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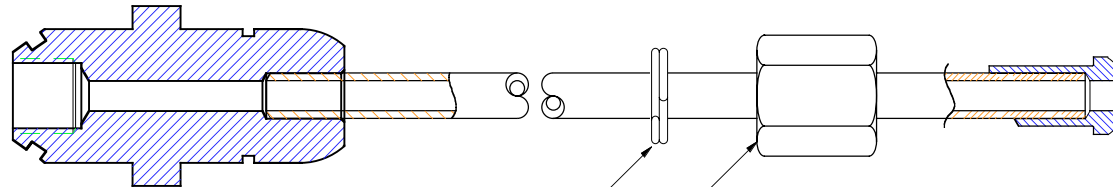
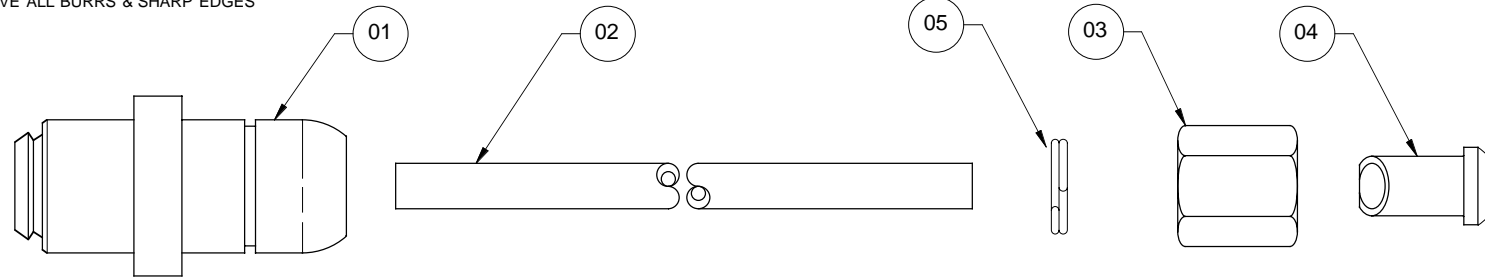
NOTES:

- 1. MATERIAL: SEE COMPONENT SPECIFICATIONS.
- 2. FINISH: AQUA-POLISH, BRIGHT-DIP OR EQUIVALENT
- 3. CLEAN: PER BRAZING PROTOCOL GAP-003.
- 4. MARKING: UNLESS OTHERWISE SPECIFIED, PER IN-HOUSE DOC. ESR-005.

REVISION HISTORY

REV	DATE	E. C. O. / APPR.	NOTES
A	10-02-01	PLM	DRAWING SHOWS REV A PARTS
B	11-11-11	HBS / PLM	ADDED SPLIT-RING TO ASSY. DETAIL

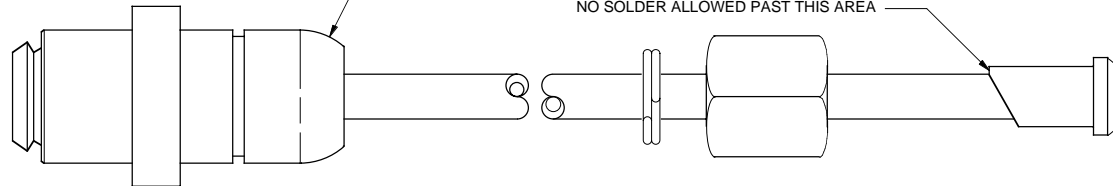
REMOVE ALL BURRS & SHARP EDGES



NO SOLDER ALLOWED ON NUT OR SPLIT-RING

NO ALLOWED SOLDER PAST RADIUS

NO SOLDER ALLOWED PAST THIS AREA



ASSEMBLY NOTES:

- 1. STAGE 1: BRAZE (SILVER SOLDER) TUBE (ITEM 02) TO FITTING (ITEM 01).
- 2. STAGE 1: ASSEMBLE NUT (ITEM 03) ON TUBE WITH THREADS FACING SMALL CONE FITTING.
- 3. STAGE 1: BRAZE (SILVER SOLDER) TUBE TO FITTING (ITEM 04).
- 4. STAGE 1: ASSY. MUST BE FREE OF ALL POST BRAZING OXIDIZING BLEMISHES BY FINISHING PROCESS

REF	QTY	DWG / PART NO.	REV	SUB-ASSY.	NOMENCLATURE
01	01	0TA54-0205-00	A	-	FITTING, CGA-540 NIPPLE
02	01	19606-0003-16	-	-	TUBE, 1/8" OD X 8" LONG COPPER
03	01	00VEN-0042-00	-	-	NUT, AN805-3 (VENDOR ITEM)
04	01	00VEN-0040-00	-	-	FITTING, AN800-3 NIPPLE (VENDOR ITEM)
05	01	09004-0001-00	-	-	SPLIT-RING 0.380 X 0.288 X 0.068 BRASS

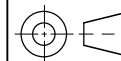
UNLESS OTHERWISE SPECIFIED DIMS ARE IN INCHES. TOLERANCES ARE:

0.X ±0.015 ANGLES FRACTIONS 63/

0.XX ±0.010 ± 0.5° ± 1/64

0.XXX ±0.005

THIRD ANGLE PROJECTION.



<CR> KEY CHARACTERISTICS PER CORP. DOC: ESR-001

NO. -0-



MOUNTAIN HIGH E&S CO. REDMOND, OR. USA

INTERPRET DIM AND TOL PER ASME Y14.5

ISSUED:	11-23-99	MATERIAL:	NOTE 1	ASSY, TUBE CGA-540-N TO AN800-3
DRAWN:	TEM	FINISH:	NOTE 2	
ENGINEER:	PLM	CLEAN:	NOTE 3	DWG. #: TA54-101-000
APPR:	PLM	MARKING:	NOTE 4	REV B
			SIZE A	SHEET 1 OF 1
			DO NOT SCALE DRAWING	

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