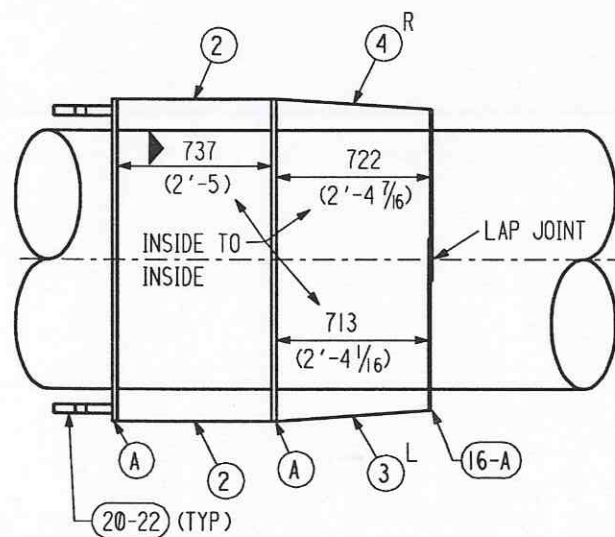
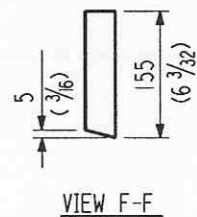


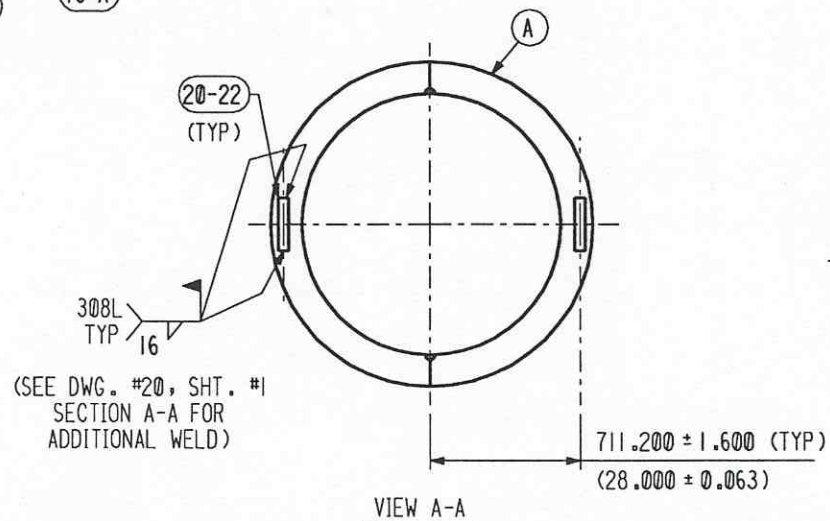
TERMINATION SUPPORT RING (A)



