

Outer Vacuum Tube Technical Drawings for CVSC

NOTE: These archival drawings were generated from 3/2/1972 to 12/8/1975 and are suitable for reference only.

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69001	Current images		
69001	SDZ36109749_A_0	6/7/1972	CONTAINER ASSY CORE TUBE (VACUUM LRL)
69001	SDZ36109749_NC_0	3/20/1972	CONTAINER ASSY CORE TUBE (VACUUM LRL)
73001	Current images		
73001	SDZ36115077_NC_0	10/14/1975	CAN, STORAGE – DRILL STEM AND DRIVE TUBE
73001	SDZ36115077_NC_3917	12/8/1975	CAN, STORAGE – DRILL STEM AND DRIVE TUBE

1. Current images outer container for 69001



69001



69001

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2. SDZ36109749_A_0

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3. SDZ36109749_NC_0

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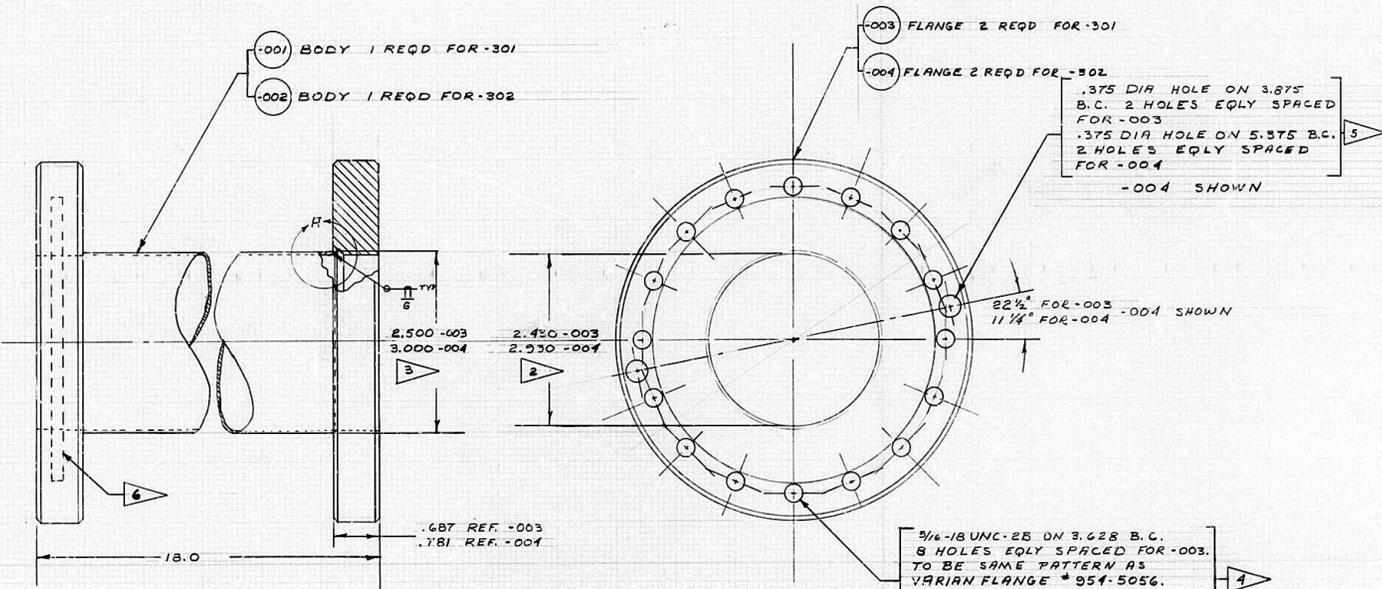
4. Current image outer container for 73001



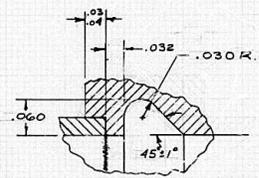
Outer Vacuum Tube Technical Drawings for CVSC

5. SDZ36115077_NC_0

12-24-75 N.W. AD



-301 ASSY
-302 ASSY
(-302 SHOWN)



