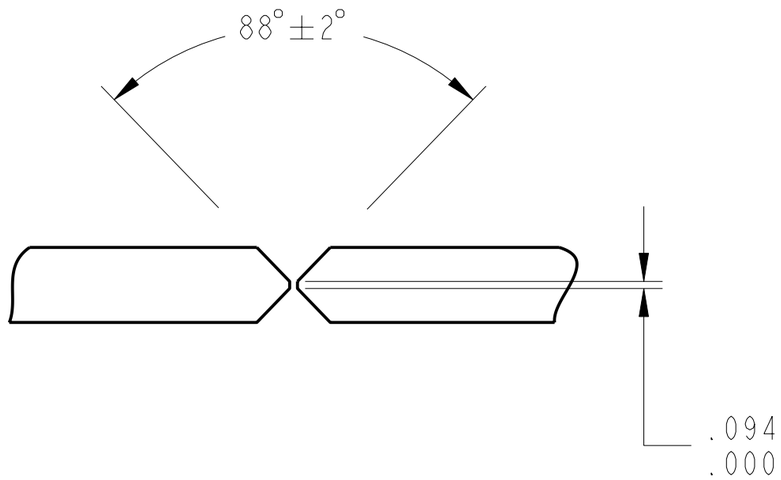
1. MEETS AWS TF.1-1.B.1 PER WELDING PROCEDURE SPECIFICATIONS (QW-482).

2. ROOT GAP DIMENSIONS ARE SPECIFIED ON THE WELD PROCEDURE SPECIFICATIONS (WPS).



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CHG	ZONE	DESCRIPTION	APP/DATE
B	XX	SEE ECO CHANGE NUMBERS AIX-ECR-131, AIX-ECR-122	CMB 09/18/07
A	XX	REMOVE ROOT GAP DIMENSION	CMB 06/14/07

REVISIONS

PRIOR TO USE VERIFY THE INTENDED PURPOSE IN PDM ("FOR" ATTRIBUTE)

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCE ON	
.X	±
.XX	±
.XXX	±
FRACTION	±
ANGULAR	±
BREAK EDGES	

CONTRACT	
CONTRACTOR	
TASK ORDER	
DRAFTER	DEZ/G. DUTT
ENGINEER	SAIC/S. ANZALONE
DESIGNER	DES/K. BERGQUIST

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
JOHN H. GLENN RESEARCH CENTER
LEWIS FIELD
CLEVELAND, OHIO

ARES I-X

A931 DOUBLE V-GROOVE WELD PREP

PDM REL LEVEL: **Released** PDM REVISION: **B**

PDM DATABASE:

MODEL NAME: **060213MFA931**

CHECK FOR ANY OUTSTANDING ECO'S PRIOR TO USE

SIZE	DRAWING NUMBER	REV	BLDG	AREA
B	060213MFA931	B	50	HI BAY

UNITS: INCH

SCALE:	INITIAL REL DATE	SHEET	DISCIPLINE
1/1	03/23/2007	1 OF 1	MECHANICAL

PRO/E VERSION: Wildfire 2.0

SIZE B | DRAWING NUMBER 060213MFA931 | REV B

NAME:CBLASER OBJECT:060213MFA931 DATE:18-Sep-07 10:52:43