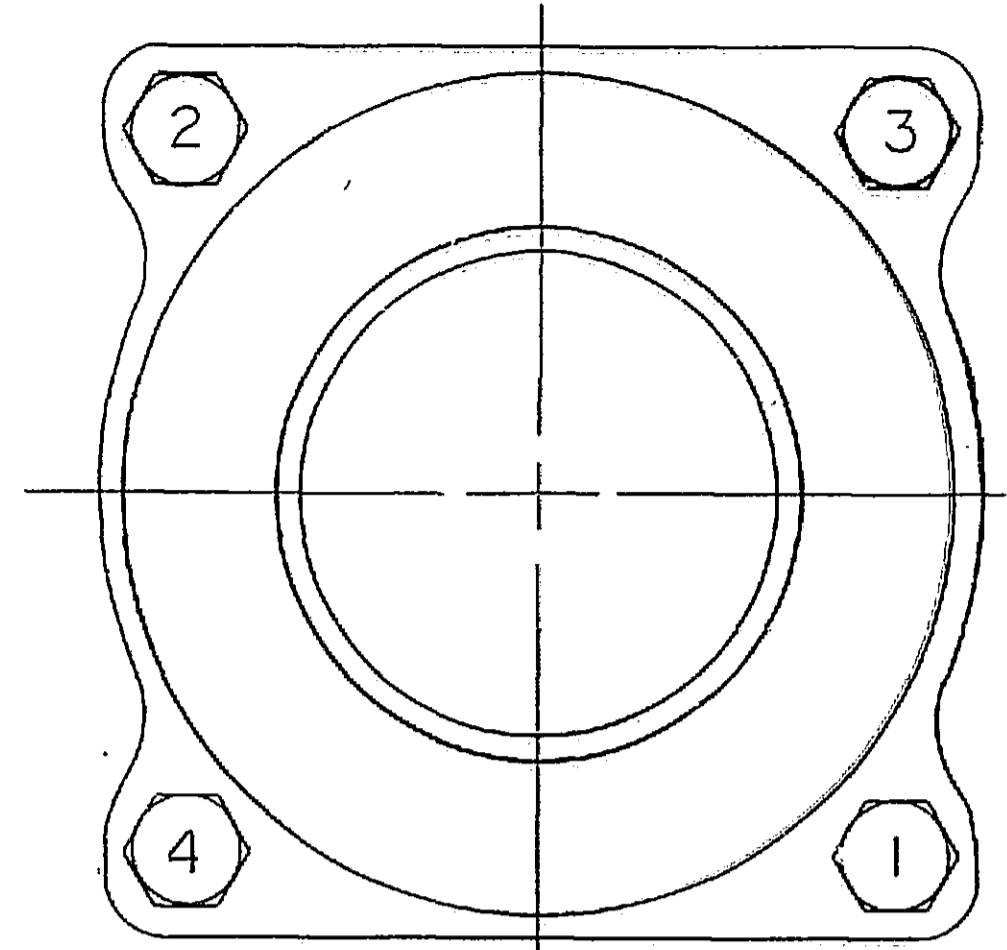
