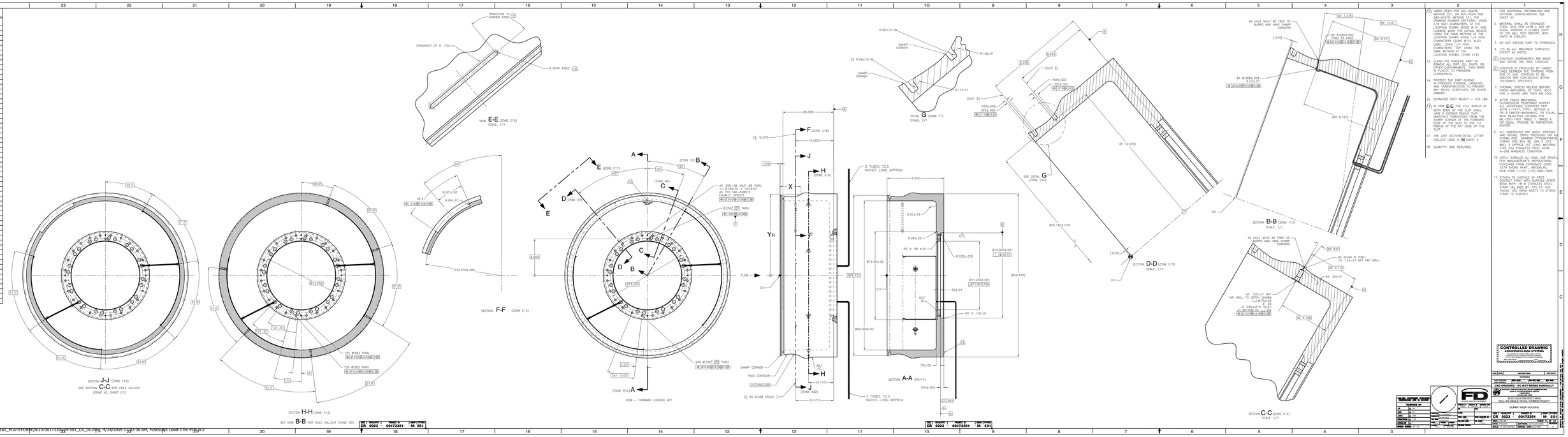
CONTOUR COORDINATES (S3)	(S3)
X	YR
0.00000	13.19200
0.17259	13.15710
0.22318	13.14631
0.36500	13.11592
0.52120	13.08297
0.67750	13.04934
0.79938	13.02484
0.90981	13.00184
1.02583	12.98054
1.15865	12.97361
1.24501	12.95928
1.35463	12.94598
1.46422	12.93389
1.57736	12.92286
1.69013	12.91318
1.80227	12.90576
1.91403	12.90252
1.98694	12.90273
2.07952	12.90568
2.14363	12.90960
2.26037	12.92068
2.41700	12.94291
2.57788	12.97439
2.73787	13.01465
2.84545	13.04731
2.95932	13.08703
3.07060	13.13140
3.18190	13.18116
3.29000	13.23450
3.39074	13.28769
3.48762	13.34074
3.60618	13.40307
3.71479	13.45510
3.81850	13.49778
3.92544	13.53140
4.04153	13.55761
4.15630	13.57323
4.27300	13.57956
4.38937	13.57784
4.50941	13.56974
4.61744	13.55713
4.73518	13.54110
4.84251	13.52287
4.95475	13.50342
5.06729	13.48361
5.18024	13.46433
5.29358	13.44644
5.40610	13.43081
5.51714	13.41800
5.62950	13.40810
6.10210	13.40810
6.57470	13.40810
7.43370	13.40810
8.24960	13.40810
9.27380	13.40810
9.40680	13.40810
9.41590	13.40810



1. FOR ADDITIONAL INFORMATION AND OPTIONAL CONFIGURATION, SEE SHEET 02.
2. MATERIAL SHALL BE STAINLESS STEEL, AISI 304 PER AMS 5513 OR EQUAL. PROVIDE A LEGIBLE COPY OF THE MILL TEST REPORT, WITH UNITS IN ENGLISH.
3. DO NOT EXPOSE PART TO HYDROGEN.
4. (25) Ra ALL MACHINED SURFACES, EXCEPT AS NOTED.
5. CONTOUR COORDINATES ARE BASIC AND DEFINE THE TRUE CONTOUR.
6. CONTOUR IS PRODUCED BY FAIRED ARCS AND STRAIGHT LINES FROM END TO END. CONTOUR TO BE SMOOTH AND CONTINUOUS WITHIN TOLERANCE SPECIFIED.
7. THERMAL STRESS RELIEVE BEFORE FINAL MACHINING. HEAT TO 1000°F FOR 2 HOURS AND THEN AIR COOL.
8. AFTER FINISH MACHINING, FLUORESCENT PENETRANT INSPECT ALL ACCESSIBLE SURFACES PER ASTM E-1417, TYPE1, METHOD A OR B (WATER-WASHABLE), OR EQUAL. PROVIDE AN INSPECTION REPORT.
9. ALL DIMENSIONS ARE BASIC. PREPARE TUNNEL INNER HOUSING FOR PAINT AS SHOWN PER DRAWING 7370D6710410. TUBING SIZE WILL BE .064 X .012 WALL IN APPROX 4.5' LONG. MATERIAL TYPE 304 STAINLESS STEEL ASTM A-269 ANNEALED CONDITION.
10. APPLY DURALCO No. 4525 SOF EPOXY PRIMER OR EQUAL. DURALCO PRODUCTS PURCHASE FROM EDTRONICS CORP. 3379 SHORE PKWY., BROOKLYN, NEW YORK 11235 (718) 646-7996.
11. ATTACH TO SURFACE AT FIRST CONTACT POINT WITH TUNNEL AFTER SAND BLASTING 8 STAINLESS STEEL STRAP (¾ WIDE BY .015 TO .032 THICK). USE DRIVE RIVETS TO ATTACH STRAP TO SURFACE.

REV	DATE	DESCRIPTION	APPROVED
A	4/24/09	INITIAL RELEASE	

CAD DRAWING - DO NOT REVISE MANUALLY
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CELL 100 MACHINE SHOP, PRODUCTION FACILITY
TUNNEL INNER HOUSING
SIZE: C | SCALE: 1/1 | WEIGHT: - | SHEET 1 OF 1
CR 0023 - 00173391 - 5E- 501

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