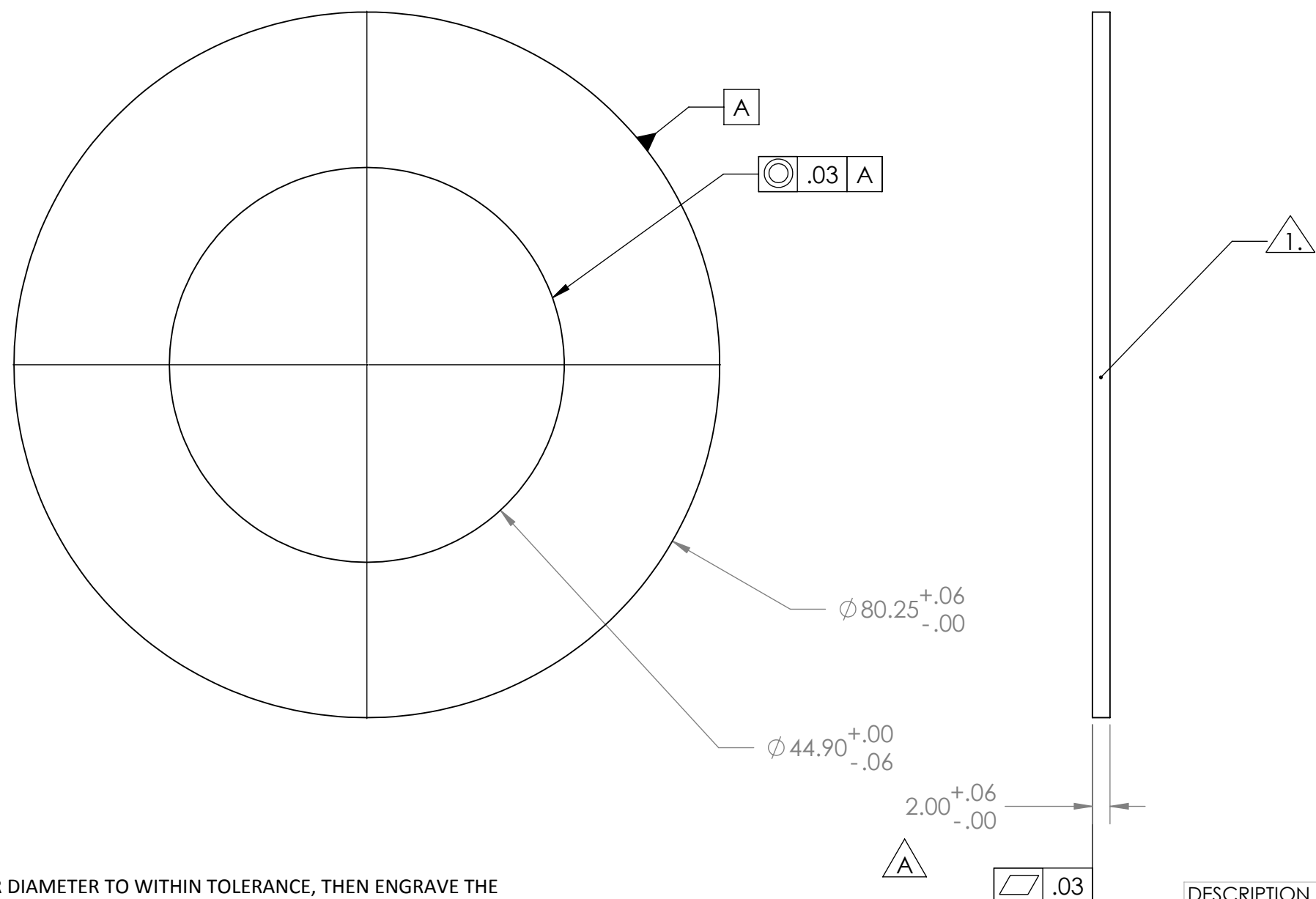


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	2.00 WAS 1.25	7/20/2010	MKM2
	B	RELEASED TO PRODUCTION	8/20/2010	MKM2



NOTES:

1. TURN OUTER DIAMETER TO WITHIN TOLERANCE, THEN ENGRAVE THE FOLLOWING USING A VIBRATORY TOOL WITH A TIP WITH A MINIMUM RADIUS OF .005":
 - a. HEAT NUMBER
 - b. LOT NUMBER
 - c. PART NUMBER
2. PROVIDE A COUPON, SIZED 2" X 2", FROM THE SAME HEAT NUMBER, LOT, AND THICKNESS OF THE MATERIAL.
3. NO WELD SPLICES OR REPAIR WELDING ALLOWED
4. MATERIAL IDENTIFICATION TO BE MAINTAINED AT ALL TIMES. IF IDENTIFICATION IS LOST, TESTING REQUIRED FOR THE MATERIAL MUST BE REPEATED.
5. NO GRINDING ALLOWED
6. FORGING MUST BE PROTECTED FROM CONTAMINATION FROM CARBON STEEL OR HYDROCARBONS. KEEP FORGINGS PROTECTED AT ALL TIMES.
7. PACKAGE FORGINGS PER ASTM A-700.

DESCRIPTION FORGING, 2.00 THK, 44.90 ID, 80.25 OD
 MATERIAL: AISI 304L PER ASME SPEC SA-182 GRADE F; MAX SULFUR CONTENT .006%

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES:
 ANGULAR: $\pm 1^{\circ}$
 .XX $\pm .06$
 .XXX $\pm .005$
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS

FINISH 250

WEIGHT: 2008.47 #

APPROVALS	DATE
DRAFTER MKM2	6/14/10
CHECKER RW	6/14/10
ENGINEER MKM2	6/14/10

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 ELK GROVE, CA, 95758
 916-395-3003 FAX: 916-395-3363
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TITLE: FORGING, 44.90 ID, 80.25 OD, SMOOTH

DO NOT SCALE DRAWING

THIRD ANGLE PROJECTION

DWG. NO. 114303-00S
 SCALE: 1:16
 SHEET 1 OF 1

REV B