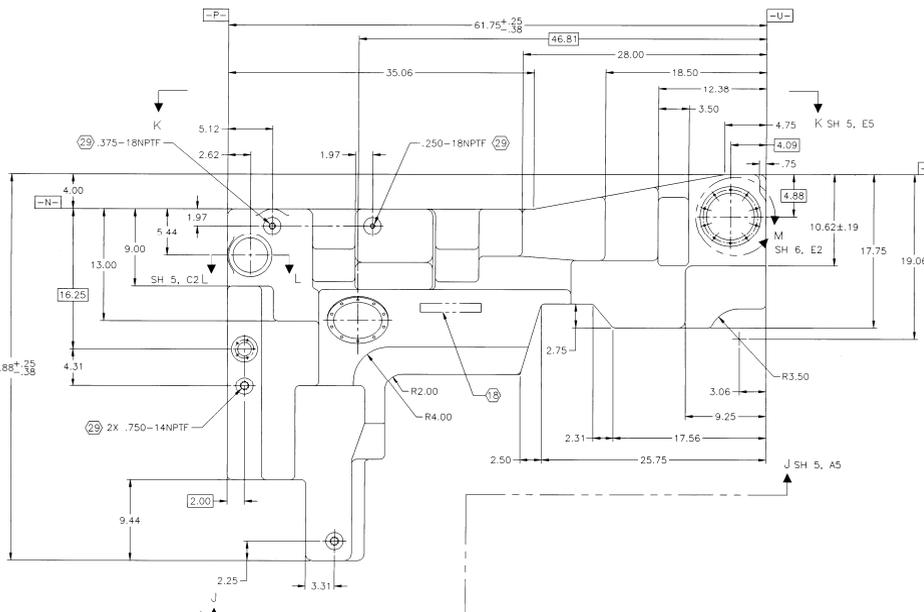


NOTES CONTINUED FROM SHEET 1.

