



Test Monitoring Center

6555 Penn Avenue
Pittsburgh, PA 15206-4489
(412) 365-1000

June 13, 2005

TO: Subcommittee D02.B

SUBJECT: Revision of Adjunct ADJD5704

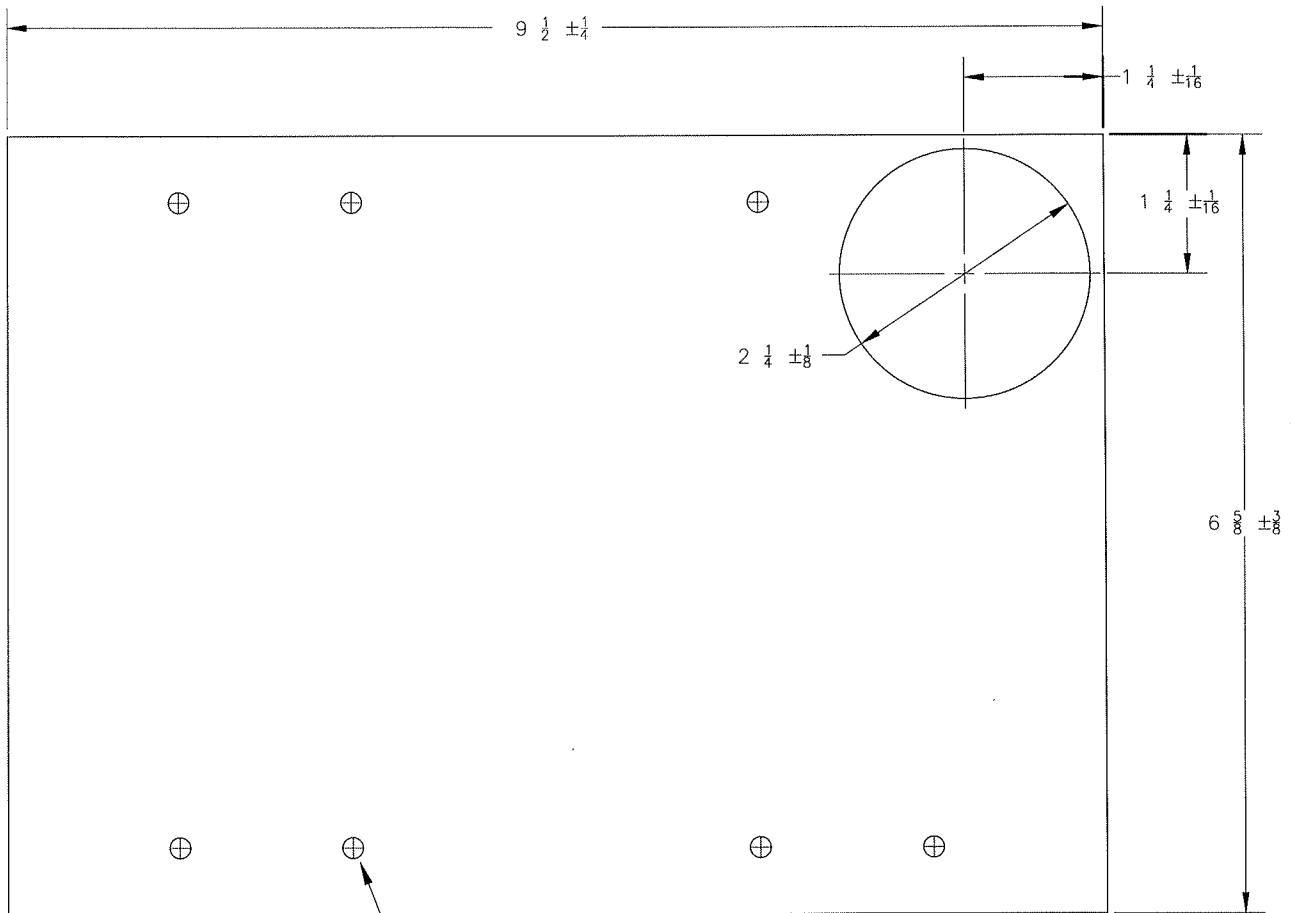
Ladies/Gentlemen:

Attached are revised drawings for the revision of Adjunct ADJD5704. These detailed drawings are necessary for stand construction for Test Method D5704-05. These drawings must be balloted and given a new adjunct number as per ASTM requirements.

Attachments

DML/let05-013.dml.doc

c: F. Farber, TMC
J.L. Zalar, TMC

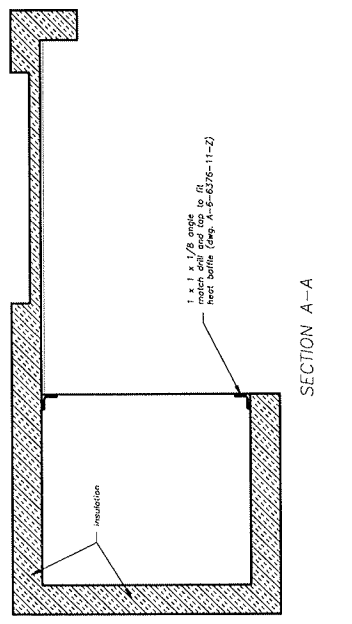
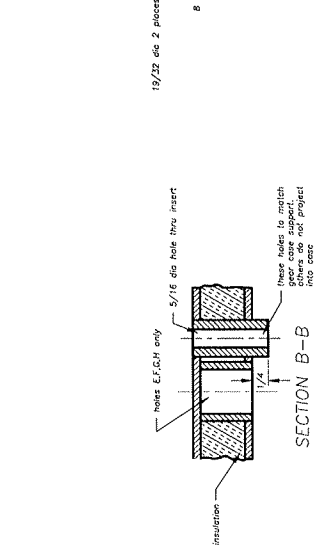
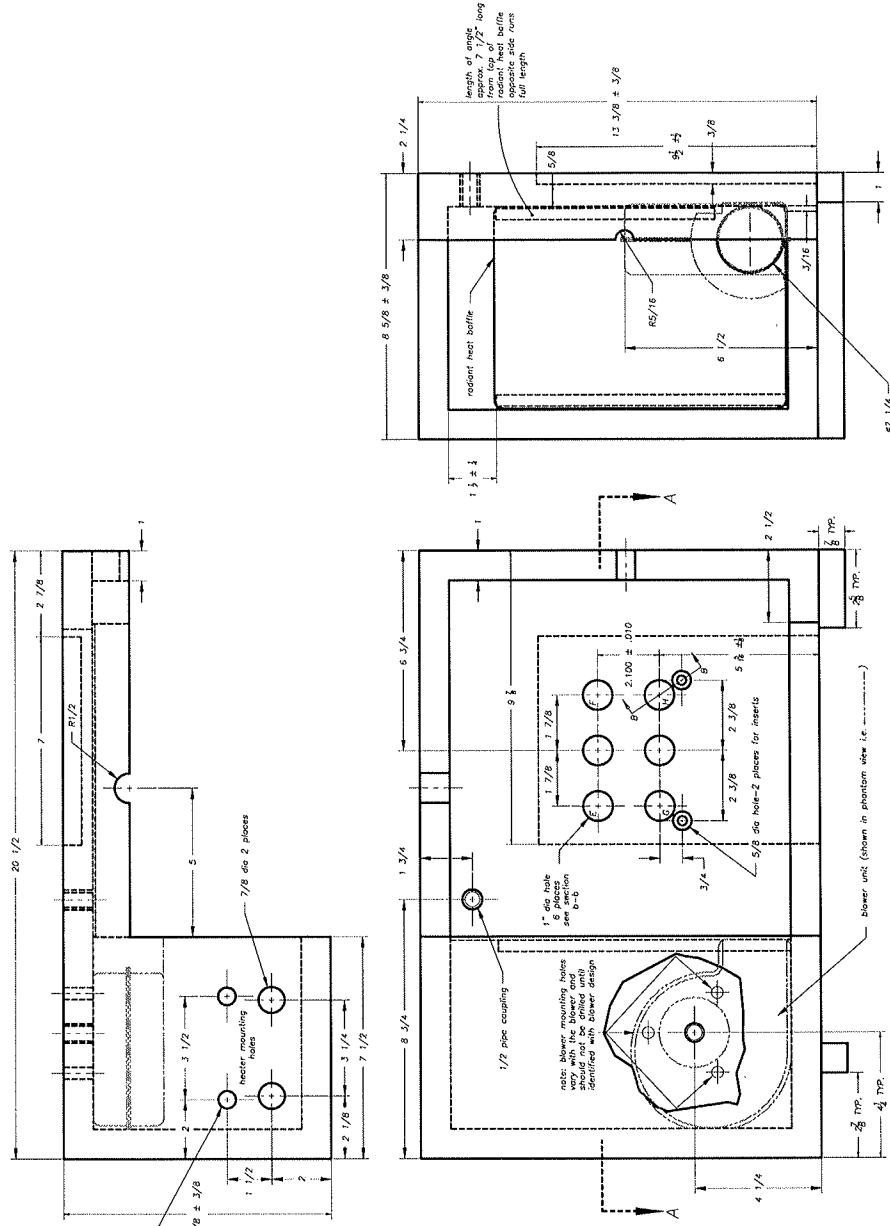


