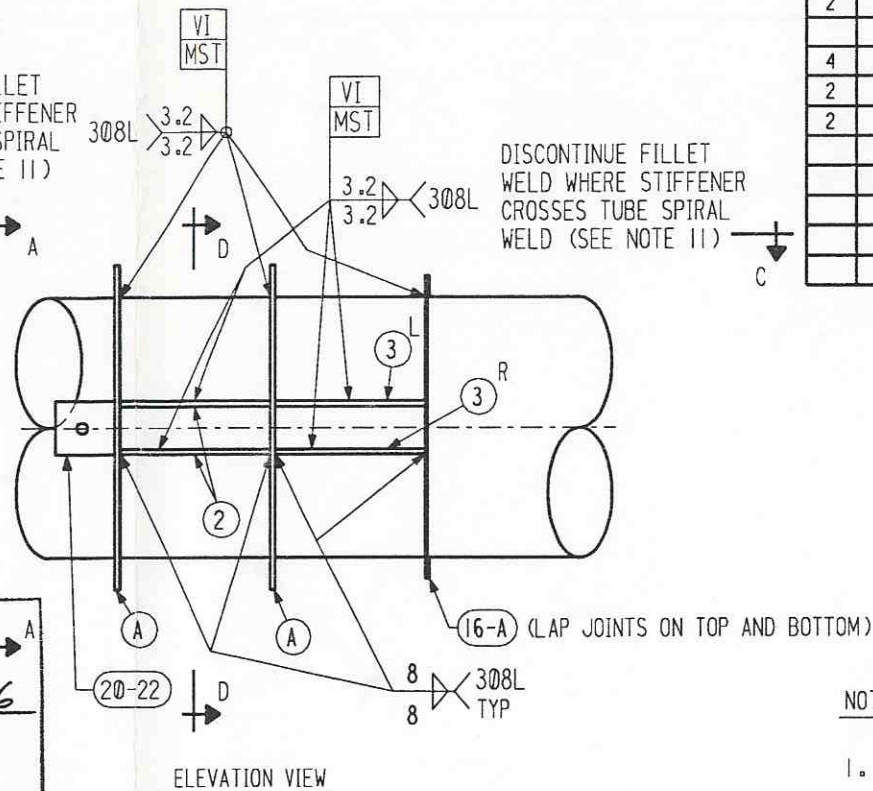


DISCONTINUE FILLET WELD WHERE STIFFENER CROSSES TUBE SPIRAL WELD (SEE NOTE 11)



