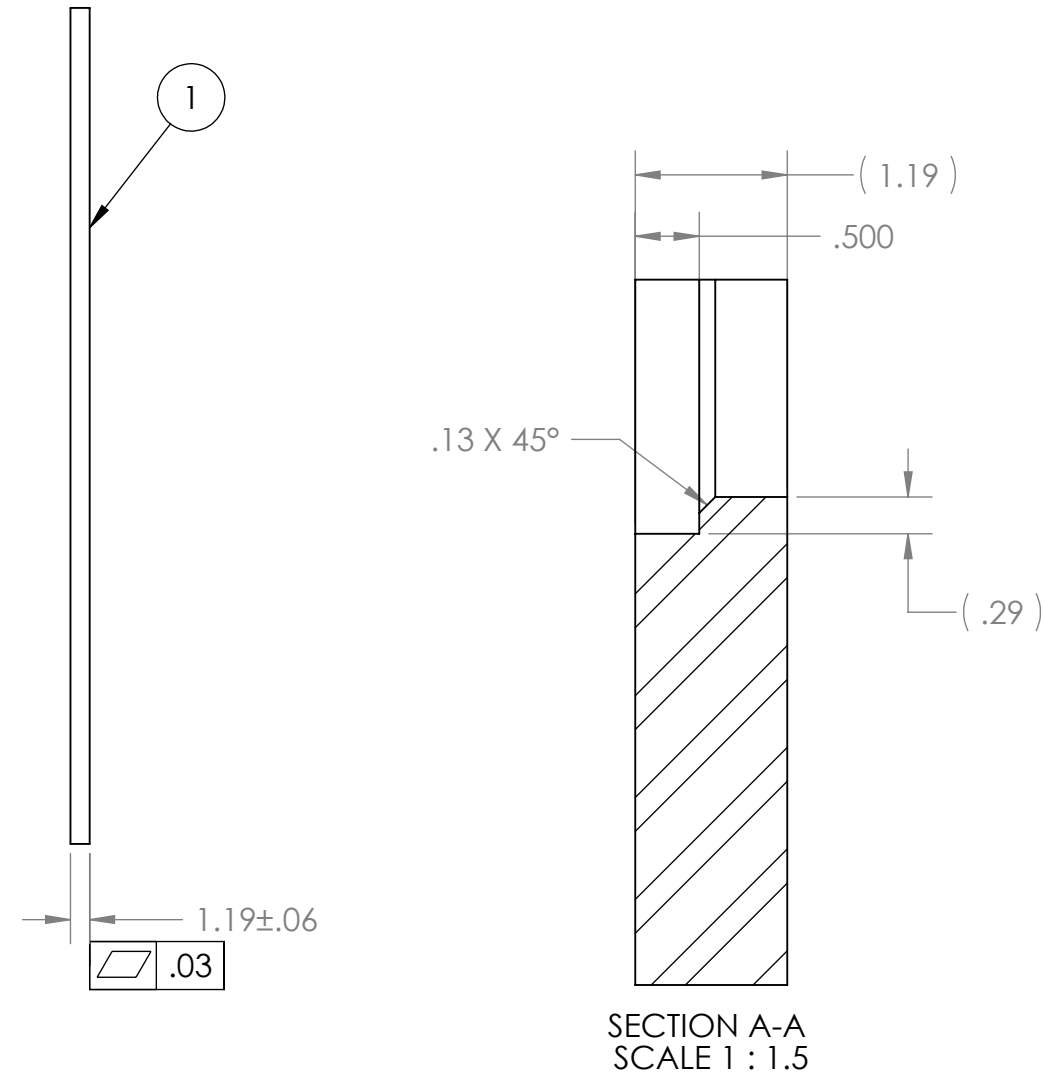
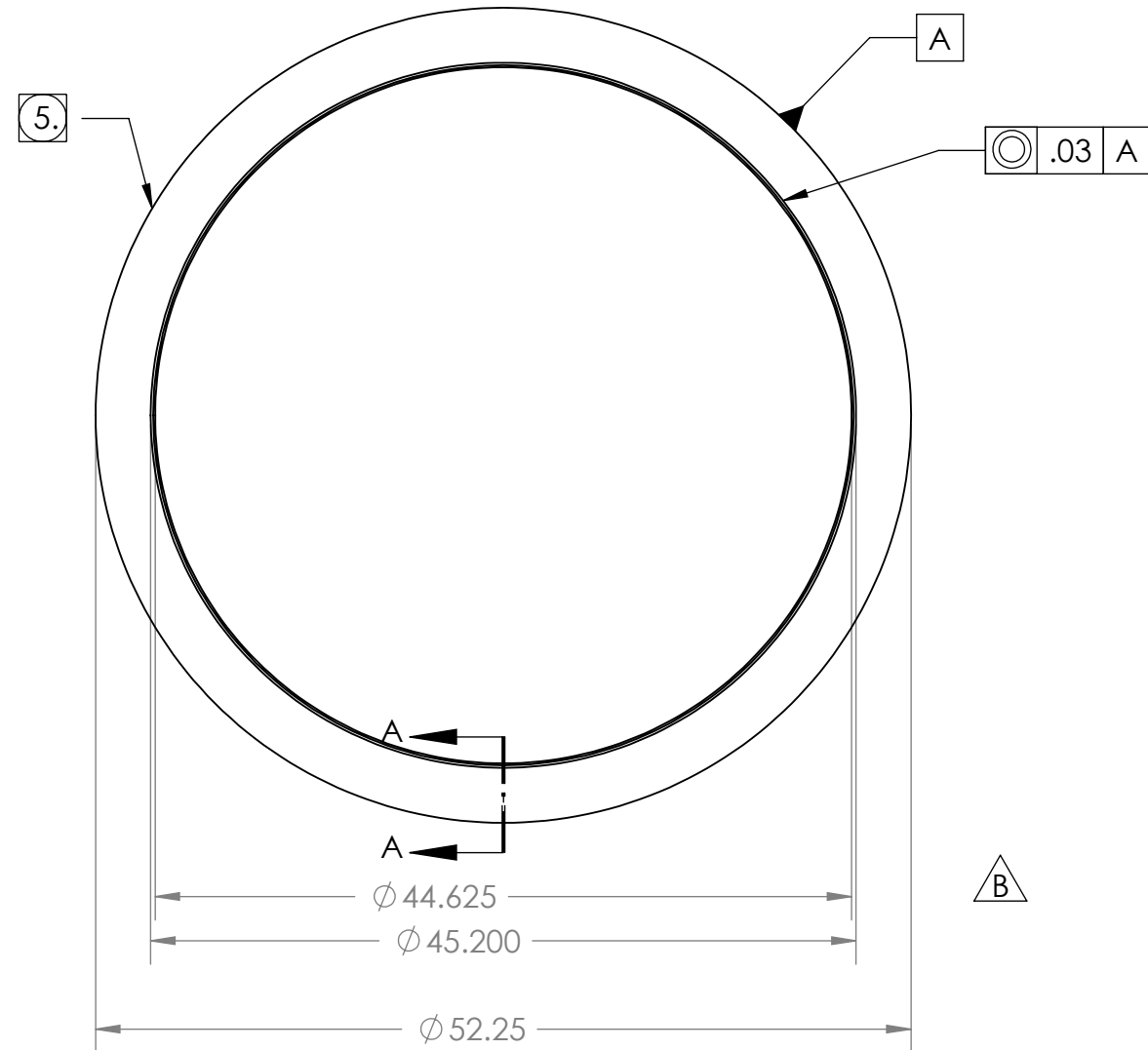


