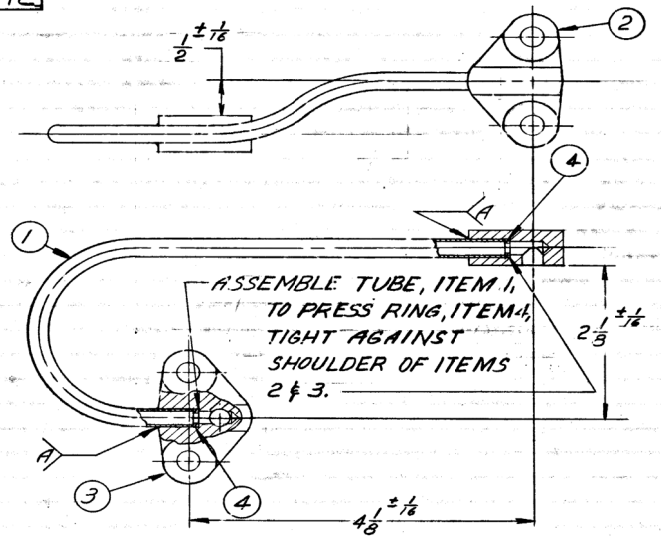
8039842

TOLERANCES ON ALL DIMENSIONS NOT SPECIFIED ON THE DRAWING TO BE IN ACCORDANCE WITH A.I.-2100.

BREAK ALL SHARP CORNERS UNLESS OTHERWISE SPECIFIED.

COUNTERSINK ALL TAPPED HOLES 1 1/8" X ONE THR'D DEEP.

SURFACE FINISH SPECS. IS IN ACCORDANCE WITH G.M. ENGR. STDS.



SCALE TO BE REMOVED WITH AN ACID PICKLE BATH.
USE AN INHIBITOR IN PICKLE BATH.

BRAZE NOTE "A":
BRAZE WITH IT. 4.
FLUX WITH IT. 5.

PROCESS PER IT. 6

(K1) TEST TO INSURE FREE FLOW THROUGH TUBE ASSEMBLY AFTER BRAZING.

X	A.I. 1953	CLEANING OF PIPING		6
AS REQ.	E.M.S. 870	BRAZING FLUX		5
2		RING-BRAZING	8194632	4
1		FLANGE	8029185	3
1		FLANGE	8029184	2
1		TUBING-1/4	8039841	1
NO. REQUIRED PER ASSEMBLY	MATERIAL	NAME OF PART	PART NO.	IT. NO.

DR. S. TARKEY 12-21-38
CH. S. TARKEY 12-21-36
SUP.
WELD. MOD. ENGR.
MAT'L. ENGR.

ELECTRO-MOTIVE DIVISION
GENERAL MOTORS CORPORATION
LA GRANGE, ILLINOIS, U.S.A.

LUBE OIL LINE ASM

DATE OF PRINT

PART NO. 8039842

R.F.C. NO.	REV. LET.	REVISION	DATE	BY	CK.	APV'D.
CON'T	K,	NOTE ADDED				
03955	K	COPPER FLASH NOTE REVS. IT. 4 WAS E.M.S. 864 IT. 3 WAS 8339069 IT. 2 WAS 8339068 IT. 1 WAS 8339067 REDRAWN	11-5-46	CB		
FIRST USED ON		567 ENG.				

Form EMD 417-G 3000 11-46

GLENNON & KEENE, INC., CHICAGO

A B