DETAIL A
SCALE .01/1
TYP FOR -003 & -004

ALTERED		ITEM		
QTY	PART NUMBER	DESCRIPTION	MATERIAL	SPECIFICATION
2	-004	FLANGE, LARGE	MAKE FROM VARIAN FLANGE 354-5051	1
- 2	-003	FLANGE, SMALL	MAKE FROM VARIAN FLANGE 354-5056	1
1	-002	BODY, LARGE	304 SST TUBE 3.0 O.D. X .035 WALL X 16.5	MIL-T-8504
- 1	-001	BODY, SMALL	304 SST TUBE 2.5 O.D. X .035 WALL X 16.8	MIL-T-8504
-	-302	CAN, LARGE		
-	-301	CAN, SMALL		

- NOTES:
- 6 ENGRAVE WITH PIN & S/N 1/8 LETTERS PER MSC-SPEC-M-1.
 - 5 ALIGN WITH LIKE HOLES IN OTHER END FLANGE.
 - 4 CUT THREADS OVERSIZE .005/.010 ON PITCH DIAMETER.
 - 3 ADJUST AS REQD TO MATCH -001 O.D. FOR -301 OR -002 O.D. FOR -302.
 - 2 ADJUST AS REQD TO MATCH -001 I.D. FOR -301 OR -002 I.D. FOR -302.
 - 1 VARIAN VACUUM DIV., PALO ALTO, CA.

VACUUM LEAK CHECK AFTER FINISHING WITH HELIUM LEAK DETECTOR. LEAKAGE MUST BE LESS THAN 2×10^{-10} CC/SEC HELIUM.
2. ELECTRO POLISH TO BRIGHT FINISH INSIDE/OUT.
1. WELD PER MIL-W-8611 ACCEPTANCE PER MIL-W-22248 CLASS 3.

NOTES: UNLESS OTHERWISE SPECIFIED

DIMENSIONAL TOLERANCE UNLESS NOTED OTHERWISE 0 = .10 .00 = .02 .000 = .005 ANGULAR = 30°	SIGNATURES	DATE	NATIONAL AERONAUTICS & SPACE ADMINISTRATION LYNN B. JOHNSON SPACE CENTER HOUSTON, TEXAS
	DR. V. LYON ENG. W. LYON CH. W. LYON		
SURFACE FINISH IN MICRONS UNLESS NOTED OTHERWISE 25	APP. W. LYON		CAN, STORAGE - DRILL STEM AND DRIVE TUBE
	AUTH. W. LYON		
NEXT ASSEMBLY	W. LYON 1/6/75		CODE IDENT. NO. 21356 SCALE 1/1 ENGR DIV 304 SHEET

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6. SDZ36115077_NC_3917

NUMBER 3917		DATE 12/8/75	DRAWING CHANGE NOTICE			SHEET 1 OF 1
DRAWING NO. SDZ36115077		REV. N/C	REASON FOR CHANGE EASE OF FABRICATION		ORIGINATOR W. LYON	DATE 12/8/75
TITLE CAN, STORAGE - DRILL STEM & DRIVE TUBE			EFFECTIVITY		APPROVED W LYON	12/8/75
PROJECT LRL	DRAWING TO BE CHANGED	<input checked="" type="checkbox"/> YES			<input type="checkbox"/> NO	
DISPOSITION OF EXISTING MATL/PARTS			EFFECTIVITY		AUTH. Wattner	12/8/75
USE AS IS <input type="checkbox"/>	REWORK <input checked="" type="checkbox"/>	MODEL -301	SERIAL NO. 1001 & SUBS			
RETURN TO STOCK <input type="checkbox"/>	CONDEMN <input type="checkbox"/>					

RELEASED
 Date **12-8-75** Rev **NC**

DESCRIPTION OF CHANGE **CHANGE IN F/D ZONE B4**

DELETE REQUIREMENT FOR 5/16-18UNC-2B TAPPED HOLES FOR -003 & -004. USE STANDARD VARIAN FLANGE THRU HOLE & HOLE PATTERN.

DELETE FLAG NOTE 4

PART NUMBER	DESCRIPTION	MATERIAL	SPECIFICATION	CHANGE
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