21. MATERIAL:
NYLON, ASTM D4066, PA0422B54220, COLOR, NATURAL.
22. MATERIAL MUST BE CHEMICALLY RESISTANT TO THE FOLLOWING FLUIDS WHEN MIXED WITH 1% BY VOLUME OF FUEL SYSTEM ICING INHIBITOR PER MIL-DTL-27686 AND TESTED IN ACCORDANCE WITH THE APPLICABLE QAP: TAP WATER, ARCTIC DIESEL FUEL A-A-525557, GRADE DF-2 OR COMMERCIAL TURBINE FUEL, DIESEL FUEL A-A-52557, GRADE DF-2 OR COMMERCIAL DF-2; TURBINE FUEL PER MIL-DTL-5624 GRADE JP-4; COMBAT GASOLINE PER ASTM D4814 OR COMMERCIAL UNLEADED GASOLINE PER ASTM D4814.
23. EXTERNAL COATING: ALL EXTERNAL SURFACES EXCEPT GASKET SEALING AREAS AND FUEL TRANSFER NECKS MUST RECEIVE ONE COAT OF ALBI COTE FRL, COLOR WHITE, DRY FILM THICKNESS 1.0 MIL MINIMUM. ALBI COTE FRL IS A PRODUCT OF ALBI MANUFACTURING CO, 100 E MAIN ST, ROCKWELL, CT.
24. WALL THICKNESS: TO BE MINIMUM OF .250 AND A MAXIMUM OF .312 EXCEPT AS OTHERWISE SPECIFIED. MINIMUM THICKNESS OF .160 IS ALLOWED WITHIN ONE INCH OF INSIDE (INWARD) CORNERS. THICKNESS IN THE IMMEDIATE AREA OF FLANGE GASKET SEALING SURFACES MUST BE A MINIMUM OF .230.
25. EXTERIOR SURFACES: POROSITY CAVITIES SHALL NOT EXCEED .125 DIAMETER OR .060 IN DEPTH. PROTRUSIONS SHALL NOT EXCEED .125 DIAMETER OR .060 IN HEIGHT.
26. INTERIOR SURFACES: POROSITY CAVITIES SHALL NOT EXCEED .125 DIAMETER OR .060 IN DEPTH. GAS POCKETS OR VOIDS IN CORNERS ARE ACCEPTABLE AS LONG AS MINIMUM THICKNESS REQUIREMENTS ARE MAINTAINED AFTER ALLOWING FOR SIZE OF VOIDS OR GAS POCKETS.
27. NO CRACKS ARE ALLOWED.
28. WARPING OR DISHING CAN NOT EXCEED .50 INWARD. ANY OUTWARD WARPING OR BULGING MUST NOT CAUSE THE FUEL TANK TO EXCEED DIMENSIONAL TOLERANCES AND OUTWARD BULGING MUST NOT EXCEED .50 UNDER ANY CIRCUMSTANCES.
29. HOLES SPECIFIED AS NATIONAL PIPE TAPERED THREAD (NPTF) MAY BE TAPPED DIRECTLY INTO THE NYLON MATERIAL OR MAY BE TAPPED INTO EMBEDDED METALLIC INSERTS. EMBEDDED INSERTS WILL BE CONSTRUCTED OF MATERIAL: FREE CUTTING BRASS RODS, BARS AND SHAPES, TEMPER OPTIONAL PER SPEC ASTM B16. EMBEDDED INSERTS MUST BE ABLE TO RESIST A TORQUE SUFFICIENT TO SEAL AN APPROPRIATE SIZE BRASS PLUG WITHOUT LEAKAGE OR VISUAL DEFORMATION TO THE INSERT OR SURROUNDING NYLON MATERIAL.
30. ALL SCREW THREADED HOLES MUST BE BLIND HOLES TAPPED INTO METALLIC INSERTS IMBEDDED IN THE PLASTIC MATERIAL DURING THE MOLDING PROCESS. THE MATERIAL OF THESE INSERTS MUST BE: FREE MACHINING STAINLESS AND HEAT RESISTANT STEEL, TYPE 303 CONDITION A, SPEC ASTM A581. TAPPING OF SCREW THREADS DIRECTLY INTO THE PLASTIC MATERIAL IS NOT ALLOWED. DEPTH SPECIFIED ON SCREW THREAD CALLOUTS IS USABLE THREAD DEPTH. ALL IMBEDDED INSERTS MUST BE CAPABLE OF RESISTING THE APPLICABLE TORQUE WITHOUT ANY EVIDENCE OF RELATIVE PLASTIC TO METAL DISPLACEMENT.
THREAD SIZE TEST TORQUE AT 70°F±5°
10-24 UNC-2B 72 LB-FT
.250-20 UNC-2B 10 LB-FT
31. FLANGE OR FLANGE SURFACE MOUNT DESIGN IS NOT CONSTRUED TO LIMIT CONSTRUCTION WITH FEATURES AS SHOWN HERE BY DIMENSIONS AND CONFIGURATION.
32. THE FOLLOWING TOLERANCES SHALL APPLY UNLESS OTHERWISE SPECIFIED (INCHES):
.01 TO 5.00 DIMENSION ±.06
5.01 TO 10.00 DIMENSION ±.12
10.01 TO 30.00 DIMENSION ±.25
30.01 AND OVER DIMENSION ±.38
33. ALL FILLETS AND RADII TO BE 1.00±.12 UNLESS OTHERWISE SPECIFIED.
34. PART SHALL MEET CLEANLINESS REQUIREMENTS OF MIL-STD-1246, LEVEL 300.
35. LEAKAGE TEST:
THE FUEL TANK SHALL BE SUBJECTED TO THREE (3) PSIG INTERNAL PRESSURE FOR TEN (10) MINUTES. ANY PRESSURE DROP WILL BE CAUSE FOR REJECTION.
36. THE TANK SHALL BE SHIPPED AND STORED IN A CONTAINER WHICH PROTECTS IT FROM DIRECT SUNLIGHT AND PHYSICAL ABUSE.



DISTRIBUTION STATEMENT A
APPROVED FOR PUBLIC RELEASE:
DISTRIBUTION IS UNLIMITED.

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES		DESIGN NUMBER		PART NO. 12361460	
3 PLACES	3 PLACES	12361460-01	DESIGN ACTIVITY		
3	3	12361460-02	U.S. ARMY PARK AUTOMOTIVE AND AERONAUTICS COMMAND		
		12361460-03	WARREN, MICHIGAN 48397-5000		
		12361460-04	FUEL TANK, LOWER		
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