

REVISION	

NOTES:

1 MATERIAL OPTION 1: 17-4 PH STAINLESS STEEL PER UNS S17400, CONDITION H1150/HH1150. MATERIAL CERTIFICATION REQUIRED WITH PARTS.

MATERIAL OPTION 2: START WITH PAD HOUSING CASTING AS PER 02739903.

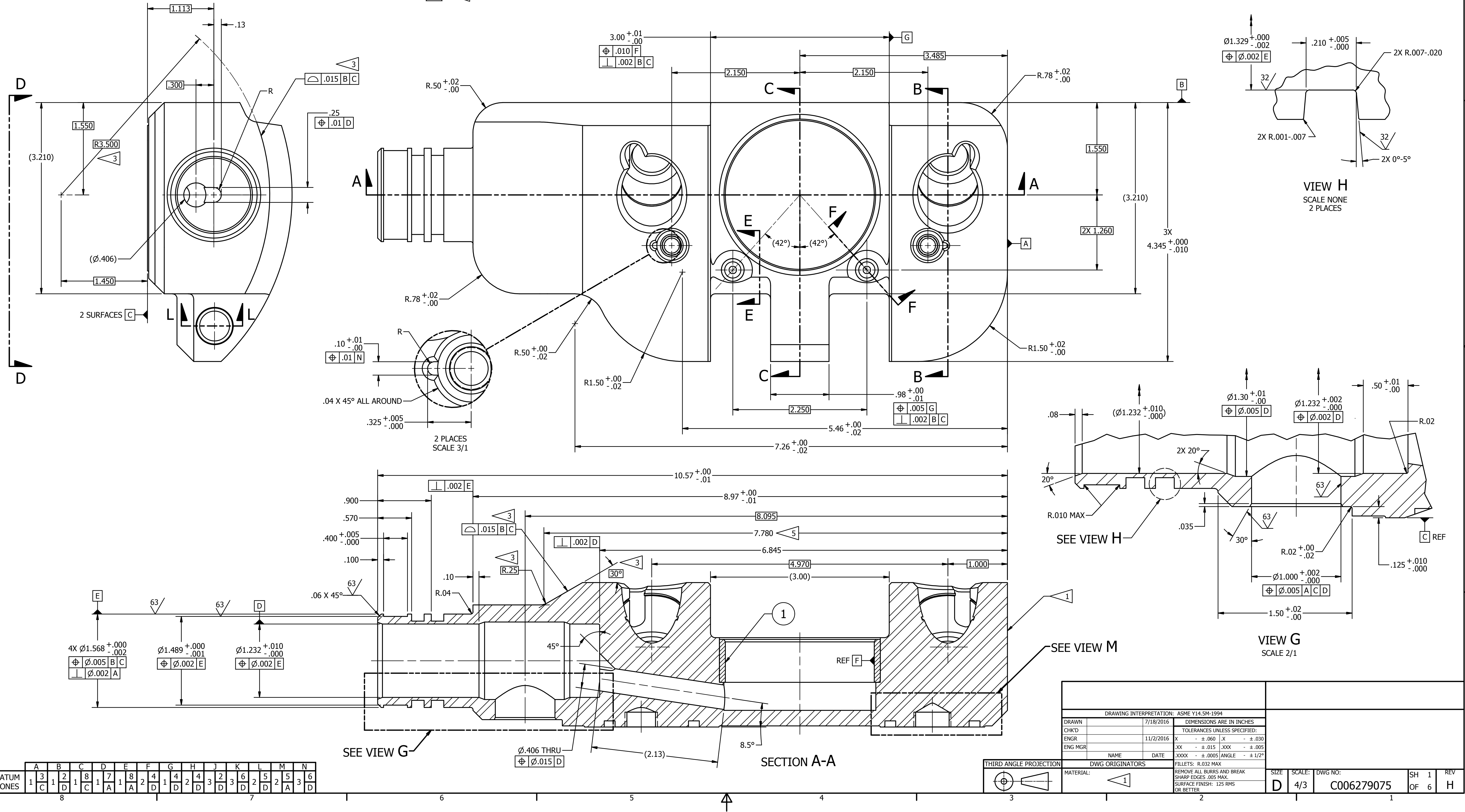
2. UNLESS OTHERWISE SPECIFIED, ALL DIAMETERS TO BE  $\varnothing .005$  A B C

3 ONLY APPLICABLE WHEN MACHINING THE PART FROM PLATE. WHEN STARTING WITH A CASTING THESE SURFACES ARE TO BE LEFT AS CAST PRIOR TO HARDFACING.

4. FOR ALL TAPPED HOLES FOR SCREW THREAD INSERTS, ITEMS 4 AND 5, FOLLOW MANUFACTUER'S INSTALLATION INSTRUCTIONS.

5 | DIMENSION IS TO THEORETICAL SHARP CORNER

 SHOULDER OF BUSHING, ITEM 3, TO BE .03-.05 INSIDE FACE OF SHARED DIAMETER WITH PAD HOUSING BODY.