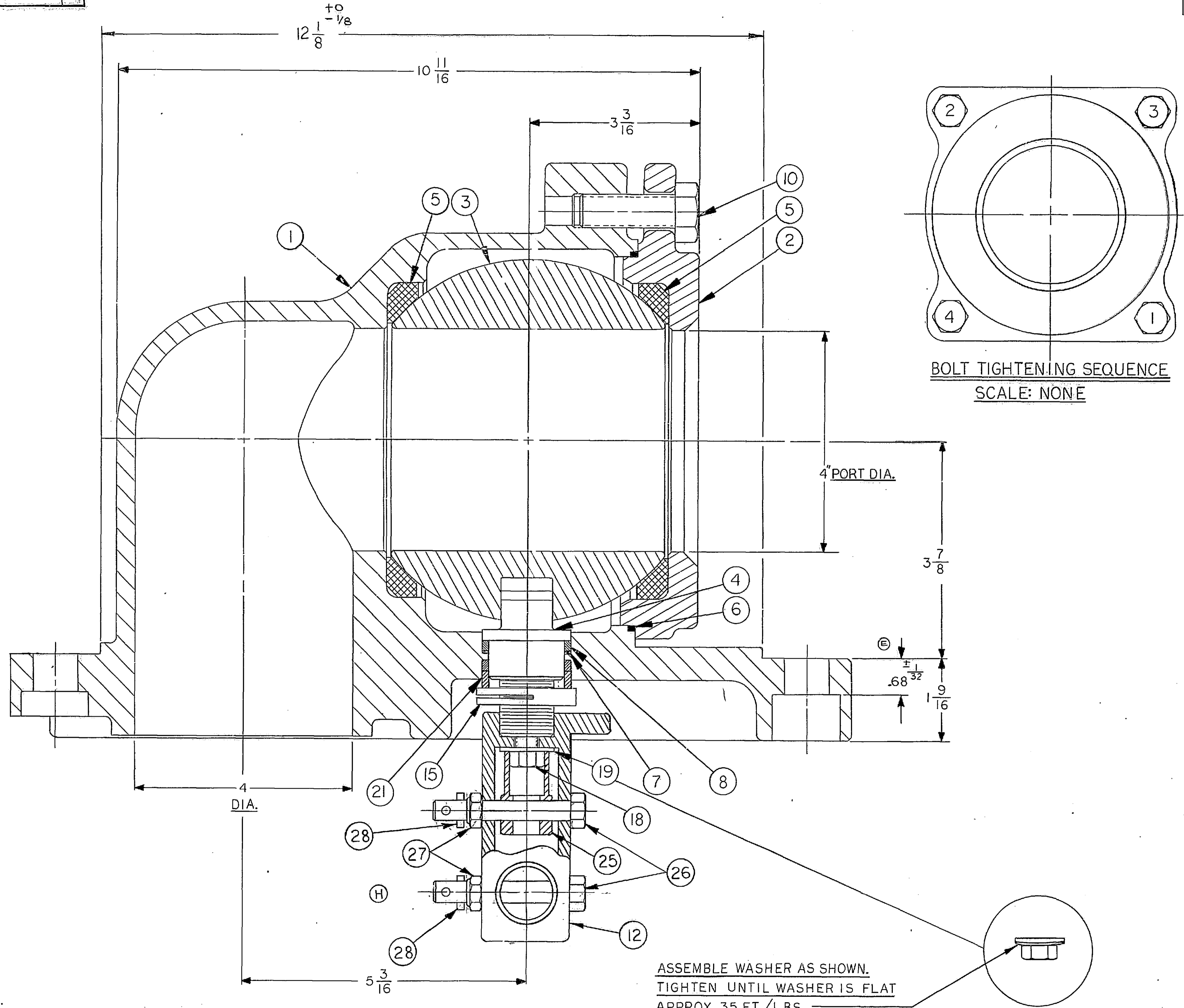


