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DWG NO. 0207710

SH 1

1

NOTES:

1. DIMENSIONING, TOLERANCING, AND CONTROL SYMBOLS PER ANSI Y14.5M.

2. FOAM FILLER TO HAVE A DENSITY OF 5 LBS/cu ft. FOAM TO BE FREE OF LARGE HOLES OR VOIDS.

3. MIX CONCRETE WITH VERMICULITE TO A DENSITY OF 1.637 G/CC (102.19 LBS/cu ft) +/- 1%. THE MIXING PROCEDURE SHALL BE HOMOGENOUS SO THAT THERE ARE NOT AREAS WITH LARGE CONCENTRATIONS OF VERMICULITE. REMOVE AIR BUBBLES BY AIR EVACUATING THE MIXING CONTAINER.

4. MANUFACTURE PER LAYUP SCHEDULE SHOWN BELOW.

5. ANCHOR CONNECTOR AND DETONATOR CONNECTOR TO BE BONDED TO FOAM CORE USING FIND NO. 2.

6. SHELL CASE TO BE BONDED TO ANCHOR CONNECTOR USING FIND NO. 2. SEAL ALL SEAMS AND JOINTS USING FIND NO. 9 TO FORM WATER TIGHT SEAL.

REVISION HISTORY				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
	1	ADDED FIND NO. 10 AND HOLE IN FIND NO. 7,8 AND 5		
	2	REVISED HOLE IN FIND NO. 7,8 AND 5		
	3	REVISED HOLE IN FIND NO. 5, WAS .250-20UNC-2B IS .375-16UNC-2B, FIND NO. 10 WAS, .250 DIA, IS .375 DIA		

THIS DRAWING HAS BEEN GENERATED AND IS MAINTAINED BY A CAD SYSTEM. CHANGES SHALL ONLY BE INCORPORATED AS DIRECTED BY THE COGNIZANT DESIGN ACTIVITY.

LAYUP SCHEDULE

LAYUP	LAYUP DESCRIPTION	
SHELL, CASE NOMINAL THICKNESS .310 - .375	GEL COAT 1ST PLY 2ND PLY 3RD PLY	12243 ORANGE PER FED-STD-595B 1.5 OZ MAT, 2 LAYERS (HAND LAYUP OR SPRAY UP) 1.5 OZ MAT, 3 LAYERS (HAND LAYUP OR SPRAY UP) 3 OZ MAT (HAND LAYUP OR SPRAY UP)

SEE SEPARATE PARTS LIST

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Note: Distribution to potential U.S. DoD contractors for the purpose of soliciting bids is authorized.

-	3	2	3	REVISION	REVISION STATUS OF SHEETS
4	3	2	1	SHEET	

INTERPRET DRAWING IN ACCORDANCE WITH MIL-STD-100, ASME Y14.5M-94 DO NOT SCALE THIS DRAWING		SPAWAR SYSTEMS CENTER, SAN DIEGO, SAN DIEGO, CA 92152-5001	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES. BREAK ALL EDGES .015 MAX. REMOVE ALL BURRS. TOLERANCES ARE: .XX ±.03 .XXX ±.010 ANGLES ±0°30' FILLETS MAX. SURFACE ROUGHNESS ✓ RELEASED DATE	PROG MGR	CHARGE, COMBAT, INERT TARGET, MK 50, MOD 0	
0207713	DESIGN	SIZE	CAGE CODE
NEXT ASSY	CHECKED	D	55910
USED ON	PREPARED K. KRUEGER	DRAWING NUMBER	0207710
APPLICATION	PROJECT NUMBER	REV	3
	COGNIZANT CODE	SCALE	1/1
	APPROVED FOR	SHEET 1 OF 4	
	BY DIRECTION	0207710_01_2.DWG	