## NOTES:

7 IF NECESSARY CUT SCREW THREAD INSERT TO SHORTER LENGTH TO FIT TAPPED HOLE DEPTH AS PER PRINT.

H CHANGED NOTE NUMBER 7 WAS 6

REVISION

SECTION B-B

SECTION C-C

SECTION E-E

SCALE 3/2  
2 PLACES

SECTION F-F

(SHOWN ROTATED 48° CCW)  
SCALE 2/1  
2 PLACES

VIEW M

SCALE 2/1  
2 PLACES

VIEW N

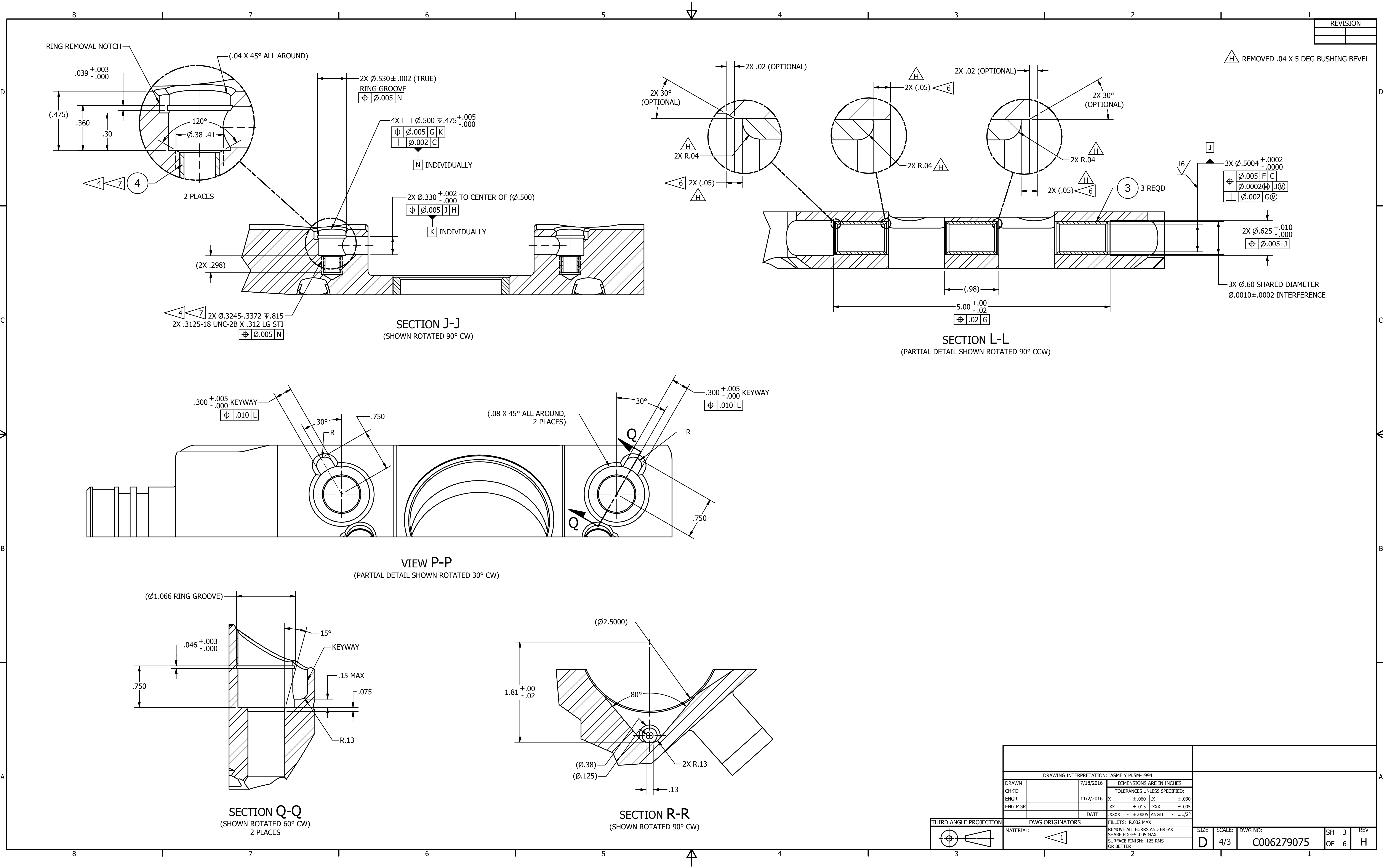
SCALE NONE  
2 PLACES

