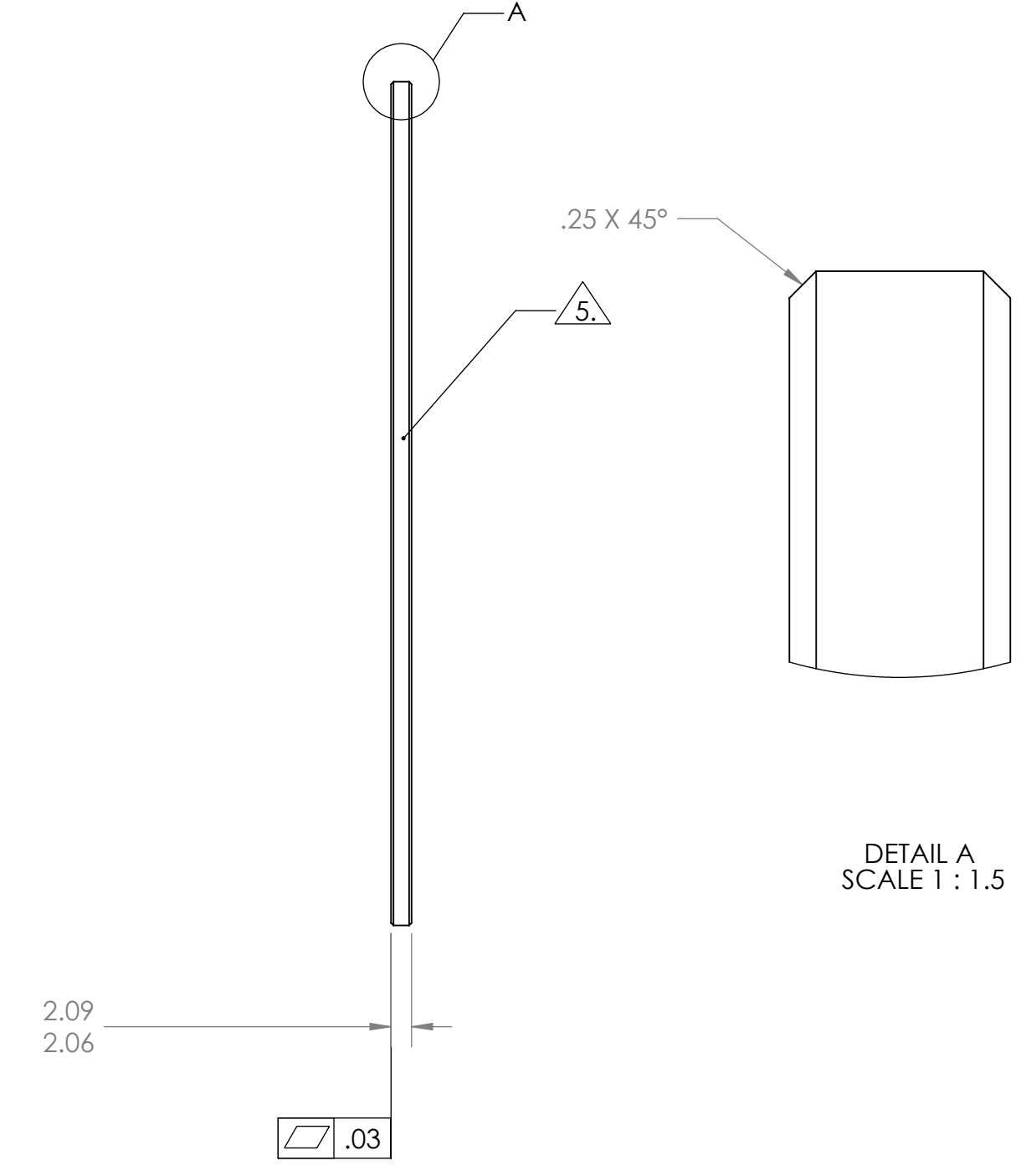
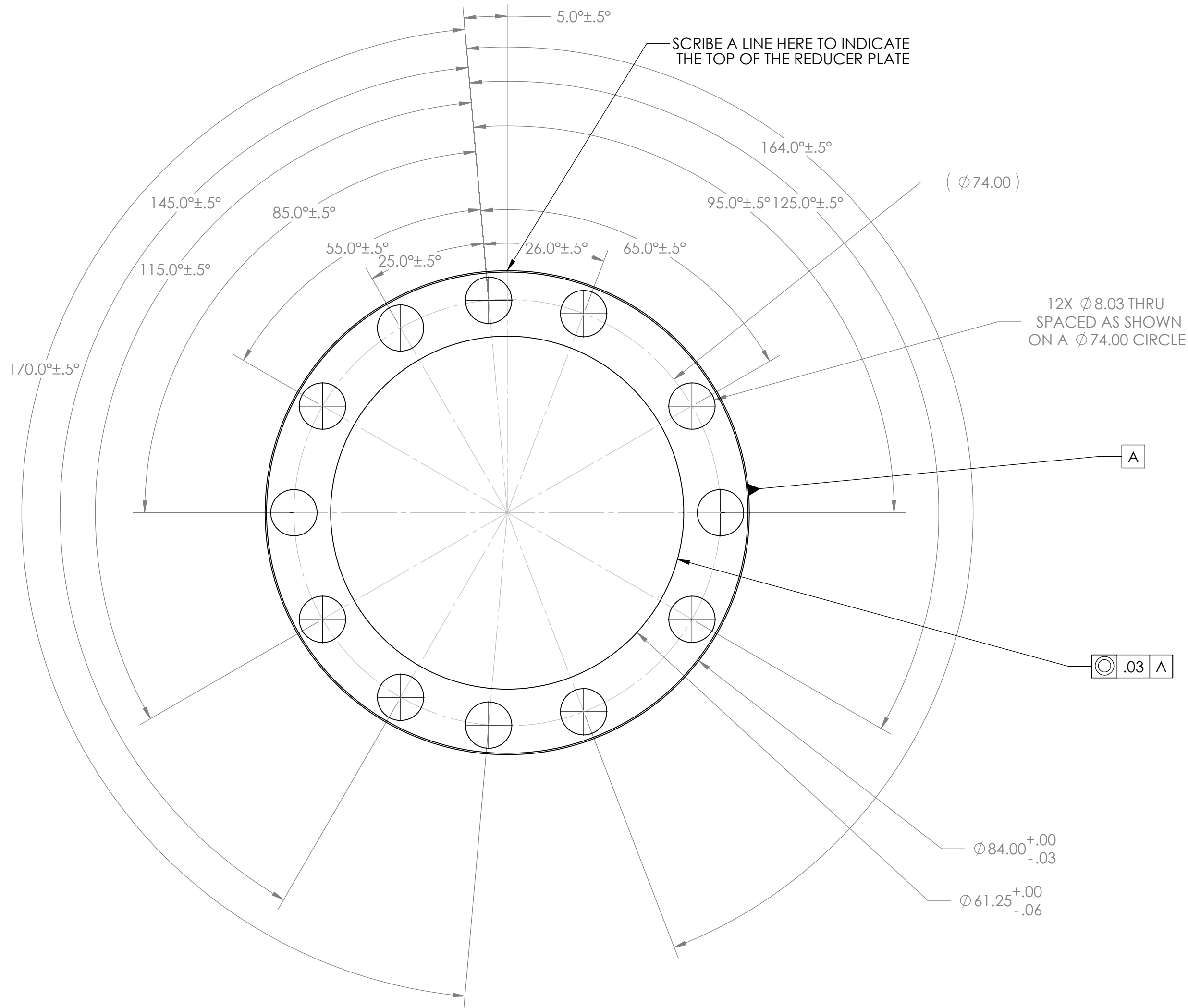


