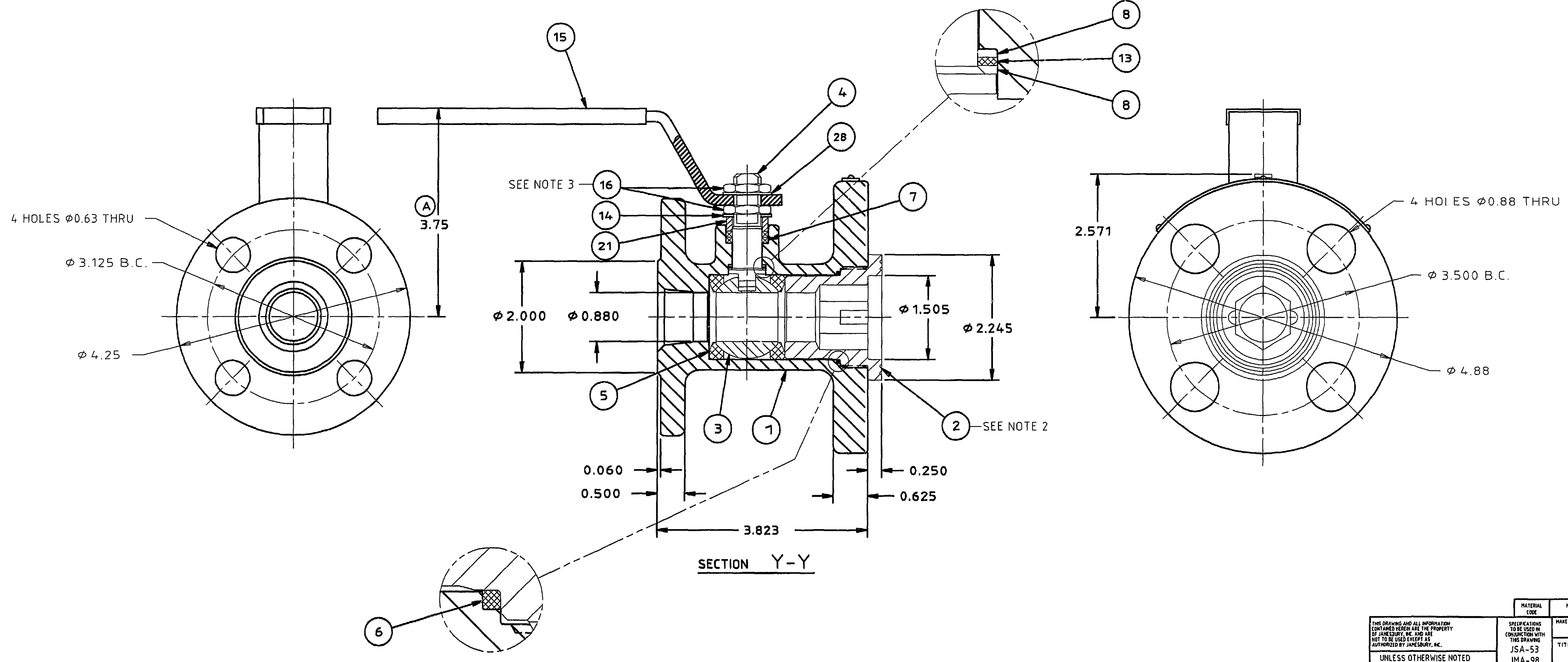
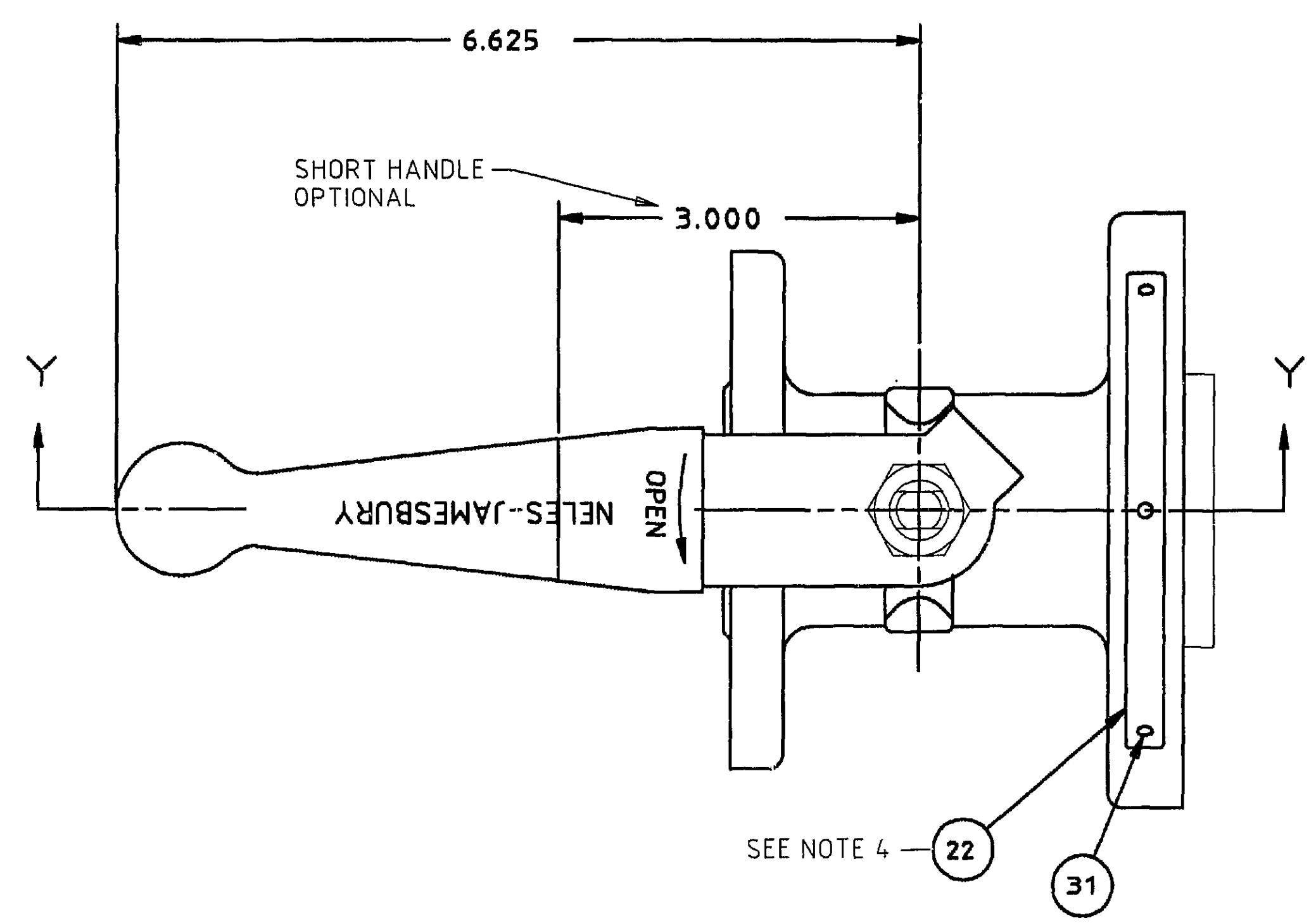


