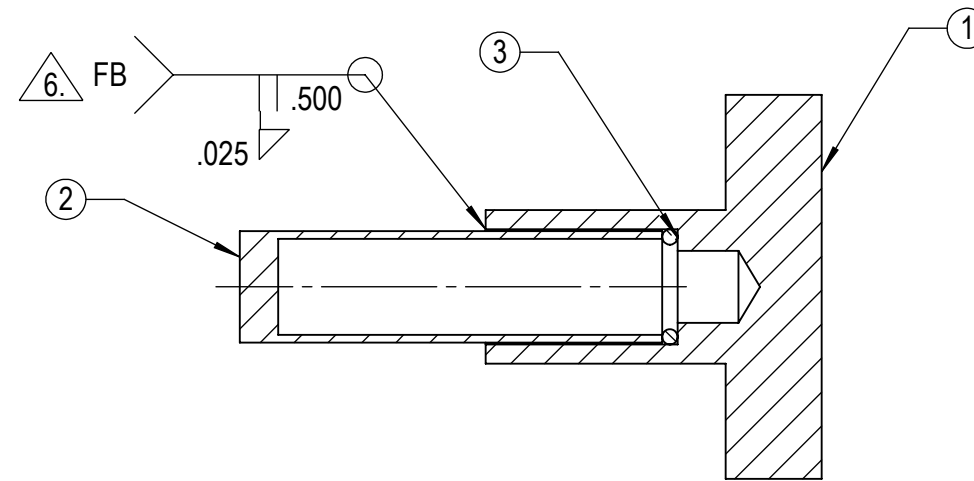
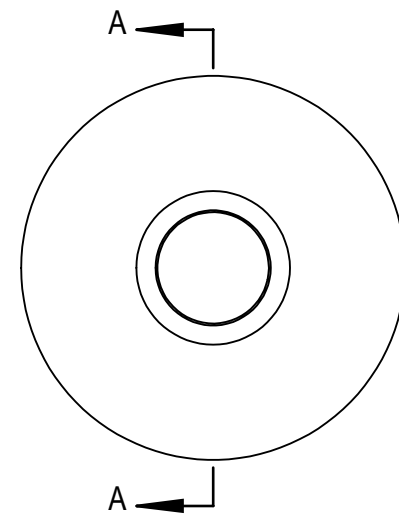


REVISION			
REV.	DESCRIPTION	DATE	APPROVED



SECTION A-A

1. VACUUM FURNACE BRAZE PER AMS 2678, CLASS B JOINT, MACRO-ETCH SHALL BE 100% VOID FREE.

2. DYE PENETRANT INSPECT BRAZE JOINT PER ASTM E1417.

3. PROCESS PARTS IN CLASS 5 FURNACE PER AMS 2750.

4. FURNACE BURNOUT PER FLAMING NEWSPAPER TECHNIQUE IS REQUIRED PRIOR TO PROCESSING PARTS.

5. APPLY ALUMINUM BRAZING FLUX, TYPE FB1A PER AWS A5.31 TO JOINT FAYING SURFACES PRIOR TO ASSEMBLY.

6. APPLY BRAZE FILLER METAL PASTE TO JOINT AS SHOWN TO ENSURE EVEN STRESS DISTRIBUTION THROUGH FILLET.

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	SPECIFICATION	QTY.
3	742-1	PRE-FORM	BALSi-2	AWS A5.8	1
2	6-2015	TUBE	ALUMINUM, 6061	ASTM B221	1
1	14-2015	FITTING	ALUMINUM, 6061	ASTM B 221	1

DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1994		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON .XX ± .010 .XXX ± .005 FRACTION ± 1/64 ANGLES ± 1/2 DEG. BREAK EDGES .005 - .015 SURFACE FINISH 100 RMS MINIMUM FILLET AND CORNER RADII .005 TO .015	DRAWN BY NOLAN BEAL	<b>ACME AEROSYSTEMS</b>	
			CHECKED		
		MATL	PROJECT ENGINEER CHRIS FLOCK	<b>BRAZE ASSEMBLY</b>	
		SPEC.	APPROVED		
USED ON		HEAT TREAT	DATE ISSUED	SIZE B	CODE IDENT. NO. 55725
NEXT APPLICATION		FINISH		DWG. NO. 20-2015	REV.
			DO NOT SCALE	2:1	SHEET 1 OF 1