



NOTES:
1. WELD P/N -112 TO P/N -110.
2. WELD P/N -111 TO P/N -113.
3. WELD ASSY MADE IN STEP 1 TO -105 AND LEAK CHECK.
4. WELD ASSY MADE IN STEP 2 TO -106 AND LEAK CHECK.
5. WELD ASSY MADE IN STEP 3 TO -103.
6. WELD ASSY MADE IN STEP 4 TO -104.
7. WELD ASSEMBLIES MADE IN STEPS 5 & 6 TO P/N -102.
8. WELD P/N -107 TO ASSY MADE IN STEP 7, USING FIXTURE TO OBTAIN PROPER ORIENTATION.
9. FORM 3/16" COILED TUBING USING FORMING TOOLS.
10. TRIM 3/16" TUBING ENDS TO ALIGN WITH PARTS -109 & -111.
11. WELD 3/16" TUBE TO P/N -109.
12. WELD P/N -109 TO P/N -107 (ASSY MADE IN STEP 8).
13. WELD 3/16" TUBING TO P/N -111 (ASSY MADE IN STEP 12).

REVISIONS			
ZONE	REV	DESCRIPTION	DATE

UNLESS OTHERWISE SPECIFIED:			
DIMENSIONS ARE IN INCHES			
DECIMAL TOLERANCES:			
X	±.030	XX	±.015
XXX	±.005		
ANGULAR TOL: ± 1° SURFACE ROUGHNESS: √			
INTERNAL AND EXTERNAL SURFACE INTERSECTIONS SHALL BE UNIFORMLY FINISHED WITH CHAMFER .005/.010 X 45° OR RADIUS .005/.010. CHAMFER ALL THREADED HOLES 110% OF MAJOR DIAMETER X 45°			
MATERIAL:			
FINISH:			

1648 Vottec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com			
TITLE: p02101-270 pre-cooler assy			
CONFIGURATION:			
SIZE	QTY PER ASSY:	SCALE: 1:1	SHEET 1 OF 1
D	DATE: 6/3/2004	DRAWN BY: C. Danaher	REV A