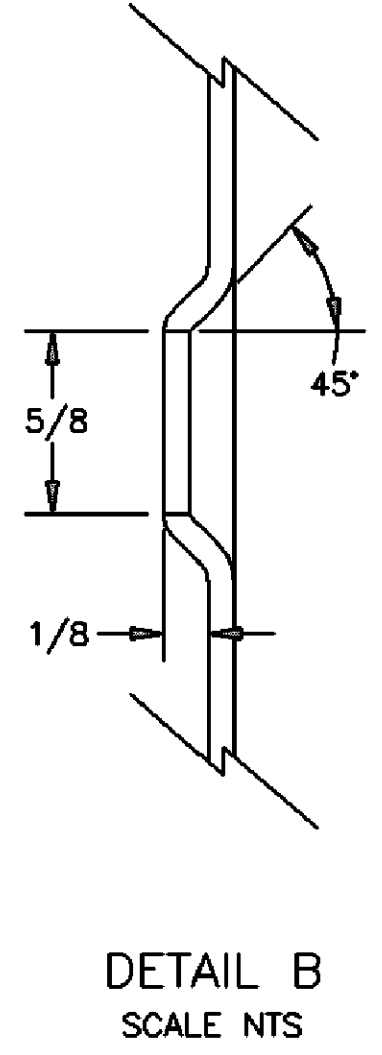
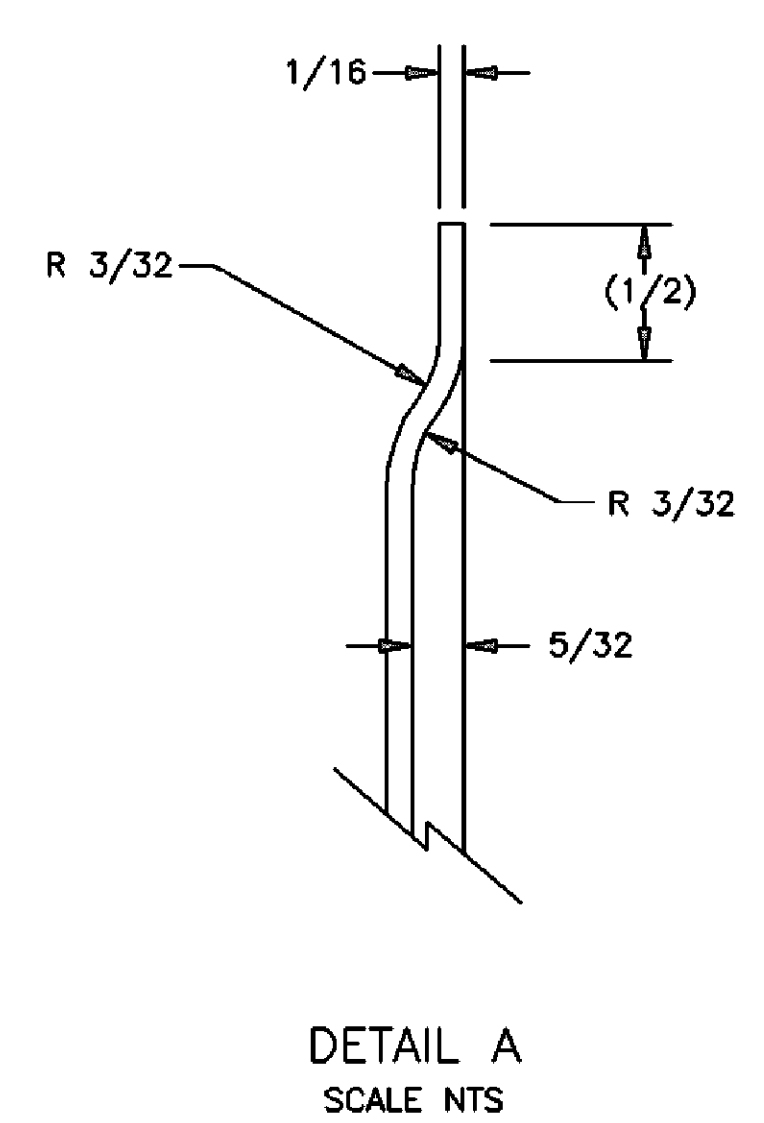
