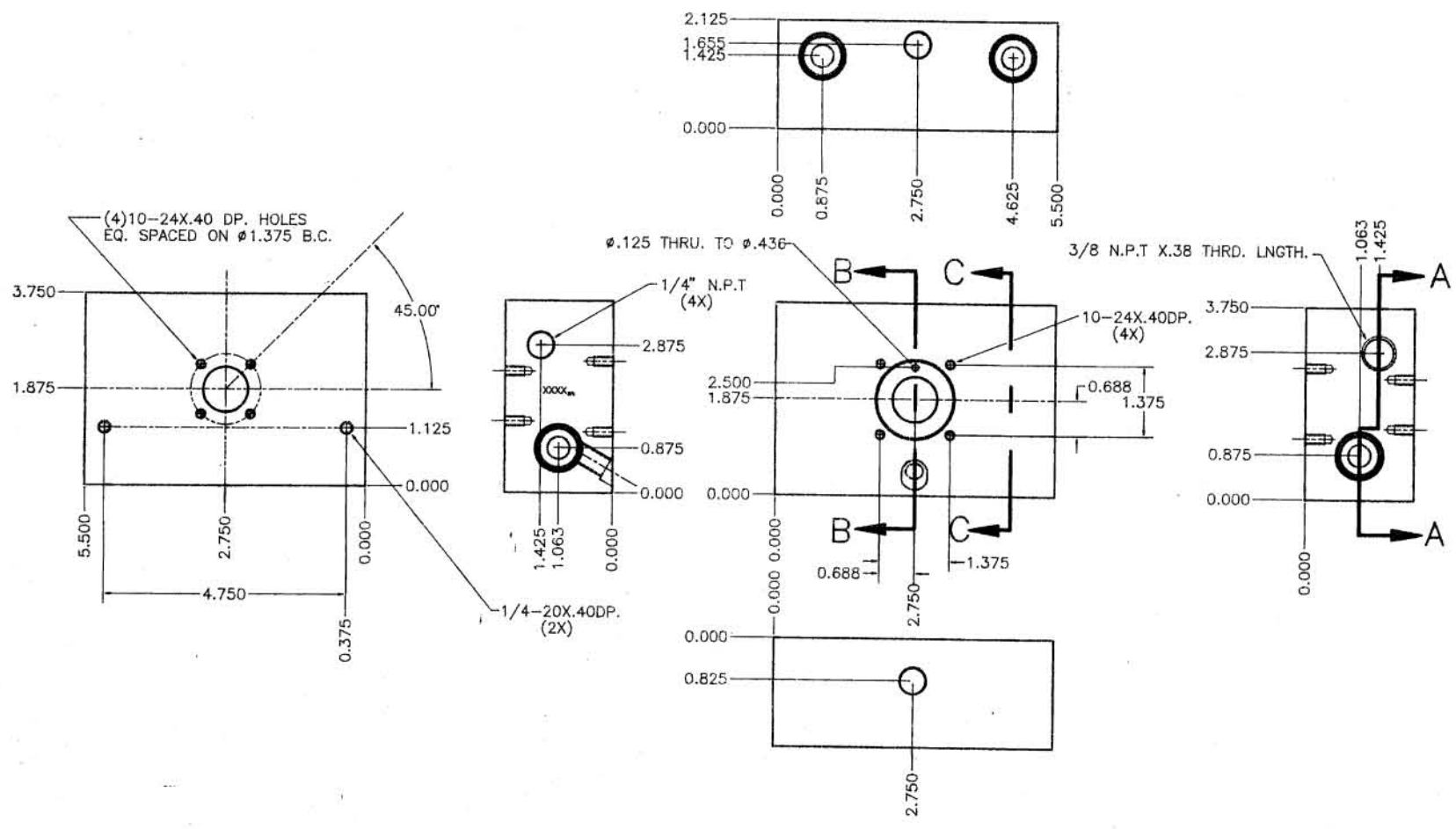


REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
A1	(1)/4	NPT. REPLACED BY 3/8 NPT.	3/30/92	WEISKOPF



NOTES:

ITEM NO.	QTY	FROM RECD	FROM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION
BILL OF MATERIALS						
MATERIAL				6061-T6 ALALY		
FINISH				HARD BLK. ANODIZE		
UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES				APPROVALS		
TELEPHONE				DATE		
NEXT ASSY. USED ON APPLICATION				3/30/92		
DRAWING NO.				90001		
SCALE:				DO NOT SCALE DRAWING		
SHEET: 1				OF: 2		

