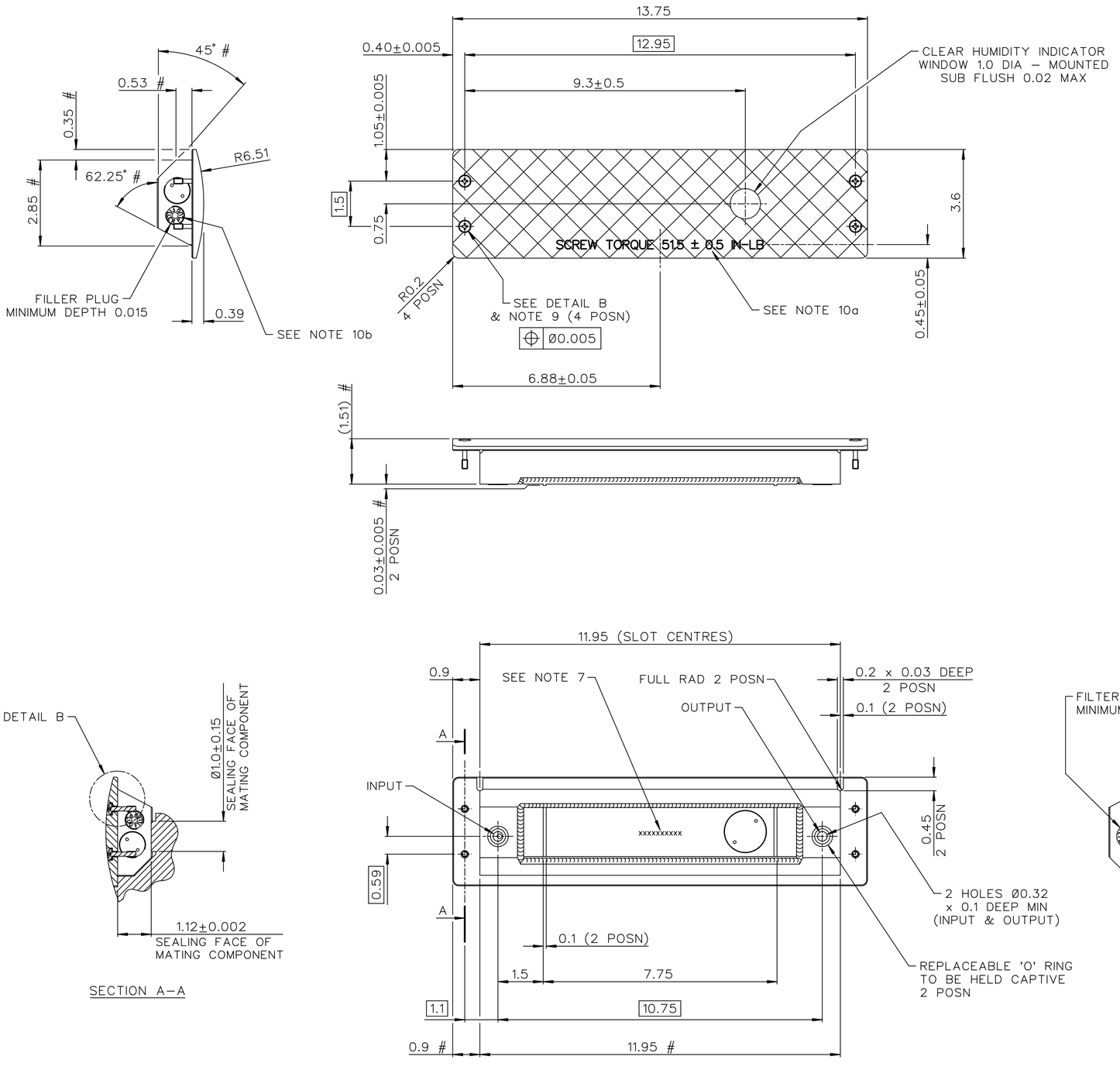
DRAWING NUMBER
BL/D 8150 INST
USED ON

THIRD ANGLE PROJECTION



NOTES

1. THIS DRAWING TO BE READ IN CONJUNCTION WITH PRODUCT SPECIFICATION REF No: M002.
2. ALL THREADS TO BE UNIFIED TO BS1580.
3. ALL BURRS AND SHARP EDGES TO BE REMOVED, 0.020 MAX.
4. A FILLET RADIUS OR CHAMFER OF 0.002 TO 0.020 IS PERMITTED IN THE CORNERS OF BLIND HOLES, RECESSES AND STEPS UNLESS OTHERWISE STATED.
5. ALL DIMENSIONS APPLY AFTER FINSH.
6. SURFACE TEXTURE TO BE 63µin OR BETTER UNLESS OTHERWISE STATED.
7. PART TO BE MARKED WITH PART NUMBER VZ–11–0014–111 ISSUE/VERSION AND SERIAL No. IN ACCORDANCE WITH DEF STAN 00–970 PART 1/2 SECTION 4.2 USING METHOD 3, PRIOR TO FINISH IN APPROXIMATE POSITION INDICATED.
8. FINISH: CHROMATE CONVERSION TO MIL–C–5541 CLASS 3. FOLLOWED BY, PAINT ALL SURFACES UNLESS OTHERWISE STATED. PAINT WITH ONE COAT OF PRIMER PER MIL–PRF–23377, TYPE II, CLASS C, DRY FILM THICKNESS 0.6 TO 0.9 MILS. PAINT TOP COAT PER MIL–PRF–85285 TYPE 1 LUSTERLESS GREY COLOUR No. 36375 TO FED–STD–595B. DRY FILM THICKNESS 1.7 TO 2.3 MILS. IN AREAS INDICATED THUS: ▨ AND ADJACENT EDGES.
9. CAPTIVE FIXING DATA: NAS8103U–13 SCREW, PAN HEAD, CRUCIFORM RECESS, 10–32 UNJF x 0.81 LONG, CRES, NON LOCKING, RAW. PASSIVATE TO ANS–QQ–P–35 TYPE II. MODIFIED AS DETAILED – MACHINED SURFACES TO BE PASSIVATED TO ANS–QQ–P–35 TYPE II. NAS620C10L WASHER.
