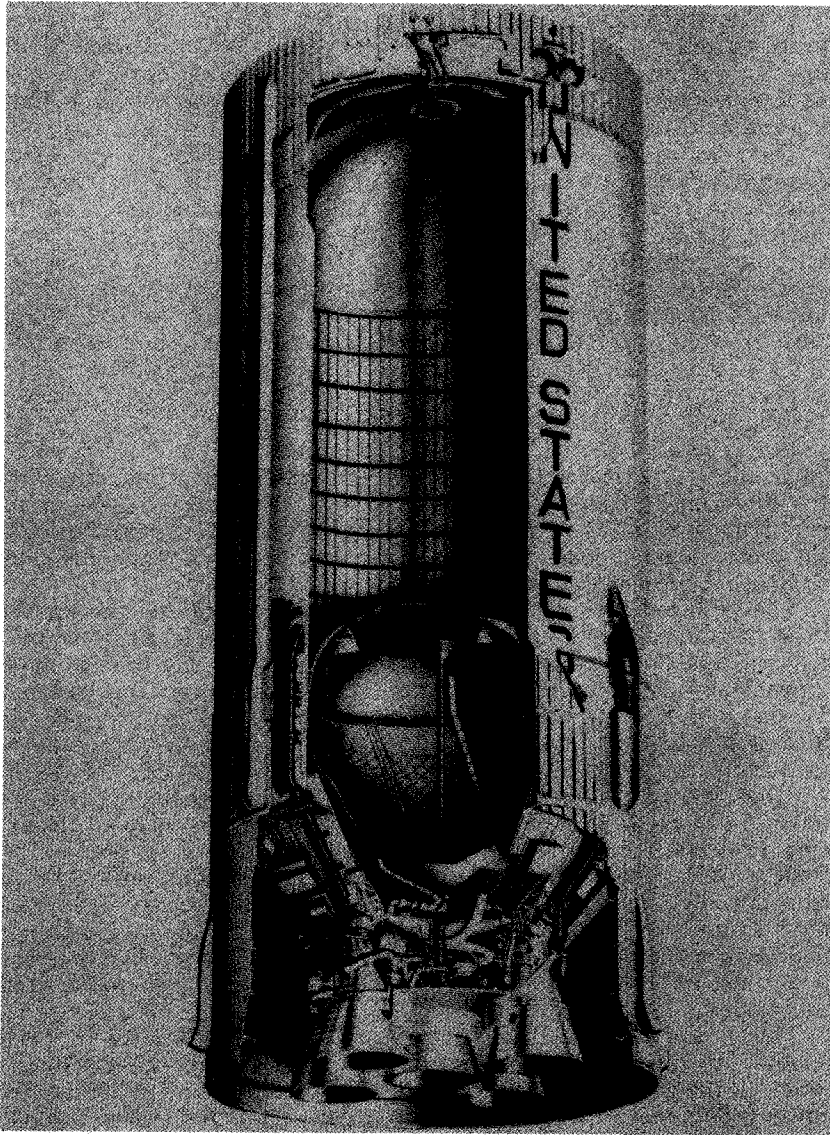




SLIDE 15. S-II CUTAWAY

The No. 6 cylinder here, which is at the top of the stage, has to be welded to this bulkhead which runs over the top. We weld up to the No. 6 cylinder from quarter panels as a complete cylinder, then we weld gores, little pie-shaped pieces, in to make the bulkhead, then we have to make what is about a 1,200-inch weld all the way around to put this bulkhead on that cylinder. The thickness of the material that we are using there is slightly over a quarter of an inch, and we can't have a mismatch, an offset at any point, of more than 10 percent