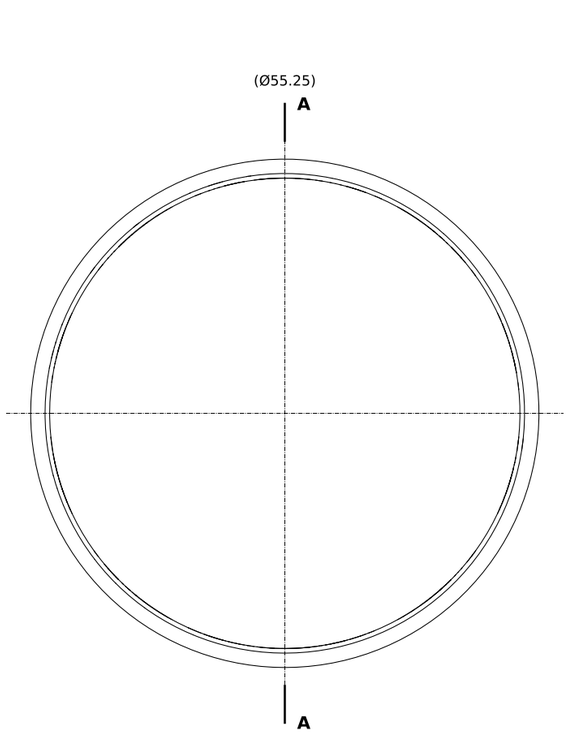
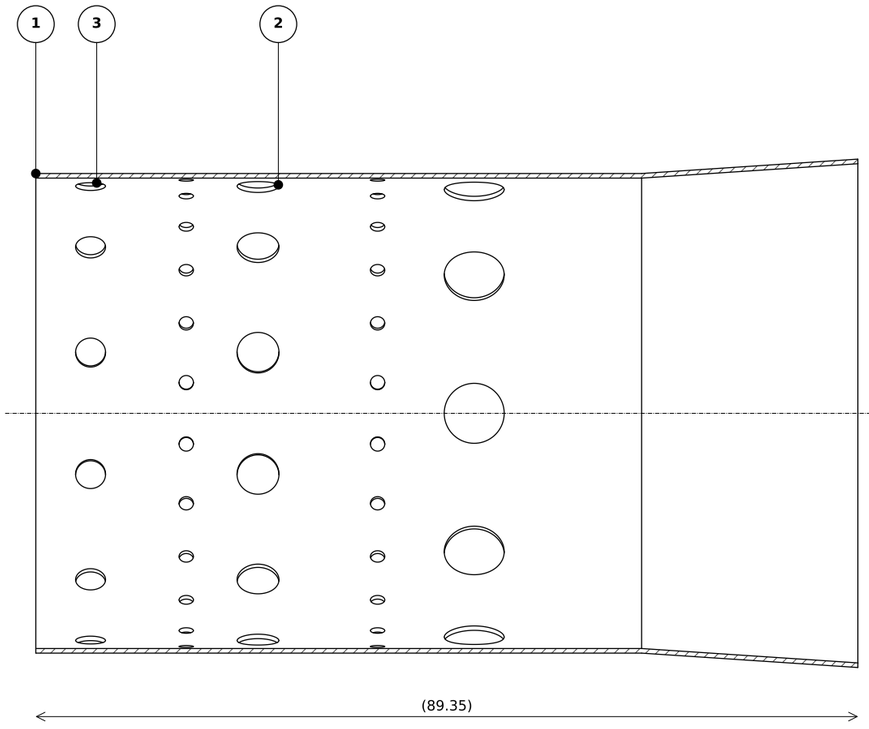



VIEW FROM THE INLET




SECTION A-A

## REQUIREMENTS

**1** OD Ø52.12 ±0.05 at the front, through the plate's bore; welded to the plate

**2** 310S sheet 0.5: a rolled cylinder and a rolled cone, butt-welded at 65.8 from the front; seam at 0°

**3** Holes, laser-cut in the flat: 12× Ø3.26 at 5.95152; 24× Ø1.56 at 16.3515; 12× Ø4.56 at 24.1515; 24× Ø1.56 at 37.1515; 10× Ø6.52 at 47.6515 (mm from the front edge); each row equally spaced, Ø ±0.05

## NOTES

1. Model is master: sizes not called out come from combustor_inner.step, at the general tolerance.
2. Break sharp edges 0.1–0.3 unless noted. No burrs. No tool marks across sealing or seating faces.
3. Surface finish Ra 1.6 µm unless noted. Threads to ISO 965 (metric fine).
4. Inspection report, CMM and material certificates are add-ons on the quote.

**HIGHLAND** Turbojet, 170 N class

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| | | | |
|---|---|---|---|
| PART<br>Combustor inner liner | PART NUMBER<br>HL-TJ-13 | | REVISION<br>A |
| MATERIAL<br>Stainless 310S sheet (ASTM A240), annealed | | | |
| FINISH<br>None, as machined | | HEAT TREAT<br>None | |
| TOLERANCE UNLESS NOTED<br>±0.13 mm (±0.005 in) unless noted; angles ±0.5° | | | |
| QUANTITY<br>1 per engine | MASS<br>54.9 g | | SCALE<br>1.5:1 |
| UNITS<br>mm | PROJECTION<br>Third angle | DATE<br>2026-11-20 | SHEET<br>A3, 1 of 1 |