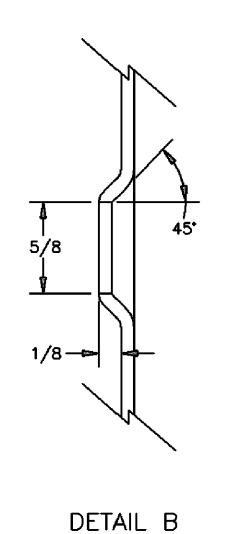


MAGNESIUM ANODE



SCALE NTS

SEE NOTE 10

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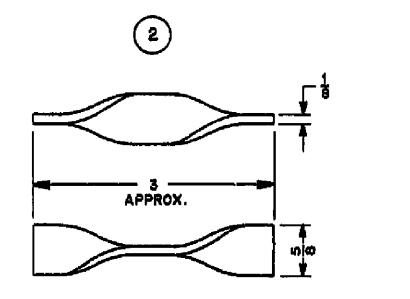
(11)- SEE NOTES 8 & 9

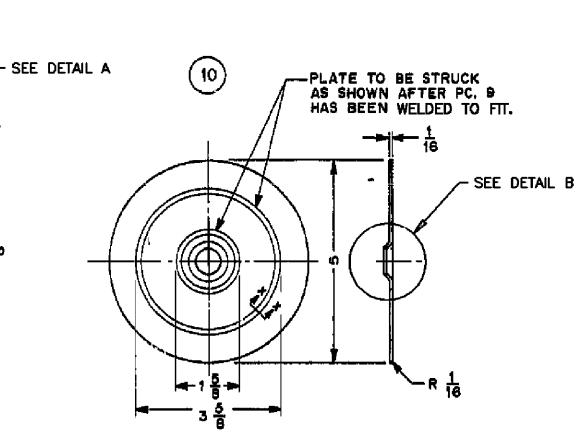
CROSSPIECE WELDED TO NUT BEFORE

CASTING.

← 4 APPROX.

- 17. THE MAGNESIUM ALLOY SHALL BE TYPE AZ63B IN ACCORDANCE WITH ASTM SPECIFICATION B843-93 (1998). THE MANUFACTURER SHALL CONFIRM THIS IN THEIR TENDER RESPONSE
- 18. PIECES 9 & 10 SHALL BE WELDED TOGETHER, WITH PIECE 9 WITHIN 2 DEGREES OF PERPENDICULAR TO PIECE 10. ALL WELDING FLASH AND ROUGH EDGES SHALL BE REMOVED SO AS TO AVOID PUNCTURING THE INSULATION.
- 19. THE INSULATING COMPOUND (POLYVINYL CHLORIDE 20 TO 45 DUROMETER HARDNESS BEFORE AGING) COATING THE PIECE 9 & 10 ASSEMBLY SHALL BE APPROXIMATELY 3/4 INCHES THICK, TOP & BOTTOM SUCH THAT THE COMPLETED ASSEMBLY SITS FLUSH UNDER PIECE 8. THIS WILL ALLOW THE COMPLETED ASSEMBLY (NOTE 20) TO BE WELDED TO THE VESSEL'S HULL PLATING.
- 20. AFTER FINAL COMPLETION OF PIECES 8, 9 & 10, THEY ARE TO BE SUITABLY CLEANED, ALIGNED AND THEN SECURELY GLUED TOGETHER USING LOCTITE BONDING COMPOUND E-30CL OR EQUIVALENT. IN ORDER TO GET A TIGHT FIT BETWEEN THE TWO SURFACES, IT MAY BE NECESSARY TO ENLARGE THE HOLE IN PIECE 8 SO THAT THE INSULATION ON THE SHOULDER OF THE BOLT PIECE 9, FITS CLEANLY THROUGH THE HOLE.
- 21. AFTER THE PIECES HAVE BEEN GLUED TOGETHER, PLACE THE "SHIPPING BLOCK" ON THE STUD, ADD THE LOCK WASHER AND THEN PUT THE "JAM NUT/WASHER" ASSEMBLY ON FINGER TIGHT. WITH A MEGGER (250 OR 500 VOLTS), MEASURE THE INSULATION RESISTANCE BETWEEN THE STUD AND THE "MOUNTING PLATE" (PIECE 8). THE RESISTANCE SHALL BE AT LEAST 10 MEGOHMS, OTHERWISE THE ASSEMBLY IS NOT ACCEPTABLE.





