

INITIATOR BW

DATE 1-13-99

ENGINEERING CHANGE REQUEST (ECR)

1 OF 2

NEXT ASSEMBLY NO. D972397

CUSTOMER DRAWING NO. D972472

DRAWING TITLE ~~BK~~ BELLOWS REMOVAL I-BERM JSG

REVISION: FROM A TO B



HYTEC
INCORPORATED

DESCRIPTION OF CHANGE (Simple Phrase. Identify Data if Possible):

- ① ZONE 5D ELIM. TAPPED HOLE AT 11.500
- ② ZONE 1-3A DELETE ITEM 7
- ③ ADD 3/8 GUSSET (SHEET 2 OF ECR) TO P/L

REASONS FOR CHANGE:

- ① & ② CUSTOMER REQUEST
- ③ REDUCE DISTORTION OF DWG ITEM 2

IDENTIFY OTHER PARTS/GROUPS THAT INTERFACE WITH THE ABOVE (Required):

INTERFACE	RESPONSIBLE PARTY	INITIAL

NOTIFY COGNIZANT DESIGNER: BILL K

NOTIFY COGNIZANT ENGINEER: T²

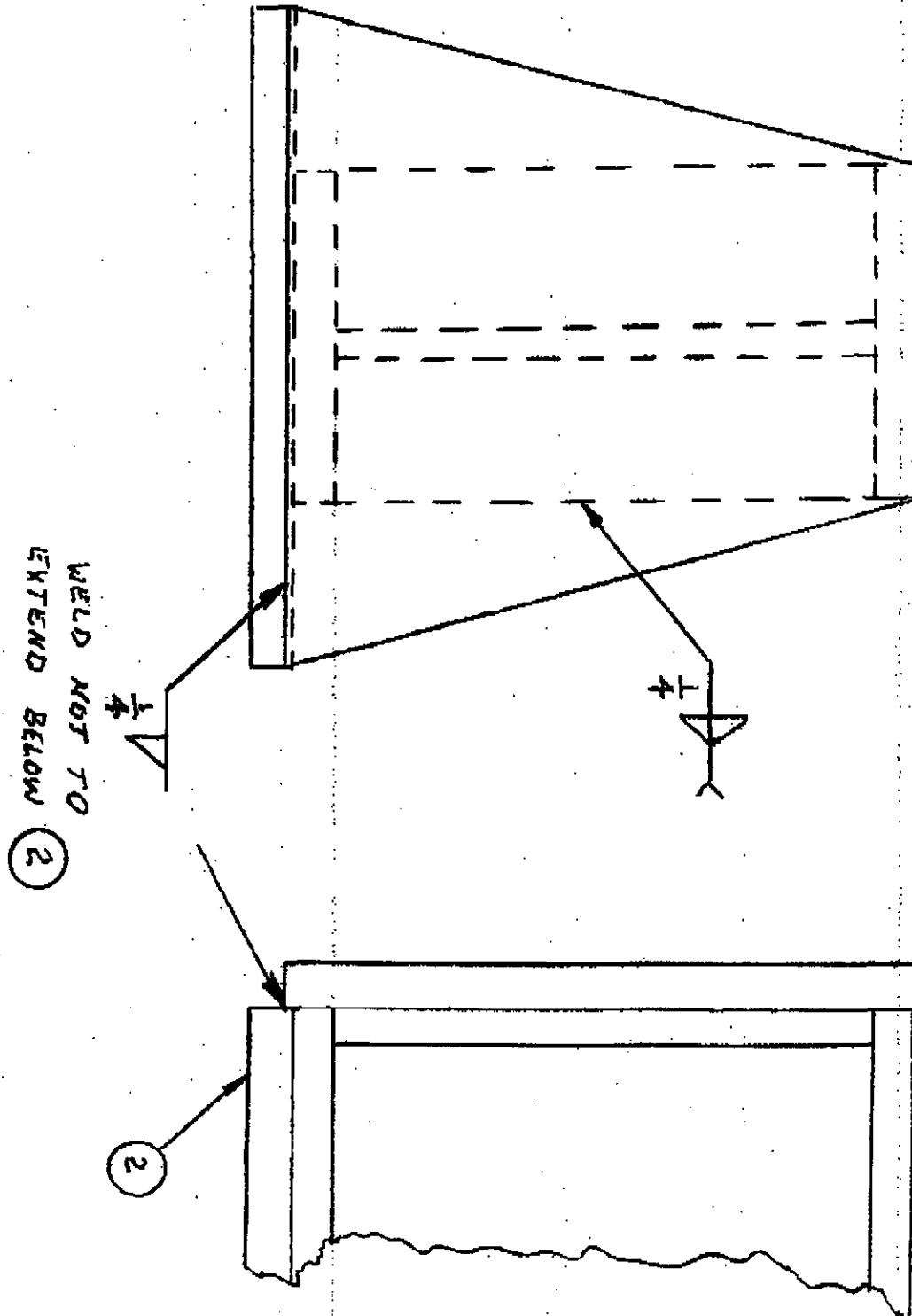
972472
1 of 3

APPROVED: T

ELR D972472 A TO B

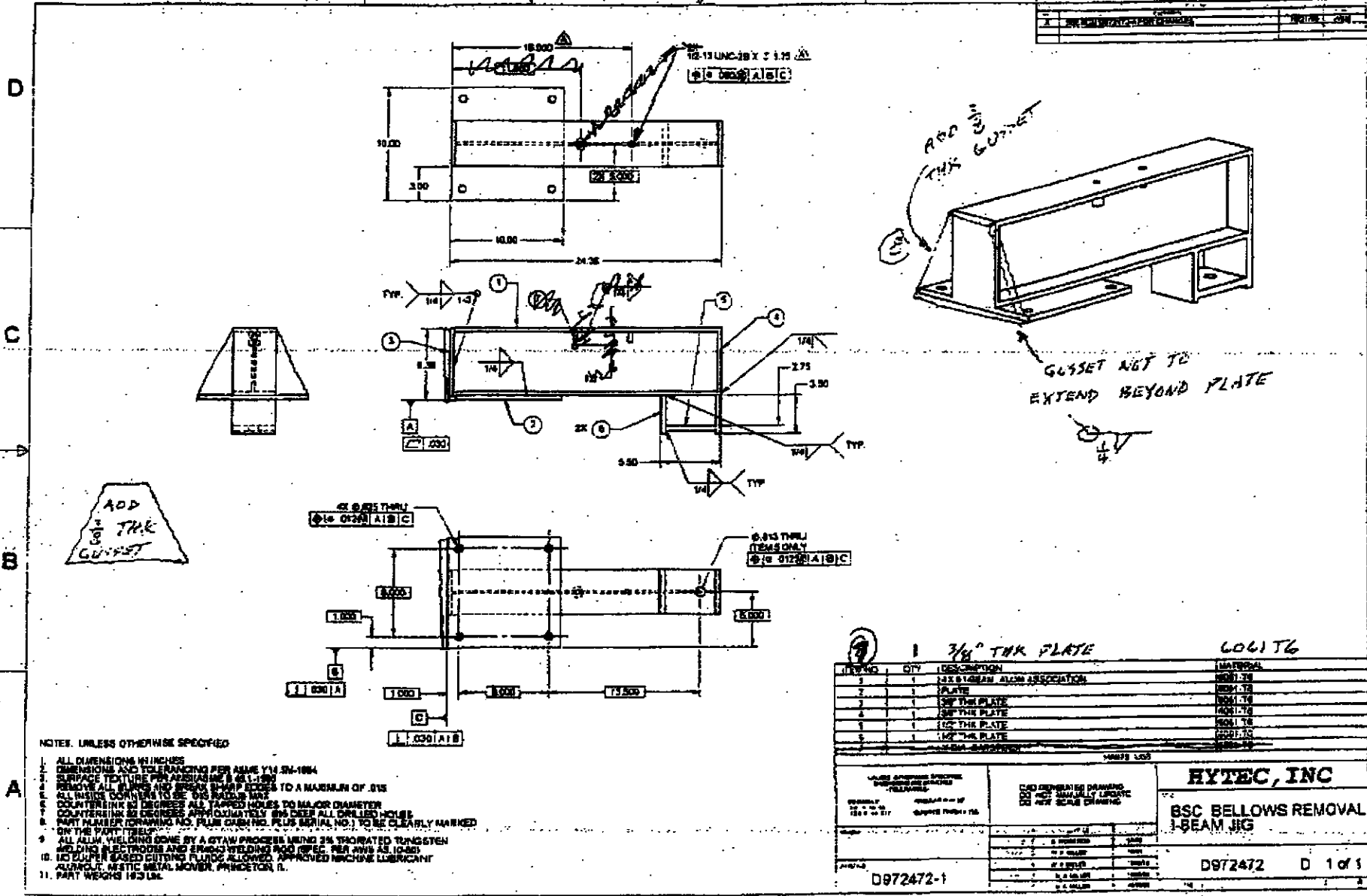
1-13-99

2 OF 2



972472
2 of 3

DATE	BY	CHKD	APP'D
09/24/92	J.P.	J.P.	J.P.



NOTES: UNLESS OTHERWISE SPECIFIED

1. ALL DIMENSIONS IN INCHES
2. DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
3. SURFACE TEXTURE PER ASSOCIATED B & L-1999