DRILL 3/16 DIA HOLES TO MATCH TAPPED 4X TYP.
 HOLES IN 1/8 x 1 x 1 ANGLE MOUNTED IN
 HEATER CASE

MAT'L 12 GA MILD STEEL OR STAINLESS STEEL 1 REQ'D

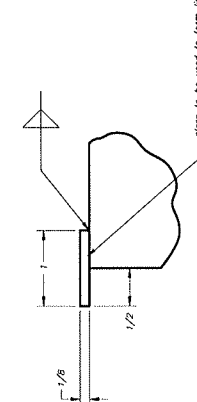
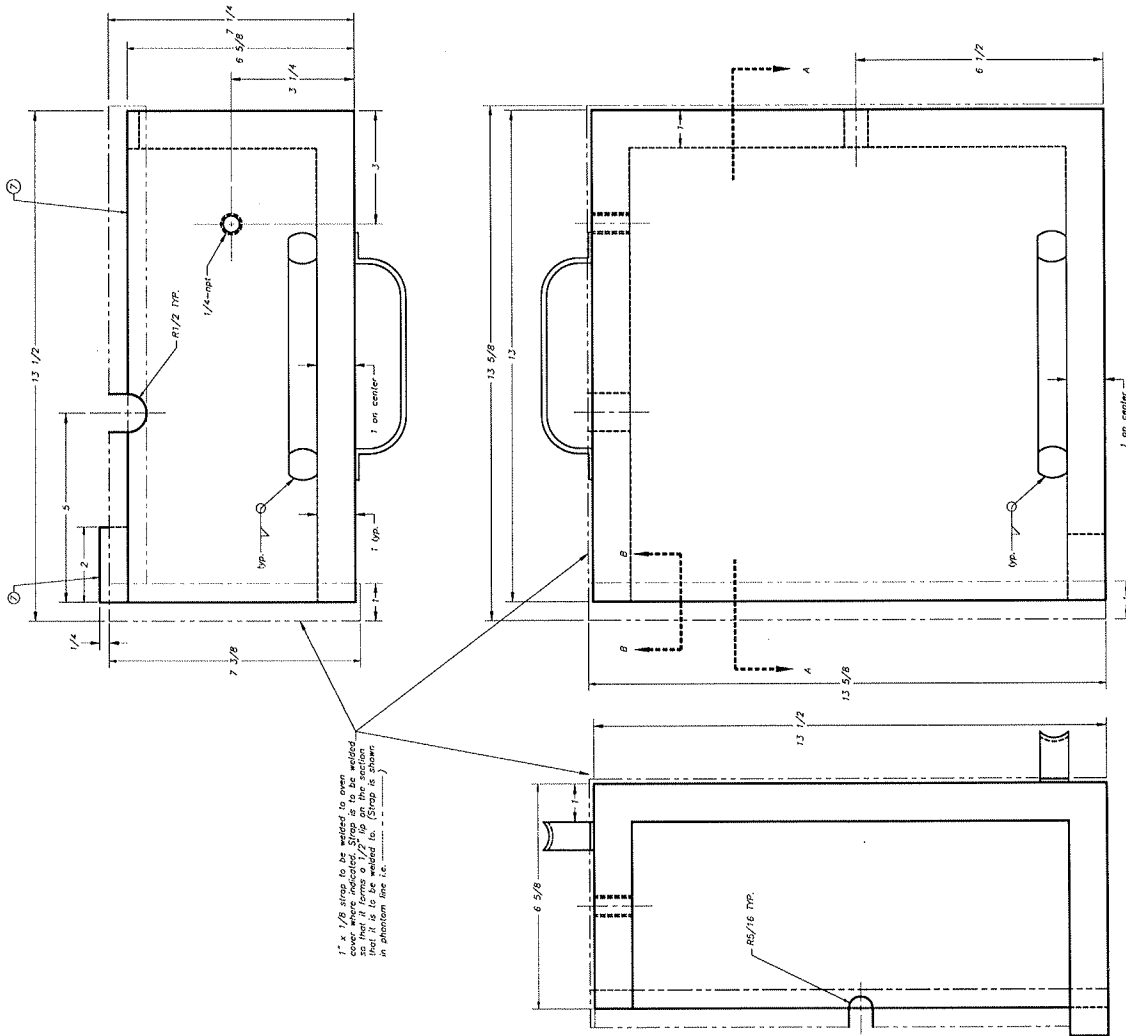
2		L-60-1	TITLE RADIANT HEAT BAFFLE	
DWG FILE	A:24			
DRAWN BY	T.L. HABY ± .015	SCALE	DATE	DRAWING NO
ASTM		NTS	14JAN2004	A-6-6376-11-Z

DESIGNER	DATE	REV.	BY
ASTM	MTC	RF	C-OVERN
DESIGN	DATE	REV.	BY
L-60-1	SCALE	AS SHOWN	R. T. L. HURT
TITLE HEATER CASE			
PROJECT	DATE	DRAWING NO.	
1-1/8	1-4/JAN/2004	D-6-6376-41-Z	
REVISION NO.	2		



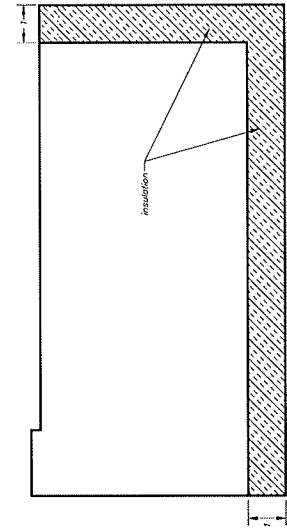
NOTES

1. CASE CONSISTS OF A DOUBLE WALL CONTAINER WITH INSULATION BETWEEN THE WALLS
2. WALLS TO BE 16 GA HOT OR COLD ROLLED STEEL
3. ALL JOINTS TO BE WELDED LEAK PROOF
4. INSULATION TO BE INSTALLED DURING CONSTRUCTION
5. ALL HOLES THRU CASE TO BE LINED WITH METAL TUBE AND WELDED TO INNER AND OUTER WALLS
6. MUST MATCH COVER WITHIN 1/8"



SECT. B-B

1" x 1/8" strap to be welded to oven cover where indicated. Strap is to be welded to cover where indicated. (Strap is shown in phantom line i.e.)

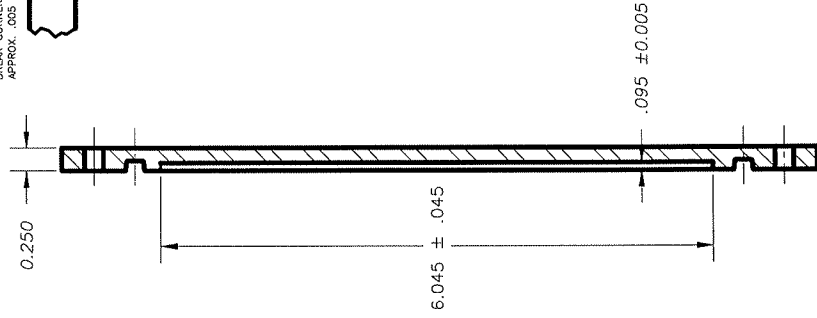
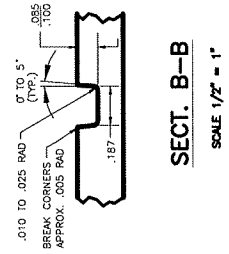
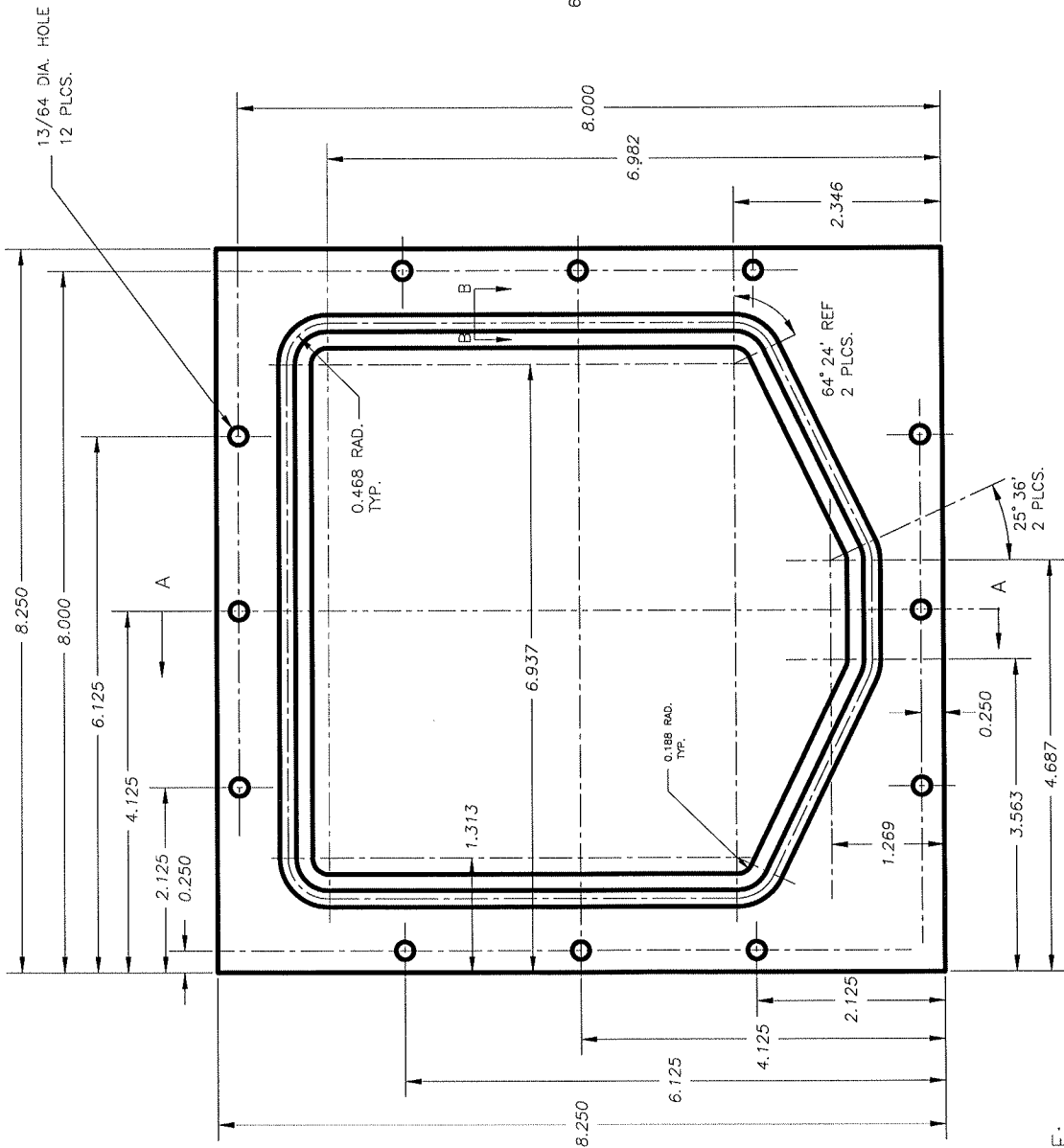