LIST OF MATERIAL										
PC Na	DESCRIPTION	QTY.	MATERIAL	MATERIAL SPEC.	FINISH	NAV. CAT.				
	MAGNESIUM ANODE ASSEMBLY NAV. CAT. 5340-001-3732									
	MAGNESIUM ANODE ASSY.			!	_					
1	ANODE MK V TYPE A	1	MAG. ALLOY	сомм.	SEE NOTES 15 & 17	5340-21-001-3732				
2	CROSS PIECE SUPPORT	1	STEEL	сомм.	SEÉ NOTE 2					
3	NUT, 5/8-18 AMER. STD. HEX. (Semi. Fin.)	1	STEEL	COMM.	SEE NOTE 2					
	RESISTOR MOUNTING ASSEMBLY NAV. CAT. 2040-001-3733									
4	LOCK WASHER, 5/6 X 13/64 X 3/32, S.A.E. STD.	1	STEEL	сомм.	ZINC					
5	JAM NUT, 5/8-19 AMER. STD. HEX. (Semi. fin.)	1	STEEL	COMM.	SEE NOTE 5	<b>2040~21~797~</b> 4286				
6	WASHER, 21/32 (.D. 1 & 5/16 O.D095 THK.	-	BRASS			2040-21-737-4286				
7	ANODE RESISTANCE WASHER MK 1.		NOT SUPPLIED	EEC-STD-138		5905-442-1715				
8	MOUNTING PLATE	1	STEEL	SAE 1010- 1020						
9	CAP SCREW, 5/8-18, AMER.STD. F.H.M. (SEMI. FIN.)	1	STEEL	сомм.	SEE NOTE 6					
10	PLATE	1	STEEL	SAE 1010 - 1020	SEE NOTE 19					
11	INSULATION	1	POLYVINYL CHLORIDE MELT MIX	MIL-R-900						

\* \* MIL-R-900 EXCEPT WAIVE REGUIREMENT FOR: (A) HARDNESS BEFORE AGING, PARA 3-7-1. (B) ULTIMATE ELONGATION AFTER AGING. (C) COMPRESSION SET.

(D) SEAL TEST AGED.

