

Part O  
 Flight Tube  
 Quantity:1  
 Tolerances: +/- 0.010" unless  
 otherwise noted  
 Scale: Full

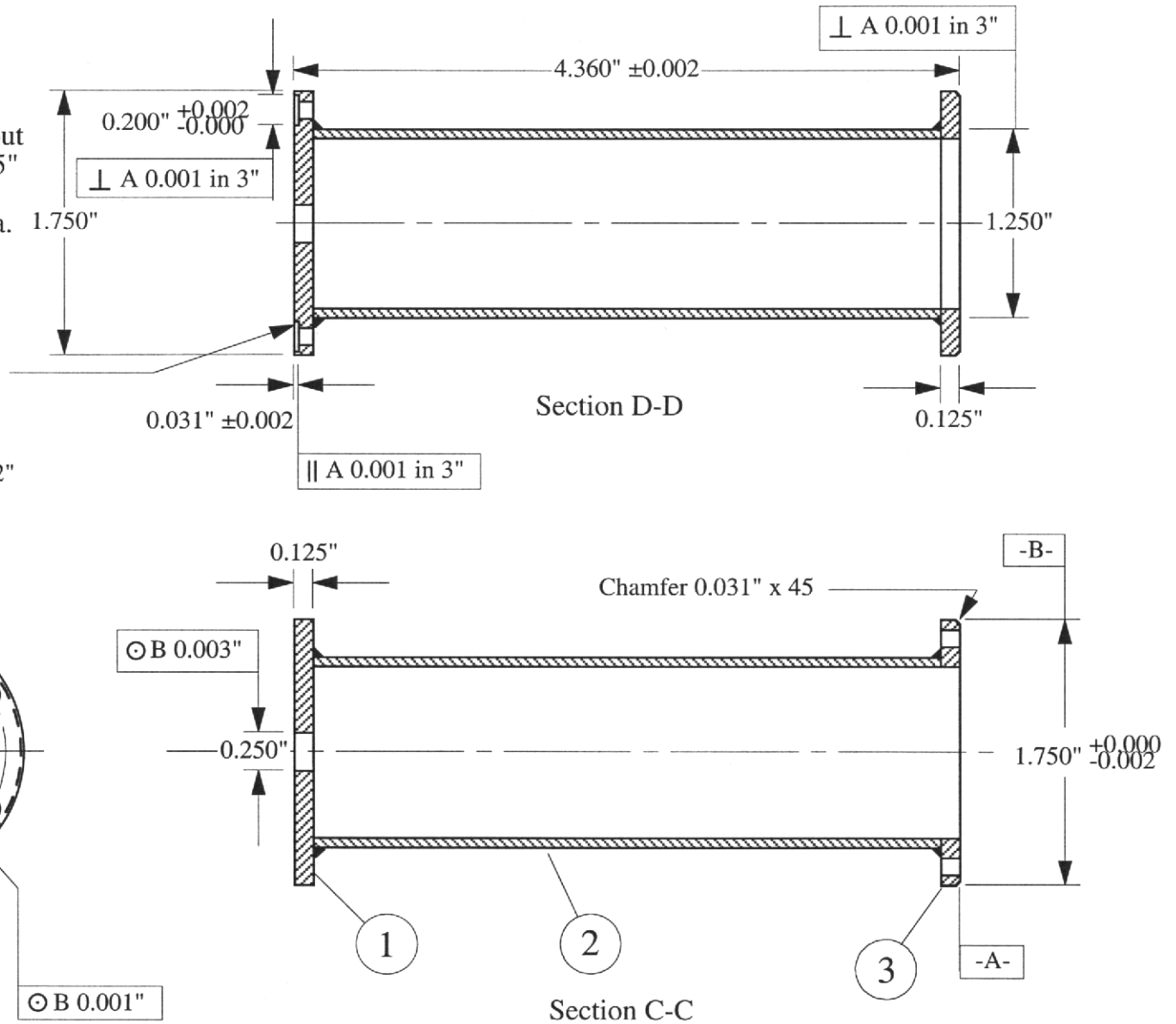
**IMPORTANT: DO NOT DRILL OR  
 COUNTERBORE HOLES UNTIL AFTER  
 WELDING IS DONE!!**

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 Butler Group  
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 2-9003

Materials:  
 1: SS304 plate similar to Part M, but  
 no chamfer is necessary on the 0.25"  
 orifice  
 2: SS304 tubing, 1.25" O.D., 16 ga.  
 3: SS304

Cut corners sharp to accomodate  
 Part P, which must key in to

6 4-40 clearance through holes, placed as  
 shown on a 1.500" bolt circle within 0.002"  
 of t.p. Relative orientation of the holes in  
 the 2 bolt circles is important.



4 of 6 evenly spaced 4-40  
 clearance through holes, placed  
 as shown on a 1.500" bolt circle  
 within 0.002" of t.p., with  
 counterbores as indicated.