SECTION A-A

NOTES

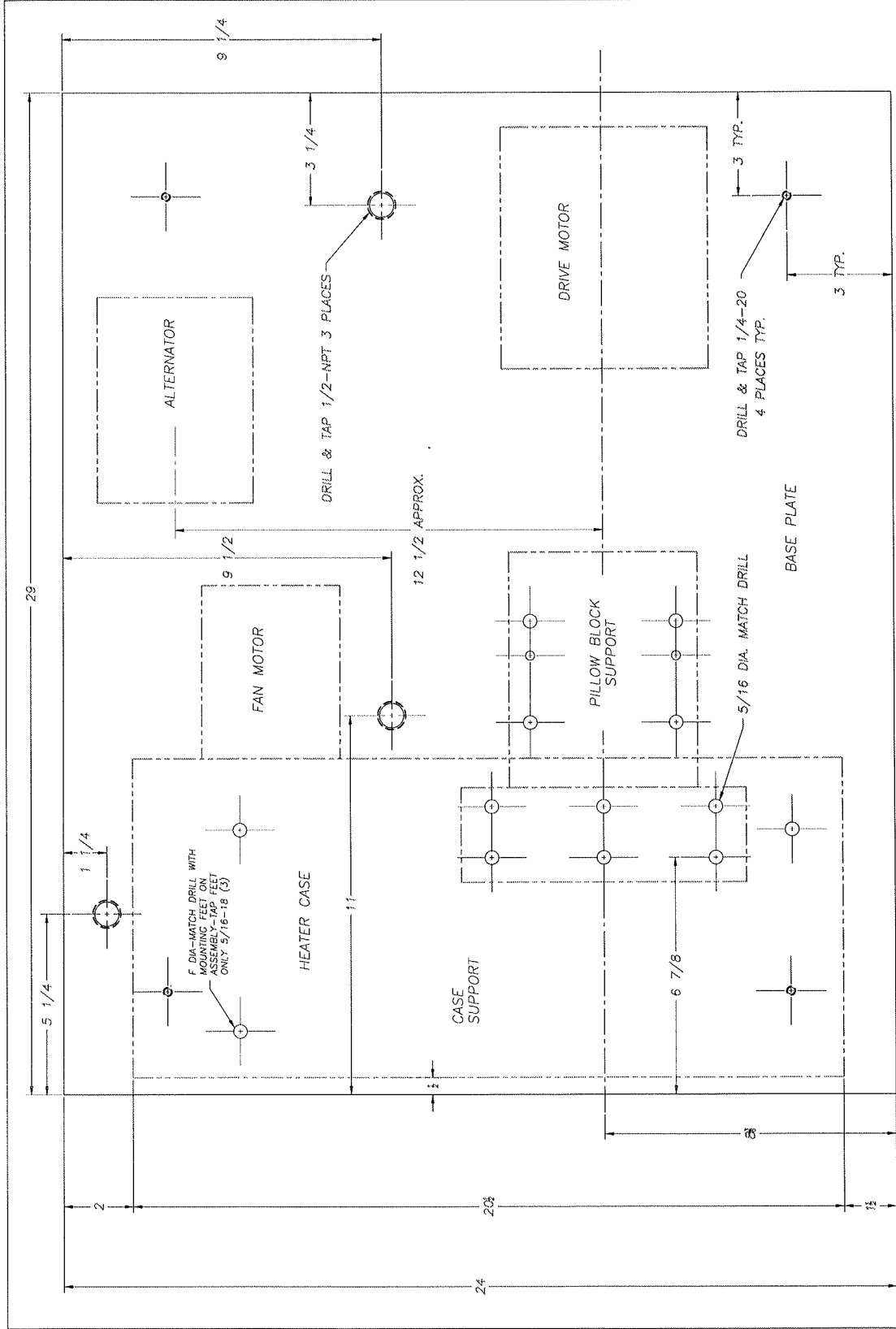
1. CASE CONSISTS OF A DOUBLE WALL CONTAINER WITH INSULATION BETWEEN THE WALLS.
2. WALLS TO BE 16 GA. HOT ROLLED STEEL.
3. ALL JOINTS TO BE WELDED LEAK PROOF.
4. INSULATION TO BE INSTALLED DURING CONSTRUCTION.
5. ALL HOLES THRU CASE TO BE LINED WITH METAL TUBE AND WELDED TO INNER AND OUTER WALLS.
6. MUST MATCH OVEN WITHIN 1/8".
7. FLANGED MOUNTING SURFACE OF THE OVEN COVER ASSEMBLY CAN BE MODIFIED FOR PROPER SEALING, PROVIDED THE INNER DIMENSIONS OF THE BOX ARE MAINTAINED ACCORDING TO THE PRINT.

TOLERANCES UNLESS OTHERWISE SPECIFIED		Dwg. File	
DECIMAL	± .005	C-COVEN/2	
FRACTION	± 1/8	SCALE	AS SHOWN BY T.H. HARRY
ANGULAR	± 1°	PROPOSED BY	
REVISION NO.	1	TITLE	HEATER CASE COVER
DATE	12-7-04	DRAWING NO.	D-6-6376-41a-Z



- NOTE:
- 2-264 FLUOROCARBON RUBBER O-RING.
 - ALL DIMENSIONS ARE IN INCHES.
 - SURFACE FINISH 32 RMS TYP.

TOLERANCES UNLESS OTHERWISE SPECIFIED		ASTM	
DECIMAL	MATERIAL	SCALE	DRAWN BY
± 0.005	303 OR 304 SS	1" = 1"	T. HABY
FRACTION	TITLE	COVER, T.O.S.T. GEARCASE O-RING, L-60-1	
ANGULAR ± 0° 30'	DATE	DRAWING NO.	REVISION NO.
	13MAY2004		1
			C-7518-655-Z

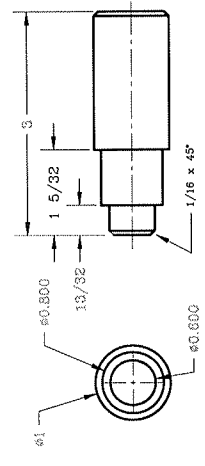
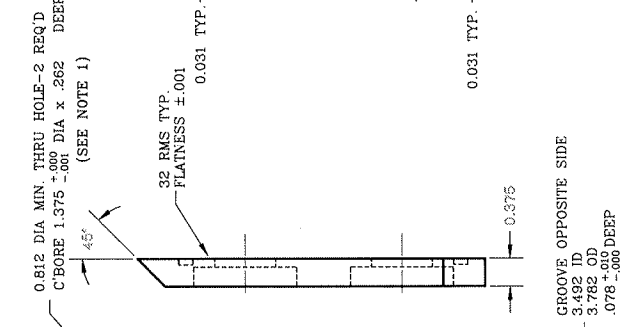
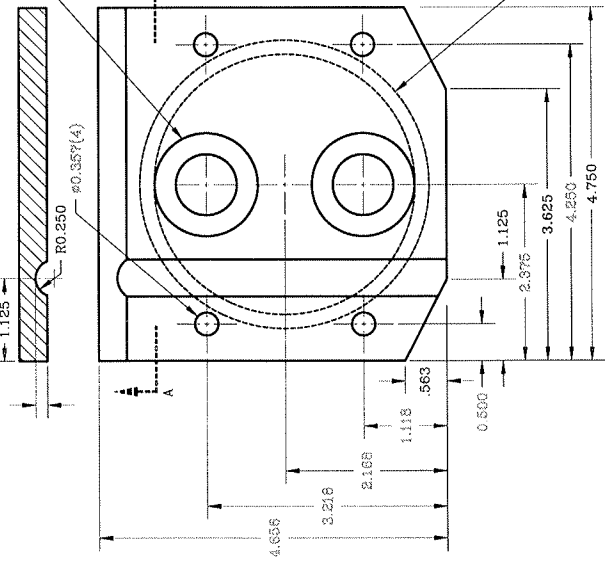


TOLERANCES UNLESS NOTED OTHERWISE	ASTM	DWG FILE
DECIMAL	L-60-1	104
FRACTION	NTS	DRWN BY T. HASTY
ANGULAR	BASE PLATE	MATERIAL
REVISION NO.	DATE	DRAWING NO.
1	15 JAN 2004	C-6-6376-05-Z

TYPICAL BASE PLATE LAYOUT

SEAL PLATE
TYPE 303 OR 304 STAINLESS
0.156

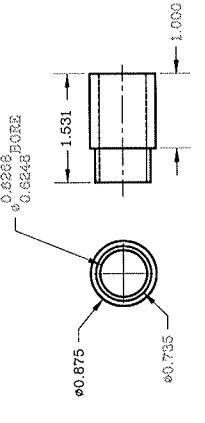
SECTION A-A



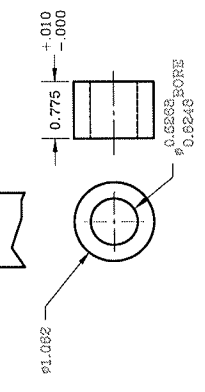
SEAL REMOVAL TOOL - CRS
MATERIAL MAY BE REMOVED FROM SHOULDER
TO FACILITATE LIP SEAL REMOVAL

NOTE 2:
O-RING - NO. 2-153 2 REQ'D
OIL SEAL - CR-6383 2 REQ'D
SPEEDY SLEEVE - CR-99062 2 REQ'D
V-RING - CR-400164 2 REQ'D

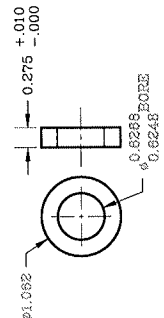
NOTE 3:
FOR PROPER STACK-UP ASSEMBLY, THE DISTANCE
FROM THE SNAP RING GROOVE TO THE COUNTER
BORE OF THE SEAL PLATE SHOULD BE .400
±.03125 INCHES. THE COUNTER BORE DEPTH
OF .282 INCHES MAY BE ADJUSTED TO GIVE PROPER
STACK-UP ASSEMBLY OF THE OIL SEAL (CR-6383)
AND V-RING (CR-400164).