APPROVED

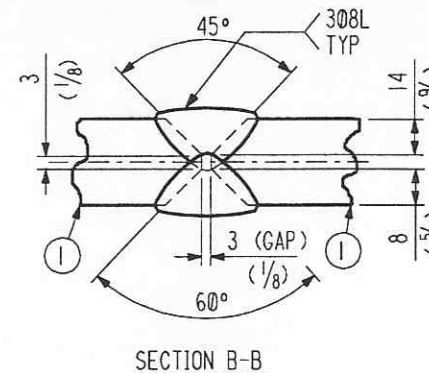
M. Tellalian 9-13-96

CBI DATE

J. Jones 9/23/96

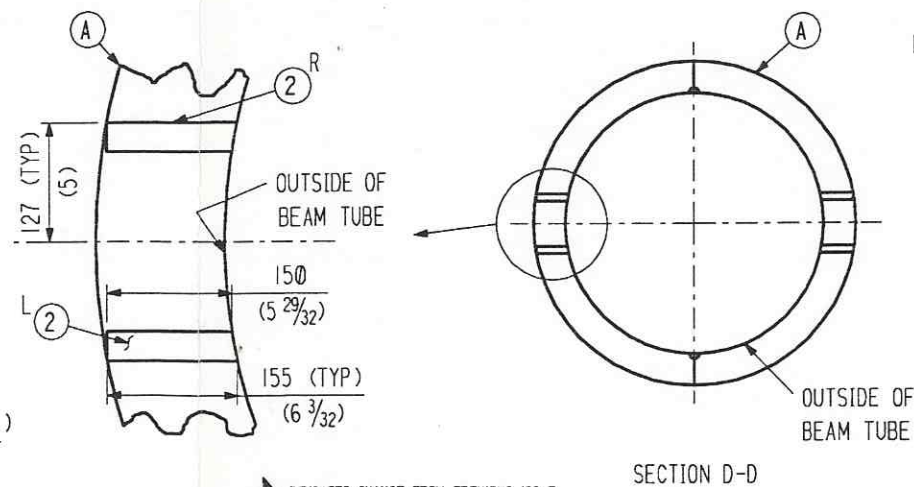
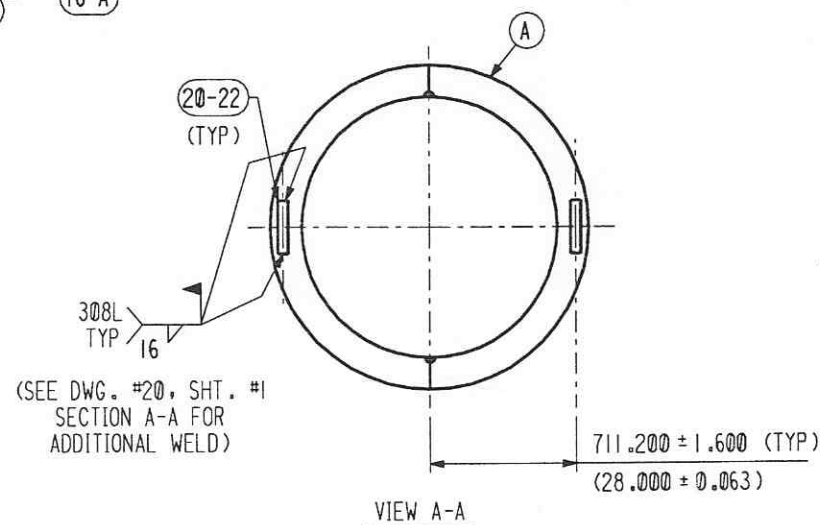
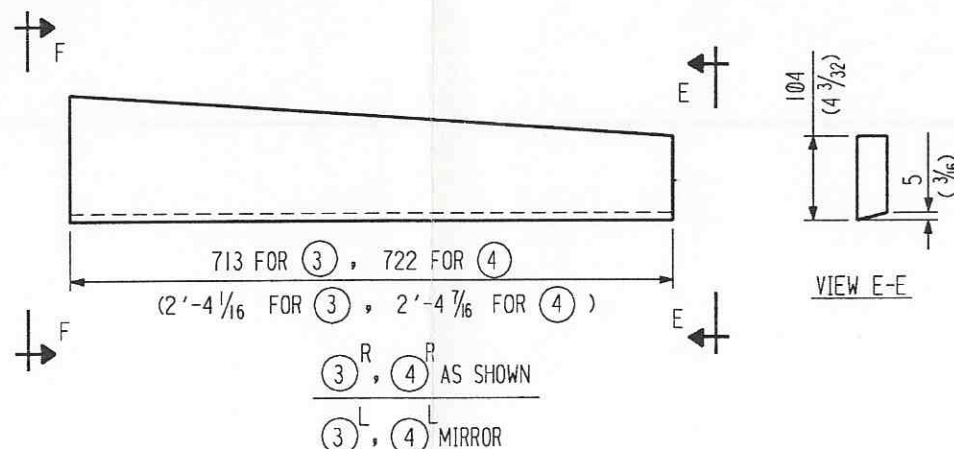
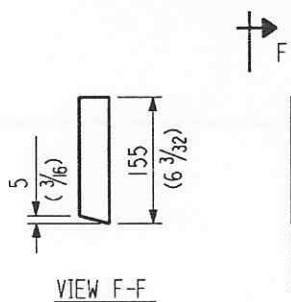
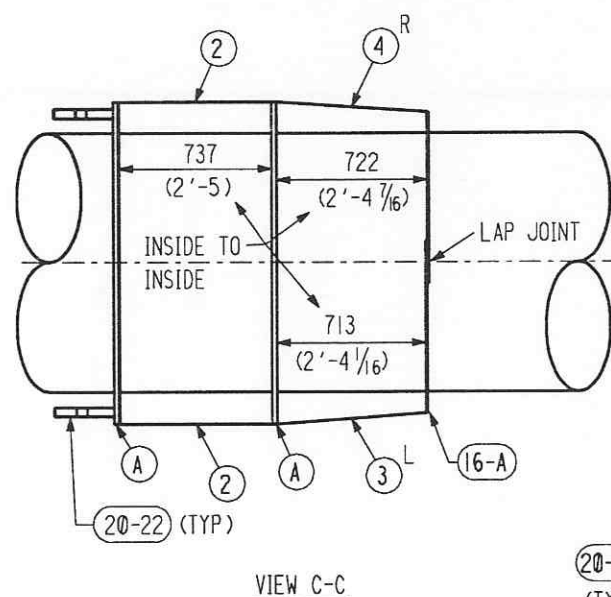
CALTECH DATE