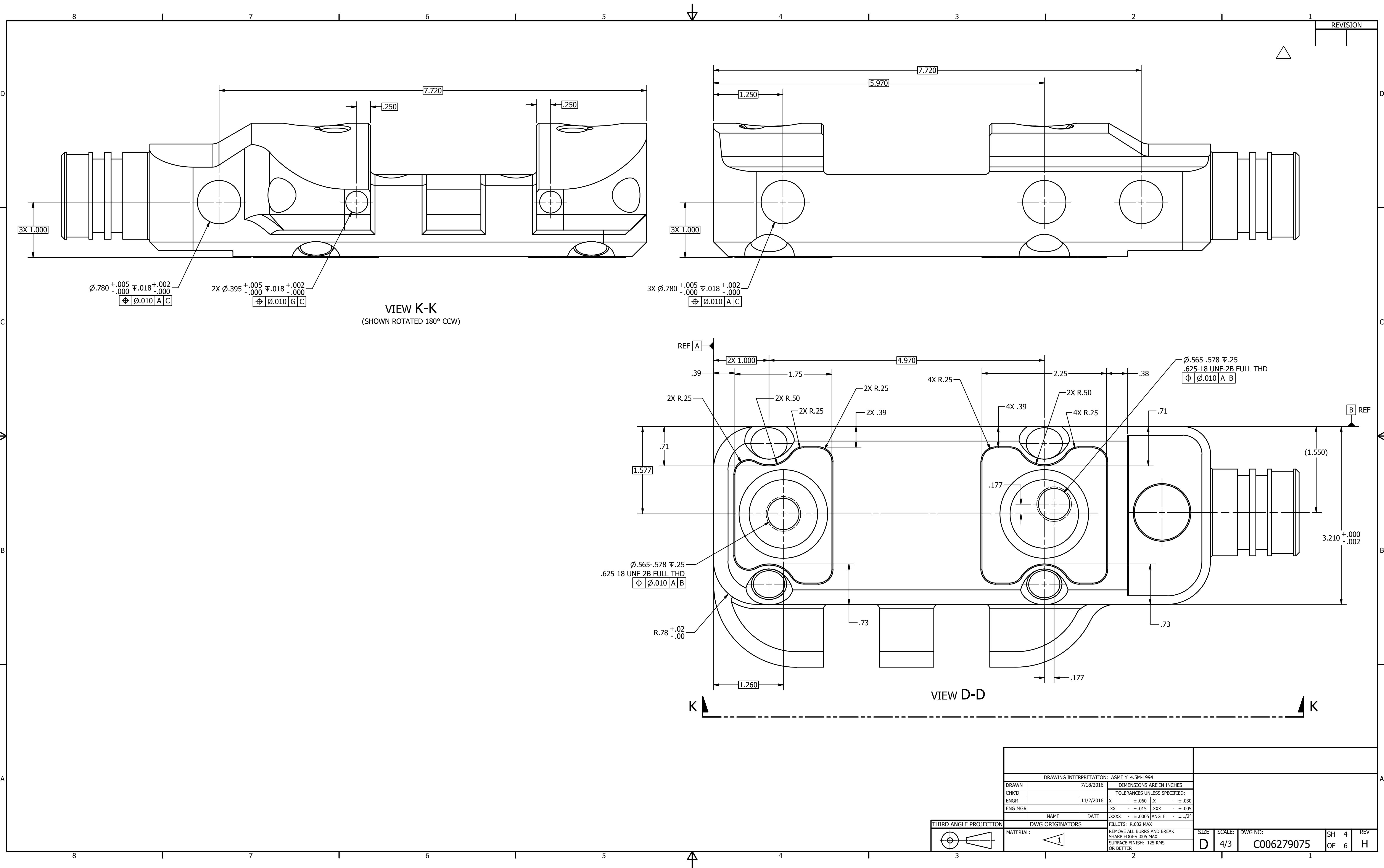
DRAWING INTERPRETATION: ASME Y14.5M-1994

DRAWN	7/18/2016	DIMENSIONS ARE IN INCHES	
CHK'D		TOLERANCES UNLESS SPECIFIED:	
ENGR	11/2/2016	X	- ± .060 X - ± .030
ENG MGR		XX	- ± .015 XXX - ± .005
		XXXX	- ± .0005 ANGLE - ± 1/2°

NAME	DATE	FILLET: R.032 MAX
DWG ORIGINATORS		REMOVE ALL BURRS AND BREAK SHARP EDGES .005 MAX.
MATERIAL:		SURFACE FINISH: 125 RMS OR BETTER