RETAINER BUSHING - 2 REQ'D
TYPE 303 OR 304 STAINLESS

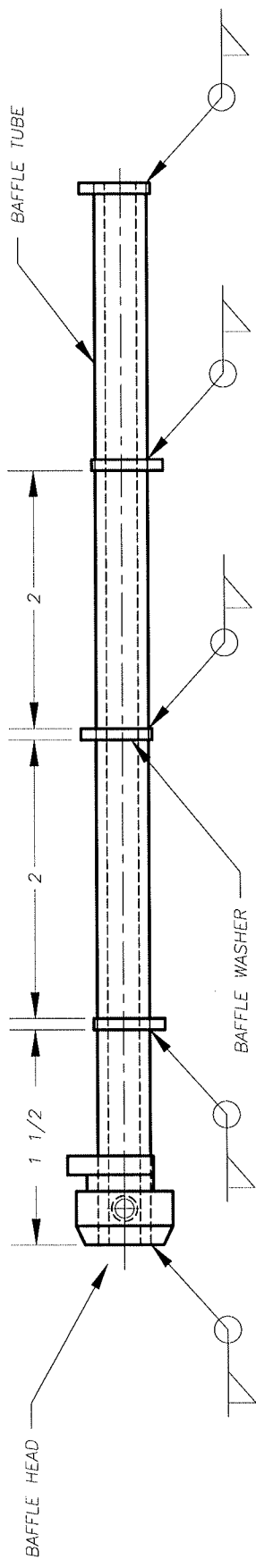


SPACER BUSHING - UPPER
TYPE 303 OR 304 STAINLESS

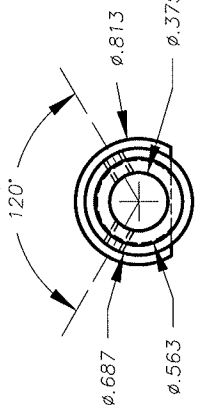


SPACER BUSHING - LOWER
TYPE 303 OR 304 STAINLESS

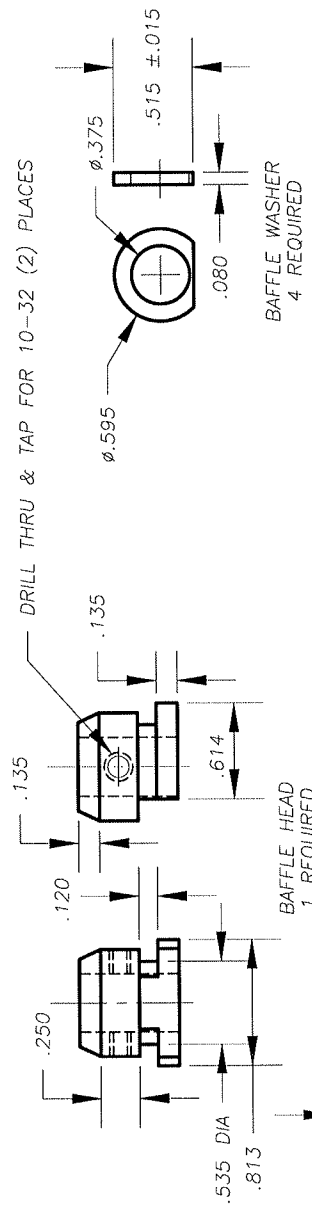
TOLERANCES UNLESS OTHERWISE SPECIFIED	ASTM	DWG FILE C:\SPL\T
DECIMAL ±.005	L-60-1	SCALE 1=1
FRACTION ±1/32	MODIFIED SEAL PLATE	DRAWN BY T. HADY
ANGULAR		MATERIAL
REVISION NO. 3		DRAWING NO. C-3963-1277-Z



BAFFLE TUBE ASSEMBLY

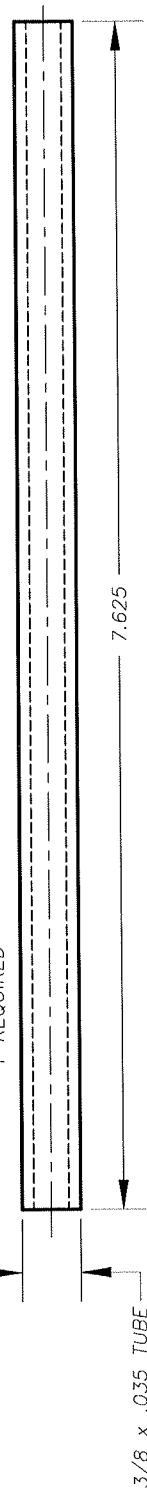


BAFFLE HEAD
1 REQUIRED



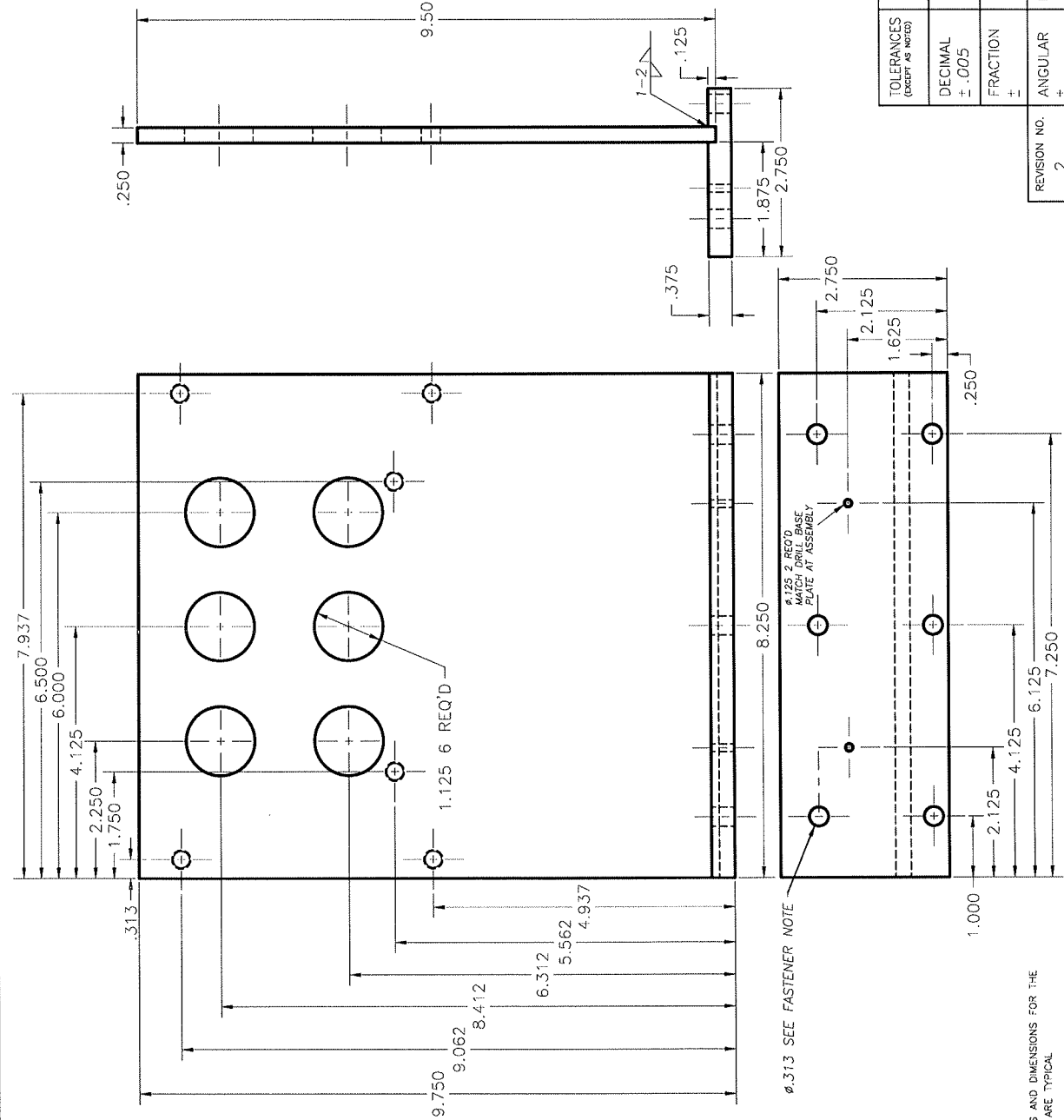
BAFFLE WASHER
4 REQUIRED

NEW BAFFLES BUILT AFTER
JULY 30, 2004 MAY BE
BUILT WITH SOLID STEEL.



3/8 x .035 TUBE
1 REQUIRED

TOLERANCES (EXCEPT AS NOTED)	ASTM	DWG FILE 66A
DECIMAL ± 0.010	L-60-1	SCALE NTS
FRACTION ± 1/16	DRAWN BY T. HABY MATERIAL 304 SS	
ANGULAR ± 1°	DATE 13MAY2004	
REVISION NO. 1	DRAWING NO. B-6-6376-35-Z	
TITLE VENT TUBE BAFFLE		

