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NOTES:

1. DOUBLE BAG & TAG PER MIL-STD-130 AS: 65113-2A07936-101 AND APPLICABLE REV. LETTER.
 2. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1982.
 3. FN 2,3,4,5,6 & 7 SHALL BE CLEANED PER MIL-STD-1246, LEVEL 200A OR EQUIVALENT PRIOR TO WELDMENT.
 4. FN 2,3 & 5 SHALL BE CUT TO FIT ASSEMBLY INTO TOOLING FIXTURE FN 8.
 5. DIMENSIONS AND VIEWS REPRESENTS INSTALLATION IN FN 8 WITHOUT PANEL THERMAL ISOLATORS OF FN 2 AND FN 3.
 6. WELD PER SAE-AMS-STD-2219 CLASS B OR LAC 3853-050200 WITH He LEAK CHECK. FILLER ALLOY TO BE SPECIFIED IN WELD PROCEDURE. WELD ROOT PENETRATION OF FN 6 AND FN 7 TO BE .015 MINIMUM. WELD PROCEDURE TO BE APPROVED BY LMSS.
- POSITIVE GAS PURGE SHALL BE MAINTAINED DURING WELDMENT TO MINIMIZE CONTAMINATION. PENETRANT INSPECTION TO BE PERFORMED AFTER PROOF TEST AND LEAK CHECK.
7. CLEAN PER MIL-STD-1246 LEVEL 200A. INLET AND OUTLET QUICK CONNECTS SHALL BE PROTECTED WITH CAPS.

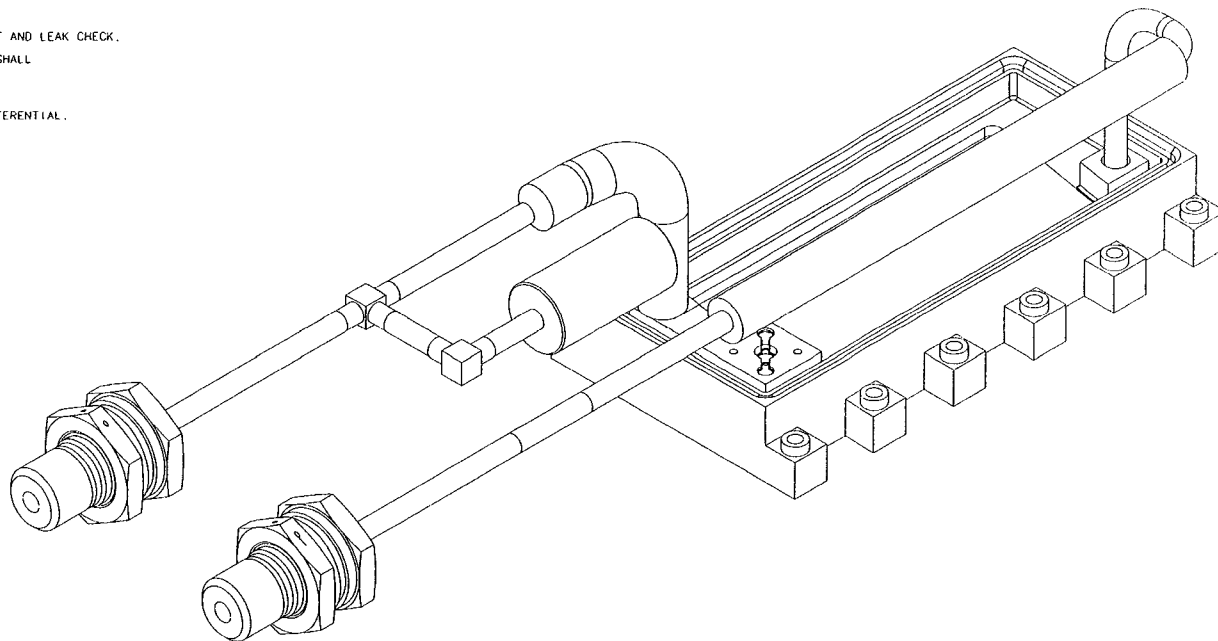
PERFORMANCE:

8. LEAKAGE: 1X10E-6 SCCS HELIUM MAXIMUM AT ONE ATMOSPHERE PRESSURE DIFFERENTIAL.
9. TEMPERATURE: OPERATING ENVIRONMENT 15°C TO 50°C.
NON-OPERATING ENVIRONMENT -20°C TO 65°C.
FLUID TEMPERATURE 0.5°C TO 50°C.
10. PRESSURE: 121 PSIG MAXIMUM OPERATING PRESSURE.
-15 PSIG MINIMUM OPERATING PRESSURE.
242 PSIG PROOF.
484 PSIG ULTIMATE.
11. PRESSURE DROP: 1.5±0.1 PSID (10.3 kpa ±0.7 kpa) AT 21 LB/HR
(9.5 kg/hr) water at 0.5-45.5 °C.
12. FLUID: DEIONIZED WATER MIL-STD-1246A LEVEL 300.

