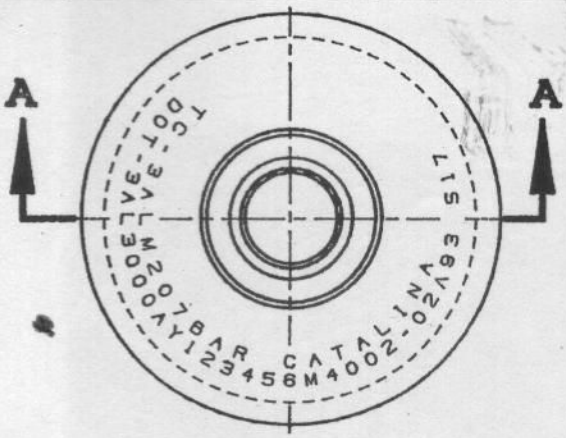
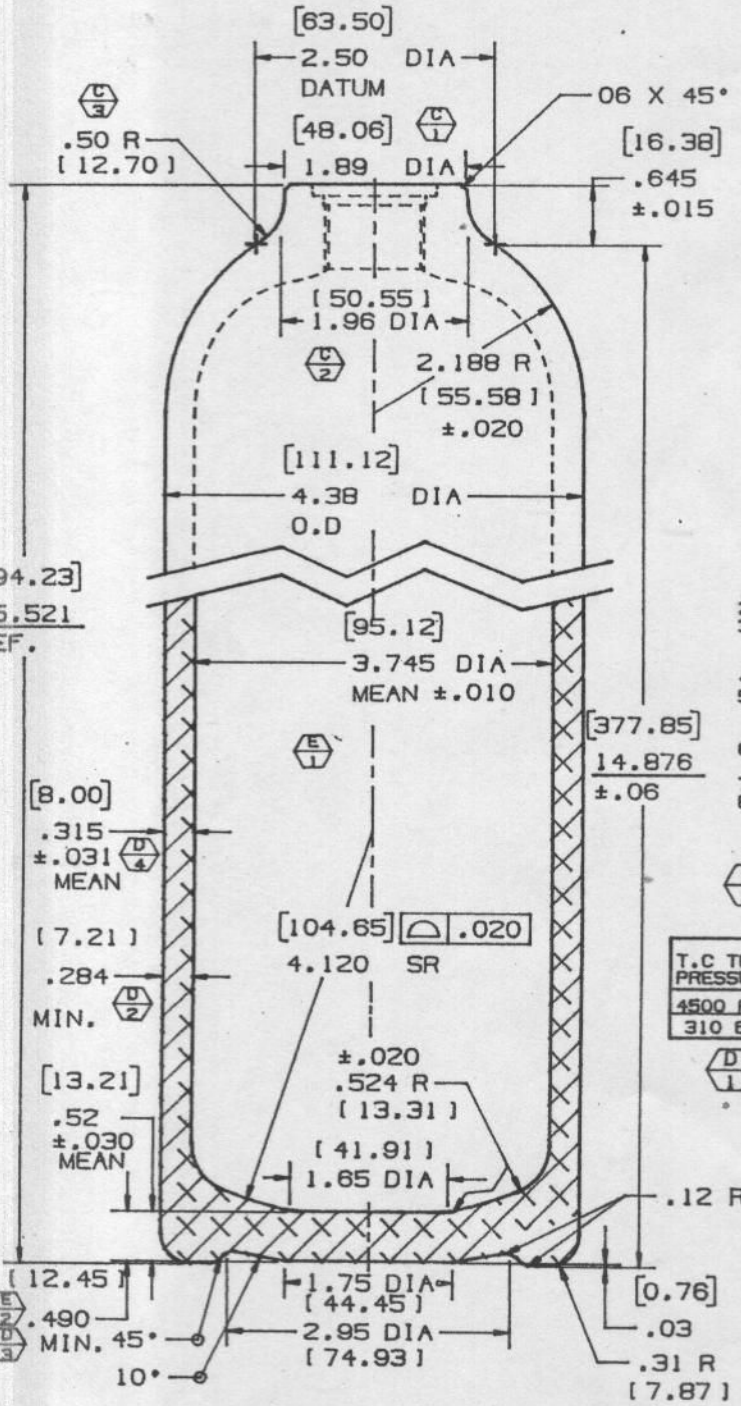
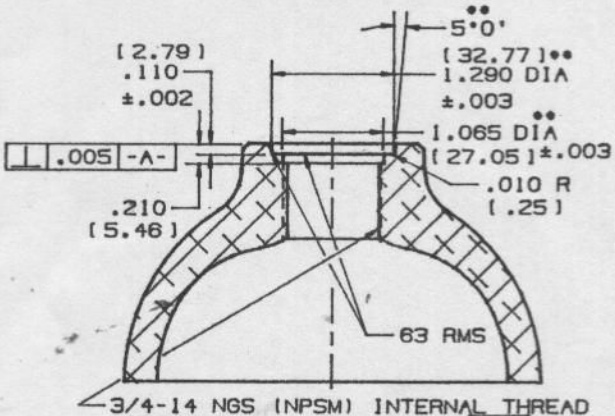
6