SIZE	SCALE:	DWG NO:	SH	2	REV
D	4/3	C006279075	OF	6	H

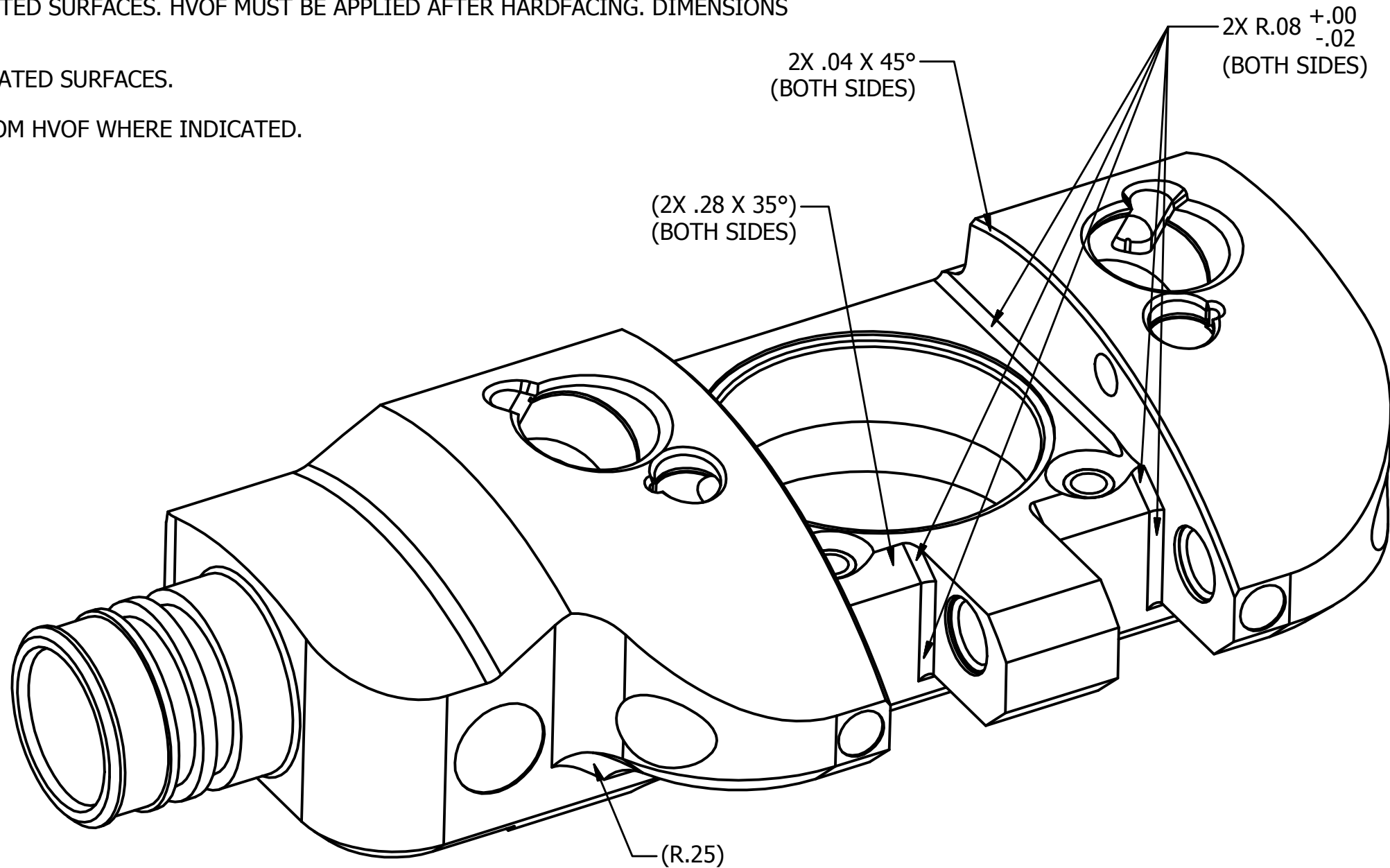




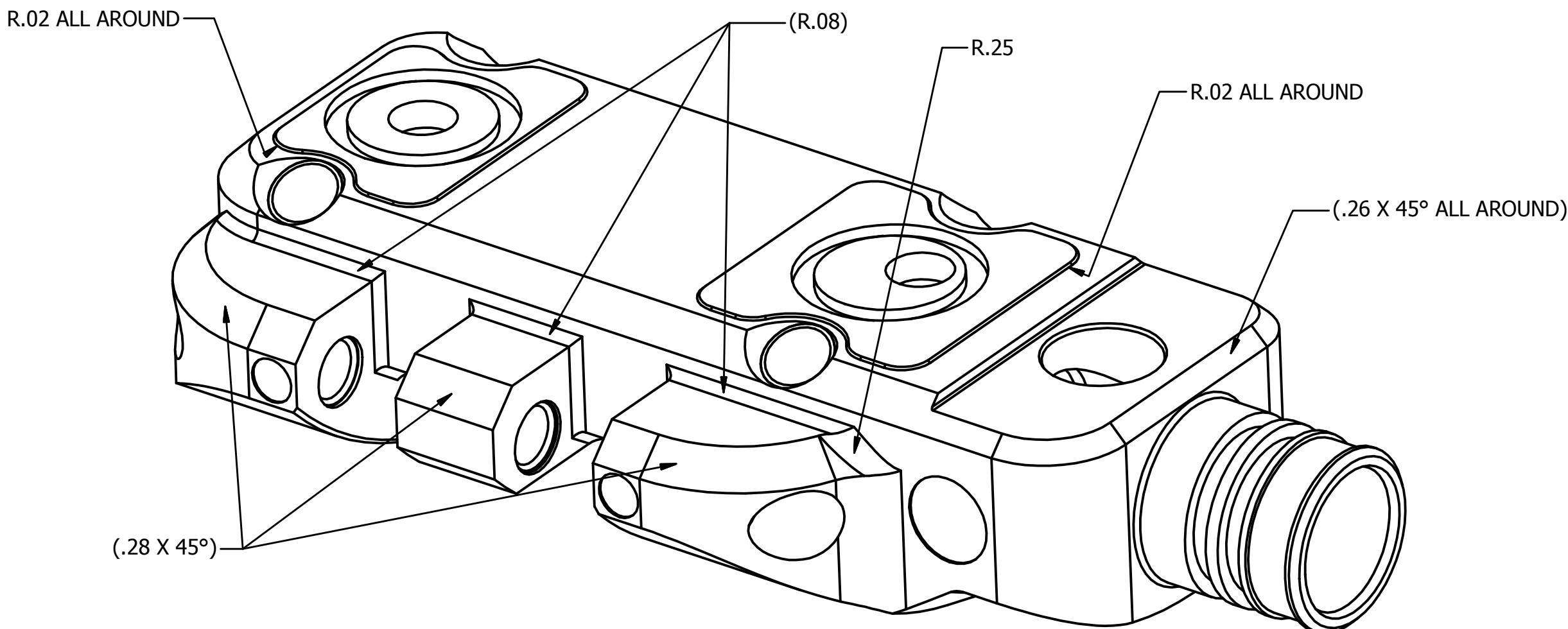
NOTES:

- 8 APPLY METCO 73F-NS-1 OR EQUIVALENT (17% Co, 83% WC) USING HVOF (HIGH VELOCITY OXYGEN FUEL) .008-.015 THICKNESS TO INDICATED SURFACES. HVOF MUST BE APPLIED AFTER HARDFACING. DIMENSIONS APPLY POST COATING.
- 9 OVERSPRAY ALLOWED ON INDICATED SURFACES.
- 10 SURFACES MUST BE MASKED FROM HVOF WHERE INDICATED.