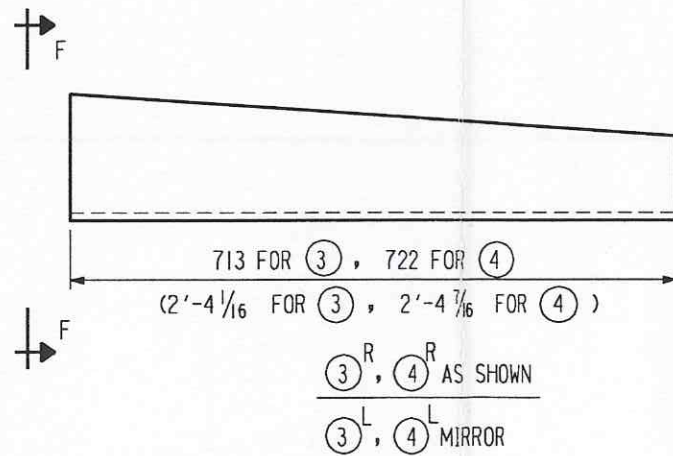
VIEW C-C



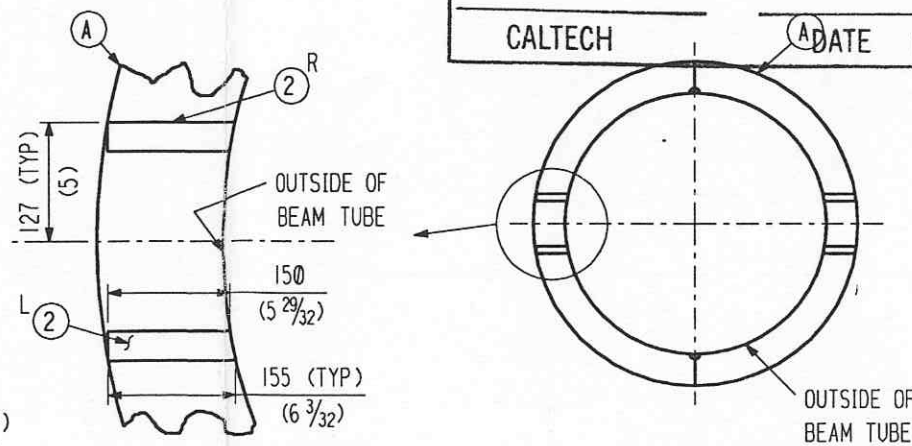
VIEW F-F



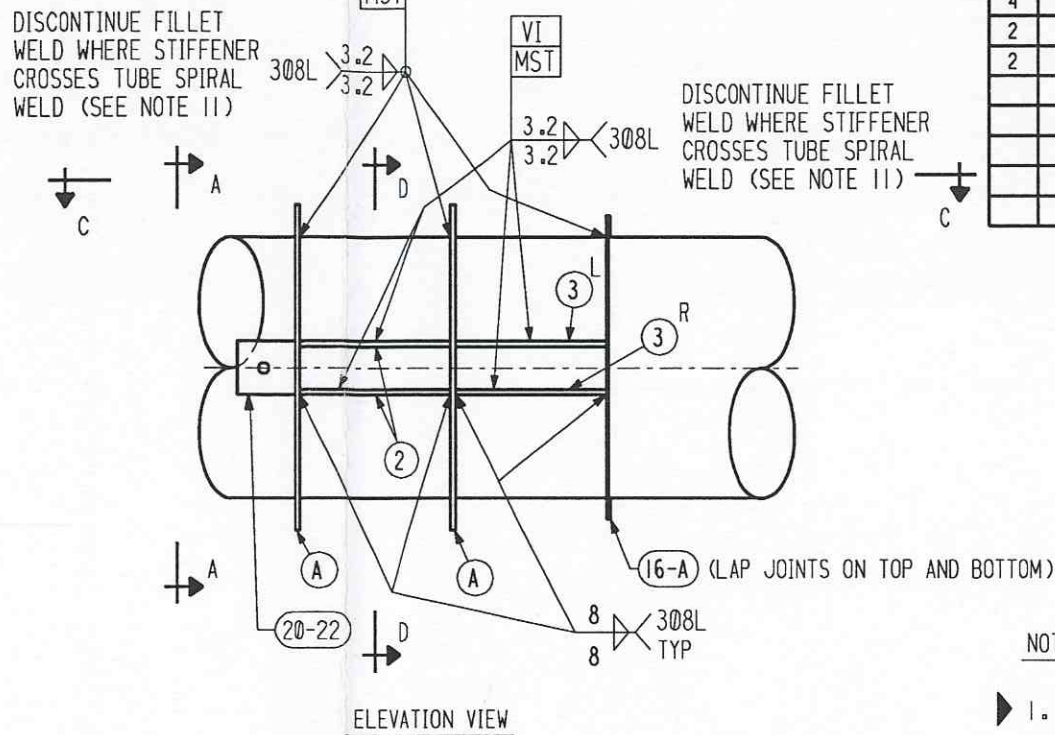
VIEW A-A



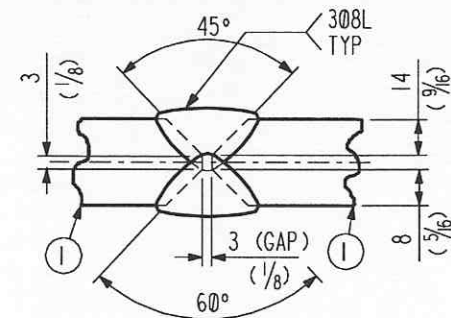
APPROVED
M. Tellalian 6-28-96
 CBI DATE
 CALTECH (A) DATE



SECTION D-D



ELEVATION VIEW



SECTION B-B

SHP PC	MARK	ASSM PC	DESCRIPTION	LENGTH MM	SPEC	ID
2	21-A		TERMINATION SUPPORT RING ASSEMBLY			
	21-1	4	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	BY	DATE
CHKD	DATE	CHKD	DATE
DATE	DATE	DATE	DATE
DATE	DATE	DATE	DATE

REVISIONS: 1. REV. NOTE 1 TO SHOW CORRECT DATE 6-28-96 SPEC.

CUSTOMER'S NO: _____ CONTRACT NO: 953571
 BY DTR CHKD CST DATE 4/16/96
 M. L. TELLALIAN
 ENGINEERING ASSIGNED

DWG 21 REV 1P
 SHT 1P

DS60573-01-B