LET.	CHANGE DESCRIPTION	BY	DATE
A	CHANGE AND REDRAWN	S.C	09/3/93
B	CHANGE TO COLD EXTRUSION AND RE-DESIGN	S.C	09/21/93
C	WAS:1.82,1.88,.31	S.C	12-11-93
D1-4	ADD T.C/D.O.T TENSILE NOTES,WAS 6 THDS. MIN.	---	---
---	WAS .280 MIN. WALL,.349 BASE,.035	S.C	05/08/96
E1-3	REM. MAX. I.D (3.755"),WAS .355.	---	------
---	ADD NOTE "FULL BOUYANCY"	S.C	10/23/97





DIMENSIONS WITH SYMBOL •• SHOULD BE CONCENTRIC WITHIN .005" TO -A-



SECTION A-A
(FULL SCALE)

NOTES:

1. CYLINDER TO MEET DOT,TC,SPECIFICATION 3AL,3ALM
2. MATERIAL:6061-T6 ALUMINUM ALLOY
3. CYLINDER SURFACES TO BE FREE OF ALL FOREIGN CONTAMINANTS,SCALE,ODORS AND CORROSION.
4. SURFACE TO BE FREE OF ALL TOOL MARKS
5. THREADS AND SEALING SURFACES TO BE PROTECTED FROM NICKING DURING SHIPPING AND STORAGE.
6. METAL STAMP 1/4 INCH HIGH CHARACTERS LOW STRESS STAMPS ON CYLINDER AS SHOWN
7. WATER STAIN DISCOLORATION IS ACCEPTABLE
8. NO PAINT ALLOWED IN O'RING GLAND,THREADS. AND BORE SURFACES.

ALL DIMENSIONS IN BRACKETS ARE MM.
DIMENSIONS ARE WITH OUT ANY COATING
FULL CYL. APPROX. BOUYANCY = -1.27 LBS
APPROX. BOUYANCY = 0.00
APPROX. INSIDE VOLUME = 149 CU.IN

T.C TEST PRESSURE	CYLINDER CAPACITY	OVERALL DIM.REF	CYLINDER WEIGHT	SERVICE PRESSURE	DOT TEST PRESSURE	WATER CAPACITY
4500 PSI	17 CU.FT	15.521"	6.8 LBS	3000 PSI	5000 PSI	5.38 LBS
310 BAR	481.4 L	394.2 MM	3.08 KGS	207 bar	345 bar	2.44 Kgs

DESIGN TO 49.54K TENSILE (341.58 MPa)

ITEM	REQ	DESCRIPTION

BILL OF MATERIALS

SPECIALIST IN HIGH PRESSURE ALUMINUM GAS CYLINDERS

CATALINA CYLINDERS

DIVISION OF ALUMINUM PRECISION PRODUCTS INC.

LIMITS ON DIM. UNLESS OTHERWISE SPECIFIED	BREAK ALL SHARP EDGES UNLESS NOTED	SCALE FULL
ANGULAR ±1°	125 FINISH UNLESS NOTED	COMPUTER FILE NAME SCUBA-AY17 — DRAWN SERGIO COSTA
FRACTIONAL ± 1/16		
DECIMAL .X ±.1 .XX ±.02 .XXX ±.005	CYL. NO. AY-S17	NEXT ASSY. — APPROVED TOM H.
DRAWING NAME 4.38 DIA SCUBA CYL.S17 3000 PSI	DRAWING NUMBER 017 D30 U43 R1E AY	DATE 03-01-93 — SHEET 1 OF 1

ORIGINAL