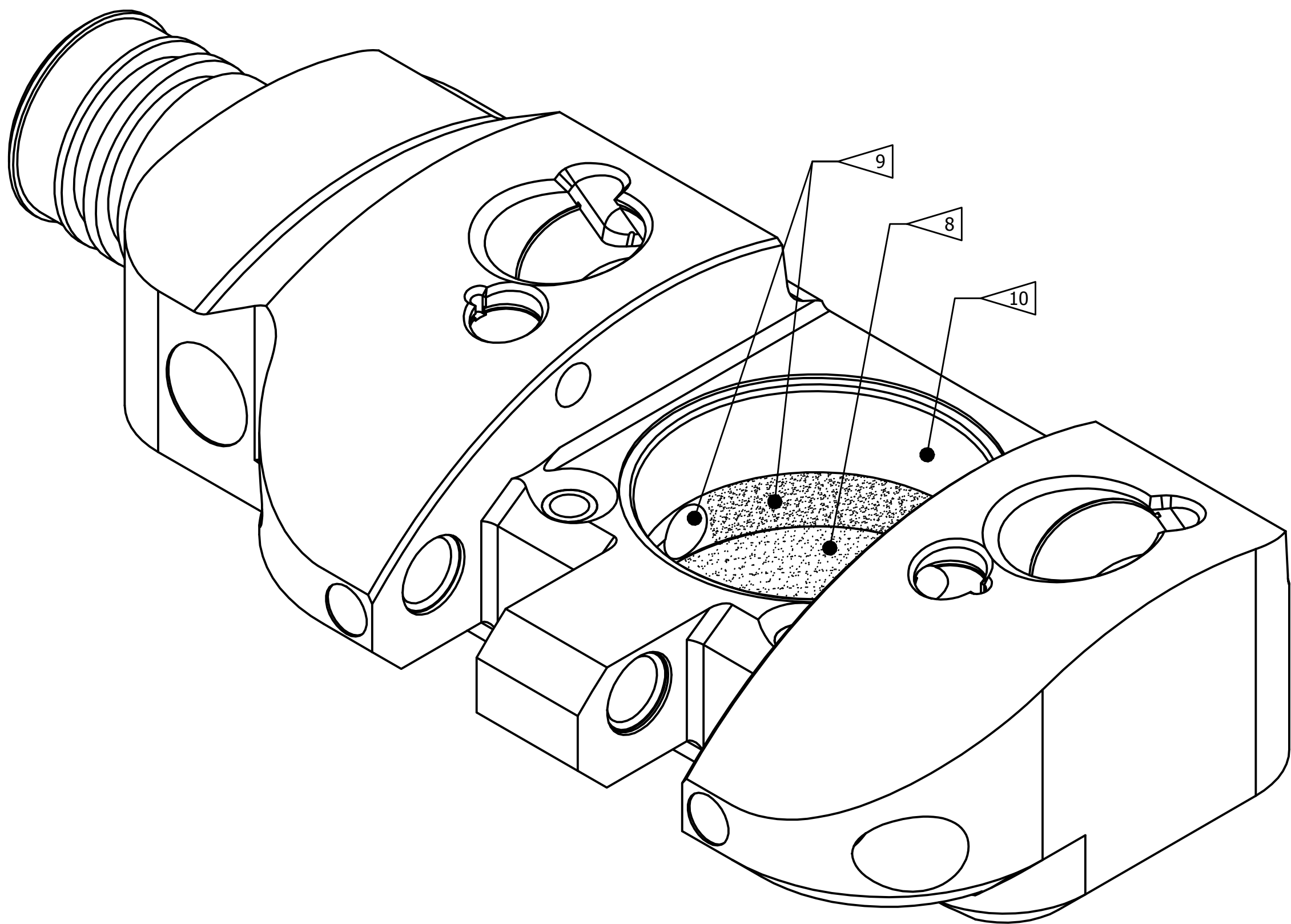
CHANGED NOTE NUMBERS



ISO VIEW 1  
SCALE NONE



ISO VIEW 2  
SCALE NONE



ISO VIEW 3  
(HVOF COATING DETAIL)  
SCALE NONE

DRAWING INTERPRETATION: ASME Y14.5M-1994					
DRAWN	7/18/2016	DIMENSIONS ARE IN INCHES			
CHK'D		TOLERANCES UNLESS SPECIFIED:			
ENGR	11/2/2016	X	- ± .060	X	- ± .030
ENG MGR		XX	- ± .015	XXX	- ± .005
	DATE	XXXX	- ± .0005	ANGLE	- ± 1/2°
THIRD ANGLE PROJECTION		DWG ORIGINATORS		FILLET: R.032 MAX	
MATERIAL:		REMOVE ALL BURRS AND BREAK SHARP EDGES .005 MAX.		SURFACE FINISH: 125 RMS OR BETTER	
SIZE		SCALE:	DWG NO:	SH	REV
D		4/3	C006279075	5 OF 6	H

