1. SURFACE FINISH INSIDE DOME TO BE 32 MICRO-INCHES OR BETTER PRIOR TO WELDING.
2. DEBUR AND BREAK SHARP EDGES.
3. STRESS RELIEVE PRIOR TO MACHINING.
4. PART TO BE VISIBLY CLEANED PER VENDOR STANDARD CLEANING PROCESS. ALL SURFACES ARE TO BE FREE OF GREASE, OILS, FINGERPRINTS AND PARTICULATES.
5. VENDOR TO FABRICATE FIND NO'S 2, 3 AND 4.
6. HOLE LOCATION SHOWN FOR REFERENCE ONLY. ORIENTATION MAY VARY DEPENDING ON LOCATION OF FIND NO. 3.

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**ITEM NO.** | **PART NUMBER** | **DESCRIPTION** | **VENDOR** | **QTY.**
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1 | 33-20104.0101 | ASME DISH HEAD 33" ID x 1/4" TH | AMS Industries | 1
3 | 33-20104.0103 | FLANGE BLANK | 1
3 | 33-20104.0103 | VIEW PORT BLANK | 1
4 | 33-20104.0104 | HANDLE | 3

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**UNLESS OTHERWISE SPECIFIED:**
- SCALE: 1:4
- WEIGHT:
- REVDWG. NO.
- SIZE
- TITLE:
- NAME DATE
- COMMENTS:
- Q.A.
- MFG APPR.
- ENG APPR.
- CHECKED
- DRAWN
- FINISH
- MATERIAL
- INTERPRET GEOMETRIC TOLERANCING PER:
- DIMENSIONS ARE IN INCHES
- TOLERANCES:
  - FRACTIONAL: .5
  - THREE PLACE DECIMAL: .005
  - TWO PLACE DECIMAL: .01
- APPLICATION USED ON NEXT ASSY A

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**DOME, BACK**
NOTES: FINISH AND MASKING

- MASK FROM FINISH AS SHOWN.
- MASK HOLES AS SHOWN.
- CHAMFER CAN BE EITHER MASKED OR PAINTED.

4. PRIME WITH P223 PRIMER AND PAINT WITH AEROGLAZE Z306 BLACK. PER EC SS-Q-70-12A OR EQUIVALENT. THE ACCEPTANCE CRITERIA OF SECTION 6 (EXCEPT FOR ADHESION TESTING) AND THE QUALITY ASSURANCE SECTION 7 IS NOT APPLICABLE. TEST SAMPLES SHALL BE USED FOR ADHESION TESTING PER EC SS-Q-70-13 OR EQUIVALENT BY THE VENDOR AND SUPPLIED TO MIT.