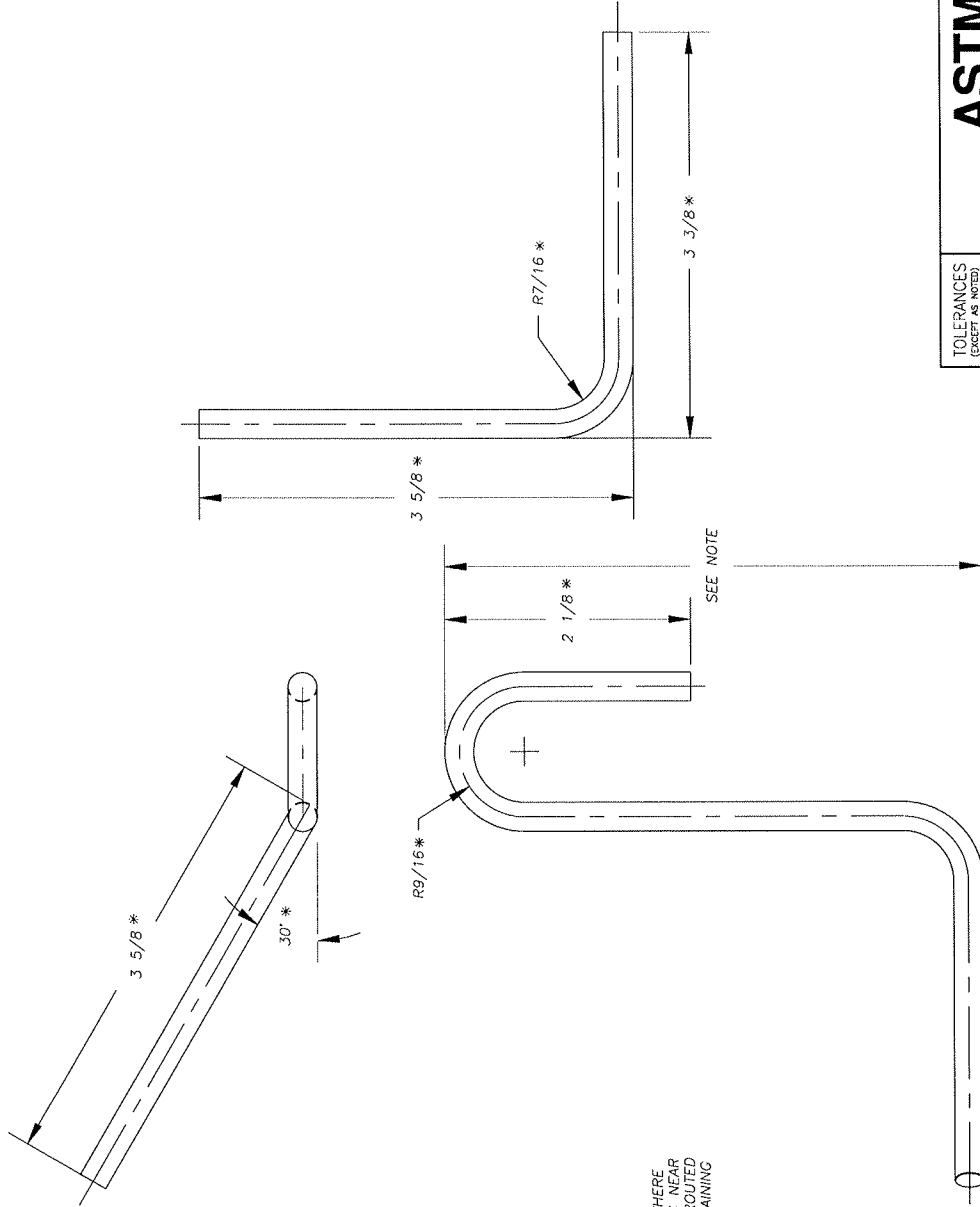


TOLERANCES (EXCEPT AS NOTED)	ASTM		DWG FILE 76A
DECIMAL ± .005	SCALE 1-60-1	SCALE NTS	DRAWN BY T. HABY MATERIAL HOT/COLD ROLL
FRACTION ±	TITLE GEAR CASE SUPPORT		REVISION NO. 2
ANGULAR ±	DATE 14JAN2004	DRAWING NO. B-6-6376-18-Z	

NOTE:
ALL HOLE LOCATIONS AND DIMENSIONS FOR THE
BASE PLATE MOUNT ARE TYPICAL

Ø.313 SEE FASTENER NOTE

Ø.125 2 REQ'D
MATCH DRILL BISE
PLANE AT ASSEMBLY



NOTE: TUBE MUST RISE A MINIMUM OF 3 INCHES VERTICALLY ABOVE THE DRAIN (WHERE OIL ACTUALLY LEAVES THE GEARCASE) AS NEAR THE CASE AS POSSIBLE BEFORE BEING ROUTED TO THE AIR SUPPLY TO PREVENT OIL DRAINING FROM THE CASE.

USE 1/4 O.D. STAINLESS TUBE

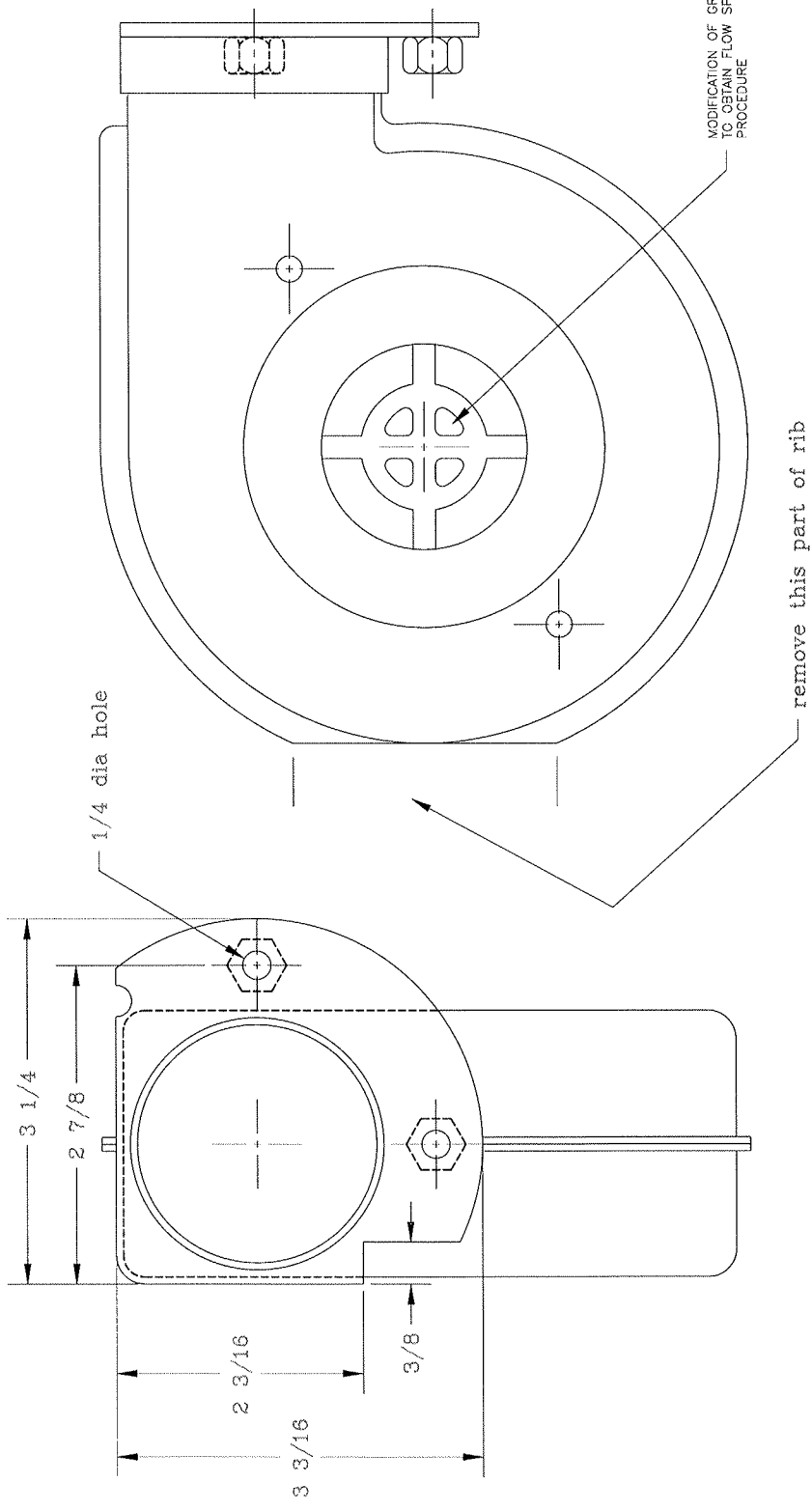
TYPICAL AIR TUBE

* TYPICAL DIMENSIONS

NOTE: STAINLESS 303 OR 304

TOLERANCES (EXCEPT AS NOTED)	ASTM		DWG FILE O:AIRSUPTB
DECIMAL ±	L-60-1	SCALE 1=1	DRAWN BY T. HABY
FRACTION ± 1/16	TITLE AIR SUPPLY TUBE		
ANGULAR 2°	DATE 15JAN2004	DRAWING NO B-4805-1374-Z	

REVISION NO. 2

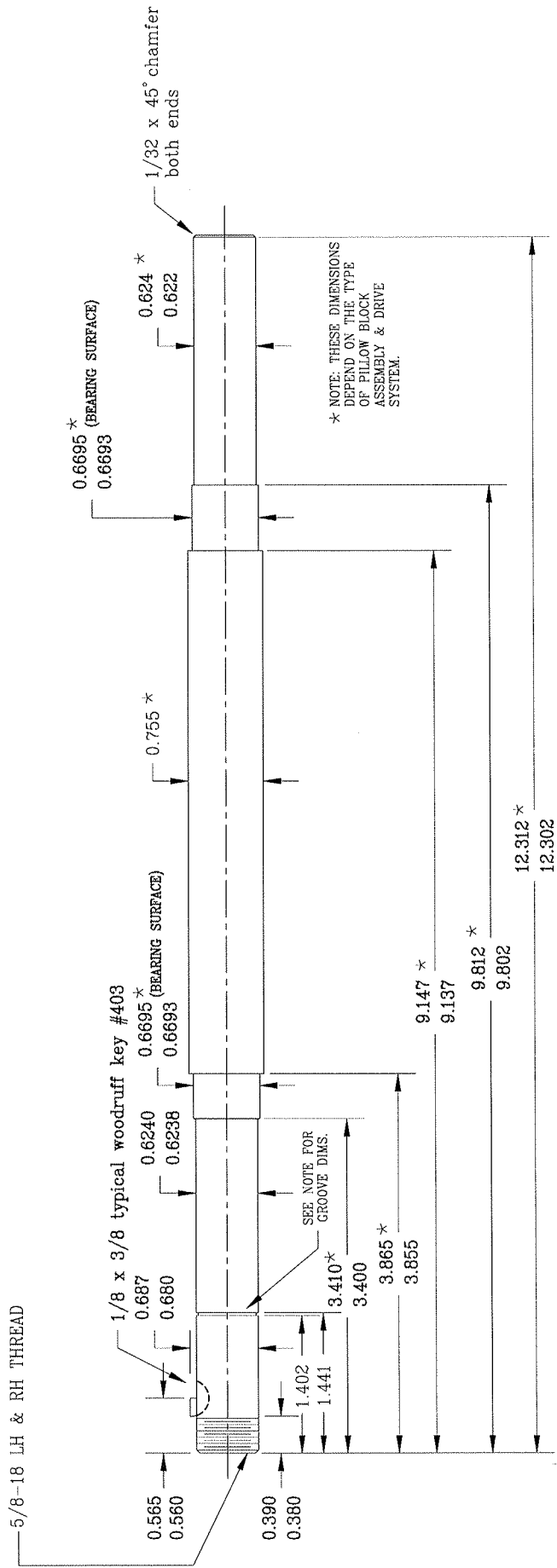


NOTE: MODIFY FLANGE AS SHOWN.
 -ADD 1/4 DIA HOLE AND WELD
 1/4-20 HEX NUTS AS SHOWN.
 -BLOWER HOUSING IS FROM
 DAYTON MODEL 4C440 SHADED
 POLE BLOWER (MOTOR IS NOT
 USED).