D
C
B
A

D
C
A

4

3

2

1

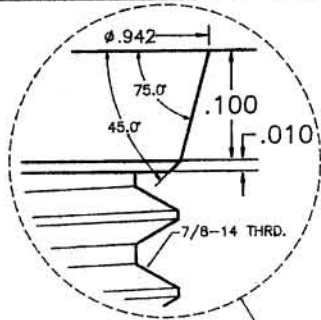
4

3

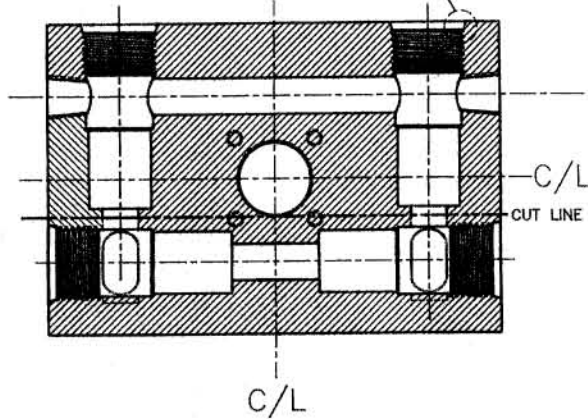
2

1

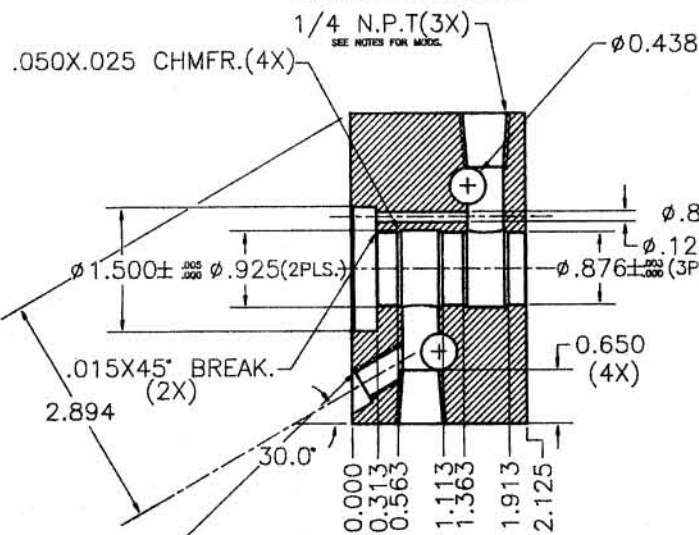
STD. SAE 7/8" O-RING PORT (4X)



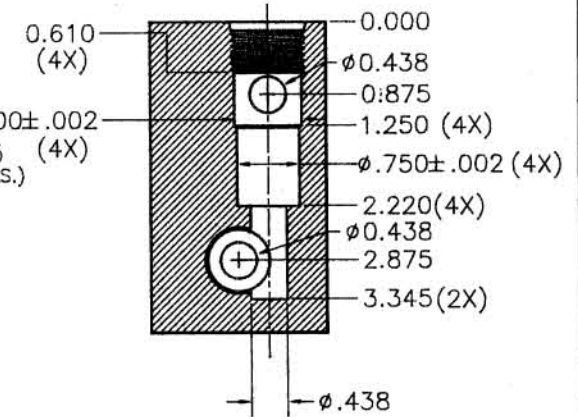
SECTION A-A



SECTION B-B



SECTION C-C



0.330 TO 0.438 BORE.
0.50 C'BORE TO MIN.FULL CIRCLE.
1/8 N.P.T X.38 THRD.LNGTH.

NOTES:

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
A1	(1)	1/4 NPT. REPLACED BY 3/8 NPT.	3/30/92	WEISKOPF

ITEM NO.	QTY	FSQM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION
BILL OF MATERIALS					
MATERIAL			6061-T6 ALALY		
FINISH			HARD BLK. ANODIZE		
UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES					
TOLERANCES			ANGLES ± 0.5°		
LINEAR			± .010		
HOLE			± .005		
RADIUS			± .005		
ROUNDEDNESS			± .005		
NEXT ASSY. USED ON			APPLICATION		
APPROVALS			DATE		
DESIGNED BY: Paul M. Weiskopf			3/30/92		
CHECKED BY: Paul M. Weiskopf			3/30/92		
DRAWING NO.			90001		
SCALE:			AS SHOWN		
SHEET: 2			OF: 2		

ARIEL LIFE SYSTEMS
VALVE, MAIN BODY

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

90008

ANTI-WRING AREA (2X)

90007

0.000

3.150

PROTECT FROM SCATCHING
DURING ASS'Y.