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	RELEASED TO PRODUCTION	8/25/2010	MKM2



- NOTES:
- THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING.
 - NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
 - WATER LEACHABLE CHLORIDES: 100PPM
 - TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
 - TOTAL SULFUR: 1000PPM
 - DO NOT ALLOW PART TO BE CONTAMINATED BY CARBON STEEL OR IRON CONTACT.
 - MACHINING TO BE IN LINE WITH LIGO SPECIFICATION E0900406, LATEST REVISION.

5. USING A VIBRATORY TOOL WITH A TIP WITH A MINIMUM RADIUS OF .005", ENGRAVE THE FOLLOWING ON THE INDICATED SURFACE:

- HEAT NUMBER
- LOT NUMBER
- PART NUMBER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114223-00SL	FORGING, REDUCER PLATE	1

MATERIAL: AISI 304L PER ASME SPEC SA-182 GRADE F; MAX SULFUR CONTENT .006%

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH
 ANGULAR: ±0°30' 125
 .XX ±.03
 .XXX ±.005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS
 // ▧ ⊥ WITHIN .03

WEIGHT: 1180.04#

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

TITLE: PLATE, REDUCER, WMCB#1

THIRD ANGLE PROJECTION

DO NOT SCALE DRAWING

C	DWG. NO. 114223-00S	REV A
SCALE: 1:16	SHEET 1 OF 1	

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