REV 10/97

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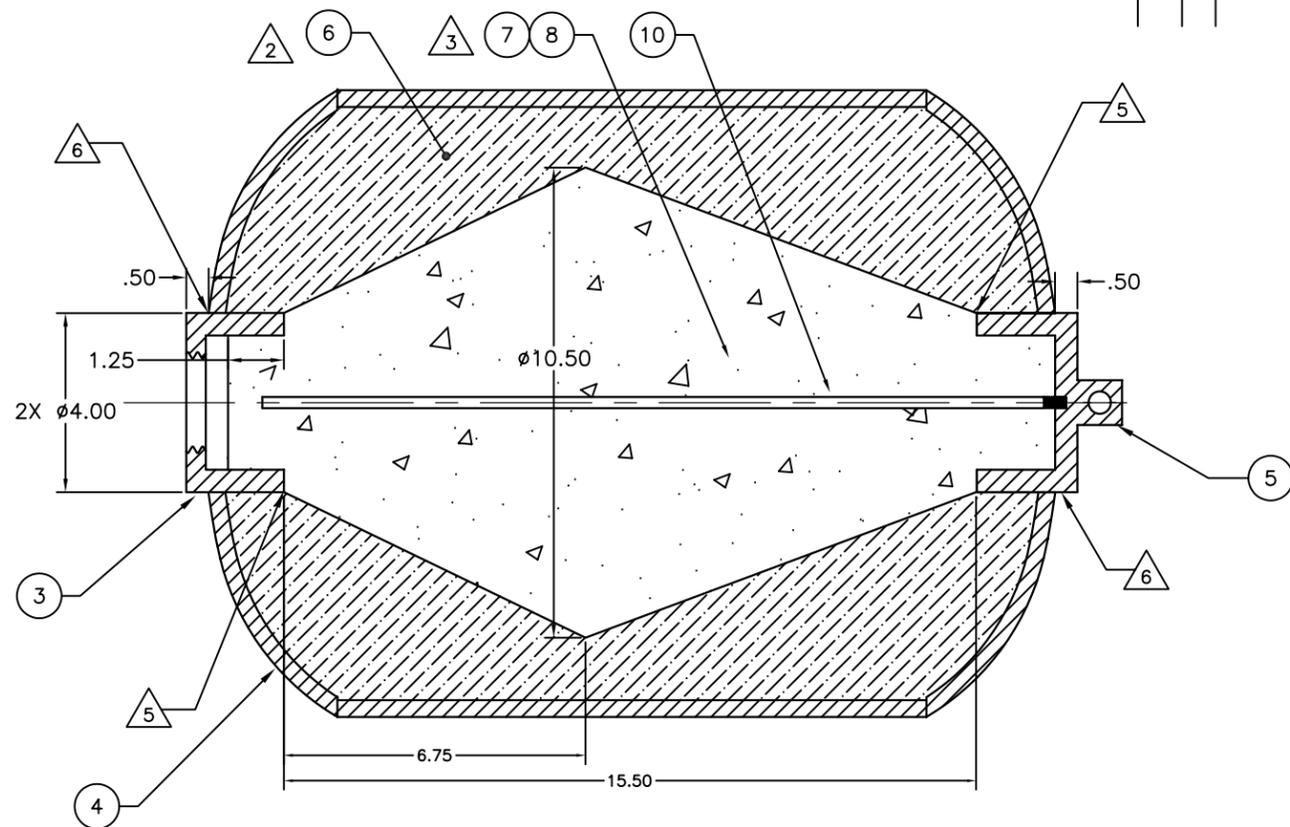
DWG NO. 0207710