LET	ECN	REVISION	DR.	APPVD.	DATE
A	15999	SEE ECN FOR CHANGES	PJD	RET	19 FEB 96
B	17325	IN NOTE 3 70-80 IN. LBS. WAS 60-72 IN. LBS.	BA	SAL	15 DEC 98

ITEM NO	PART NAME	QTY.
1	BODY	1
2	INSERT	1
3	BALL	1
4	STEM	1
5	SEAT	2
6	BODY SEAL	1
7	STEM SEAL	2
8	STEM BEARING	2
13	SECONDARY STEM SEAL	1
14	STEM WASHER	1
15	HANDLE	1
16	STEM NUT	2
21	COMPRESSION RING	1
22	IDENTIFICATION TAG	1
28	SHAKEPROOF WASHER	1
31	POP RIVET	3

- NOTES:
- FOR INSTALLATION, MAINTENANCE AND OPERATING INSTRUCTIONS SEE IMO-R12.
 - INSERT ASSEMBLY TORQUE: 125 - 150 FT. LBS.
 - STEM NUT ASSEMBLY TORQUE: 70 - 80 IN. LBS.
 - TAG ATTACHMENT PER JMA-98.



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ANGLES - 35° FINISH

REMOVE SHARP EDGES AND CORNERS TO R2 - R3 RADIUS OR RADIUS, DIMENSIONS IN INCHES.

MATERIAL CODE	MATERIAL TYPE	MATERIAL SPECIFICATIONS	DEPT MARK
		DO NOT SCALE DRAWING	
TITLE		ASSEMBLY	SCALE 1:1
1" 5RRT REDUCED PORT RAILROAD VALVE		JMA-53	DATE 8 DEC 95
		JMA-98	DATE 8 DEC 95
		APPVD RET	DATE 8 DEC 95
		SIZE D	DWG NO 5296
			REV B

JAMESBURY
NELES CONTROL GROUP
WORCESTER MA, U.S.A.