10. a) SPRAY STENCIL MARKINGS USING PAINT PER MIL–PRF–85285 COLOUR No. 36320, LOW REFLECTANCE, DARK GREY PER FED–STD–595B. DRY FILM THICKNESS 1 TO 2 MILS. ALL LETTERS SHALL BE VERTICAL GOTHIC STYLE AND NUMBERS SHALL BE ARABIC STYLE SPACED AND CENTRED PER MIL–STD–130. LETTER HEIGHT SHALL BE 0.35±0.03 AND LINE WIDTH 0.05±0.01 – CHARACTERS TO BE CENTRALLY DISPOSED ABOUT CENTRE LINES AS SHOWN.

    b) AS ABOVE EXCEPT:– LETTER HEIGHT SHALL BE 0.13±0.03 AND LINE WIDTH 0.03±0.01 IN APPROXIMATE POSITION SHOWN.
11. NINE DIMENSIONS INDICATED THUS # APPLY TO NON RELIEVED SURFACES. RELIEF (WEIGHT) OF THESE SURFACES, WITHIN THE SPECIFIED DIMENSIONS, IS PERMISSIBLE.

			5491	6	9/7/99
6041	11	14/5/03	5470	5	5/6/99
6038	10	9/5/03	5445	4	13/4/99
5985	9	9/9/02	5434	3	30/3/99
5983	8	2/9/02	5376	2	6/1/99
5902	7	11/2/02		1	22/11/98

DRAWN	CHECKED	MOD No	ISSUE	DATE	MOD No	ISSUE	DATE
LJ		CERTIFIED					

MATERIAL	PROTECTIVE FINISH	TOLERANCES	CUSTOMER	CONTRACTORS DRAWING REF
ALUM ALLOY	SEE NOTES 8 AND 9	GEN TOL ±0.01 ANG TOL ±1°	BROWNELL LTD. LONDON NW10	—
		DIMENSIONS IN INS	TITLE	DRAWING NUMBER
		SURFACE ROUGHNESS SEE NOTE 6	PIPE LINE DESICCATOR	BL/D 8150 INST
		SCALE 1 : 2		

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