SH 2

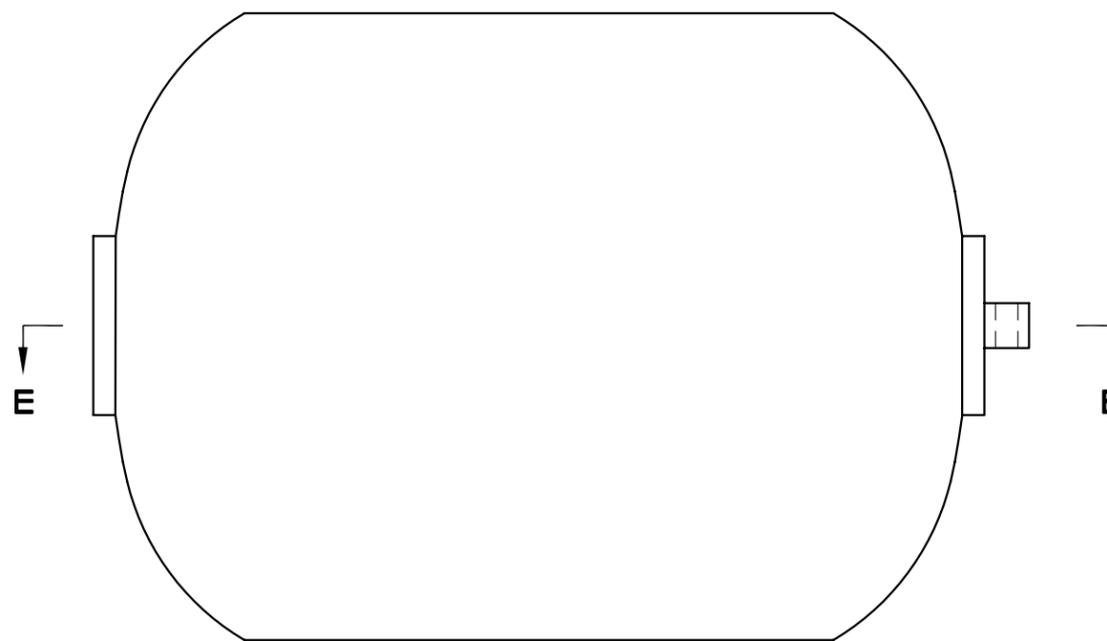
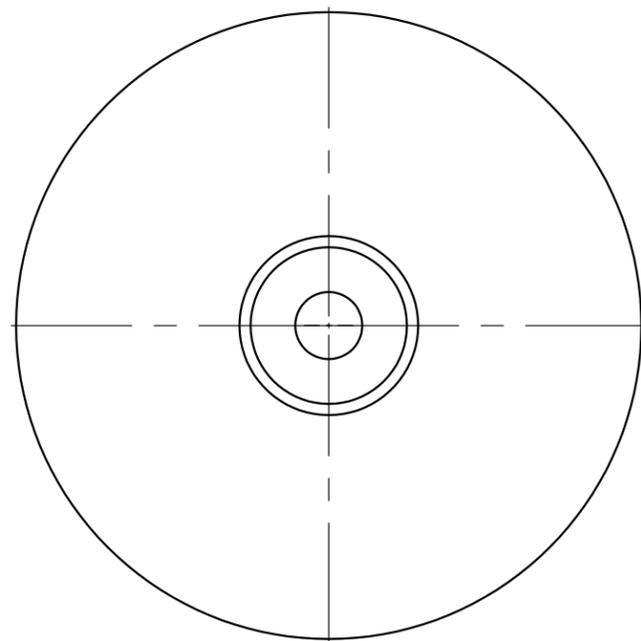
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REVISION HISTORY

ZONE	LTR	DESCRIPTION	DATE	APPROVED



SECTION E-E



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SIZE	CAGE CODE	DRAWING NUMBER	REV
D	55910	0207710	2
SCALE	1/2	SHEET	2

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DWG NO. 0207710

SH 3

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REVISION HISTORY

ZONE	LTR	DESCRIPTION	DATE	APPROVED

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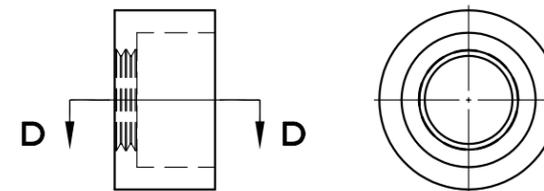
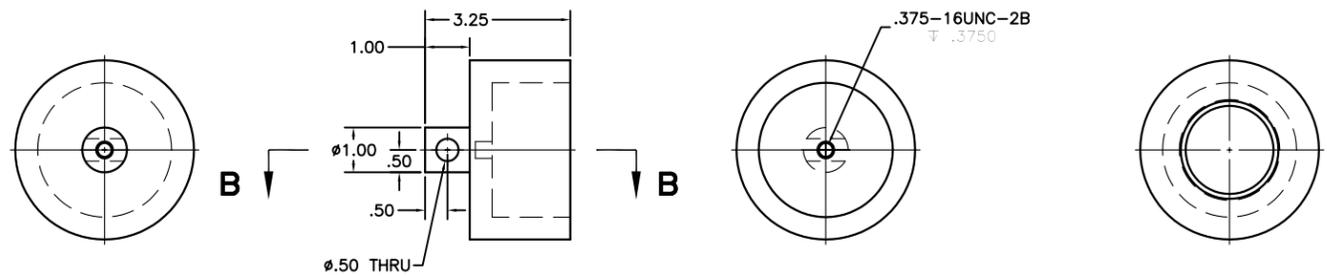
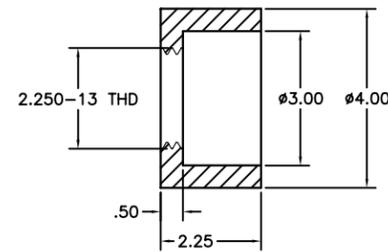
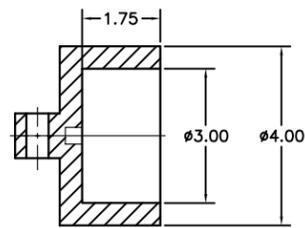
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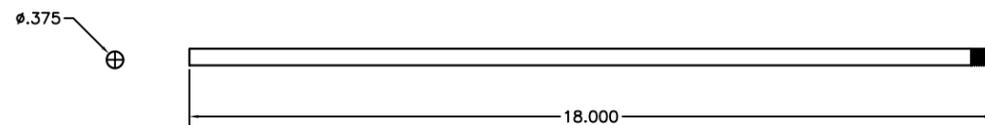
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SIZE	CAGE CODE	DRAWING NUMBER	REV
D	55910	0207710	3
SCALE	1/2	SHEET	3