TESTING:

13. EACH ASSEMBLY SHALL BE SUBJECTED TO THE FOLLOWING TEST:
 - A) LEAK CHECK TO VERIFY MAXIMUM LEAKAGE RATE SPECIFIED HEREIN.
 - B) PROOF PRESSURE FOR A DURATION OF THREE (3) MINUTES MINIMUM.
 - C) LEAK CHECK.
 - D) VERIFICATION OF CLEANLINESS LEVEL SPECIFIED HEREIN.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APVD
	A	UPDATED CONFIGURATION	12/06/01	DF
		DELETED PAGE 3		
		WAS: PAGE 4, 15; PAGE 3		



-101 HEAT EXCHANGER/ COOLANT PLUMBING ASSY

AR	QTY	CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL DESCRIPTION OR NOTE	MATERIAL SPECIFICATION	ZONE	FINO	
			6	WELD FILLER METAL				9	
			-601	TOOLING FIXTURE			5	8	
			2A07758-101	HX TOP				7	
			2A07759-101	HX BOTTOM				6	
			2A07909-101	HX SUPPLY PLUMBING				5	
			2A07908-101	FLOW REDUCER				4	
			2A07899-101	LC SUPPLY ASSY				3	
			2A07898-101	LC RETURN PLUMBING ASSY				2	
			-101	PLUMBING ASSY				1	
			-101	PARTS LIST					

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION SPACE STATION BIOLOGICAL RESEARCH PROJECT AMES RESEARCH CENTER		UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES. TOLERANCES ON: FRACTIONS: ± 1/16 DECIMALS: .X ± .1 .XX ± .01 .XXX ± .005 ANGLES: ± 2 DEG	DATE 02/12/01 DWG. J. MIX APVD ENGRG J. MIX CHWR APVD D. FRANK	Lockheed Martin Missiles & Space Company PALO ALTO, CALIFORNIA HEAT EXCHANGER/ COOLANT PLUMBING ASSY SIZE: E 65113 SCALE: 2:1	DRAWING NO: 2A07936 REV: A SHEET 1 OF 3
REVISION STATUS OF SHEETS WILL ALL CARRY THE SAME REVISION LETTER		2A07923 INCUBATOR HEAT ASSY USED ON APPLICATION:	CONTR 7-100401-AC01 -01-ACB81220		

