ASSEMBLY SEQUENCE:
1) WELD ITEM 2 (4X) 8.0 OD FLANGE TO ITEM 4.
2) WELD ITEM 3 WRAPAROUND TO ITEM 3 PORT RING.
3) WELD ITEM 1 (2X) FACE FLANGE BLANK TO ITEM 3.
4) MACHINE GROOVES IN ITEM 1 AS SHOWN IN DETAIL B.

NOTES:
1. FULL PENETRATION WELD. HELOM LEAK CHECK.
2. FINISH MACHINE FLANGE ID AND THE WELD, FLUSH WITH TUBE ID AT 18.90° OD DIAMETER BEFORE LEAK CHECK.
3. CLOCK BOLT HOLES END TO END AS SHOWN.
4. PLACE SKIP WELDS BETWEEN EVERY OTHER BOLT HOLE.
5. VIBRA-ETCH OR SCRIBE PART NUMBER AND REVISION APPROXIMATELY WHERE SHOWN.
6. FINAL CLEANING PER SLAC PLATING SHOP PROCESS SPECIFICATION C03, SLAC PUB 07-03-04-00, OR EQUIV.
7. REF - THE O-RING TO BE USED ON THIS ASSEMBLY WILL BE PARKER 2-469 VITON, AND THE RF SEAL WILL BE BAL SEAL PART NO. XST1226_F107L(C)(C)(20.000)+(31880R-0902-1)

ESTIMATED MASS: 87.723 lbm