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REMOVED SULFUR CONTENT REQUIREMENT	8/20/2010	MKM2
	B	TIGHTENED TOLERANCE ON ID	8/20/2010	MKM2
	C	RELEASED TO PRODUCTION	8/23/2010	MKM2



SECTION A-A
 SCALE 1 : 1.5

NOTES:

1. THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING.
2. NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
 - a. WATER LEACHABLE CHLORIDES: 100PPM
 - b. TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
 - c. TOTAL SULFUR: 1000PPM
3. DO NOT ALLOW PART TO BE CONTAMINATED BY CARBON STEEL OR IRON CONTACT.
4. MACHINING TO BE IN LINE WITH LIGO SPECIFICATION E0900406, LATEST REVISION.
5. DO NOT MACHINE OD OF FORGING; FORGING MANUFACTURER'S NUMBERS TO REMAIN INTACT

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114292-00S	FORGING, FLANGE, 44ID X 52.25 OD	1

MATERIAL: AISI 304L PER ASME SPEC SA-182 GRADE F

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES:
 ANGULAR: ± 0°30'
 .XX ± .03
 .XXX ± .005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS

//, ⊥, ⊥ WITHIN .03

THIRD ANGLE PROJECTION



WEIGHT: 192.93#	
APPROVALS	DATE
DRAFTER MKM2	7/2/10
CHECKER RW	7/9/10
ENGINEER MKM2	7/2/10

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TITLE: FLANGE, SMALL, ADAPTER A-16	
DO NOT SCALE DRAWING	DWG. NO. B 114291-00S SCALE: 1:12
	REV C SHEET 1 OF 1