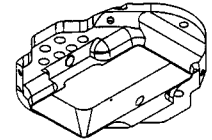


GENERAL VIEW  
REFERENCE ONLY  
SCALE: NONE



GENERAL VIEW  
REFERENCE ONLY  
SCALE: NONE

# NOT FOR FABRICATION

AUG 23 2001

6. PRIOR TO MACHINING ANNEAL AT 816°C FOR 30 MINUTES PER 25mm OF THICKNESS. WATER QUENCH REHEAT TO 316°C FOR 1 HOUR AIR COOL. REHEAT TO 93°C FOR 48 HOURS AIR COOL.
7. ALL RADIi ARE R3.18 EXCEPT AS NOTED.
8. GOLD PLATE PER MIL-G-45004, TYPE III CLASS 3.
9. BAG AND TAG INDIVIDUAL PARTS PER JPL SPEC. F5300451.
10. REMOVE ALL BURRS AND BREAK SHARP EDGES 0.05-0.2 MAX.
11. BOND ITEM NO. 2, INSERT, 0.13-0.38 BELOW SURFACE OF ITEM 1, TOP RING, USING ITEM NO. 3, FASTENER BONDING, AND MANUFACTURER TOOL, THKNH 1.6 X 0.35. DRIVE LOCKING KEYS DOWN.
12. NOTES: UNLESS OTHERWISE SPECIFIED.

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