4. REMOVE ALL BURRS AND BRUSH SWAMP EDGES TO A MAXIMUM OF .015
5. ALL INSIDE CORNERS TO BE .015 RADIUS MAX
6. COUNTERSINK 90 DEGREE ALL TAPPED HOLES TO MAJOR DIAMETER
7. COUNTERSINK 90 DEGREE APPROXIMATELY 80% DEEP ALL DRILLED HOLES
8. PART NUMBER, DRAWING NO., PLUS CHG. NO. PLUS SERIAL NO. 1 TO BE CLEARLY MARKED ON THE PART ITSELF
9. ALL ALUM. WELDING DONE BY A GTAW PROCESS USING 2% THORIATED TUNGSTEN AND 90% ARGON GAS AND ERW WELDING PER SPEC. PER AWS AS 10-80
10. NO FLUOR BASED CUTTING FLUIDS ALLOWED. APPROVED MACHINING LUBRICANT QUINOLIC NESTIC METAL MONOR, PRINCETON, N.J.
11. PART WEIGHS 183 LB.

ITEM NO.	QTY	DESCRIPTION	MATERIAL
1	1	3/8" THK PLATE	6061 T6
2	1	1/2" B I-BEAM ALUM ASSOCIATION	6061 T6
3	1	1/2" THK PLATE	6061 T6
4	1	1/2" THK PLATE	6061 T6
5	1	1/2" THK PLATE	6061 T6
6	1	1/2" THK PLATE	6061 T6
7	1	1/2" THK PLATE	6061 T6

CAD GENERATED DRAWING DO NOT MANUALLY EDIT DO NOT SCALE DRAWING		HYTEC, INC BSC BELLOWS REMOVAL I-BEAM JIG
D972472-1		D972472 D 1 of 1

912472
3 of 3

1/20/1999 16:39 5056625179 HYTEC PAGE 10