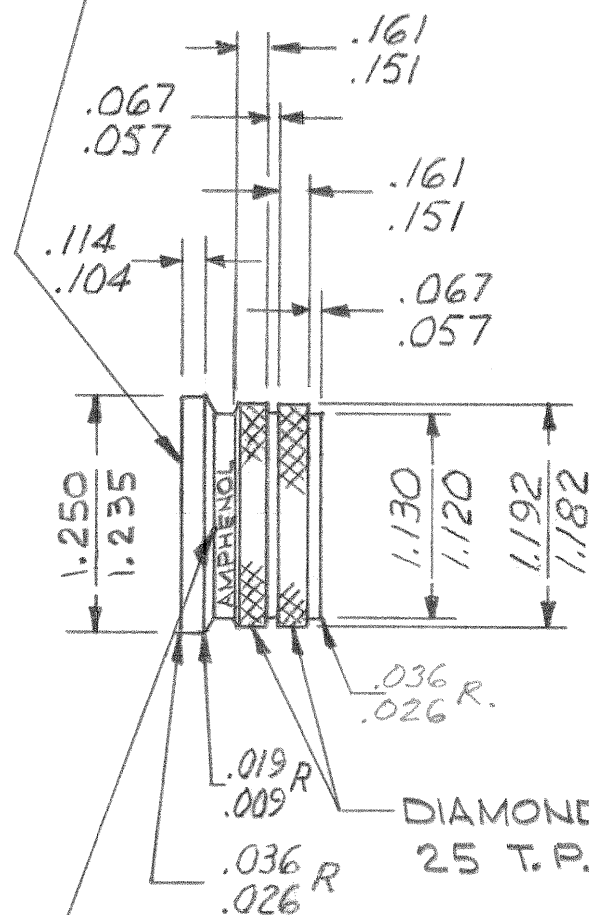


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MUST BE SHARP AS POSSIBLE
AND FREE OF BURRS. DO NOT
MARR THIS CORNER OR
SURFACE WHEN
THREADING.

THIS IS A BEARING SURFACE
MUST BE FREE OF BURRS
OR TOOL MARKS



UNDERCUT
SEE DETAIL 'A'

IMPORTANT

UNDERCUT
SEE DETAIL

1-20 UNEF-2B THD
USEABLE THREADS MUST
RUN TO 2 THDS. (.100) MIN.
FROM BOTTOM OF HOLE

STAMP AMPHENOL
AS SHOWN

BURR PERMISSIBLE IN THE
UNDERCUT AREA ONLY.
BURR MUST BE ABOVE DIA.
.883/.878
DETAIL 'A' (OPTIONAL)

UNLESS OTHERWISE SPECIFIED
LINEAR DIMENSIONS ARE IN INCHES
TOLERANCES: .XXX±.010,
.XX±.03, .X±.1, ANGLES ± 2°
OTHER STANDARDS PER 9-3800
AND DOD-D-1000.

FINAL ASSEMBLY NEXT USED ON
MATERIAL ALUMINUM
AMS-4150 OR AMS-4082
FINISH AMPHENOL 9-3047
APPLY 9-7568 OR 9-8625
TO THREADS

DRAWN C.E.W.

DATE
4-29-52

CHECKED

APPROVED

EPA/DOR

ENGINEERING RELEASE

NO. C/N 5538

DATE
7-16-52

INDUSTRIAL ENGRG APPD.

DESIGN ACTIVITY APPD.

EXPERIMENTAL NO.

REVISIONS

SYM	ZONE	DESCRIPTION	DATE	APPROVED
E		REDRAWN, NO CHANGE WAS "A" SIZE	7-29-85	TH
F		ADDED OPTIONAL U' CUT TO FRONT FACE ECN 46102	12-8-86	
G		BCO DOCUMENT NOS. INCORPORATED CHANGED FSCM NO. TO 77820 ECN: 75005-342	9/11/87	TH
H		(CL II) SEE CHG NOTICE ECN: 23022	4/28/90	Shepler Prescott DM
J		(CL II) SEE CHG NOTICE ECN: 26324	6/2/92	McElligott DM
K		(CL II) SEE CHG. NOTICE ECN: 27205	11/31/92	Casey 7/8/04 g.c.d.
L		(CL II) WAS 9-8563 (9-8554) ECN: 94673	7/8/04	g.c.d.
M		(CL II) REM'D 9-SPECS ECN: 97766	10-12-06	JONES

NOTE:

SEE THREAD SPEC. 9-8554 FOR PITCH DIA.
REMOVE ALL BURRS
DO NOT SANDBLAST

ITEM NO.	PART OR IDENTIFYING NO.	QTY REQD	NOMENCLATURE OR DESCRIPTION
LIST OF MATERIALS OR PARTS LIST			



Amphenol
Products

Commercial & Industrial Operations
Lisle, IL 60532

TITLE

COUPLING RING

SIZE

B

FSCM NO.

77820

10-825905-17

REV

M

SCALE FULL

WT: EST.

ACT.

SHEET

OF