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DWG NO. 0207710

SH 4

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REVISION HISTORY

ZONE	LTR	DESCRIPTION	DATE	APPROVED

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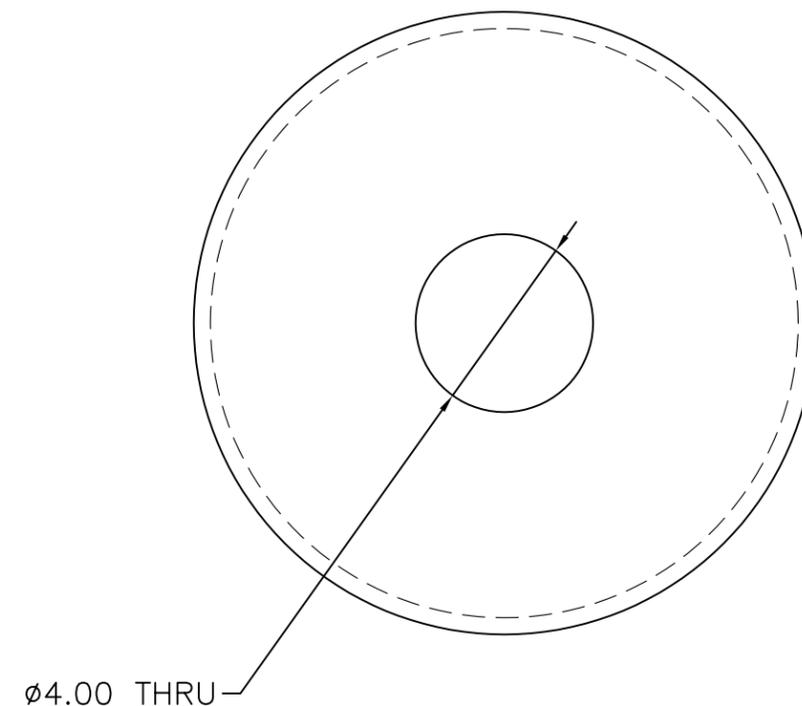
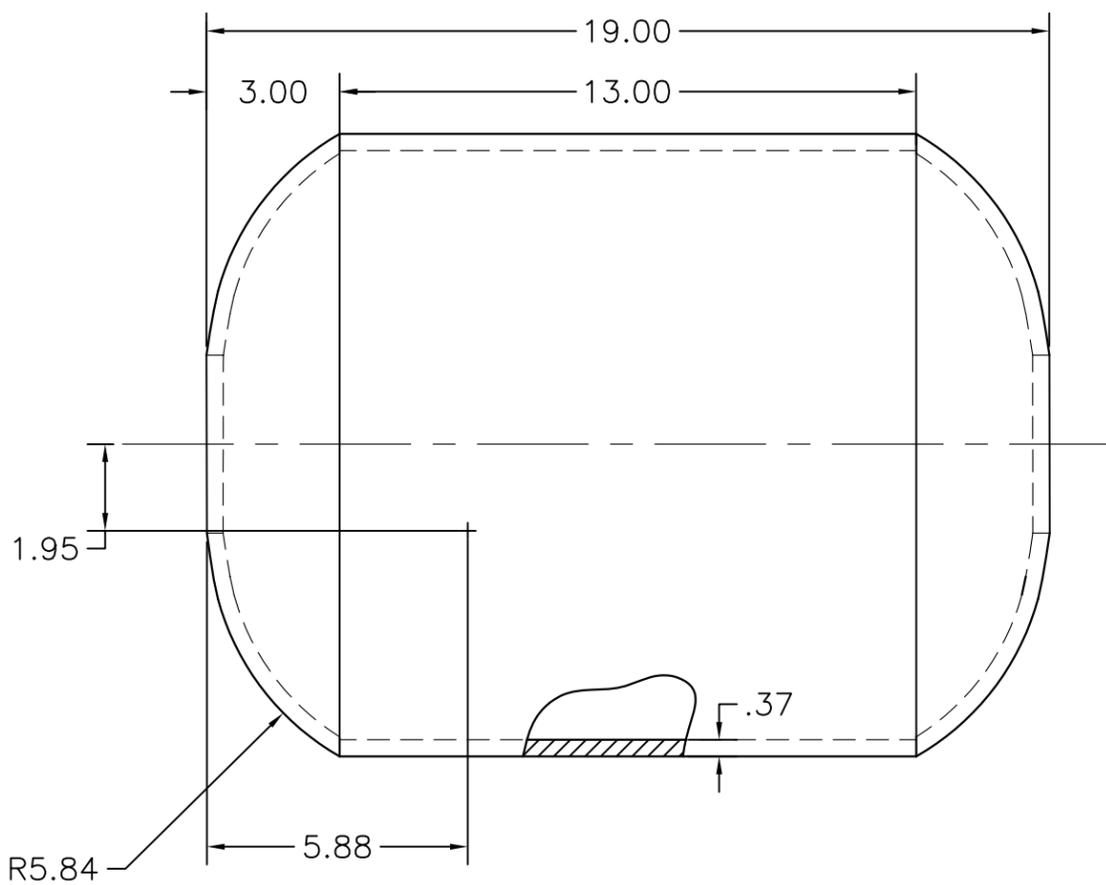