SHIP PC	MARK	ASSM PC	DESCRIPTION	LENGTH MM	SPEC	ID
2	21-A	4	TERMINATION SUPPORT RING ASSEMBLY			
	21-1		PL SK X 25 (1")		M8	Ac
4	21-2		PL SK X 25 (1")		M8	C
2	21-3 R/L		PL SK X 25 (1")		M8	C
2	21-4 R/L		PL SK X 25 (1")		M8	C
			M8 = SEE SPEC C-TERMSTF (SA240-TP304L)			



NOTES:

- REFER TO SPECIFICATION C-TERMSTF FOR ADDITIONAL MATERIAL AND FABRICATION INFORMATION.
- FABRICATE THE SUPPORT RING HALVES TO THE ROUGH I.D. AND O.D.
- TACK WELD THE BUTT JOINTS TOGETHER.
- MACHINE THE SUPPORT RING O.D. AS SHOWN.
- MEASURE THE CIRCUMFERENCE OF THE TUBE WHERE THE STIFFENER SUPPORT RING WILL BE PLACED. CALCULATE THE O.D. OF THE TUBE.
- MACHINE THE SUPPORT RING I.D. TO THE EXACT O.D. OF THE TUBE (WHERE IT WILL BE ATTACHED) WITH A TOLERANCE ON THE RING ID AS SHOWN.
- REMOVE THE TACKS IN THE BUTT JOINTS AND PLACE THE SUPPORT ON THE TUBE. USE CARE TO MAKE SURE EACH SUPPORT IS FITTED TO THE PLACE IT WAS MACHINED FOR.
- TACK THE SUPPORT RING TO THE TUBE AND THEN WELD THE BUTT JOINTS
- WELD THE SUPPORT RING TO THE TUBE.
- WORK THIS DRAWING WITH DRAWINGS 4 AND 20.
- ALL WELDING TO TUBE WALL TO BE DONE USING FILLER MATERIAL CLEANED PER SPEC WMS-ER308L.
- AFTER FINAL MACHINING, ID OF SUPPORT RING (A) IS TO BE CONCENTRIC WITH OD WITHIN ± 0.254 (0.010).
- AFTER FINAL MACHINING, OD OF SUPPORT RING (A) IS TO BE ROUND WITHIN 0.254 (0.010).



DETAILED AND BILLED FOR (1), (16) REQUIRED

REVISIONS		REMARKS	
BY	DATE	ADDED NOTE TO INSIDE RAD. OF ASS'Y. A.	
CHKD	DATE	REV. NOTE 1 TO SHOW CORRECT SPEC.	
DATE	DATE	DATE	DATE

CUSTOMER'S NO		CONTRACT NO	
BY DTR_CHKD CST DATE 4/16/96		953571	
M. L. TELLALIAN		DWG	REV
ENGINEERING ASSIGNED		21	2
SHT			

2190-D960513-02-B