3	1			4-40X.25 STD. HEX SET SCR.		
2	1	90008		VALVE ACTUATOR SCREW		KERK STK.
1	1	90007		VALVE ACTUATOR		C.R.S.
ITEM NO.	QTY REQD	FROM NO.	PART OR IDENTIFYING NTL.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	

BILL OF MATERIALS

MATERIAL		APPROVALS		DATE	TITLE
UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES		Desl BR	Beltopf	5/15/92	ARIEL LIFE SYSTEMS VALVE ACTUATOR ASS'Y.
TOLERANCES FRACTIONS DECIMALS ANGLES		Desl BR	Beltopf	5/15/92	
NEXT ASSY. USED ON APPLICATION		Desl BR	Beltopf	5/15/92	SIZE: C
DRAWING NO: 90007A		DO NOT SCALE DRAWING		SCALE:	SHEET: 1 OF 1

NOTES:

DRAWING SHEET

A

4

3

2

1

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

D

D

C

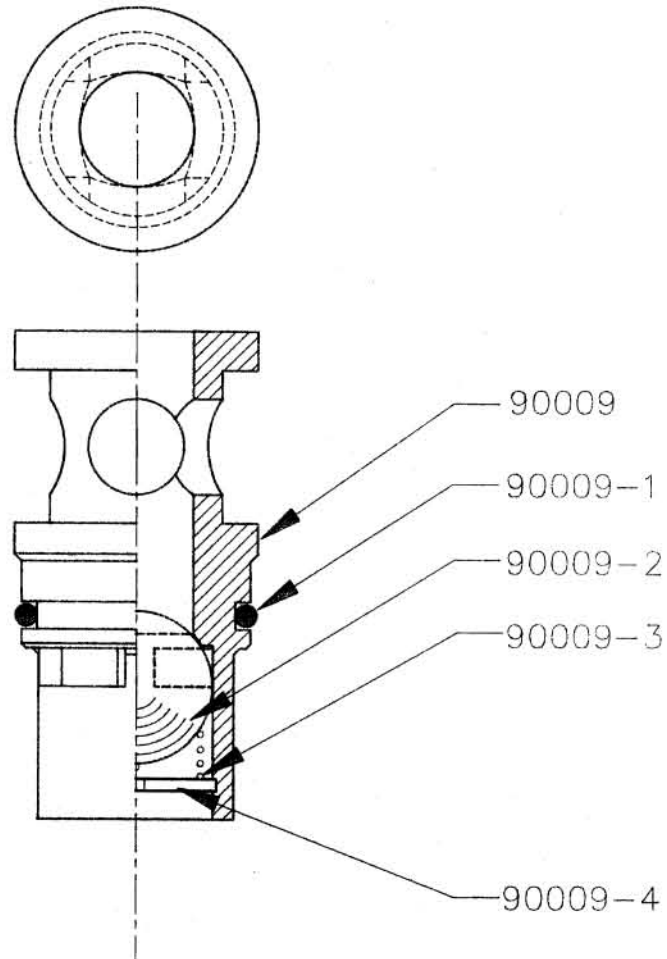
C

B

B

A

A



ITEM NO.	QTY	FORM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION
5	1		90009-4	Ø.500 INT.EXP.SNAP RING	SPR.STL.
4	1		90009-3	CHECK SPRING	SPR.STL.
3	1		90009-2	Ø.5000 BEARING BALL	TOOL STL.
2	1		90009-1	Ø.750X.0625C.S.O-RING	BUNA-N
1	1		90009	CHECK VALVE BODY	STEEL