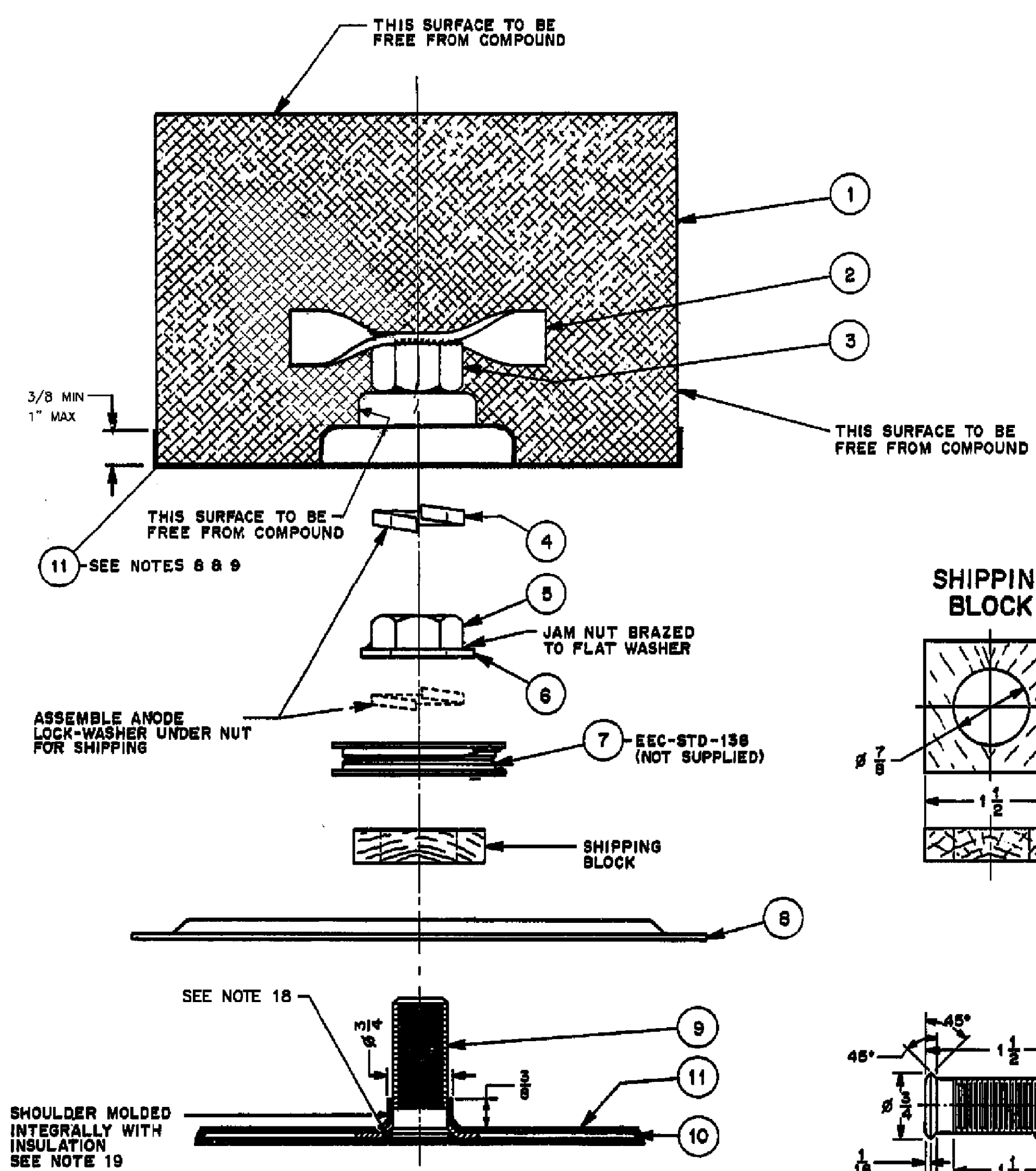
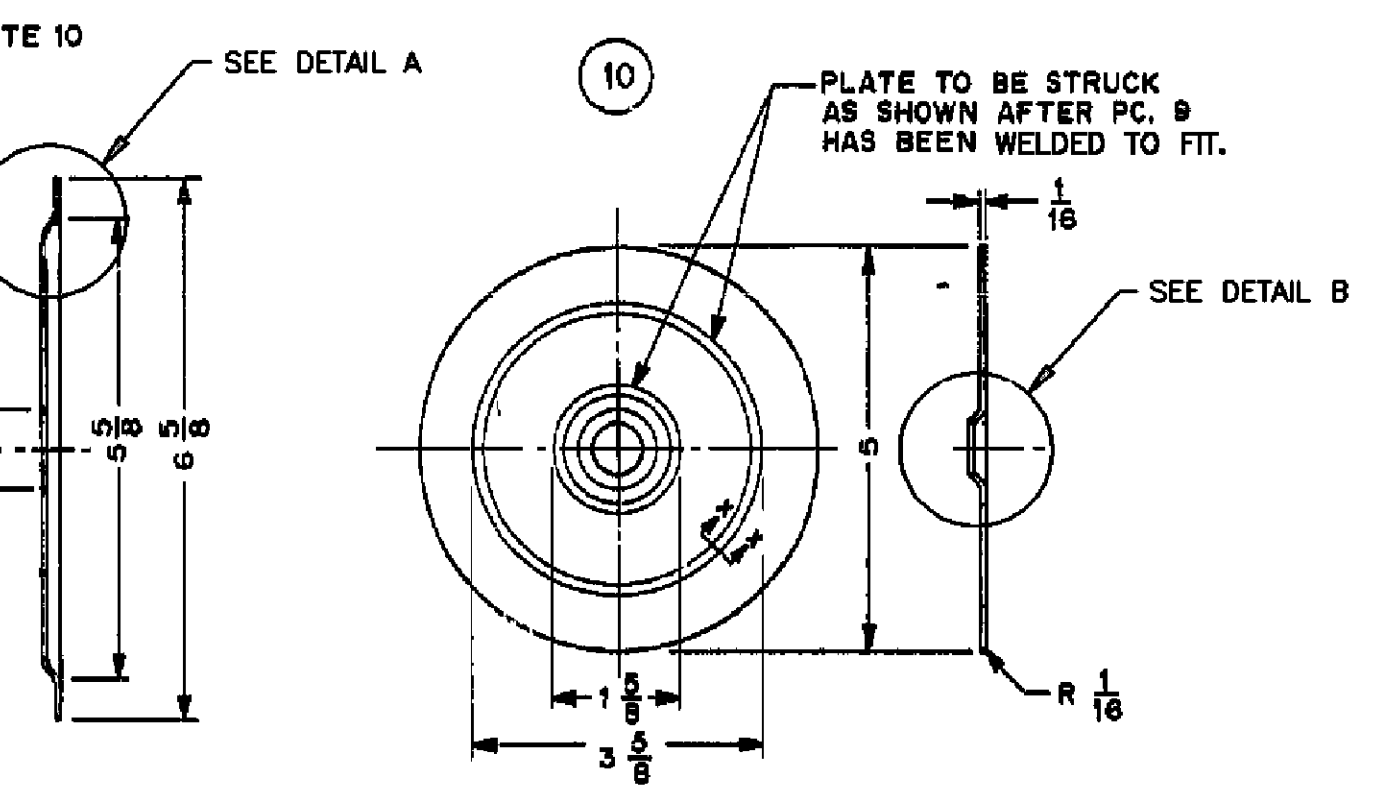
