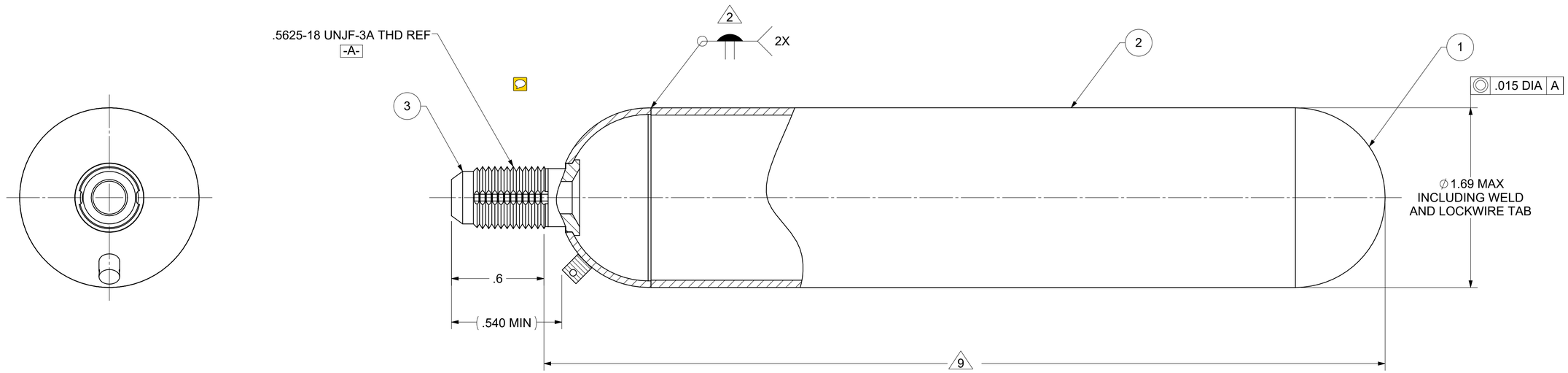
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	REVISED PER DCN 165	86-3-7	AF
B	SEE ECN #1522	11/06/22	DR
C	SEE ECN #01597	12/01/13	DR
D	SEE ECN 2202	15/03/31	SK
E	SEE ECN 2772	20/05/27	SK



10. REF. BORG - WARNER DWG 37523.

9 COAT EXTERNAL SURFACE WITH POWDER COAT 'T009-YL01'. SURFACE PREPARATION WITH MEK OR ACETONE WIPE OR BATH AT A MINIMUM IS REQUIRED. ONLY A-4108-YL01 MAY BE USED AS A TOUCH FOR SURFACE NICKS OR SCRATCHES AS NEEDED.

8. MAGNETIC PARTICAL INSPECT IAW ASTM-E1444, CONTINUOUS WET FLUORESCENT, CIRCULAR & LONGITUDINAL METHOD. ACCEPTANCE CRITERIA IAW MIL-STD-1907, EXCEPT NO DEFECTS ALLOWED.

7. IAW SP 7694 (g) PERFORM FLATTENING TEST. SAMPLE MAY NOT CRACK WHEN FLATTENED SO THAT ITS OUTER SURFACE ARE NOT MORE THAN TEN TIMES WALL THICKNESS APART.

6. HYDROSTATICALLY TEST TO DESTRUCTION. BURST TEST AT 15,109 PSI MIN. MINIMUM OF ONE (1) SAMPLE PER EACH HEAT TREAT LOT.

5. PROOF TEST TO 11,109 MIN PSIG FOR 60 SECONDS MIN. NO PERMANENT DEFORMATION ALLOWED.

4. HEAT TREAT TO 180KSI MIN, IAW AMS 2759/1. ROCKWELL C SCALE 40-43

3. RADIOGRAPHIC EXAMINE IAW ASTM E1742/1742M

2 INERT GAS WELD AS NOTED PER IAW AWS D17.1/17.1M

1. INTERPRET DWG PER IAW ASME-Y14.100

NOTES: (UNLESS OTHERWISE SPECIFIED)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
3	10588	CAP ASSEMBLY	1
2	10380	CYLINDER, GAS SUPPLY TANK	1
1	10381	SHELL, CYLINDER GAS SUPPLY TANK	1

PARTS LIST

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272-9	272-9
NEXT ASSY	USED ON
APPLICATION(S)	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE:
DECIMALS .X=±.1 .XX=±.03 .XXX=±.010 FRACTIONS ±1/16 ANGLES ±0.30°

MATERIAL

FINISH 9

DO NOT SCALE DWG

APPLIED PRESSURE VESSELS

APPROVALS	DATE
DRAWN L. ZYKIN	02/02/04
CHECKED	
ISSUED	
Q.A.	

TITLE: CYLINDER ASSY - GAS SUPPLY TANK

SIZE D | DWG. NO. 10385 | REV. E | FSCM NO. 72QQ7 | SCALE NTS | SHEET 1 OF 1

CAD: SOLIDWORKS