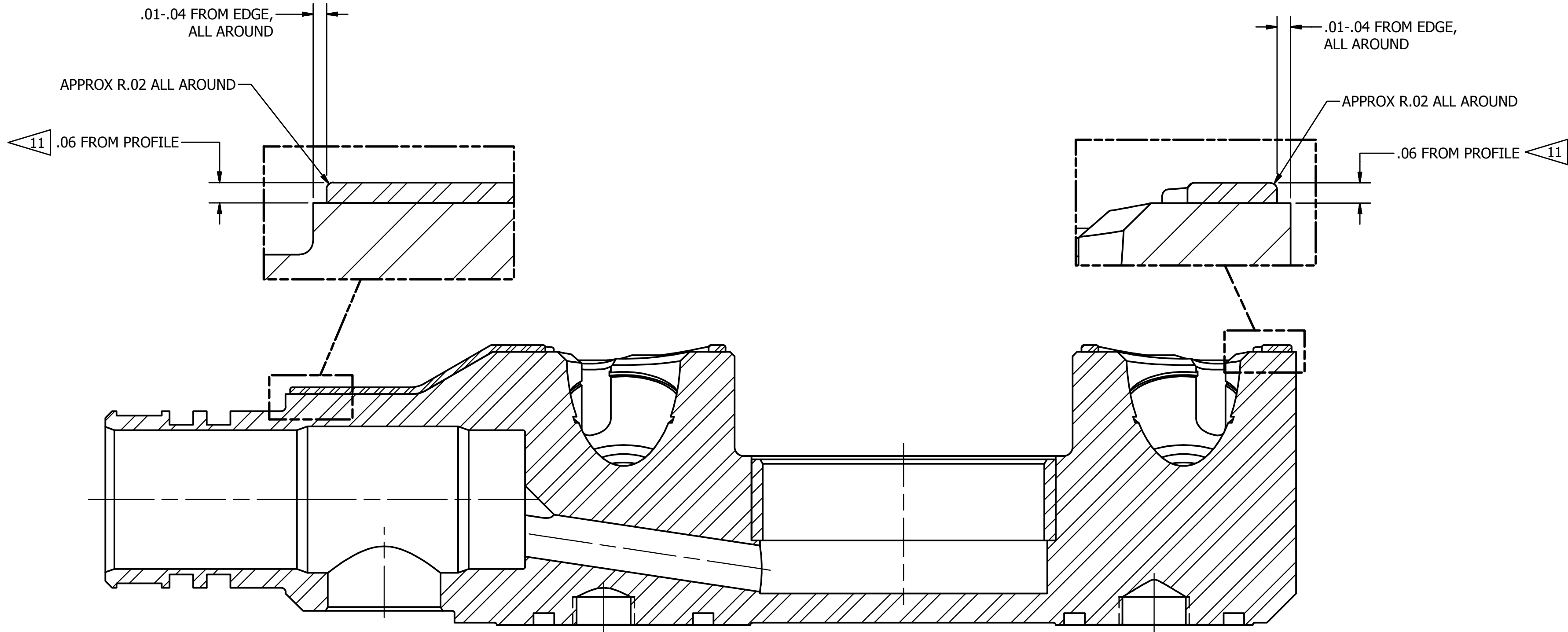
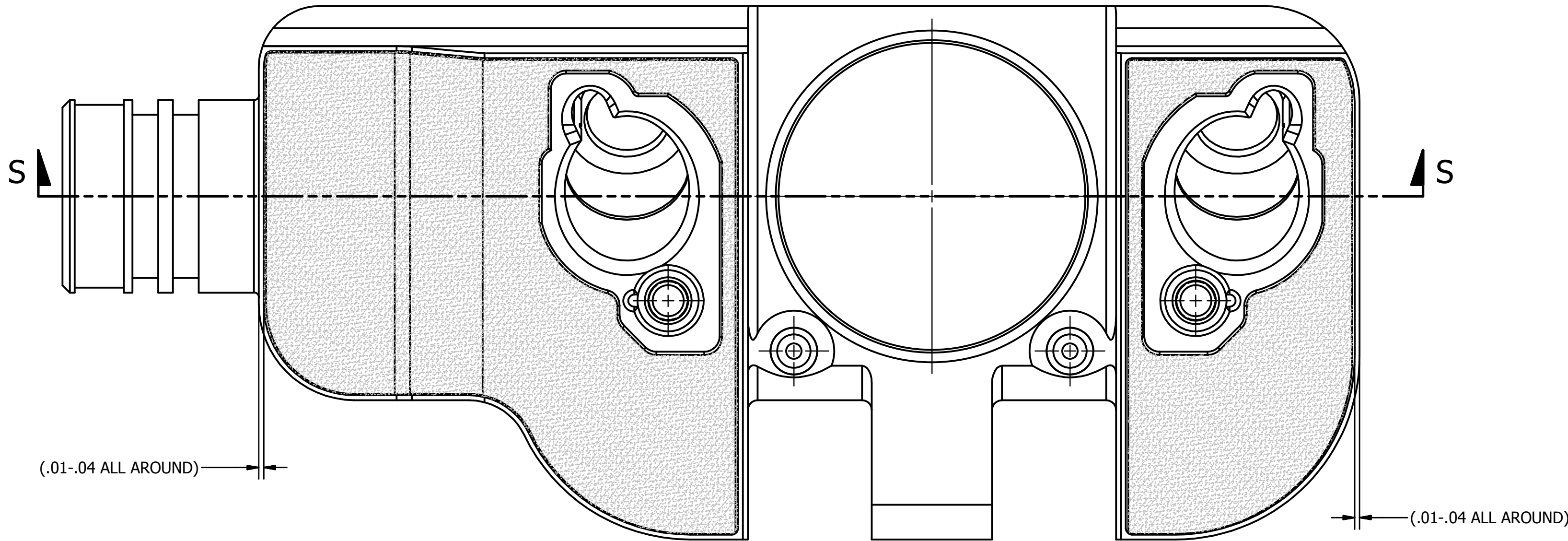