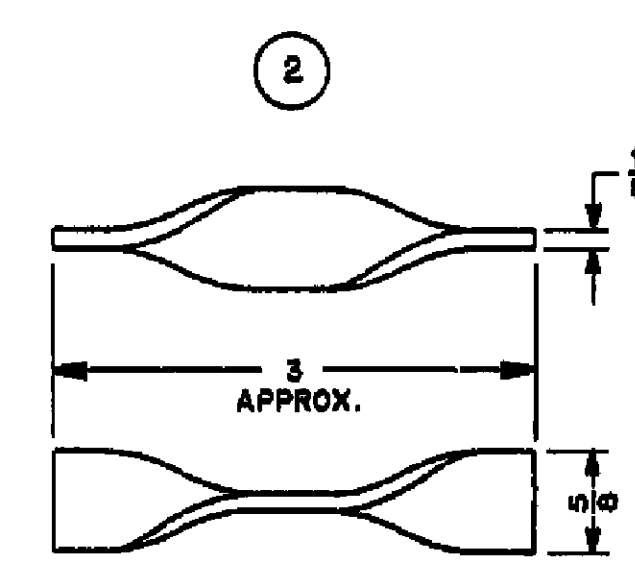
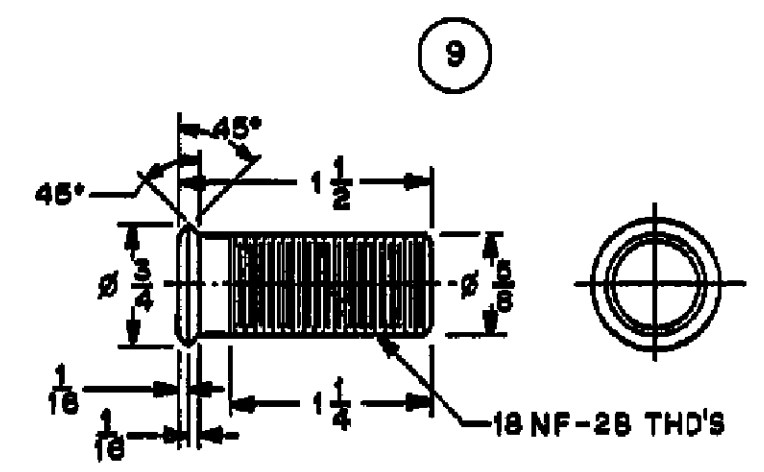
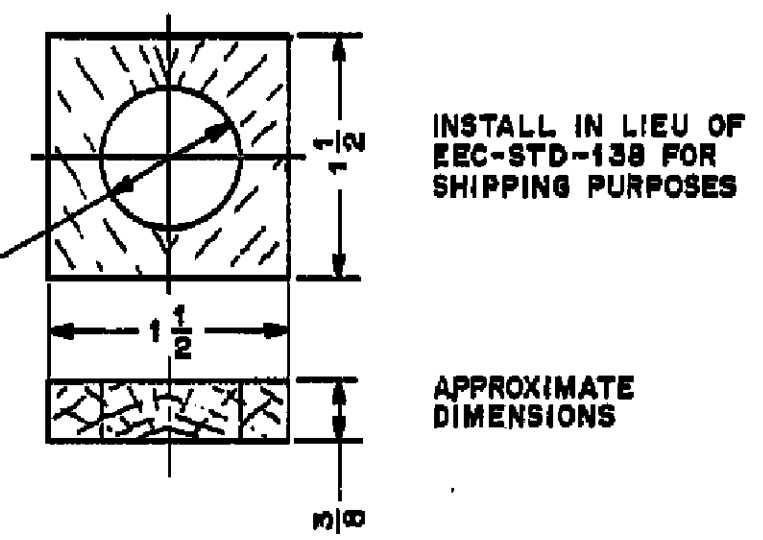


