COIL & REMOVE DRIVING TANG

559-4CN REQD HELI-COIL 8 REQD FOR -11

RW PRESSURE SYSTEMS, INC.

TANK ASSY, HYDRAZINE