NOTES: (PERTAINING THIS PAGE ONLY)

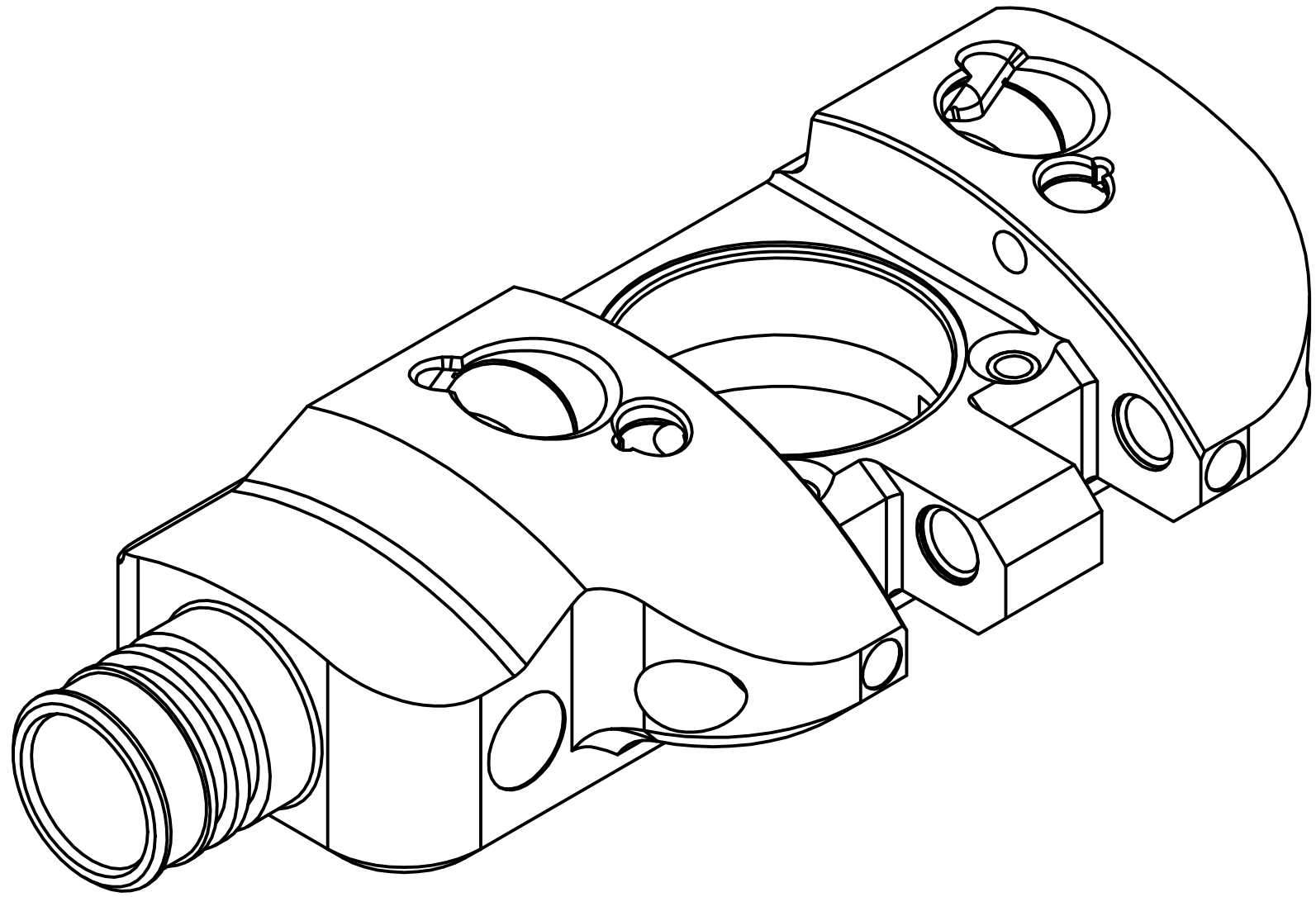
11 APPLY TECHNOBASE 40S HARDFACING TO ACHIEVE INDICATED DIMENSION FROM PROFILE.  
HARDFACING MUST BE APPLIED PRIOR HVOF COATING.

