

5

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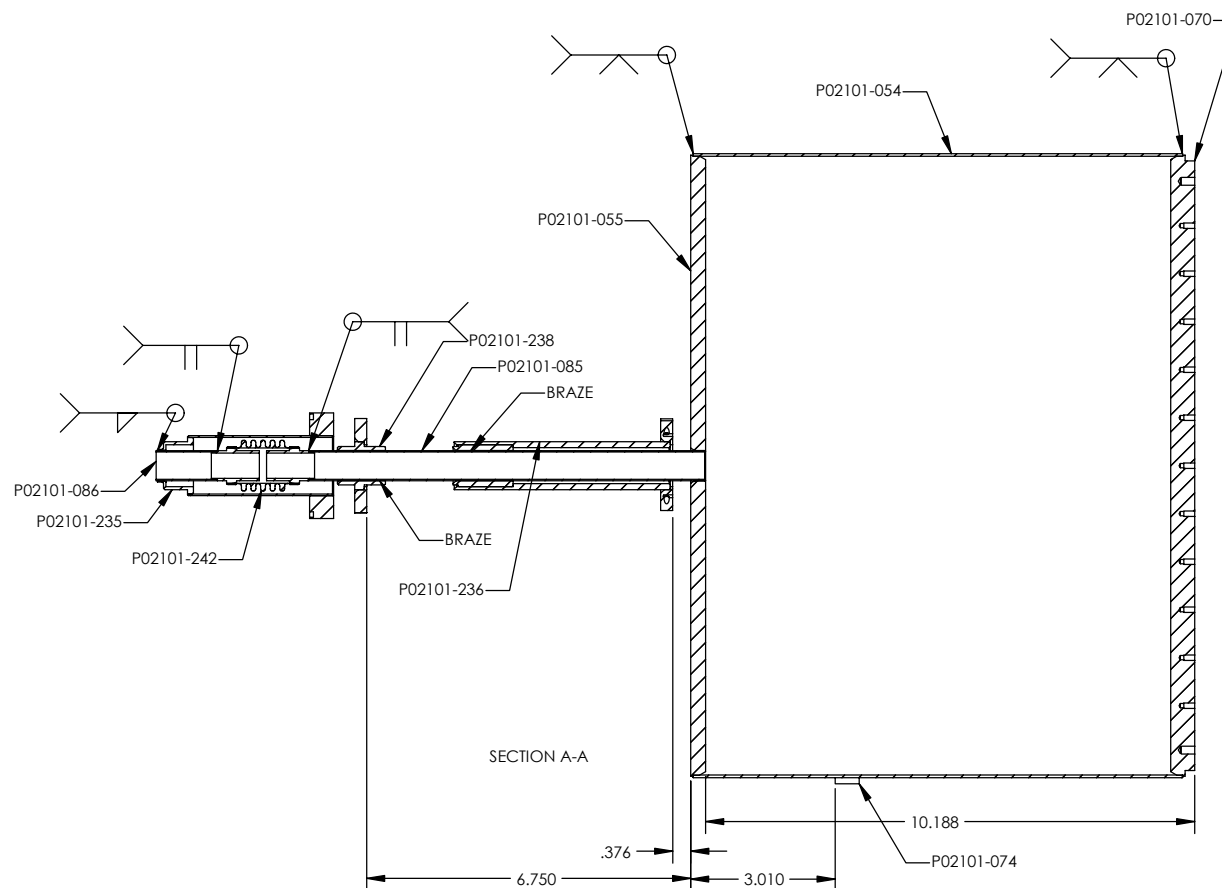
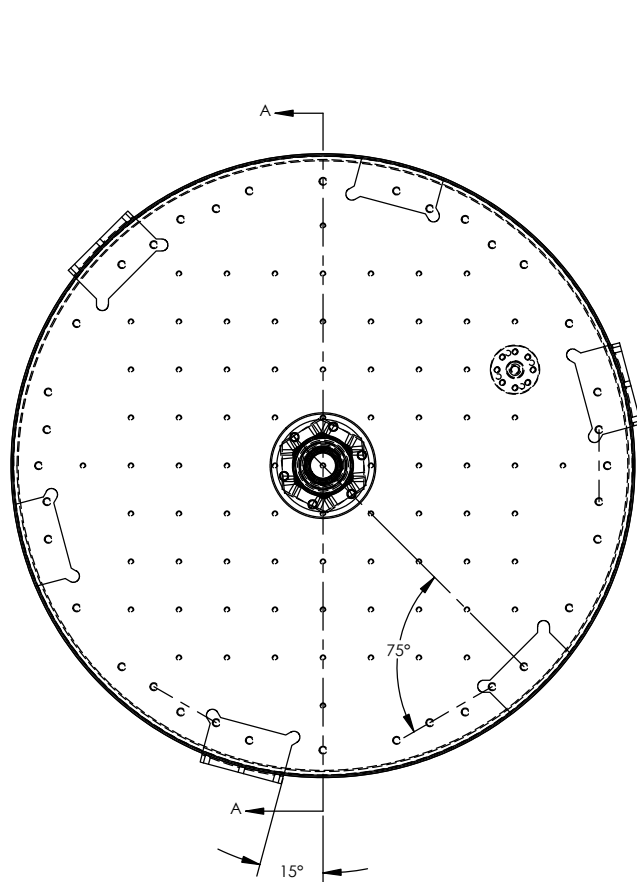
REVISIONS			
ZONE	REV	DESCRIPTION	DATE

D

C

B

A



- NOTES:
1. WELD P02101-086 TO P02101-242.
 2. BRAZE P02101-236 & P02101-238 TO P02101-085.
 3. WELD SUBASSEMBLY MADE IN STEP 2 TO P02101-242.
 4. WELD SUBASSEMBLY MADE IN STEP 3 TO TOP PLATE (P02101-055), WHILE ALIGNING -236 & -238 TO RECESSES IN TOP PLATE.
 5. ASSEMBLE P02101-054 & -070 TO SUBASSEMBLY MADE IN STEP 4.
 6. THE TWO-BOLT HOLE PATTERNS IN P02101-070 TO BE ALIGNED TO RECESSES IN TOP PLATE, ROTATED BY 15 DEGREES.
 7. BOLT HOLES ON FLANGE ASSY (P02101-235) MUST BE ALIGNED WITH CENTER OF RECESSES ON TOP PLATE (P02101-055).
 8. WELDS BETWEEN P02101-242 AND TUBES TO BE LEAK CHECKED PRIOR TO ATTACHING P02101-235.
 9. WELD ON P02101-074, USING RECESSES IN -055 FOR ALIGNMENT. DO NOT ALIGN WITH RECESS NEAREST THE TWO-BOLT PATTERNS, BUT EVERY OTHER.

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES
DECIMAL TOLERANCES:
X $\pm .030$ XX $\pm .015$ XXX $\pm .005$
ANGULAR TOL: $\pm 1^\circ$ SURFACE ROUGHNESS:
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:
FINISH:

High Precision Devices

1668 Valtrec Lane, Suite C, Boulder, Colorado 80301
Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com

TITLE:		p02101-237 He can assy	
CONFIGURATION:		-0 Default	
SIZE	QTY PER ASSY: 1	SCALE: 1:2	SHEET 1 OF 1
DATE: 5/19/2004	DRAWN BY: C. Danaher	REV A	