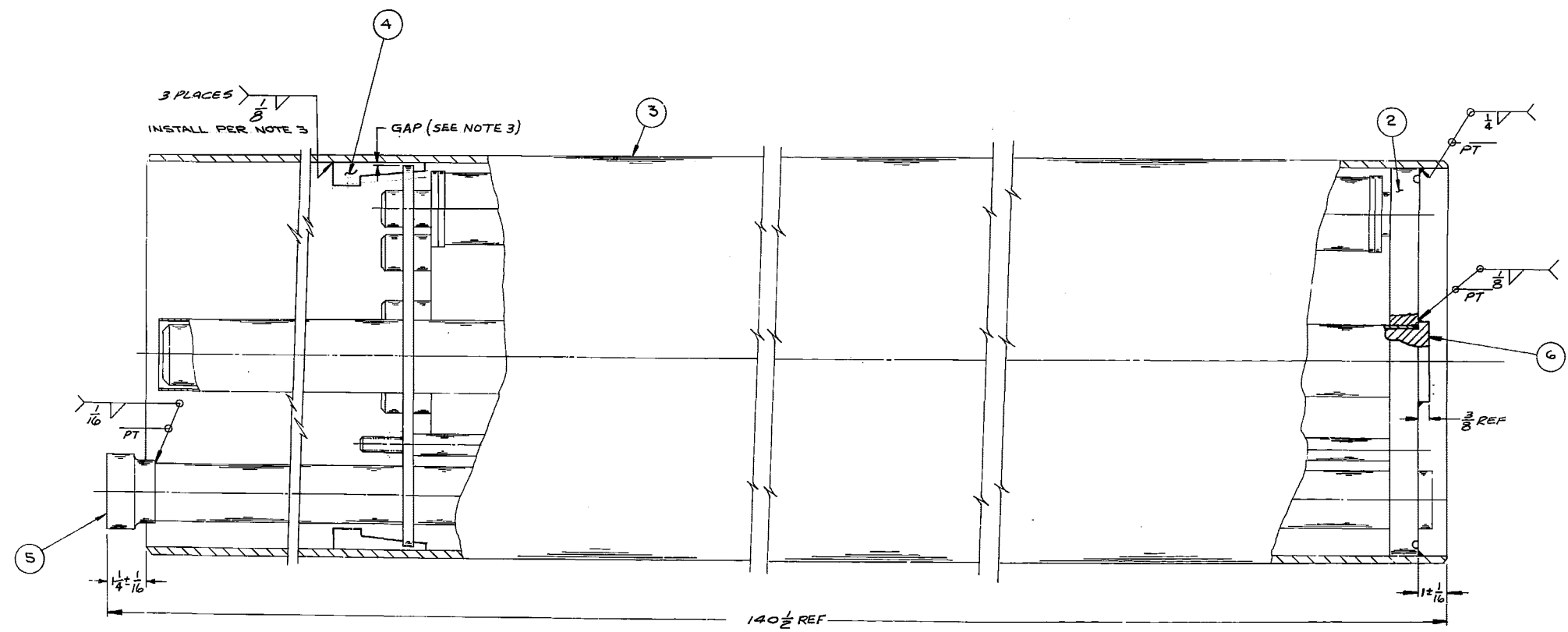


REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
1	ADDED WELD SIZE @ E-4 REV. PICTORIAL VIEW OF PT NO. 6, ADDED 3/8 REF @ D-4, DELETED NUT @ D-10	11/1/84	JW PCC
2	ADDED WELD SIZE @ D-12 REV. NOTE 2.	11/1/84	JW PCC
3	DWG. NO. FOR ITEM 2 WAS 1150963F, IN NOTE 3 AND WAS ANS	2-26 85	JW PCC

BILL OF MATERIAL				
PART NO.	QUAN.	DWG. NO.	DESCRIPTION	MATL SPEC.
1	1	1154020E	FILTER CANISTER SUB-ASSY	---
2	1	1095757D	FILTER BUNDLE ASS'Y.	---
3	1	1150945C	SHELL, FILTER CANISTER	---
4	3	1150960C	CHOCK BLOCK	---
5	1	1154050C	FERRULE, DRAIN TUBE	---
6	1	1150949C	POISON TUBE ASS'Y.	---



- NOTES:
- "PT" DENOTES A LIQUID PENETRANT EXAMINATION TO BE PERFORMED IN ACCORDANCE WITH ASTM E-165
 - WELD WIRE PER AWS 5.4 TYPE 316L OR 308L STAINLESS STEEL.
 - INSTALL CHOCK BLOCKS P/N 4, 3 PLACES AS SHOWN TO SET GAP BETWEEN UPPER SUPPORT PLATE AND SHELL WITHIN ± 1/2" OF EACH OTHER AT LOCATIONS OF CHOCK BLOCKS (TYP 3 PLACES)

① FILTER CANISTER SUB-ASSEMBLY

TOLERANCES UNLESS OTHERWISE SPECIFIED						
ALL DIMENSIONS ARE FOR PART TEMPERATURE OF 68°F						
	UP TO 6" INCL.	OVER 6" TO 12" INCL.	OVER 12" TO 24" INCL.	OVER 24" TO 48" INCL.	OVER 48" TO 14'-0" INCL.	OVER 14'-0"
DECIMAL DIMENSIONS	± .003"	± .005"	± .010"	± .015"	± .031"	± .062"
FRAC. DIM. MACH.	± 1/64"	± 1/32"	± 1/32"	± 1/16"	± 1/16"	± 1/8"
FRAC. DIM. UNMACH.	± 1/16"	± 1/16"	± 3/32"	± 1/8"	± 3/16"	± 3/16"
DIM. FOR BURNING	± 1/8"	± 1/8"	± 1/8"	± 1/8"	± 3/16"	± 3/16"
FLATNESS	.001" / IN. OF SURFACE UP TO .020" MAX				BREAK CORNERS	
PERPENDICULARITY	.002" / IN. OF SURFACE UP TO .020" MAX				1/64" R. MAX OR CHAMFER	
CONCENTRICITY	0.01" DIA.				CHAMFER ± 5°	
ANGULARITY	1° - 30°				CHAMFER ± 5°	
ALL MACHINED SURFACES TO HAVE 250/RHR FINISH UNLESS OTHERWISE NOTED						

DRAWN BY: FARMER
 CHECK'D BY: [Signature]
 PASSED BY: [Signature]
 APPROVED BY: [Signature]
 STD. SPEC. DATE: 8-31-84
 CONTRACT NO.

THIS DRAWING IS THE PROPERTY OF
 Lockheed & Wilson
 A Lockheed Company
 AND IS LOANED TO YOU UNDER THE CONDITION THAT IT IS NOT TO BE
 REPRODUCED OR COPIED IN WHOLE OR IN PART, OR USED
 FOR ANY PURPOSES WITHOUT THE WRITTEN PERMISSION OF LOCKHEED & WILSON.
 IF YOU HAVE ANY QUESTIONS REGARDING THIS DRAWING, PLEASE CONTACT THE
 DRAWING ENGINEER OR THE PROJECT ENGINEER.

FILTER CANISTER SUB-ASSEMBLY
 SCALE: 6" = 1'-0"
 DRAWING NO. 1154020 E
 REV. NO. 3

1	FILTER CANISTER ASS'Y	1154018E
2	DRAWING TITLE	DWG. NO.
3	REFERENCE DWGS	