BILL OF MATERIALS					
MATERIAL	PACKAGE	ARIEL LIFE SYSTEMS			
FINISH:		APPROVALS	DATE	TITLE:	
UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES		Paul SR	5/15/92	CHECK VALVE, ASSEMBLY	
TOLERANCES:		Paul SR	5/15/92	FORM NO.:	DRAWING NO.:
LINEAR: .002 .010	ANGLES: ± 0.1°	Paul SR	5/15/92	C	90009-A
.0004 .005	DIA CENTRICITY: ± .005	DO NOT SCALE DRAWING		SCALE:	SHEET: OF:
.00004 .0015	FLATNESS: ± .002				
	ROUNDNESS: ± .005				

NOTES:

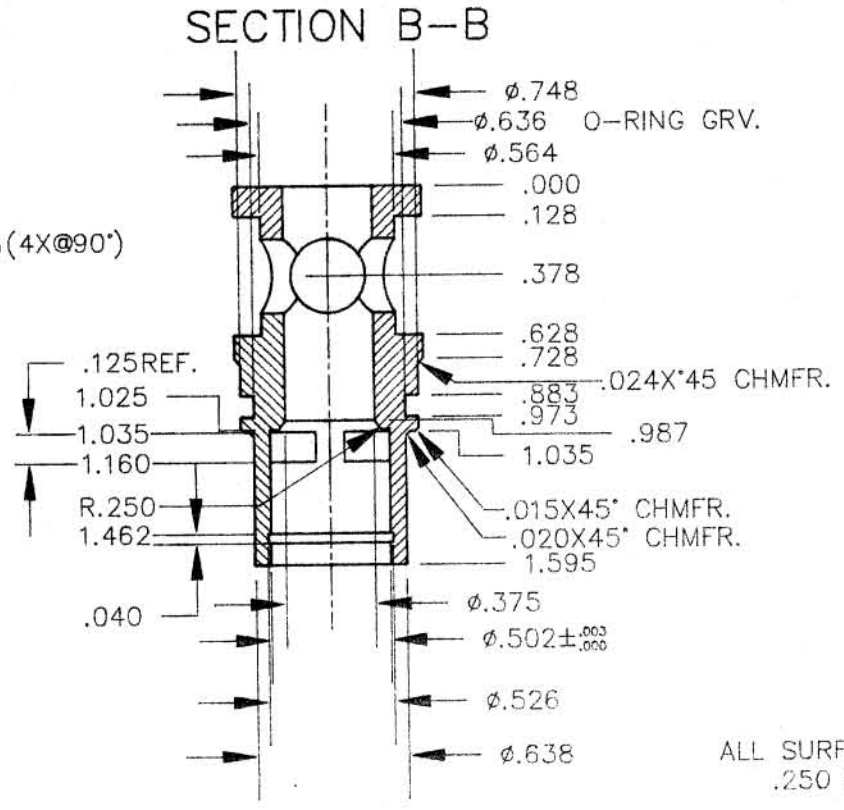
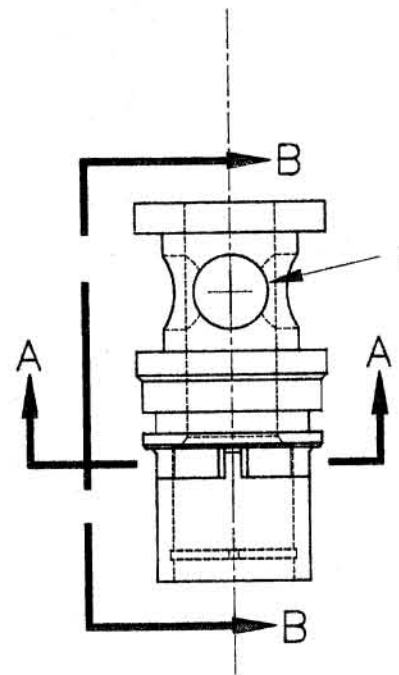
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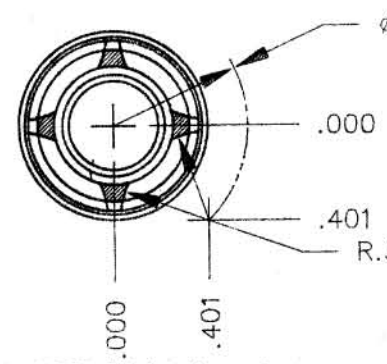
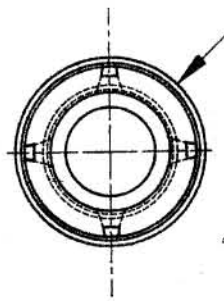
2