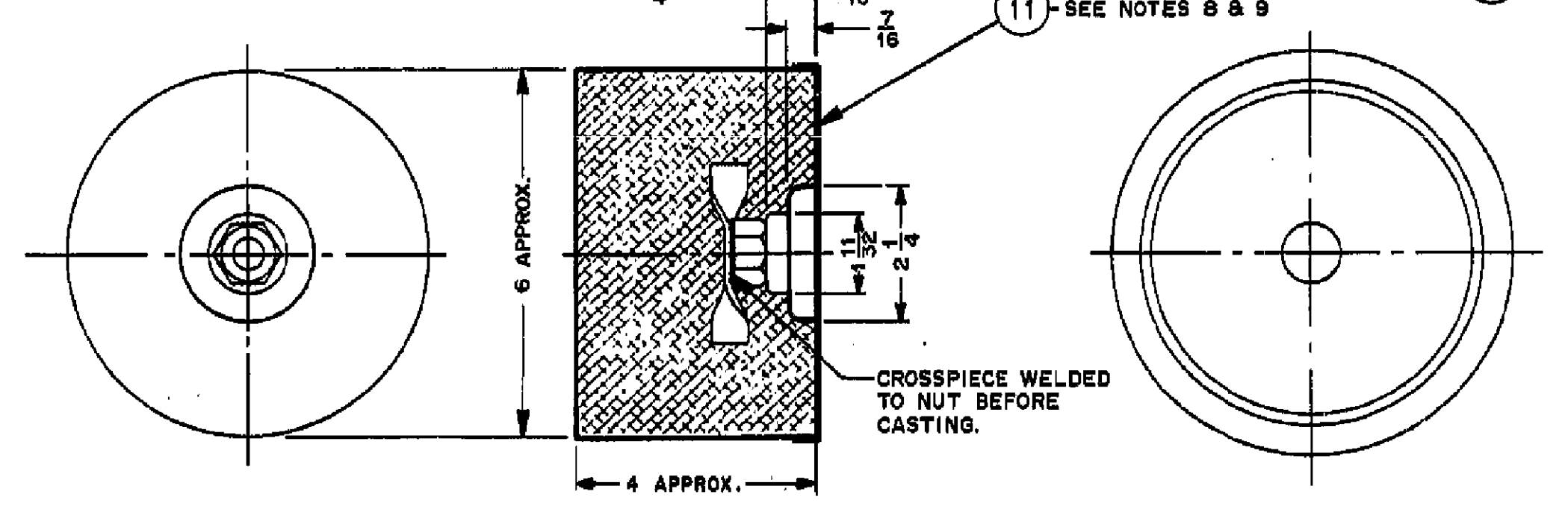
GENERAL ASSEMBLY



SHIPPING BLOCK



MAGNESIUM ANODE



LIST OF MATERIAL

PC N°	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	COMM.	SEE NOTES 15 & 17	5340-21-001-3732
2	CROSS PIECE SUPPORT	1	STEEL	COMM.	SEE 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, 5/8 X 13/64 X 3/32, S.A.E. STD.	1	STEEL	COMM.	ZINC	
5	JAM NUT, 5/8-18 AMER. STD. HEX. (SEMI. FIN.)	1	STEEL	COMM.	SEE NOTE 5	2040-21-797-4286
6	WASHER, 2 1/32 I.D. I & 5/16 O.D. .095 THK.	1	BRASS			
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	COMM.	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 REQUIREMENT FOR:
(A) HARDNESS BEFORE AGING, PARA 3-7-1.
(B) ULTIMATE ELONGATION AFTER AGING.
(C) COMPRESSION SET.
(D) SEAL TEST AGED.

NOTES:

1. _____
2. AFTER WELDING TOGETHER, pcs 2 & 3 TO BE ELECTRIC ZINC PLATED IN ACCORDANCE WITH ASTM SPECIFICATION B833-98e1. 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. N° 9 MACHINED FROM AMER. STD. CAP SCREW.
7. SURFACES OF PC. N° 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 PEEL STRENGTH OF 10 LBS. PER INCH WIDTH.
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 SHOTS, BLOW HOLES, OR ANY IMPERFECTIONS THAT MAY AFFECT THE STRENGTH IN ANY WAY. ALL SURFACES OF CASTINGS SHALL HAVE ALL FINIS AND BURRS REMOVED. SAND SURFACES SHALL BE DISTURBED AS LITTLE AS POSSIBLE.
16. BEFORE SHIPMENT ON AN ORIGINAL CONTRACT (i.e. MANUFACTURER HAS NOT PROVIDED AN ACCEPTABLE PRODUCT PREVIOUSLY), TWO PRE-PRODUCTION SAMPLES ARE TO BE FORWARDED BY THE MANUFACTURER TO THE TECHNICAL AUTHORITY.

REPLACES REVISION '9' WITH CHANGES

NO.	REVISED	DATE	BY
14	TDAN 084571026	09-01-26	AT
13	TDAN 034570031	03-12-04	AT
12	TDAN 024570027	03-02-28	AT
11	TDAN 934570038	93-09-20	SC
10	TDAN N° 874570020	87-11-17	MB

TOLERANCES UNLESS SPECIFIED OTHERWISE	SEE TABLE BELOW FOR SECURITY CLASSIFICATION OF DRAWING	NO.	REVISIONS	DATE	BY
DECIMALS ± .005 FRACTIONS ± 1/64 ANGLES ± 1/2 DIMENSIONS ARE IN INCHES	SECURITY RATING	NAVAL HEADQUARTERS DIRECTOR GENERAL SHIPS MK. V MAGNESIUM ALLOY ANODE & RESISTOR MOUNTING TYPE A			
TOLERANCES MUST NOT BE ACCUMULATIVE	TOP SECRET				
	SECRET				
	CONFIDENTIAL				
	RESTRICTED	DRN. <i>M. Gagnon</i> TOD. <i>M. Gagnon</i> SC.			
	UNCLASSIFIED	CKD. <i>A. Baker</i> APD. <i>R. Baker</i> DATE <i>Apr. 1, 1957</i>			
	REFERENCE DRAWINGS	SHT. OF 1	DWG. NO. 5340STD.137		