



- NOTES:
1. WELD BELLOWS TO -172.
 2. WELD ASSY MADE IN STEP 1 TO -130. ENSURE PROPER CLOCKING ALIGNMENT.
 3. WELD P/N -172 TO -150.
 4. ASSEMBLE P/N -173 & ASSEMBLY FROM STEP 3, USING FIXTURE -248.
 5. TO ENSURE PROPER ALIGNMENT, TACK WELD P/N -150 TO -173 WHILE IN FIXTURE.
 6. REMOVE TACKED ASSEMBLY FROM FIXTURE AND COMPLETE WELDS.
 7. COLD SHOCK AND LEAK CHECK WELDS MADE IN STEP 5.
 8. ASSEMBLE P/N -093, -091 & ASSEMBLY FROM STEP 5, USING FIXTURE.
 9. WHILE IN FIXTURE, TACK WELD P/N -173 AND -093 TO -091.
 10. REMOVE FROM FIXTURE AND COMPLETE WELDS.
 11. COLD SHOCK AND LEAK CHECK WELDS MADE IN STEP 9.
 12. WELD P/N -094 TO -095.
 13. WELD ASSEMBLY MADE IN STEP 12 TO P/N -093.

REVISIONS			
ZONE	REV	DESCRIPTION	DATE

UNLESS OTHERWISE SPECIFIED:		DIMENSIONS ARE IN INCHES	
DECIMAL TOLERANCES:		X \pm .030 XX \pm .015 XXX \pm .005	
ANGULAR TOL: \pm 1°		SURFACE ROUGHNESS: $\sqrt{\text{ }}$	
INTERNAL AND EXTERNAL SURFACE INTERSECTIONS SHALL BE UNIFORMLY FINISHED WITH CHAMFER .005/.010 X 45° OR RADIUS .005/.010.		CHAMFER ALL THREADED HOLES 110% OF MAJOR DIAMETER X 45°	
MATERIAL:		TITLE:	
FINISH:		CONFIGURATION:	
SIZE	QTY PER ASSM:	SCALE:	SHEET 1 OF 1
D	DATE: 5/20/2004	DRAWN BY: C. Danaher	REV A