1

REVISIONS			
ZONE REV	DESCRIPTION	DATE	APPROVED

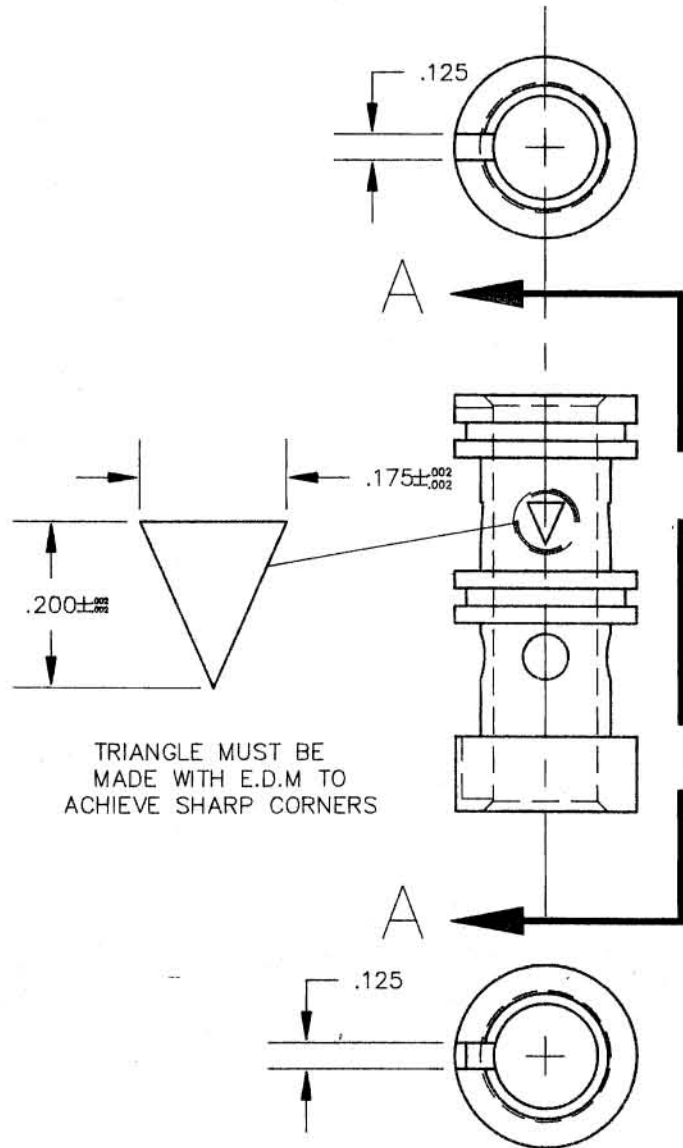


-NOTES-
 BREAK ALL EDGES
 ALL SURFACES TO BE FREE OF MACHINE MARKS.
 .250 RADIUS TO BE FINISHED TO A 4L.

