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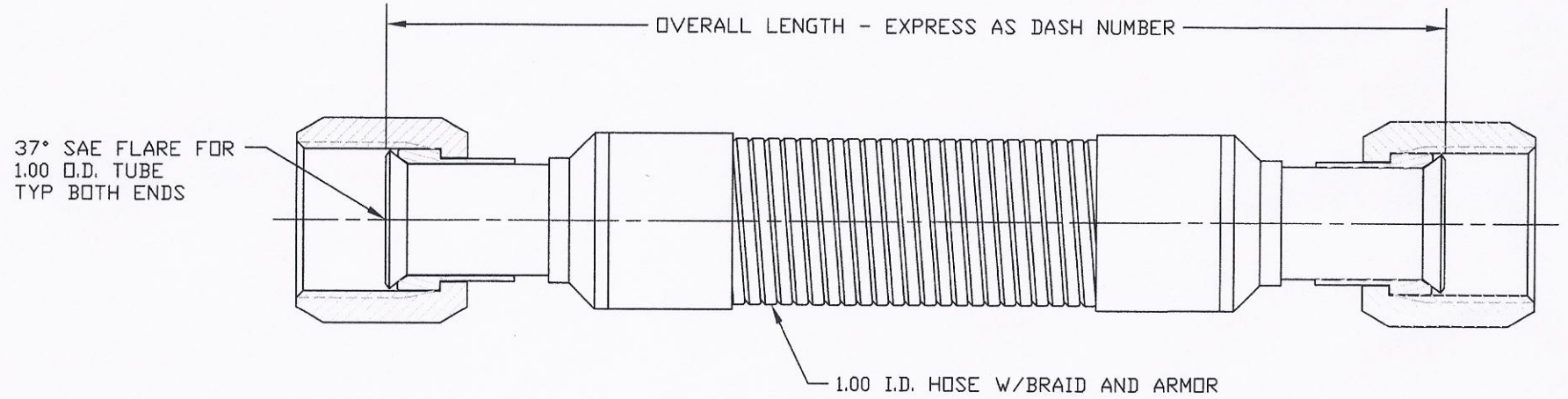
REVISIONS

LTR	DESCRIPTION	DATE	APPROVAL
A	ADD NOTE 3, OPERATING SPEC	06-06-02	HK
B	MAX WORKING PRESSURE WAS 375 PSIG INT	04-03-09	HK
C	ADD NOTE 4, CLERICAL UPDATES	10-25-12	JO



PART NUMBER SYSTEM:
ORDER PART NUMBER = 11910 - XXX

SPECIFY OVERALL LENGTH WITH DASH NUMBER IN WHOLE INCHES
EXAMPLE: -060 = A 60 INCH LONG HOSE

GENERAL NOTES:

1. CLEAN FOR OXYGEN SERVICE PER CGA G-4.1 AND PACKAGE IN A SEALED POLY BAG.
2. IDENTIFY HOSE AS FOLLOWS:
   MACRO TECH, KIRKLAND, WA
   P/N 11910-XXX (SEE DASH NO.)
   ASSY DATE CODE
3. OPERATING SPECIFICATIONS:
   TEMPERATURE: -350° TO + 350° F
   MAX. WORKING PRESSURE: 450 PSIG INTERNAL
   BEND RADIUS: STATIC = 2.00 , DYNAMIC = 8.00
4. PRESSURE TEST EACH ASSEMBLY AS FOLLOWS:
   HYDROSTATIC, INTERNAL TO 675 PSIG, NO VISIBLE SIGNS OF LEAKAGE IN 1 MINUTE

-2	-1	BSC	FSCM NO.	PART NUMBER	PART DESCRIPTION	MATERIAL / FINISH SPECIFICATION	ITEM
QUANTITY REQ'D			PARTS LIST				

NEXT ASSY PART NO.	QUAN

DRILLED HOLE TOL.
.013 TO .125 = +.004 -.001
.125 TO .250 = +.005 -.001
.250 TO .500 = +.006 -.001
.500 TO .750 = +.008 -.001
.750 TO 1.00 = +.010 -.001
1.00 TO 1.50 = +.012 -.001

* UNLESS OTHERWISE SPECIFIED *
ALL DIMENSIONS ARE IN INCHES AND ARE TO BE MET BEFORE PLATING

TOLERANCES ARE:
DECIMALS: .XX = ± .030 .XXX = ± .010
ANGULAR: ± .5°

BREAK SHARP EDGES .005-.010 & REMOVE BURRS
MACHINED FILLETS TO BE .010-.030 RADIUS
CONC. = .005 TIR; SQUARENESS = .005 PER INCH
GENERAL FINISH TO BE 100 RMS PER ASA B46.1

MATERIAL / SPEC: 304/316 CRES
HEAT TREAT / SPEC: NONE
FINISH / SPEC: NOTED

CONTRACT NO.
CUSTOMER SPEC
CUSTOMER
DESIGN ACTIVITY — DATE
CHECKED BY — DATE
ENGR — DATE
DRAWN BY: HK — DATE: 09-30-94

Macro Technologies LLC
12530 - 135th Ave N.E. * Kirkland, WA * 98034

TITLE: HOSE ASSY, 1.00 ID W/ARMOR

SIZE	CAGE CODE	DRAWING NO.	REV
B	62529	S-11910	C

SCALE	AQL LEVEL	SHEET	OF
NONE		1	1