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

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.

REMOVE ALL BURRS & SHARP EDGES

NO SOLDER ALLOWED ON NUT OR SPLIT-RING

NO ALLOWED SOLDER PAST RADIUS

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

ASSY, TUBE CGA-540-N TO AN800-3

11-23-99

MATERIAL: NOTE 1
FINISH: NOTE 2
CLEAN: NOTE 3
MARKING: NOTE 4

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

DO NOT SCALE DRAWING SHEET 1 OF 1