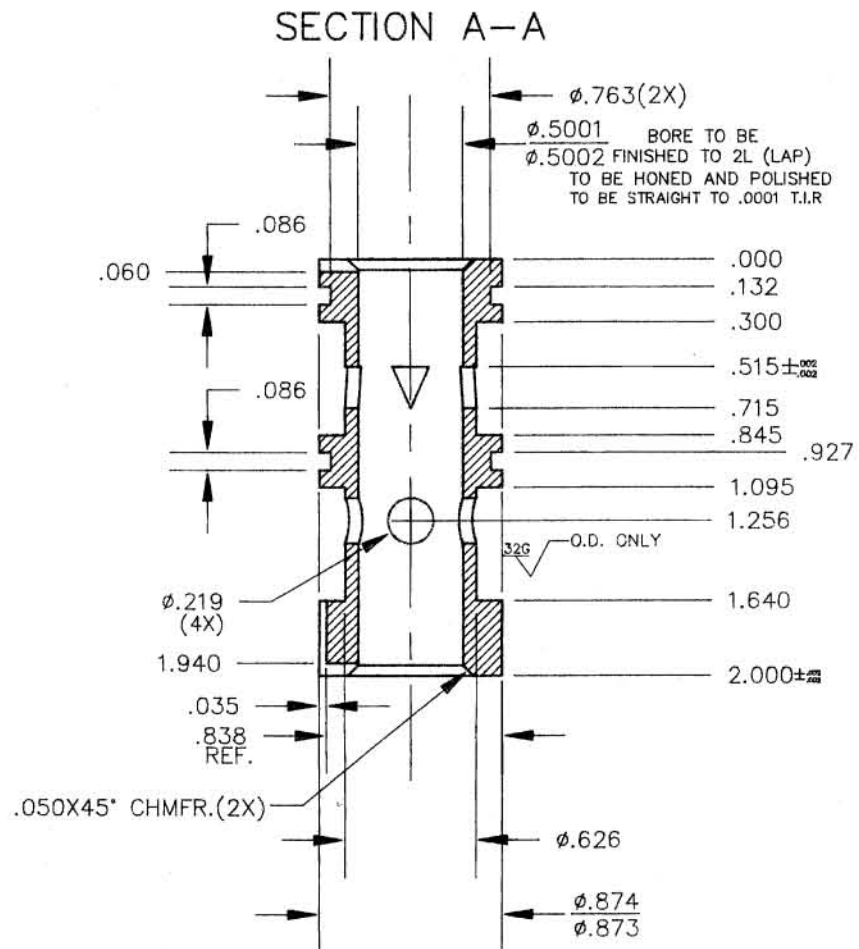


ITEM NO.	QTY	FROM REGD. NO.	PART OR IDENTIFYING NO.	MANUFACTURE OR DESCRIPTION	MATERIAL SPECIFICATION
BILL OF MATERIALS					
MATERIAL: JORGENSEN 1144 STRESSPROOF			ARIEL LIFE SYSTEMS		
FINISH: BLACK OXIDE			CHECK VALVE BODY		
TOLERANCES: UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES			APPROVALS: Paul R. Berthoff 5/21/92		
DIMENSIONS: ANGLES & SURF FINISHES: 300 & 300			DATE: 5/21/92		
NEXT ASSY. USED ON: APPLICATION			DRAWING NO.: 90009		
SCALE: DO NOT SCALE DRAWING			REV: A1		

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
A1		FIRST BUILD BY A.L.S (PROTO)	5/22/92	WEISKOPF



TRIANGLE MUST BE MADE WITH E.D.M TO ACHIEVE SHARP CORNERS



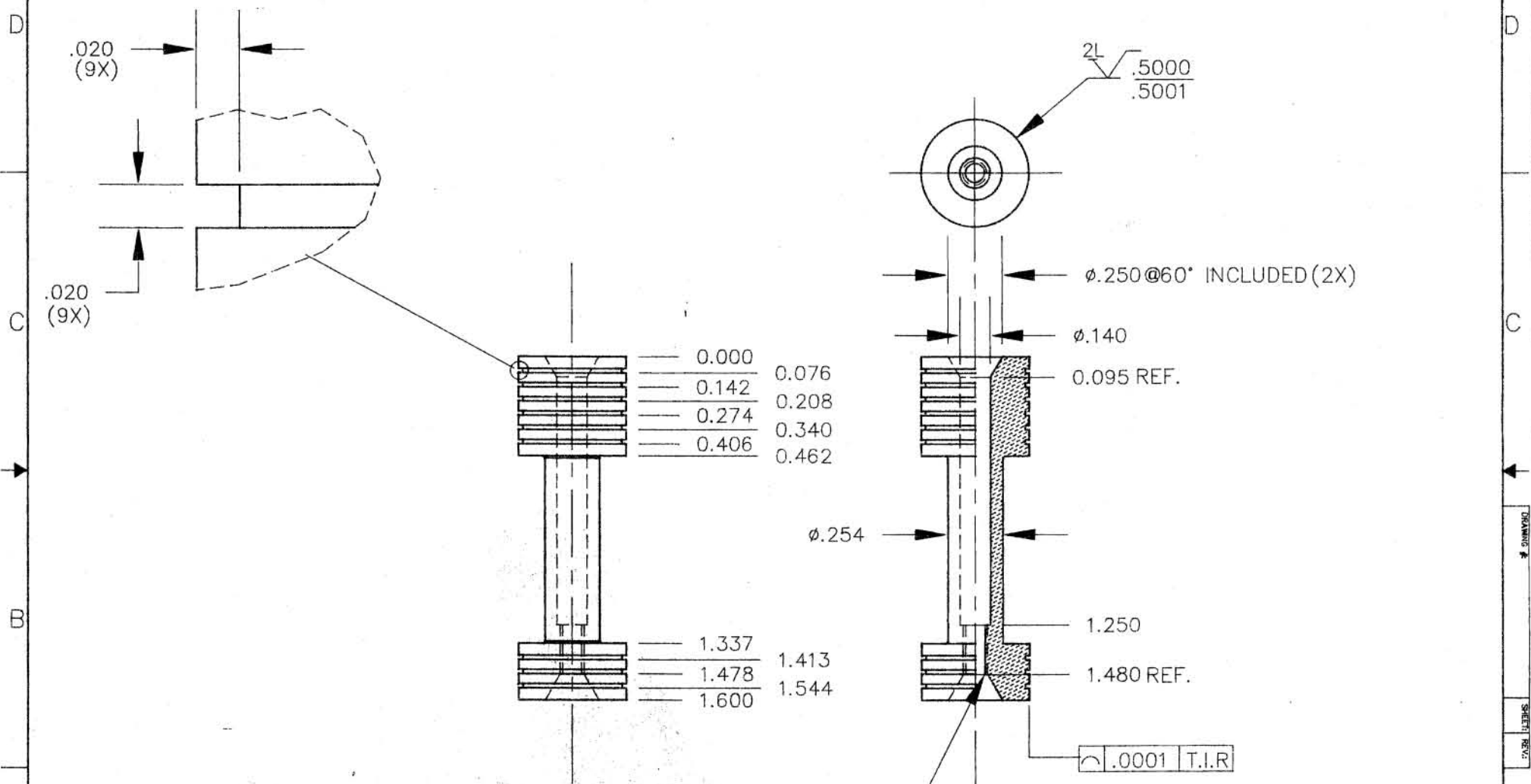
-NOTES-
 DWG.90004 AND DWG.90005
 ARE MATES AND MUST BE MADE AND CHECKED TOGETHER TO ACHIEVE .0002 TO .0007 CLEARANCE. ALL CORNERS AND EDGES TO BE BROKEN, AND THERE ARE TO BE NO VISIBLE TOOL MARKS. E.D.M PORTS PRIOR TO HONE AND LAP.