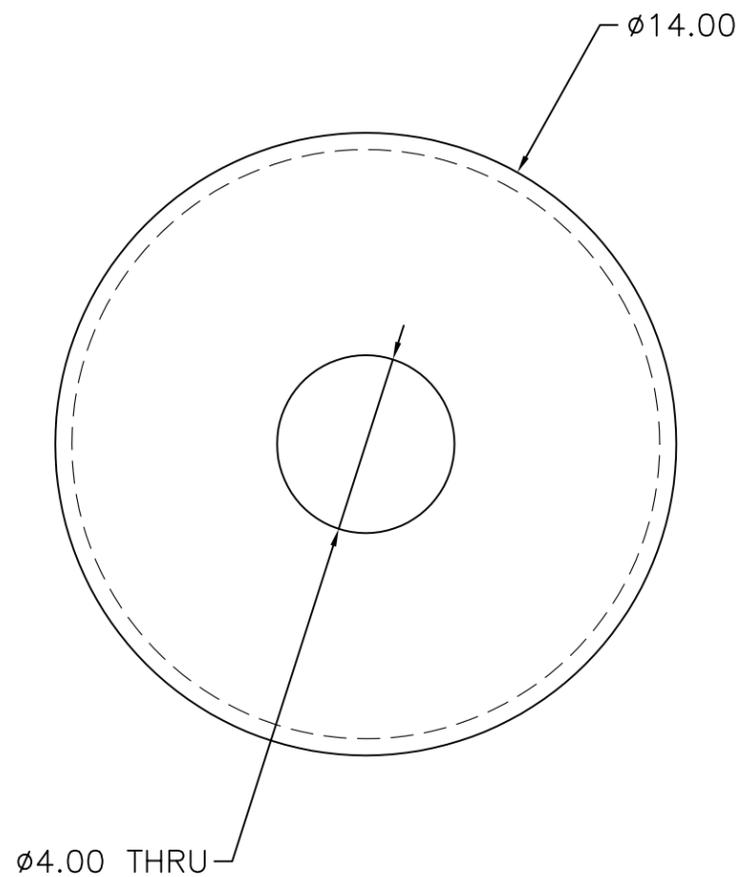
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REV. 9/92

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0207710_04_-.DWG

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SIZE	CAGE CODE	DRAWING NUMBER	REV
D	55910	0207710	-
SCALE	1/2	SHEET	4

