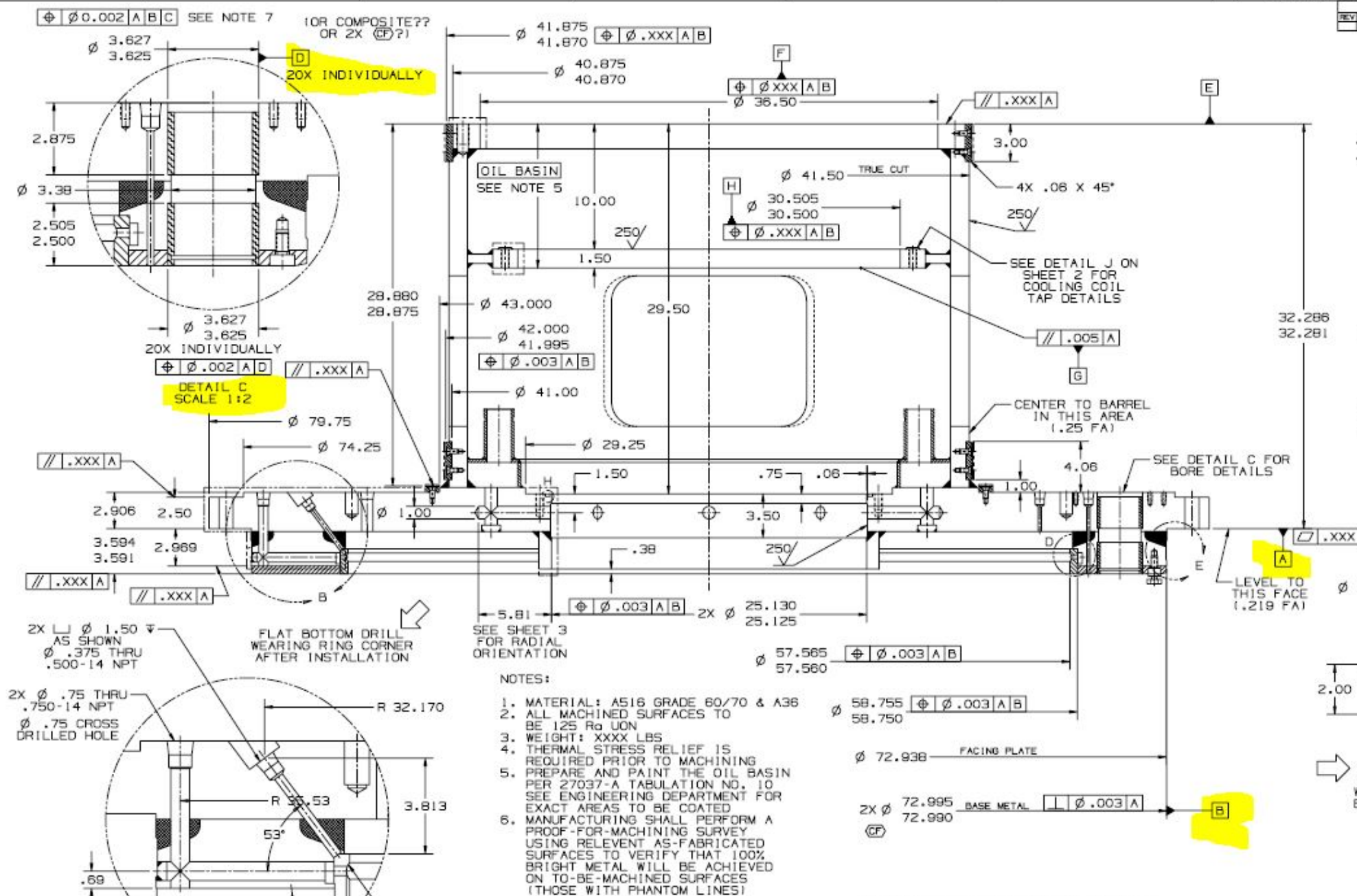




# NOTES:

1. MATERIAL: A516 GRADE 60/70 & A36
2. ALL MACHINED SURFACES TO BE 125 Ra UON
3. WEIGHT: XXXX LBS
4. THERMAL STRESS RELIEF IS REQUIRED PRIOR TO MACHINING
5. PREPARE AND PAINT THE OIL BASIN PER 27037-A TABULATION NO. 10 SEE ENGINEERING DEPARTMENT FOR EXACT AREAS TO BE COATED
6. MANUFACTURING SHALL PERFORM A PROOF-FOR-MACHINING SURVEY USING RELEVANT AS-FABRICATED SURFACES TO VERIFY THAT 100% BRIGHT METAL WILL BE ACHIEVED ON TO-BE-MACHINED SURFACES (THOSE WITH PHANTOM LINES)

375-16UNC  $\nabla$  .62

375-16UNC  $\nabla$  .62

$\phi$  7.000

$\phi$  4.812

R 4.264

PRESSURE TAP

2X .750-14 NPT  
TAP DRILL THRU  
EQUALLY SPACED  
AS SHOWN

48X  $\phi$  1.12 THRU  
 $\phi$  .015 A B C  
SEE NOTE 7

48X 7.50°

3.75°

FOUR ACCESS WINDOWS  
TO BE CENTERED IN  
RELATION TO THIS  
AXIS LINE

$\phi$  77.000

7.25°

90X .375-16UNC-28  $\nabla$  .53  
USING WEAR PAD CNC COORDINATES  
DO NOT DRILL THROUGH BARREL  
SECURE SCREWS WITH LOCTITE 242  
SCREW HEADS TO BE .09 BELOW  
BEARING SURFACE

2X  $\phi$  .500-1  
TAP DR.

$\phi$  65.500

CROSS DRILL DETAIL  
FOR SEAL COOLING WATER  
TYP 2X 180° APART  
CROSS DRILLING MUST  
BE COMPLETED BEFORE  
INSTALLATION OF  
FACING PLATE

SCRIBE AND ST/  
TIMING MARK F  
GATE RING

$\phi$  33.00

GPC

DRAFT TUBE  
HALFWAY C'LINE

4X 1.000-BUNC-28 THRU  
EQUALLY SPACED

PRESSURE TAP

ANGLED HOLE DETAIL  
FOR RTD THERMOWELL  
TYP 2X 180° APART  
ANGLE DRILLING MUST  
BE COMPLETED BEFORE  
INSTALLATION OF  
WEARING RING

COOLING COIL  
C'LINE

$\phi$  1.515 THRU  
FOR  $\phi$  1.50  
TIMING PIN  
 $\phi$  .015 A B C

PLAN VIEW

AIR ADMISSION  
PIPE

RADIAL LINE

20X 18°

2X 30°

3X  $\phi$  .50 THRU EQ. SP.  
PILOT HOLES FOR FIELD  
DOWELING

18X 1.000-BUNC-28  $\nabla$  1.62  
 $\phi$  .015 E F C

18X .625-11UNC THRU  
CAP HOLES AS SHOWN  
WITH .12 SEAL WELD  
 $\phi$  .015 G H C

DRAFT TUBE  
HALFWAY C'LINE