NOTES:

ITEM NO.	QTY	FROM	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION
BILL OF MATERIALS					
MATERIAL: -01 TOOL STEEL HEAT TREAT TO 58/62 RC.					
FINISH: NONE					
UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES					
TOLERANCES: ANGLES ± 0.1°					
LINEAR: .001 ± .001					
HOLE: .001 ± .001					
FLATNESS: ± .002					
CIRCULAR RUNOUT: ± .005					
DO NOT SCALE DRAWING					

APPROVALS	DATE	TITLE	
Paul R. Weiskopf	5/22/92	ARIEL LIFE SYSTEMS	
Paul R. Weiskopf	5/22/92	FLOW CONTROL VALVE, SLEEVE	
Paul R. Weiskopf	5/22/92	SIZE: FSCM NO.:	DRAWING NO.:
		C	90004
		SCALE:	SHEET: OF:
		1/8" = 1"	1

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED



-NOTES-

4-40 THRU TO .140 BORE

DWG.90004 AND DWG.90005
 ARE MATES AND MUST BE MADE AND CHECKED
 TOGETHER TO ACHIEVE .0001 TO .0003 CLEARANCE.
 ALL CORNERS AND EDGES TO BE BROKEN,
 AND THERE ARE TO BE NO VISIBLE TOOL MARKS.

ITEM NO.	QTY	FROM REGD. NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION
BILL OF MATERIALS					
MATERIAL: -01 TOOL STEEL			HEAT TREAT TO 58/64 RC.		
FINISH: NONE			APPROVALS: Paul R. Briffopf DATE: 5/28/92		
UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES			PROJECT ENGINEER: Paul R. Briffopf 5/28/92		
TOLERANCES: LINEAR .010 ANGLES ± 0.5°			APPROVER: Paul R. Briffopf 5/28/92		
.0008 .0005 CONCENTRICITY ± .005			SIZE: FSCM NO. DRAWING NO. REV.:		
.0008 .0005 FLATNESS ± .005			C 90005 A1		
.0008 .0005 ROUNDNESS ± .005			DO NOT SCALE DRAWING SCALE: SHEET: OF:		
NEXT ASSY. USED ON APPLICATION			CIR. FILENAME: 90005.DWG		

DRAWING SHEET REV.: