REQUISITION 47472/40301783
FOR
TUBE, PART NO. 3268AS107

A first Article sample of 32 each parts is required prior to delivery of the full production quantity.

NSWC shall inspect parts to ensure compliance with all requirements of drawing 3268AS107.

Manufacture of full production quantity is not authorized and shall be at contractor's risk until inspection and approval of First Article sample is received from the government.

Certifications that tube meets tensile strength requirement as described in NOTE 5 of drawing 3268AS107 shall be delivered with production quantity.

Tube shall be packaged for shipment in accordance with the following requirements:

The fiberboard shipping boxes shall meet the following standard.
RULE 41, ITEM 222 of ASTM D5118

The boxes shall have the following specifications.

Style: RSC

Size: 20"X20"X20"

Construction: Double-wall

Strength: Edge Crush Test (ECT) of 51 lbs./inch
Size Limit of 105 inches
Gross Weight Limit 120 lbs.

Packaging: Tubes shall be packaged on end with a fiberboard spacer between each layer.
A total of 752 tubes shall be packaged per shipping box.

Palletizing: Eight shipping boxes shall be palletized as a unit load for shipment in accordance with standard commercial practices.

N00164-04-Q-0098

DISTRIBUTION STATEMENT D:
DISTRIBUTION AUTHORIZED TO THE DEPARTMENT OF DEFENSE AND DOD CONTRACTORS ONLY; MILITARY TECHNOLOGY; JAN 1993. OTHER REQUESTS FOR THIS DOCUMENT SHALL BE REFFERED TO COMMANDER, CRANE DIVISION, NAVAL SURFACE WARFARE CENTER (CODE 407), CRANE, IN 47522-5001.

DESTRUCTION NOTICE:
DESTROY BY ANY METHOD THAT WILL PREVENT DISCLOSURE OF CONTENTS OR RECONSTRUCTION OF THE DOCUMENT.

PART NUMBER
3268AS107-001

CLASSIFICATION OF CHARACTERISTICS (DOD-STD-2101)
CRITICAL - NONE
MAJOR - NONE
MINOR - ALL OTHER CHARACTERISTICS

REVISIONS

REV	DESCRIPTION	DATE	APPROVED
A	SEE NOR 3268AS107A	951120	CMG
B	SEE NOR 3268AS107B	980615	CMG

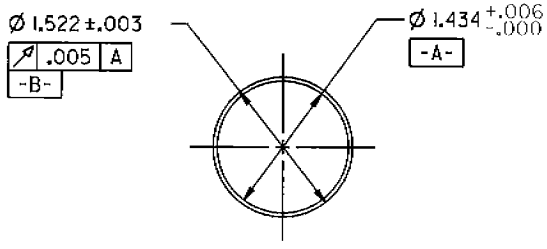
THIS DRAWING HAS BEEN GENERATED AND IS MAINTAINED BY A CAD SYSTEM. CHANGES SHALL ONLY BE INCORPORATED AS DIRECTED BY THE GOVERNMENT DESIGN AGENCY.

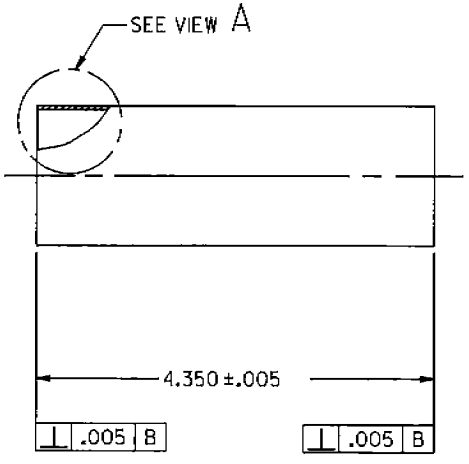
NOTES:

1. MATERIAL: FILAMENT WOUND GLASS FIBER/EPOXY COMPOSITE. 0.00050/0.00055 DIAMETER 'E' GLASS FIBER (ROVING WITH 675 YDS/LB YIELD). EPOXY RESIN IAW MIL-R-9300, TYPE I, COLOR BLACK, TREATED WITH COMPATIBLE FIRE RETARDANT ADDITIVE TO MEET UNDERWRITERS LABORATORY TEST UL 94V-0. SPECIFICATION REQUIREMENTS APPLY AFTER ADDITIVE.

2. THE GLASS FIBERS SHALL BE SATURATED WITH THE EPOXY RESIN AND APPLIED HELICALLY TO A ROTATING MANDREL AT A 65° ± 2° ANGLE TO THE TUBE AXIS.

3. THE ID OF THE TUBE SHALL BE AS DETERMINED BY THE MANDREL WITH NO FURTHER MACHINING REQUIRED.





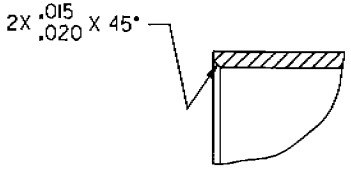
4. THE OD MAY BE ACHIEVED WITH SECONDARY MACHINING OPERATION.

5. THE APPARENT RING TENSILE STRENGTH OF THE TUBE SHALL BE 2000 LBS MINIMUM WHEN TESTED IAW ASTM D2290, PROCEDURE A, WITH THE FOLLOWING EXCEPTIONS:

   A. TEST SPECIMEN SHALL BE A RING CUT FROM A FINISHED TUBE TO A LENGTH OF 0.500±.005 INCHES.

   B. THE TEST FIXTURE AND SPECIMEN WILL BE AS CONFIGURED IN FIGURE 5 OF THE SPECIFICATION WITH A SPLIT DISK DIAMETER OF 1.425±.005 AND A THICKNESS OF 0.500±.010.

6. FINISHED COMPONENTS SHALL BE FREE FROM FRAYED FIBERS.



VIEW A
SCALE: 4/1

NEXT ASSY	USED ON
3268AS130	D-27A/ALE-29A
3268AS130	AN/ALE-47 CMDS

APPLICATION

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±
2 PLACE DECIMALS ±
PART SHALL BE FREE OF BURRS
BROKEN EDGES .01 MAX
INSIDE CORNERS MAX
SURFACE ROUGHNESS 63

DO NOT SCALE THIS DRAWING

INTERPRET DRAWING IN ACCORDANCE WITH MIL-STD-100 ANSI Y14.5M-1982

CRANE DIVISION
NAVAL SURFACE WARFARE CENTER
CRANE, IN 47522-5001

INSP			
PROJ MGR	JAK	4072	940816
DSGN ANAL	CDH	4071	940816
EVAL			
PROJ ENG	DJM	4071	940816
CHECKED	RAP	4071	940816
PREPARED	DAS	4071	940803

APPROVED FOR NASC
H.A. WEBSTER 940817
BY DIRECTION DATE

DEPARTMENT OF THE NAVY
NAVAL AIR SYSTEMS COMMAND
WASHINGTON, DC 20360

TUBE

SIZE	CAGE CODE	NAVAIR DWG NO.	REV
C	30003	3268AS107	B

SCALE 1/1 SHEET 1 OF 1

DWG 268AS107 SH 1 REV B

COMPUTER GENERATED
d27mag/3268as107.br