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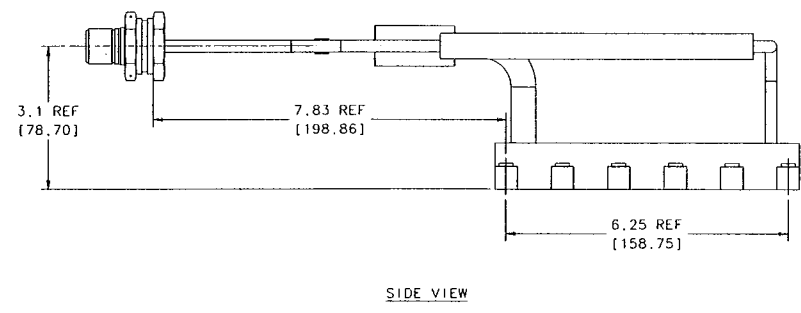
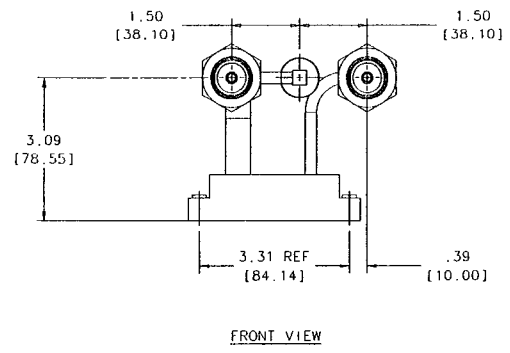
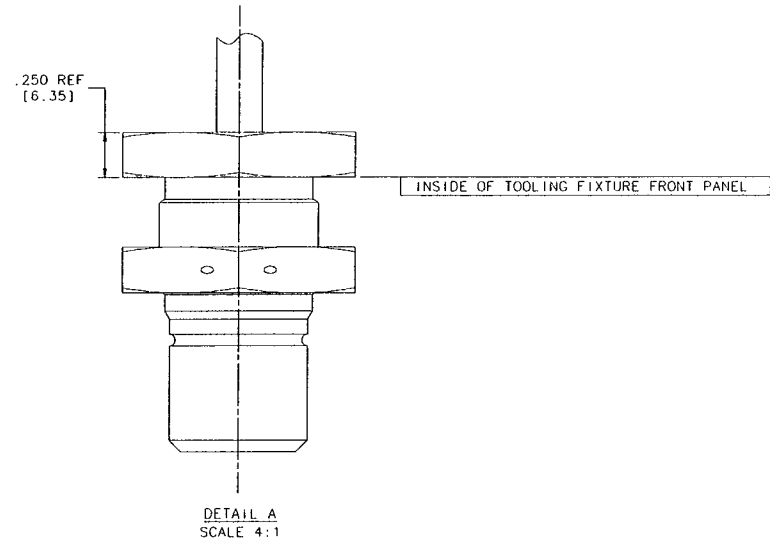
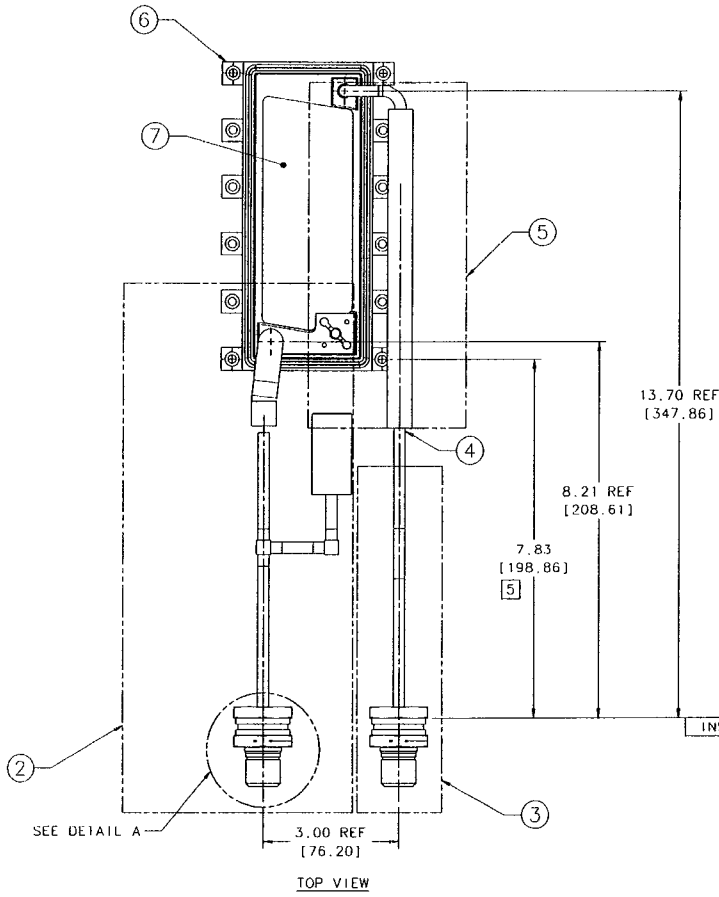
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EJRT KPG-CTDVG-0145-01X

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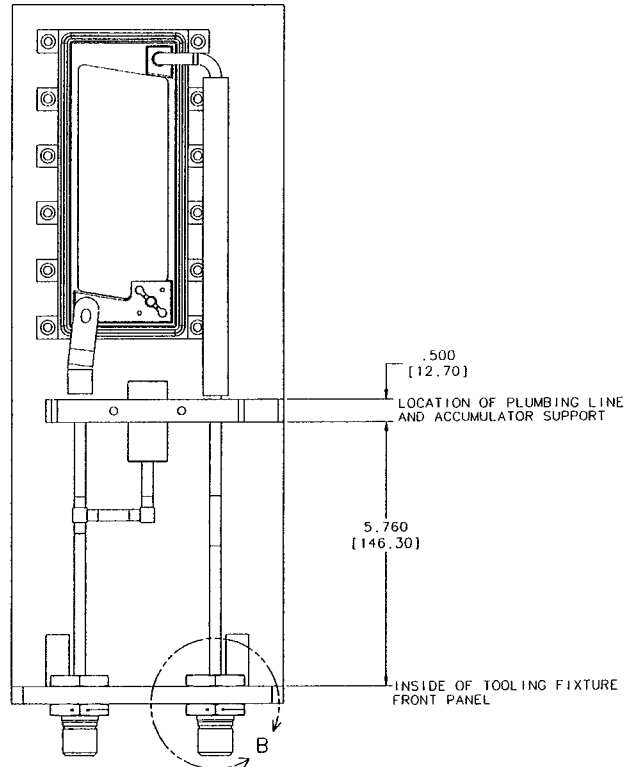
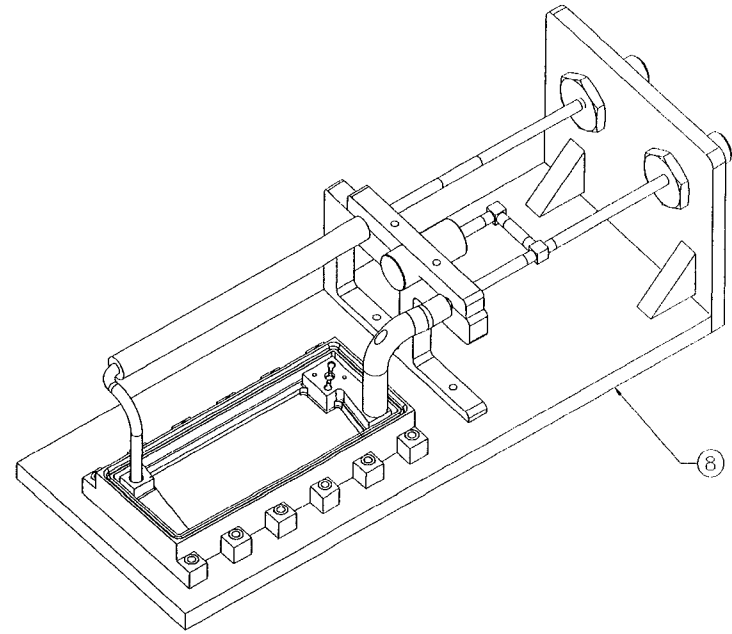
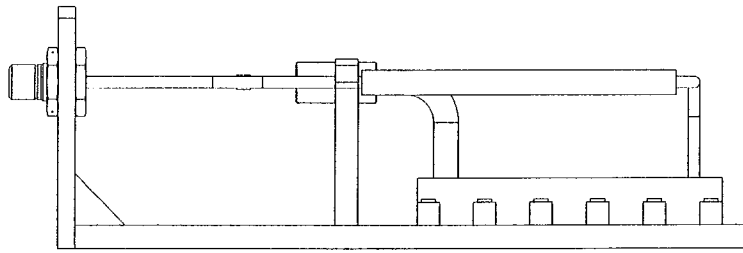
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APVD



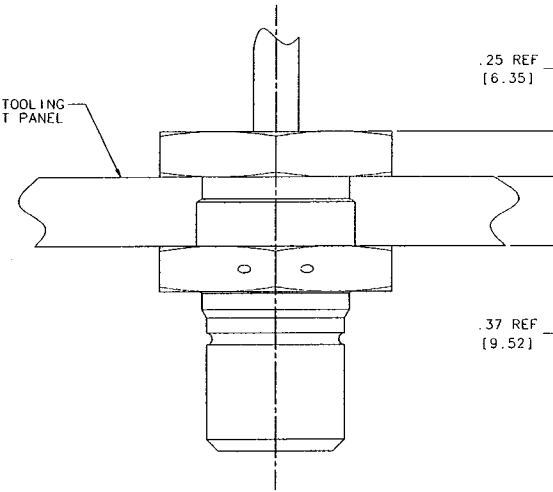
SIZE	CODE	DRAWING NO	REV
E	65113	2A07936	A
SCALE 1:1		SHEET 2	

65113 (REV 08) 2A07936 (REV 08) 1/8"

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APVD



INSIDE OF TOOLING
FIXTURE FRONT PANEL



DETAIL B
SCALE 4:1

-601 TOOLING FIXTURE

SIZE	CODE	DRAWING NO	REV
E	65113	2A07936	A
SCALE 1:1		SHEET 3	

65113 Rev. 8 2A07936 3 of 3