9077

L	14635	SEE ECN FOR CHANGES	RWB	PP	7/14/93	SUPERSEDING D-4406 REV. C	SUPERSEDED BY
M	17422	POP REVET WAS DRIVE SCR	BA	SL	6/16/99		

LET	ZONE	ECN	REVISION	DR BY	CH BY	APP BY	DATE
D	9694		REDRAWN SECTION A-A IN CORRECT MOUNTING POSITION	JM	MW	SR	1/82
E	10225		SEE ECN FOR CHANGES	S	RZ		1/83
F	10659		ADDED 12 1/8 ± 1/8 ADDED ± 1/2 TO 1 1/2 DIA.	RE	W		20.1
G	11821		ADDED -31 MATERIAL OPTION TO ITEM #10	RJ	LR		11/82
H	13116		SEE ECN FOR CHANGES	RWB			
J	13331		SEE ECN FOR CHANGES	JJK	JP		2/22
K	13758		SEE ECN FOR CHANGES	EE			1/10 5/24/11



BOLT TIGHTENING SEQUENCE  
SCALE: NONE

BOLT MAT'L.	BOLT IDENT.	ASSEMBLY TORQUE FT./LBS.
31	BB, B8C OR B8T	35-40

ITEM NO.	PART NAME	QTY.	MATERIAL SPEC.
1	BODY	1	- 22 ASTM A-216 GRADE WCB - 36 ASTM A-351, TYPE CF8M SOLUTION ANNEALED
2	BODY CAP	1	- 22 ASTM A-216 GRADE WCB - 36 ASTM A-351, TYPE CF8M SOLUTION ANNEALED
3	BALL	1	- 22 AISI 1040 ELECTROLESS NICKEL PLATE - 36 ASTM A-351, TYPE CF8M SOLUTION ANNEALED
4	STEM	1	- 43 17 4 PH ASTM A 564 TYPE 630 H-1025 OR AMS 5643 H-1025
5	SEAT	2	- 50 PTFE 100% VIRGIN
6	BODY SEAL	1	- 50 PTFE 100% VIRGIN
7	SEC. STEM SEAL	1	- 60 GRAFOIL 1/32 SHT. GRADE GTA
8	STEM SEAL	2	- 50 PTFE 100% VIRGIN
10	HEX. HD. CAP SCR.	4	-31 ASTM A 193 GR. BB, B8C OR B8T
12	HANDLE/INDICATOR STOP	1	- 22 ASTM A-216 GRADE WCB BHN RANGE 155-190
13	SOC. HD. SET SCR.	2	- 30 ANY AISI 302, 303, 304 SERIES
15	STEM NUT	1	- 22 AISI C-1117
17	PIPE HANDLE	1	- 22 3/4 SCHEDULE 80 GALVANIZED STEEL PIPE
21	COMPRESSION RING	1	- 30 AISI 302, 303, 304 TYPE 18-8
22	IDENTIFICATION TAG	1	- 30 1/64 THK SATIN STAINLESS 300 SERIES
23	POP RIVET	2	- 30 ANY AISI 302, 303, 304 SERIES
18	HEX. HD. CAP SCREW	1	- 22 ASTM A-449 OR SAE J-429 GRADE 5
19	WASHER	1	- 22 MECHANICAL ZINC PLATE
25	SCREW RETAINER	1	- 22 ANY AISI 10XX OR 11XX SERIES CARBON STEEL
26	HEX HD CAP SCREW	2	- 30 ANY AISI 302, 303 OR 304 SERIES
27	LOCK NUT	2	- 30 ANY AISI 302, 303 OR 304 SERIES
28	SPIROL PIN	2	- 30 ANY AISI 302, 303 OR 304 SERIES

ASSEMBLE WASHER AS SHOWN.  
TIGHTEN UNTIL WASHER IS FLAT  
APPROX. 35 FT./LBS.

SECTION A-A  
ROTATED 90°

JC	ALL
JL	
JM	
JN	
JS	
JT	

THIS DRAWING AND ALL INFORMATION CONTAINED HEREIN ARE THE PROPERTY OF THE JAMESBURY CORP. AND ARE NOT TO BE USED EXCEPT AS AUTHORIZED BY SAID CORP.	JAMESBURY SPECIFICATIONS APPLICABLE ON THIS DWG.	MAKE FROM PART NO.	DO NOT SCALE DRAWING	SCALE: 1:1
JSA-10	JSA-34	JMA-98	TITLE -ASSEMBLY- 4"-6RIB3 VALVE	DR. BY: J.P.B. DATE: JUL 20 1981 CH. BY: M.C. DATE: SEP 19 1981 APP. BY: B.P.H. DATE: SEP 21 1981
jamesbury CORP. WORCESTER, MASS.			D	4406