TYPICAL BLOWER HOUSING
 (OTHERS MAY BE USED BUT
 MUST COMPLY WITH FLOW
 SPECIFICATIONS IN THE D5704
 PROCEDURE.)

TOLERANCES (EXCEPT AS NOTED)	ASTM		DWG FILE A:86
DECIMAL ±	L-60-1	SCALE 1=1	DRAWN BY T. HABY MATERIAL
FRACTION ± 1/16	TITLE MODIFIED BLOWER HOUSING		
ANGULAR ±	DATE 15JAN2004	DRAWING NO B-3752-1118-Z	

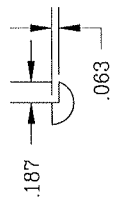
REVISION NO. 1



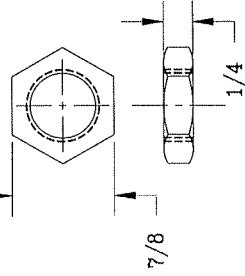
note- .015 rad all corners

- 1 SHAFT-5/8-18 RH THREAD (DRIVER)
- 1 SHAFT-5/8-18 LH THREAD (DRIVEN)

GROOVE DIMENSIONS
DEPTH: .019 ±.001
WIDTH: .039 ±.002



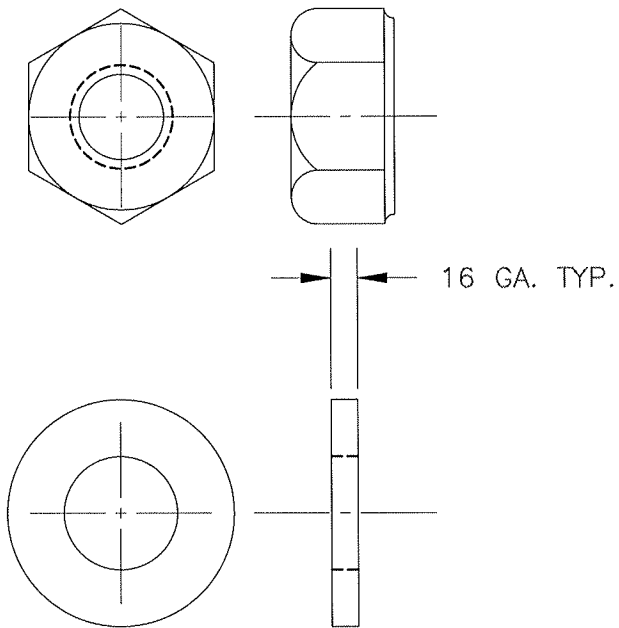
KEY MODIFICATIONS



303 or 304 stainless nut
5/8-18 LH & RH

TOLERANCES (EXCEPT AS NOTED)		ASTM		DWG FILE A:74
DECIMAL ± .001	FRACTION ± 1/32	SCALE 1=1	DRAWN BY T. HABY	MATERIAL DRILL ROD OR SS
TITLE GEAR SHAFT AND NUT (EXTENDED)				
REVISION 2	DATE 15JAN2004	DRAWING NO B-1996-629-Z		

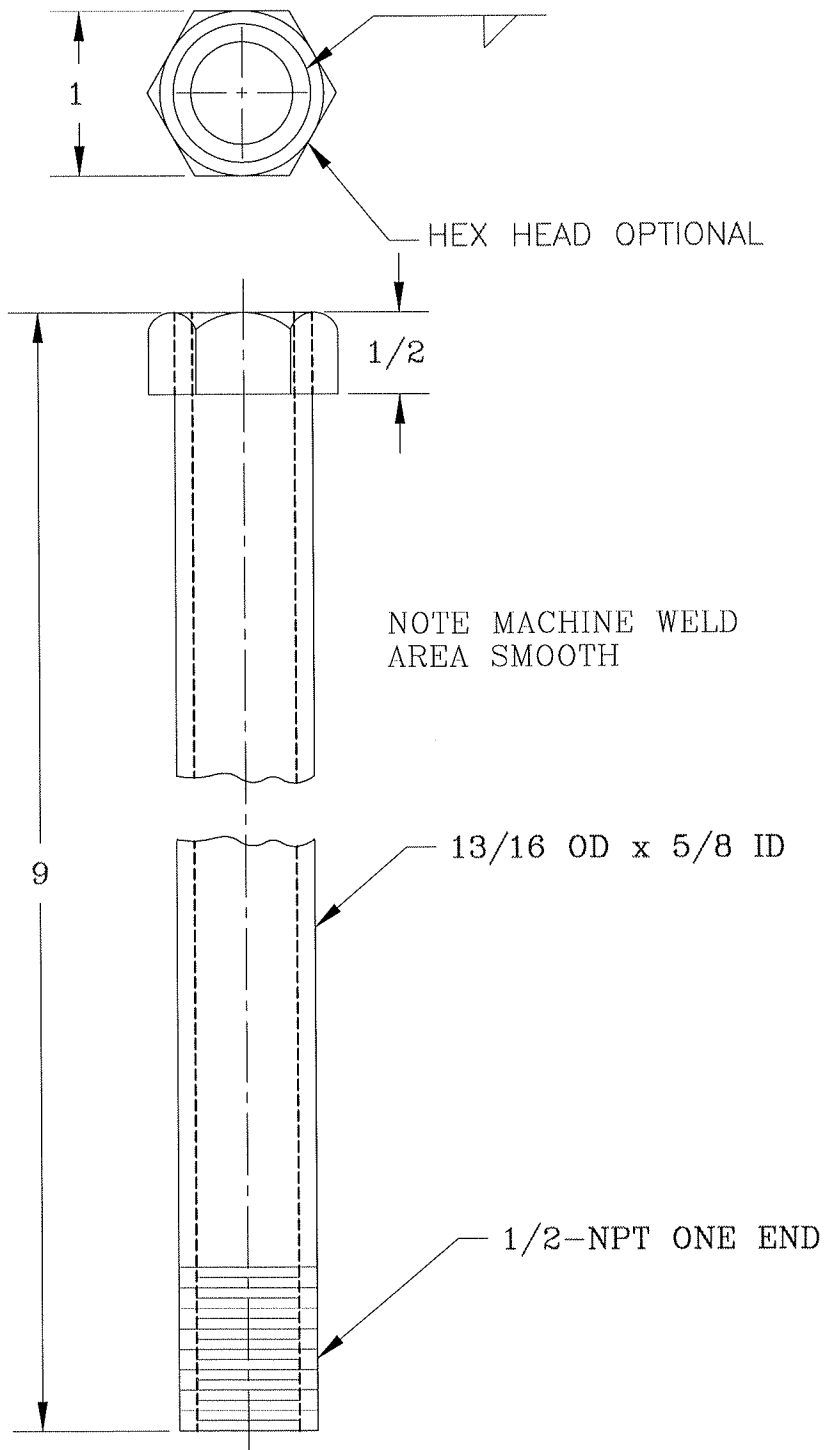
TYPICAL 5/16-18 STAINLESS NUT



TYPICAL STAINLESS WASHER 11/16 OD x 11/32 1D

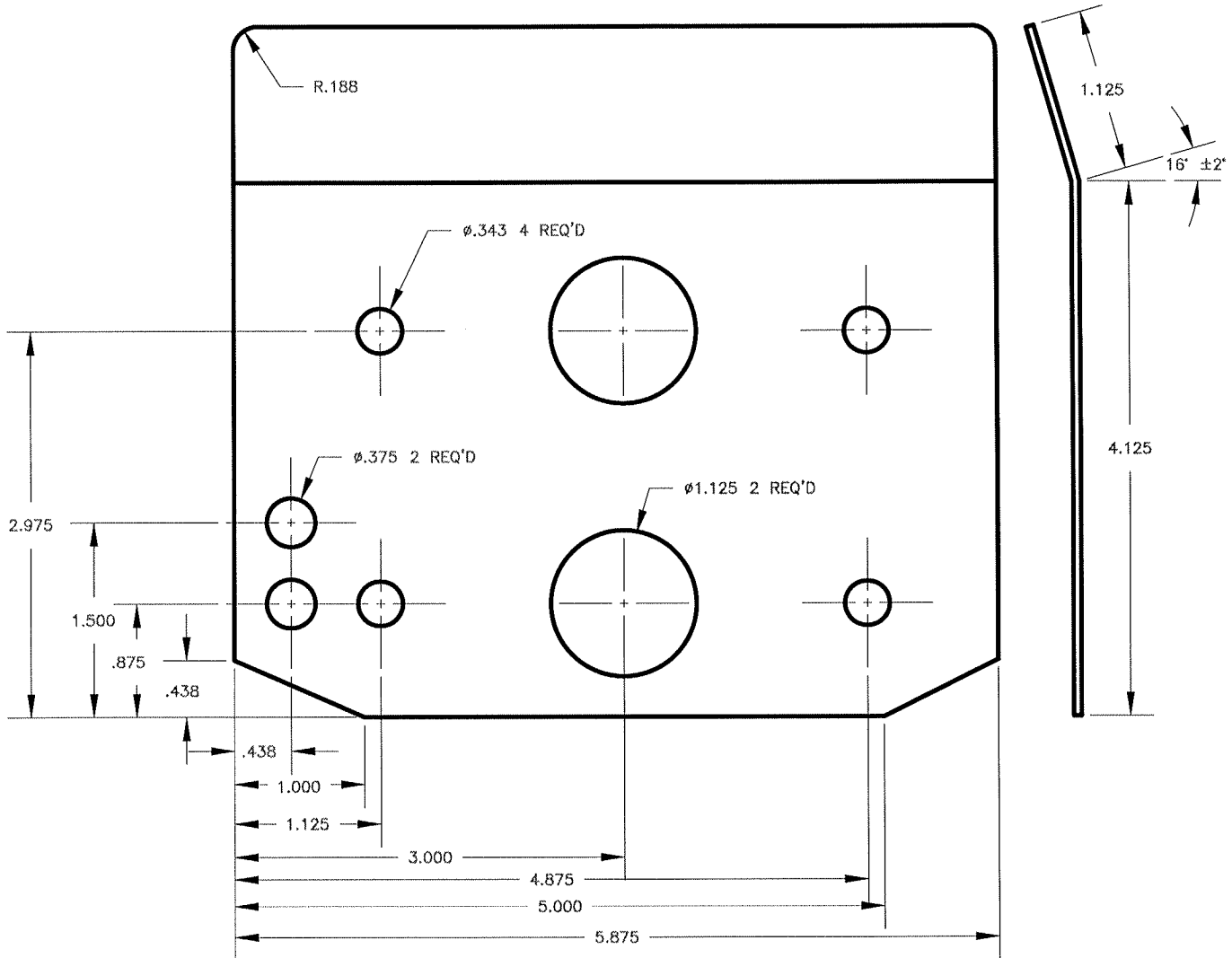
4 EACH REQ'D

REVISION NO. 1			
DWG FILE A:55		L-60-1	TITLE
DRAWN BY T.L. HABY ±			SEAL PLATE NUT AND WASHER
ASTM	SCALE	DATE	DRAWING NO
	2=1	15JAN2004	A:6-6376-44-Z



