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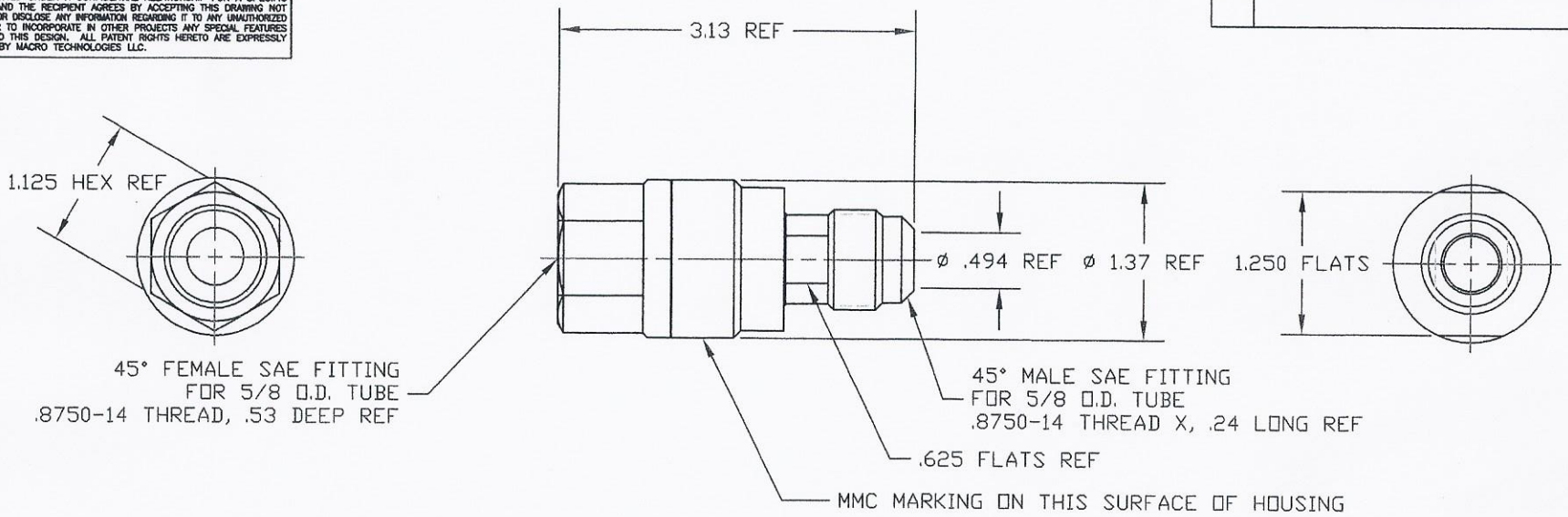
REVISIONS			
LTR	DESCRIPTION	DATE	APPROVAL



1. CLEAN ALL DETAILS FOR OXYGEN SERVICE PER CGA G-4.1
2. ASSEMBLE AND PACKAGE IN A SEALED POLY BAG IDENTIFIED PER WORK ORDER REQUIREMENTS
3. OPERATING SPECFICATIONS:
   TEMPERATURE: -325°F - +175°F
   PRESSURE: 0.00 TO +350.0 PSIG INTERNAL
   ROTATIONAL SPEED @ 350 PSI: 10 RPM MAX (100% DC)
4. SWIVEL REPAIR KIT: P/N 9551-RK
5. DESIGN CODE: ASME B31.3 2010
6. IMPACT TEST EXEMPT PER 323.2.2 AND 323.2.3 IN ACCORDANCE WITH UNF-65
7. PNEUMATIC TEST PRESSURE: 425 PSIG
8. MMC MARKED ON ø 1.37 SURFACE INDICATED
9. ALL DIMENSIONS CONTROLLED BY SUBDRAWINGS
10. MATERIAL PROPERTIES FOR HOUSING, TP303, ASTM A582:
    MIN TENSILE STRENGTH 75000 PSI
    MIN YIELD STRENGTH 30000 PSI

REFERENCE ONLY

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

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

NEXT ASSY PART NO.	QUAN

* 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: CRES, PTFE, SILICONE, BRASS
HEAT TREAT / SPEC: NONE
FINISH / SPEC: NOTED

CONTRACT NO.
CUSTOMER SPEC
CUSTOMER
DESIGN ACTIVITY — DATE
CHECKED BY — DATE
ENGR — DATE
DRAWN BY: JD — DATE: 03-06-14

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

TITLE
SWIVEL, CRYOGENIC, OXYGEN COMP.
5/8 TUBE SIZE 45° SAE, M x F

SIZE	CAGE CODE	DRAWING NO.	REV
B	62529	S-9551-3	

SCALE: NONE — AQL LEVEL — SHEET 1 OF 1