

5

4

3

2

1

REVISIONS			
ZONE	REV	DESCRIPTION	DATE
	B	ADDED WEB	6/5/2003
	C	CHANGED GROOVE DIAMETERS	9/25/2003

D

$\phi 19.740$

$\phi 19.759$ GROOVE ID

$\phi 19.925$ GROOVE OD

SECTION A-A
SCALE 1 : 4

C

24X .060

24X .120

64X #4-40 X 3d Ph Br Helicoils

$\phi 20.250$ B.C.

$\phi 20.500$

$\phi 19.500$

$\phi 18.500$

B

A

A

(19.500 DIAMETER)

(19.759 DIA)

(19.925 DIA)

2X CHAMFER 45 DEG X .015

.040

.275

45°

.015

(19.740 DIA.)

.040

.375

.188

2X .060

2X 30°

2X CHAMFER 45 DEG X .020

DETAIL B
SCALE 2 : 1

A

NOTES:
1. BREAK OD CORNERS 45 DEG X .025.
2. CENTER WEB TO BE REMOVED POST BRAZING.

UNLESS OTHERWISE SPECIFIED:					
DIMENSIONS ARE IN INCHES DECIMAL TOLERANCES: .X ±.030 .XX ±.015 .XXX ±.005					
ANGULAR TOL: ± 1° SURFACE ROUGHNESS R_a ✓					
INTERNAL AND EXTERNAL SURFACE INTERSECTIONS SHALL BE UNIFORMLY FINISHED WITH CHAMFER .005/.010 X 45° OR RADIUS .005/.010. CHAMFER ALL THREADED HOLES 110% OF MAJOR DIAMETER X 45°					
MATERIAL:	3003 Aluminum				
FINISH:	N/A				

High Precision Devices				
1668 Valtec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com				
TITLE: p02101-066 Ln2 Shield can flange				
CONFIGURATION: 0-Default				
SIZE	QTY PER ASSM:	SCALE:	SHEET	REV
B	1	1:4	1 OF 1	C
DATE:	DRAWN BY:			
5/17/2004	C. Danaher			