MAT'L 1/2 SCHED 40 STAINLESS PIPE

REVISION NO. 1			
DWG FILE	A:39	L-60-1	TITLE
DRAWN BY	T.L. HABY ± 1/16		VENT TUBE
ASTM	SCALE	DATE	DRAWING NO
	1=1	14JAN2004	A-6-6376-36-Z

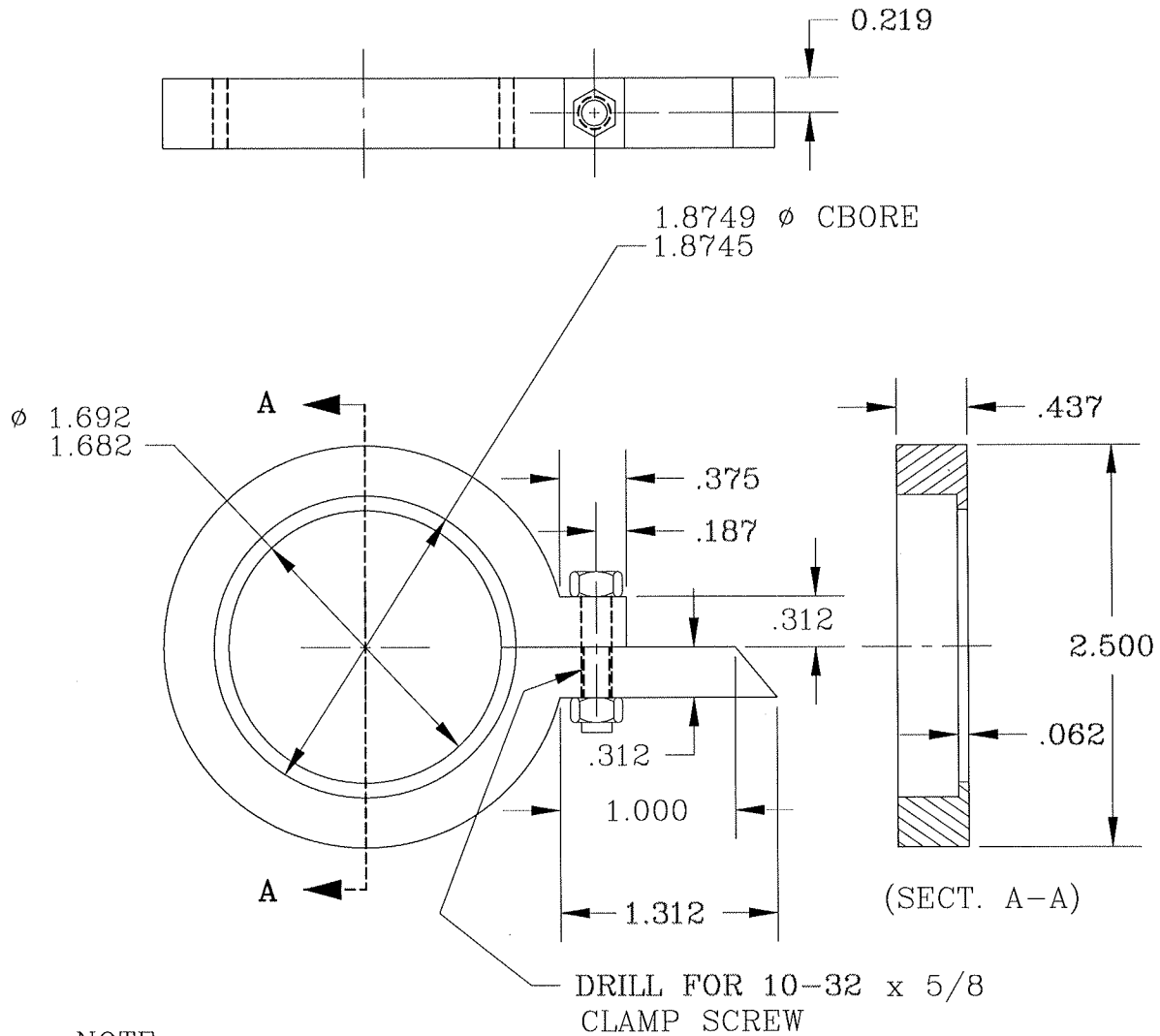


NOTE 1: TOLERANCES ARE FOR FABRICATION PURPOSES ONLY
 NOTE 2: TYPE 303 OR 304 20 GA. 1 REQ'D

MAT'L TYPE 304 20 GA 1 REQ'D

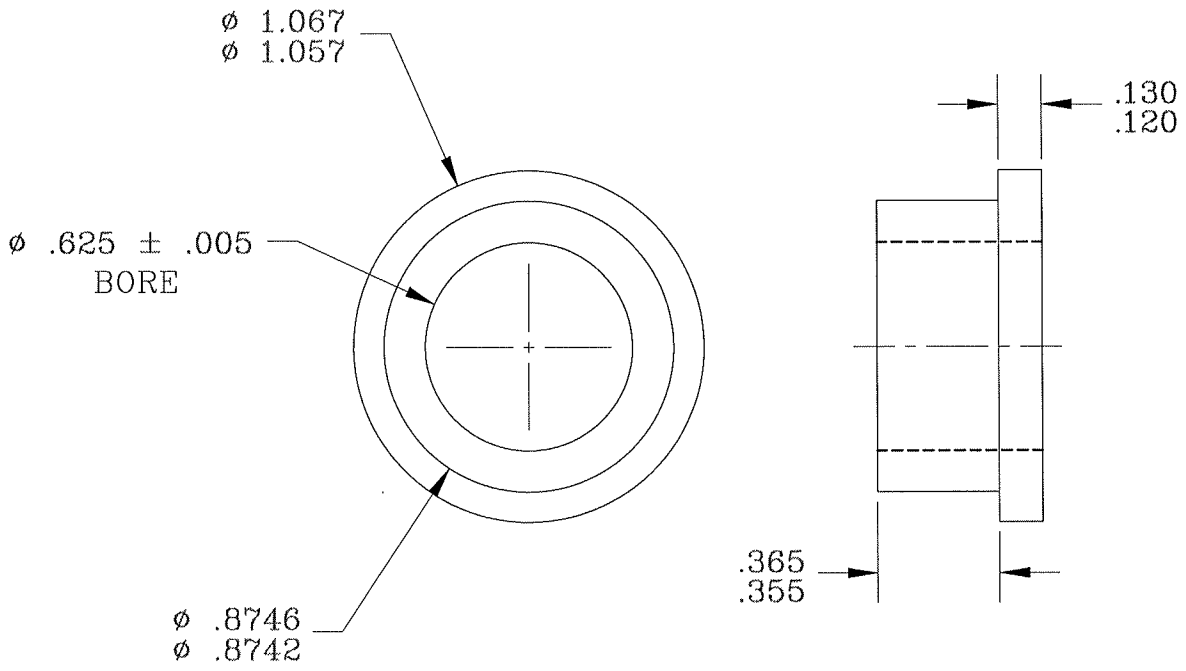
REVISION NO. 2			
DWG FILE	A:34	L-60-1	TITLE
DRAWN BY	T.L. HABY ± .010		BAFFLE PLATE
ASTM		SCALE	DATE
		NTS	15JAN2004
		DRAWING NO	A-6-6376-27-Z