## NOTES:

SECTION X-X

- 2. AFTER WELDING TOGETHER, pcs 2 & 3 TO BE ELECTRIC ZINC PLATED IN ACCORDANCE WITH ASTM SPECIFICATION B633-98e1. PLATING SHALL BE A MINIMUM OF 5 MICROMETRES IN THICKNESS.
- 3 RESISTANCE TO BE DEMANDED SEPARATELY FOR EACH APPLICATION.
- 4. THE SURFACE OF THE MOUNTING PLATE, PC. 8 WHERE ACTING AS CONTACT SURFACE FOR EEC-STD-138 SHALL BE TINNED TO ENSURE GOOD ELECTRICAL CONNECTION,
- 5. THE WELDING OF THE JAM NUT (PC. 5) TO THE BRASS WASHER (PC. 6) TO BE DONE BY THE MANUFACTURER, WITH SILVER SOLDER.
- 6. PC. Nº 9 MACHINED FROM AMER, STD. CAP SCREW.
- 7. SURFACES OF PC. Nº 8 & 10 TO BE THOROUGHLY CLEANED AND PREPARED BEFORE APPLYING INSULATION AND CEMENTING.
- 8. AFTER CASTING, MAGNESIUM ANODE TO BE HOT-DIPPED IN POLYVINYL CHLORIDE CAPSULATING COMPOUND TO A THICKNESS OF APPROX. 1/16. A PRIMER SHOULD BE USED TO ENSURE AN ADEQUATE BOND STRENGTH.
- 9. THE CAPSULATING COMPOUND SHALL HAVE A MINIMUM PREL STRENGTH OF 10 LBS. PER INCH
- 10. EDGE OF CENTRE HOLE SHALL BE ROUNDED AND FREE OF BURRS. OUTER EDGE OF PLATE SHALL BE FREE OF BURRS.
- 11. ALL PARTS SHALL BE POSITIONED BY JIG WHILE WELDING TO INSURE PROPER ALIGNMENT.
- 12. ALL SHARP EDGES SHALL BE SLIGHTLY ROUNDED.
- 13. A LABEL SHALL BE PROVIDED ON THE UNIT GIVING THE MANUFACTURER'S NAME OR INITIALS NOT LESS THAN 1/4" HIGH. THIS IDENTIFICATION SHALL BE THAT OF THE PRIME MANUFACTURER RESPONSIBLE FOR FINAL ACCEPTANCE OF THE EQUIPMENT. THE LABEL SHALL ALSO INCLUDE THE APPLICABLE STOCK NUMBER, DRAWING NUMBER, TYPE NUMBER AND DATE OF MANUFACTURE.
- 14. THE ADEQUATE STRENGTH OF WELDED COMPONENTS SHALL BE DETERMINED FROM PERIODIC CHECKS ON PRODUCTION SAMPLES BY SUBJECTING THE WELDED PIECES TO DIRECT IMPACT BLOWS OF A HAMMER SUFFICIENT TO COMPLETELY BEND, DISTORT OR CRUSH THE WELDED PIECES WITHOUT THEIR BEING TORN APART.
- 15. CASTINGS SHALL BE FREE FROM COLD SHUTS, BLOW HOLES, OR ANY IMPERFECTIONS THAT MAY AFFECT THE STRENGTH IN ANY WAY. ALL SURFACES OF CASTINGS SHALL HAVE ALL FINS AND BURRS REMOVED. SAND SURFACES SHALL BE DISTURBED AS LITTLE AS POSSIBLE.
- 16. BEFORE SHIPMENT ON AN ORIGINAL CONTRACT (ie. MANUFACTURER HAS NOT PROVIDED AN ACCEPTABLE PRODUCT PREVIOUSLY), TWO PRE-PRODUCTION SAMPLES ARE TO BE FORWARDED BY THE MANUFACTURER TO THE TECHNICAL AUTHORITY.

	JEZUNII/ NAIIIY	l l	MANAGE HENDERN	L I P L A	
CIFIED OTHERWISE	SECURITY RATING	NAVAL HEADQUARTERS DIRECTOR GENERAL SHIPS			
ERANCES UHLESS	SEE TABLE BELOW FOR SECURITY CLASSIFICATION OF DRAWING	NO.	REVISIONS	DATE	BY
REPLACES REVISI	ON '9' WITH CHANGES	13 12 11 10	T DAN Nº 874570020	CANA	87 <u>-</u> 27
		11	TDAN 934570038	93·09· 20	SC/ NB
		12	TDAN 024570027	03-02 -28	ΑT
•		13	TDAN 034570031	03-12 -04	AT
		14	TDAN 084571026	09-01 -26	AT

TOLERANCES UNLESS	SEE TABLE BELOW FOR BECURITY CLASSIFICATION OF DRAWING	NO. REVISIONS DATE BY			
SPECIFIED OTHERWISE	SECURITY RATING	NAVAL HEADQUARTERS			
DECIMALS ± .008	TOP SEQRET	DIRECTOR GENERAL SHIPS			
FRACTIONS ± 1/64 ANGLES ± 1/2 DIMENSIONS ARE IN INCHES	-SECRET	MK. V MAGNESIUM ALLOY ANODE			
TOLERANCES MUST NOT	CONFIDENTIAL	a Resistor Mounting			
BE ACCUMULATIVE	RESTRICTED	DRN. W. Land TCD. MA GAGNON SC.			
	UNCLASSIFIED	CKD. QEBANN APD. Blanky DATE Fr. 3. 1958			
PREFERENCE DIVAWING		OF 1 DWG. 5340STD. 137			
		M4 (m			

D.O. REO. NO. 1542 M. (M)