APPROVED VENDOR: TECHNOGENIA, INC.  
708 OLD MONTGOMERY RD  
CONROE, TX 77301  
PH: 936-441-4770  
www.technogeniausa.com

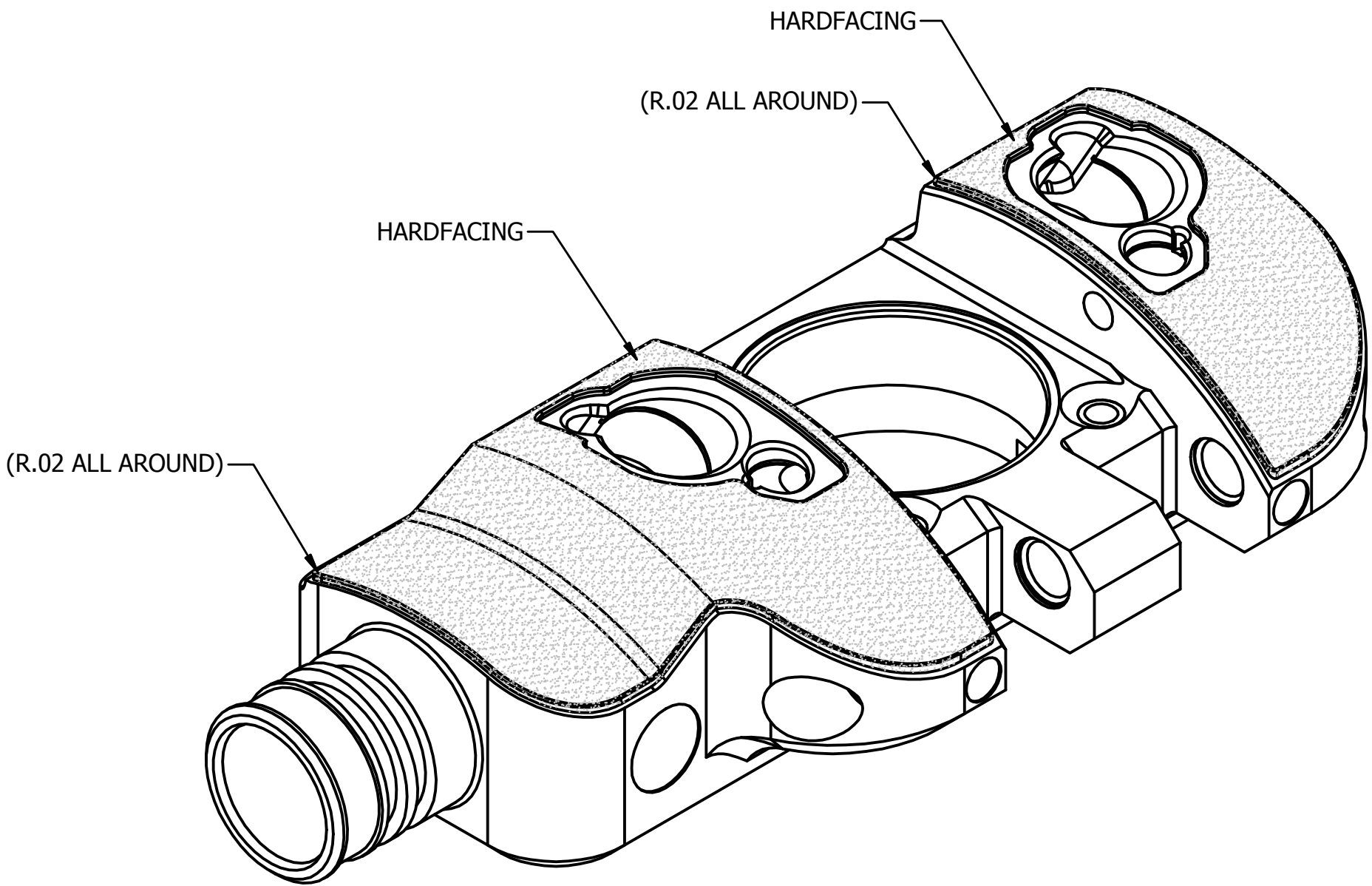
12. HARDFACING LAYOUT IS SHOWN AS AN EXAMPLE TO MAINTAIN A .01-.04 GAP BETWEEN EDGES OF PART  
AND HARDFACING. A GAP GREATER THAN .12 IS ALLOWED AROUND ALL INTERNAL EDGES IF REQUIRED.



SECTION S-S



ISO VIEW 4  
BEFORE HARDFACING  
SCALE NONE



ISO VIEW 5  
AFTER HARDFACING  
SCALE NONE

DRAWING INTERPRETATION: ASME Y14.5M-1994							
DRAWN	7/18/2016	DIMENSIONS ARE IN INCHES		SIZE	SCALE:	DWG NO:	SH 6 REV
CHK'D		TOLERANCES UNLESS SPECIFIED:		D	4/3	C006279075	OF 6 H
ENGR	11/2/2016	X	- ± .060	X	- ± .030		
ENG MGR		XX	- ± .015	XXX	- ± .005		
NAME		DATE	XXXX	- ± .0005	ANGLE	- ± 1/2°	
DWG ORIGINATORS				FILLET: R.032 MAX			
MATERIAL:				REMOVE ALL BURRS AND BREAK SHARP EDGES .005 MAX.			
				SURFACE FINISH: 125 RMS OR BETTER			