REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
		ORIGINAL PROVE DRAWING		

NOTES:

1. CUTTER WHEEL TO BE 3.000 DIA., MAX. WITH .020 RADIUS AND 90° INCLUDED ANGLE.
2. DIAPHRAGM BLANKS MUST BE FLAT WITHIN .005 T.I.R. BEFORE MOUNTING IN FIXTURE TO MILL GROOVES.
3. AFTER MACHINING AND INSPECTION, MARK WITH LAYOUT DYE (NO STAMPING) THE FOLLOWING INFORMATION:

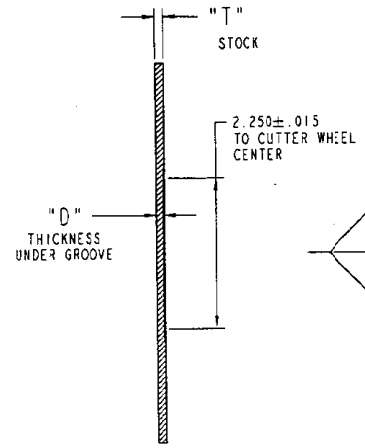
   PART NUMBER _____

   "D" _____

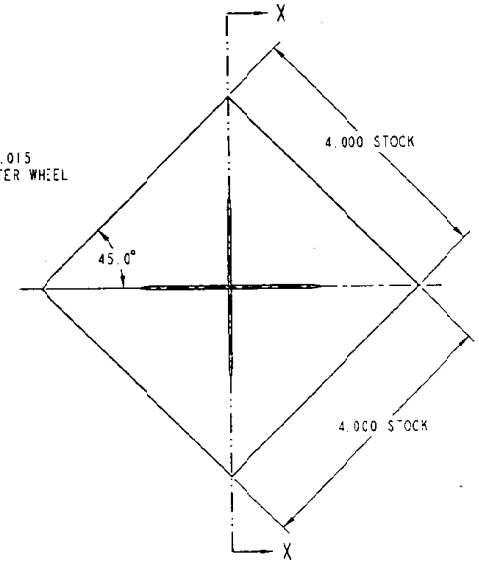
   "T" _____

   DATE _____

4. ALL MATERIAL TO BE IN THE ANNEALED CONDITION.



SECTION X-X



ENGINEERS NOTE: BURST PRESSURES ARE FOR GROOVES FACING UPSTREAM

PIECE NO.	"T"	"D" ±.002	BURST PRESSURE (PSI)	MATERIAL SEE NOTE 4
12	.125	.085	7,500	C-103
11	.056	.037	2,475	C-103
10	.068	.050	4,500	C-103
9	.125	.110	16,500	304 S.S.
8	.056	.035	2,400	C-103
7	.056	.032	1,850	C-103
6	.062	.040	2,500	TA 2.5W
5				
4	.062	.034	1,875	TA 2.5W
3	.125	.080	10,500	TA 10W
2	.075	.060	7,400	TA 10W
1	.125	.108	16,500	TA 10W

APPLICATION	
94-F-1055	MACH 7
78-E-1103	MACH 14
NEXT ASSY	USED ON

TOLERANCES

FRACTIONS	DECIMALS	.XXX DECIMALS	ANGLES
±	±	±.010	± 1°

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
REMOVE BURRS AND SHARP EDGES
.010 R OR CHAMFER MAX
INSIDE CORNERS .005 R MAX
SURFACE ROUGHNESS 125√

INTERPRET DRAWING IN ACCORDANCE WITH DOD STD-100

DO NOT SCALE THIS DRAWING

NAVAL SURFACE WARFARE CENTER
DAHLGREN DIVISION
WHITE OAK LAB, SILVER SPRING, MD. 20903

ENGINEER	WALDO	13-Nov-97
CHECKED	WALDO	13-Nov-97
DRAWN	RATTI	13-Nov-97

APPROVED

IT IS DIRECTION OF

DEPARTMENT OF THE NAVY

BURST DIAPHRAGM
(4 X 4)

SIZE	FSCM NO.	DWG NO.
C		77-C-1088

SCALE FULL | SHEET 1 OF 1

PART FILE NAME: 77-C-1088
DRAWING FILE NAME: 77-C-1088

77-C-1088 REV 1