NOTE 1: TOLERANCES ARE FOR FABRICATION PURPOSES ONLY
 NOTE 2: TYPE 303 OR 304 20 GA. 1 REQ'D



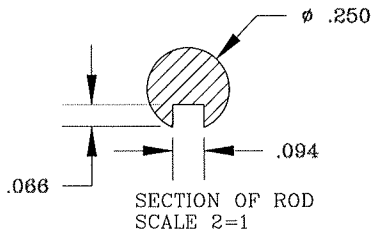
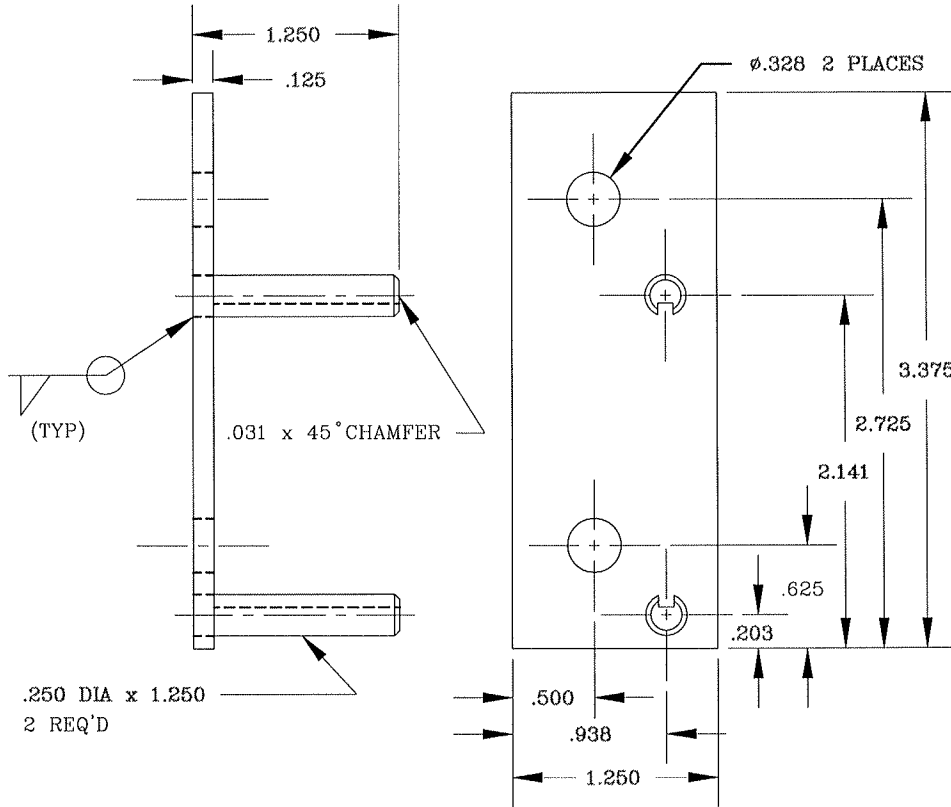
- NOTE—
 1. SAW OUT PART & ROUGH BORE
 2. SLOT & CLAMP TIGHTLY WITH CLAMP SCREW
 3. FINISH MACHINE BORE

REVISION NO. 1			
DWG FILE	A:27	L-60-1	TITLE TEST BEARING CLAMP
DRAWN BY	T.L. HABY ± .005		
ASTM		SCALE	DATE
		1=1	15JAN2004
		DRAWING NO	A-6-6376-25-Z



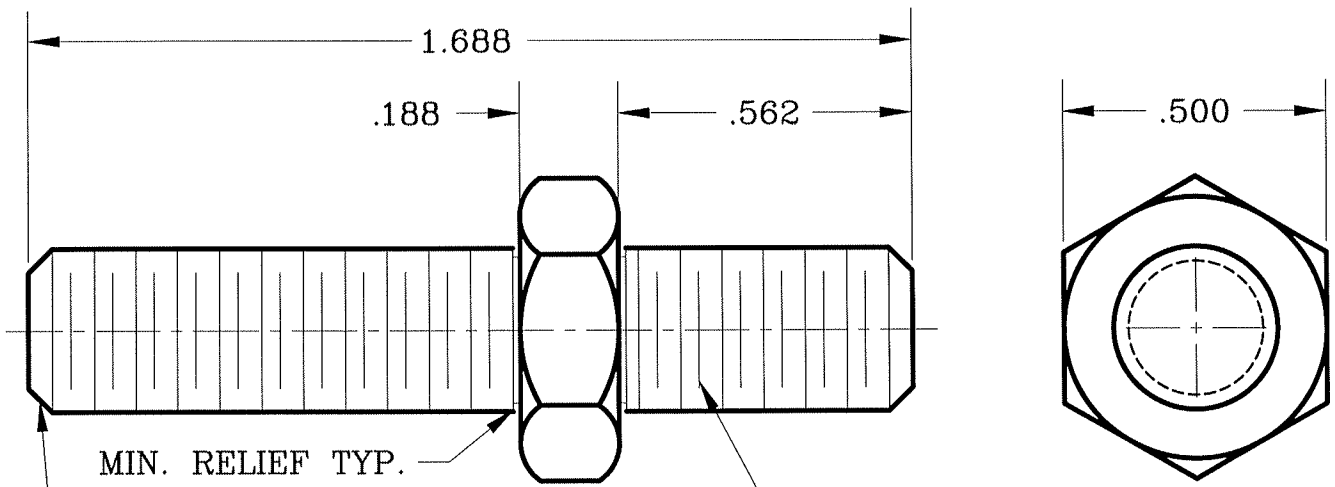
NOTE 1: TOLERANCES ARE FOR FABRICATION PURPOSES ONLY
 NOTE 2: TYPE 303 OR 304 20 GA. 1 REQ'D

REVISION NO. 1			
DWG FILE	A:33	TITLE	
DRAWN BY	T.L. HABY ±	L-60-1	TEST BEARING BUSHING
ASTM		SCALE	DATE
		2=1	15JAN2004
		DRAWING NO	A-6-6376-24-Z



NOTE 1: TOLERANCES ARE FOR FABRICATION PURPOSES ONLY
 NOTE 2: TYPE 303 OR 304 20 GA. 1 REQ'D

REVISION NO. 1			
DWG FILE	A:32	TITLE	
DRAWN BY	T.L. HABY ± .005	L-60-1	CATALYST HOLDER
ASTM	SCALE	DATE	DRAWING NO
	1=1	15JAN2004	A-6-6376-23-Z



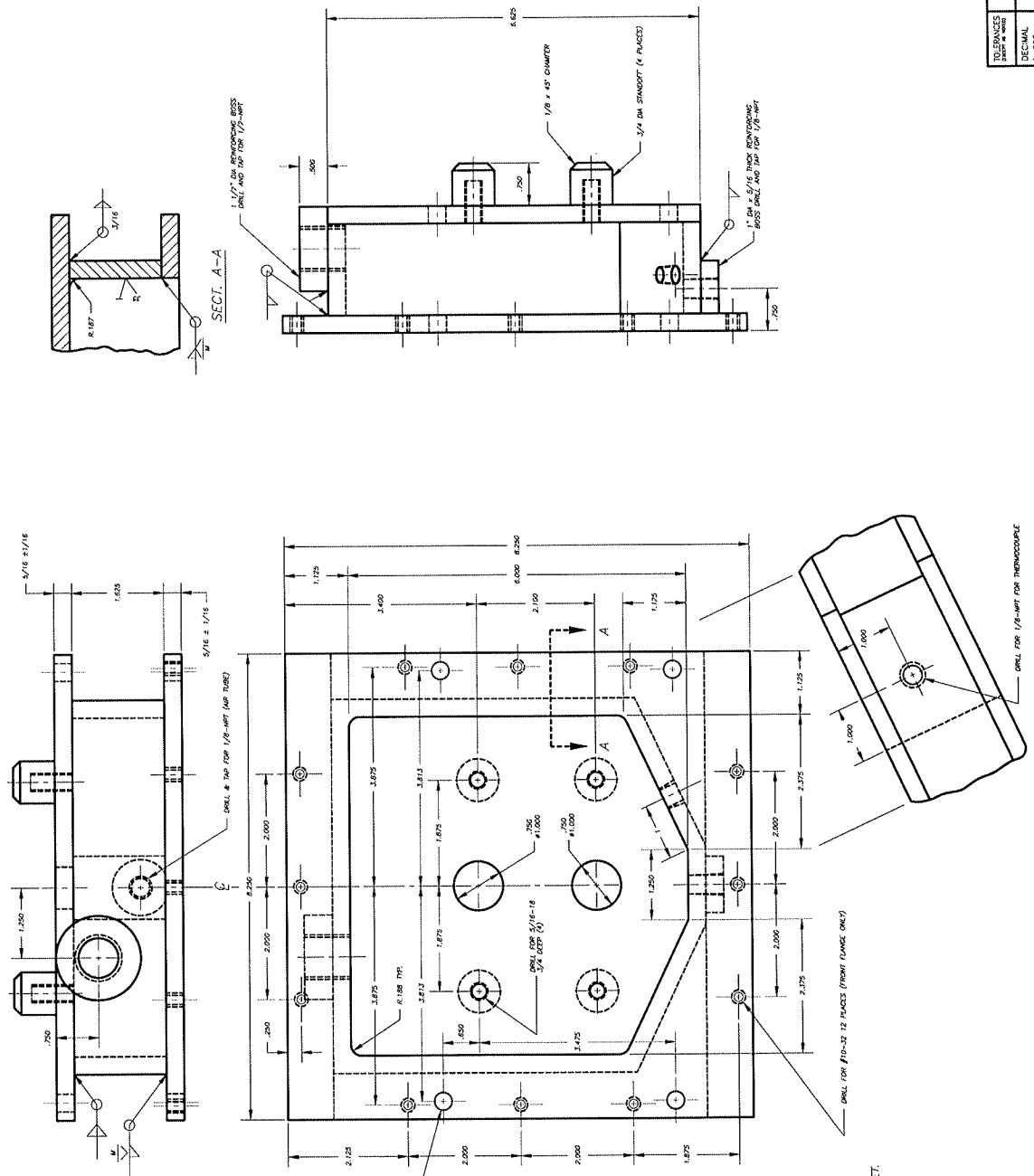
MIN. RELIEF TYP.

.045 x 45° CHAMFER BOTH ENDS TYP. 5/16-18 BOTH ENDS

MAT'L TYPE 303 OR 304 SS 4 REQ'D

REVISION NO. 2		L-60-1	TITLE	
DWG FILE	A:35		SEAL PLATE BOLTS	
DRAWN BY	T.L. HABY ± .010	SCALE	DATE	DRAWING NO
ASTM		3=1	15JAN2004	A-6-6376-19-Z

DESIGNER J. H. HARRIS	DATE 3/24/2004	SECTION 2	SECTION NO. 2
ASTM L-60-1	SCALE 7/8" = 1"	TITLE GEAR CASE	DRAWING NO. D-6-6376-42-Z
DESIGNER J. H. HARRIS	DATE 3/24/2004	SECTION 2	SECTION NO. 2
DESIGNER J. H. HARRIS	DATE 3/24/2004	SECTION 2	SECTION NO. 2



1. MATERIAL - 303 STAINLESS STEEL, 5/16" THICK; ALL JOINTS TO BE WELDED (INSIDE AND OUTSIDE CASE) OR MACHINED FROM BULLET.
2. STRESS RELIEVE AFTER WELDING
3. MACHINE FRONT FACE FLAT ±.001; MACHINE SIDES
4. MACHINE INSIDES OF BACK FLAT ±.001
5. MUST BE LEAK PROOF
6. INSIDE SURFACE OF CASE MUST BE FREE OF TOOL MARKS