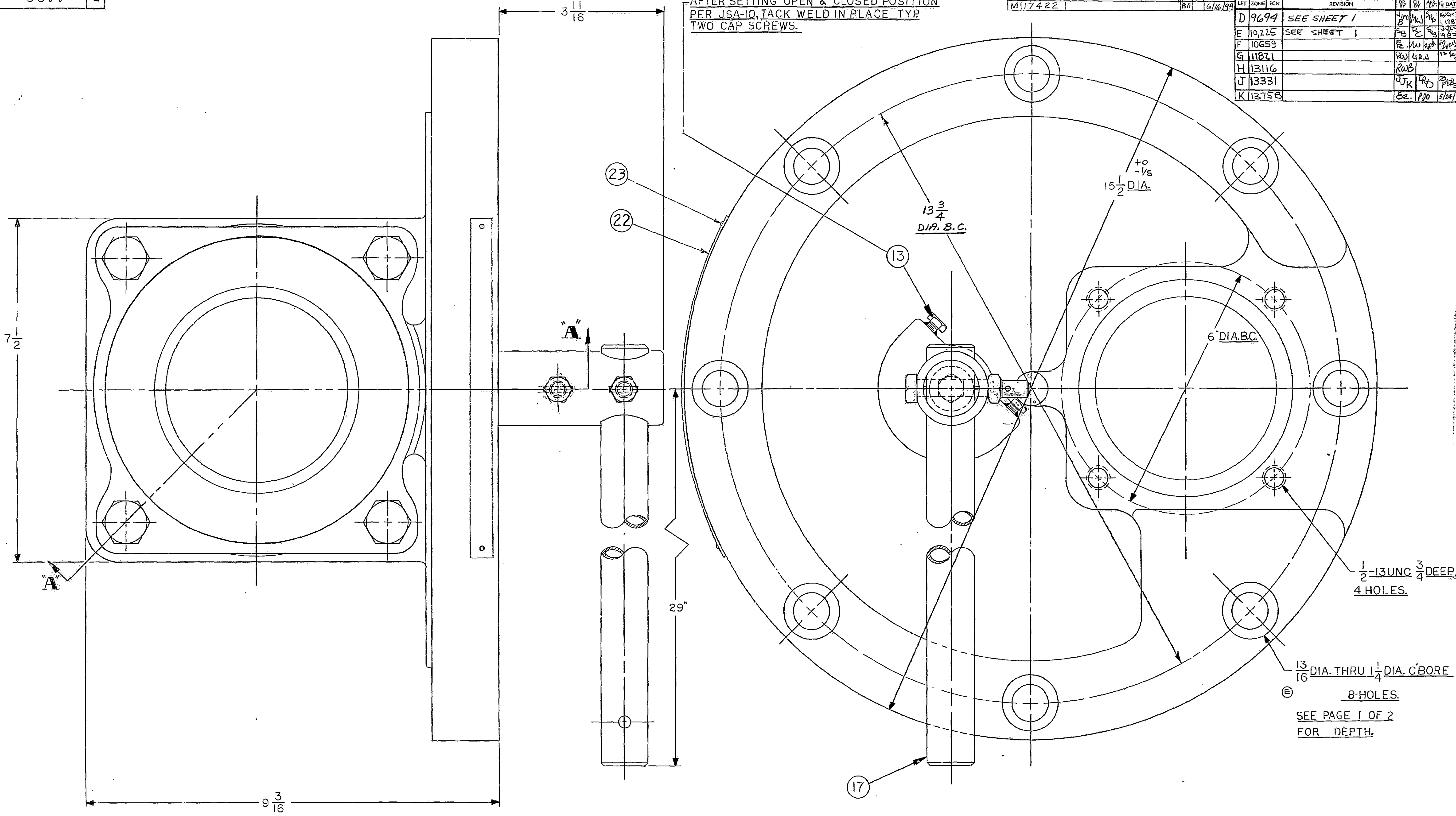
4406 D

L 14635  
M 17422

7/14/73  
6/16/79

LET	ZONE	ECN	REVISION	BY	CHK	APP	DATE
D		9699	SEE SHEET 1	JM	MJ	JPB	06-30-1981
E		10225	SEE SHEET 1	SB	CB	RS	04-27-1982
F		10659		EM	AW	KPB	08-08-1982
G		11821		RA	LR	WJ	12-22-1982
H		13116		ROB			
J		13331		UJK	TRD	PEB	05-01-1983
K		13758		EE	PJO		5/24/1983

AFTER SETTING "OPEN" & "CLOSED" POSITION  
PER JSA-10, TACK WELD IN PLACE TYP  
TWO CAP SCREWS.



1/2-13UNC 3/4 DEEP  
4 HOLES.

13/16 DIA. THRU 1/4 DIA. C'BORE  
8 HOLES.

SEE PAGE 1 OF 2  
FOR DEPTH.

JC	ALL
JL	
JM	
JN	
JS	
JT	

DEFINITION OF SYMBOLS (Total Indicator Reading)	TOLERANCE
⊙ CONCENTRICITY	UNLESS OTHERWISE NOTED
○ ROUNDNESS	
⌒ FLATNESS	
≡ SYMMETRY	FRACTIONAL ± 1/32
PARALLEL	TWO PLACE DECIMAL ± .01
⊥ PERPENDICULAR	THREE PLACE DECIMAL ± .003
	ANGULAR ± 1'
	ALL MACHINE SURFACES TO BE ± .250
	BREAK ALL SHARP CORNERS 1/64 MAX. REMOVE ALL BURRS

MATERIAL TYPE	MATERIAL SPECIFICATIONS	IDENT. MARKS
MAKE FROM PART NO.	DO NOT SCALE DRAWING	SCALE
TITLE - ASSEMBLY - 4"-6" RIB3 VALVE		DATE: 06-30-1981
DR. BY: JPB		DATE: 06-30-1981
CH. BY: MJ		DATE: 07-09-1981
APR. BY: [Signature]		DATE: 08-08-1982
jamesbury CORP. WORCESTER, MASS.		D 4406