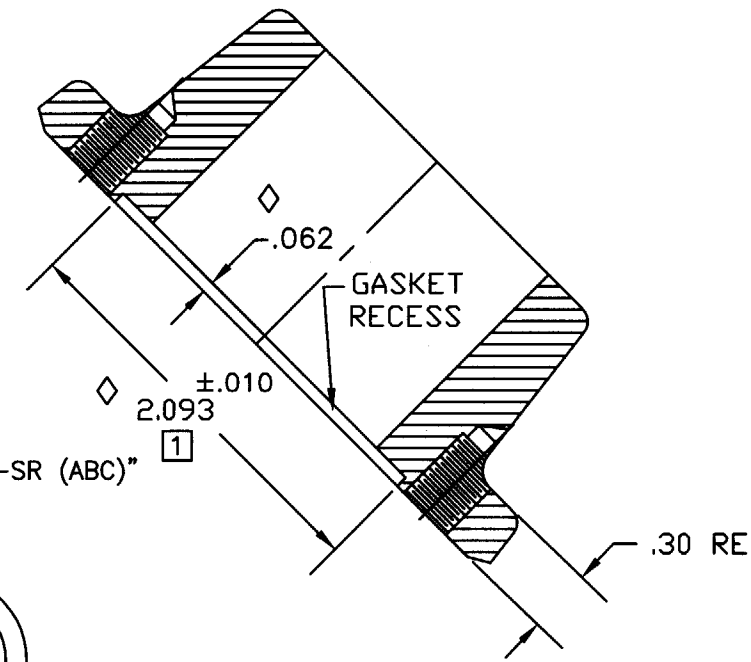
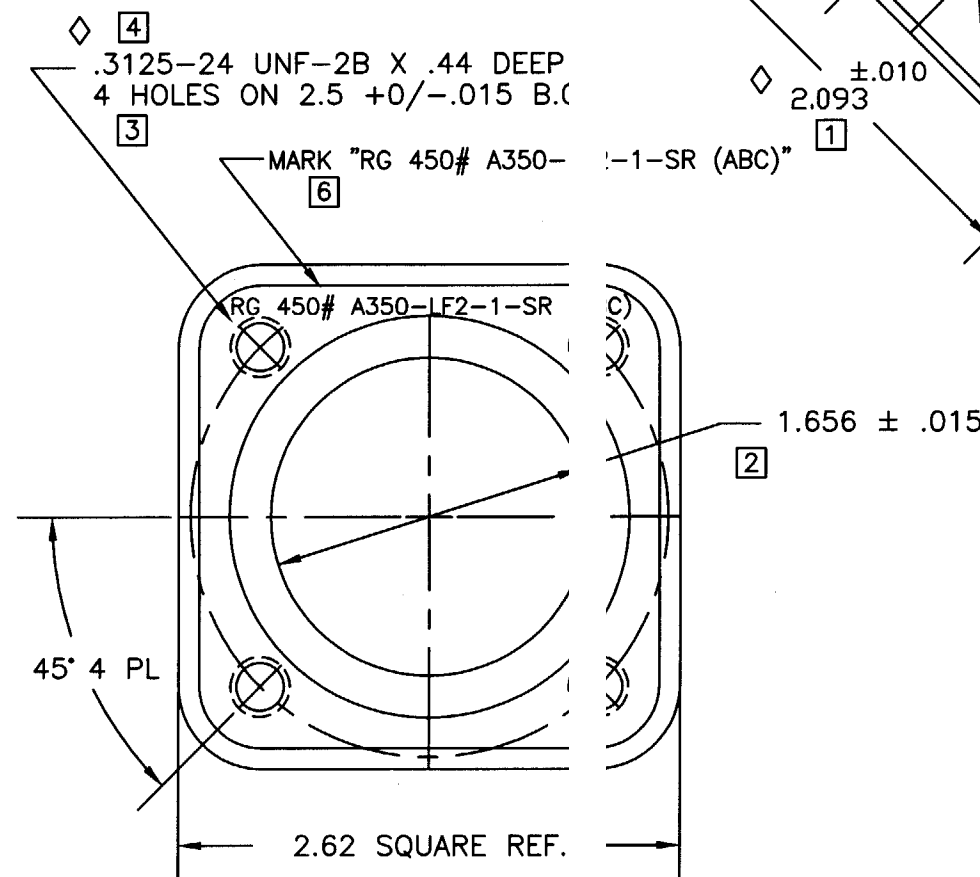
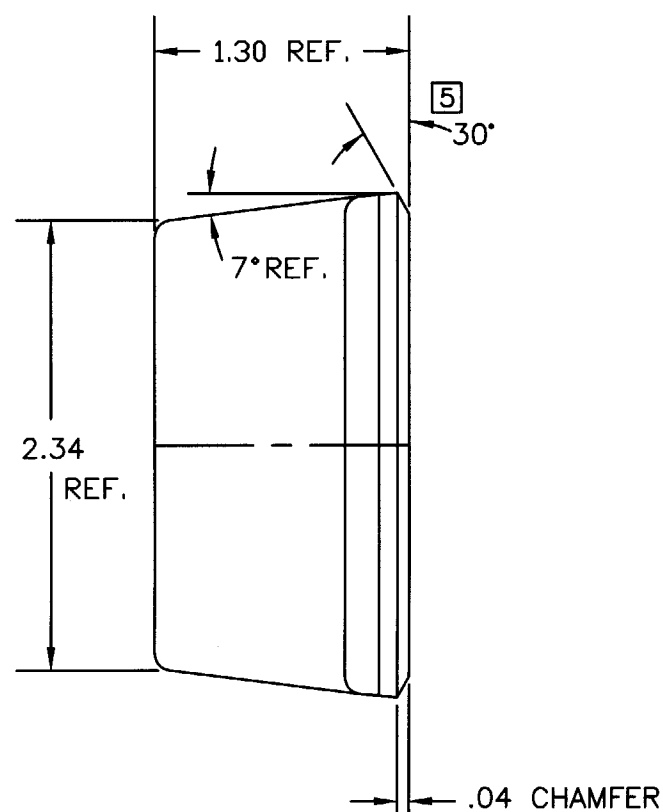


MATERIAL 22-5219 FORGING QUALITY STEEL
 ASTM A350, LF2, CLASS 1
 CONFORMING TO SECTION VIII &
 SECTION II OF ASME BOILER &
 PRESSURE VESSEL CODE.
 (FOR 450# SERVICE)

DRAWING NUMBER
 0022-05210



- OPERATIONS:
1. FACE & CUT GASKET RECESS.
 2. BORE
 3. DRILL .62 MAX. DEPTH.
 4. TAP.
 5. CUT .04 X 30° CHAMFER ALL AROUND.
 6. STAMP OR ENGRAVE AS SHOWN, EXCEPT TRANSFER 3 LETTER HEAT CODE FROM FACE OF 0022-05219.
 7. CLEAN PER DS-1481.

- SUPPLIER NOTE:
1. FOR MACHINING DETAILS NOT SHOWN SEE MS-502 (NOTE DRILL & TAP DEPTH VARIATION)
 2. ◇ DENOTES SIGNIFICANT DIMENSION.

CHRYSsafidis S.A./

ATHENS: 3 AGRINIOU STR, TAVROS - (+30) 210 4836315-20 /

THESSALONIKI: DA12A STR, OT32, BIPE SINDOU - (+30) 2310 754681-4 /

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Q	MATERIAL: A350, LF2, CLASS A1181, CLASS 60. IN STAMPING, LF2-1 WAS A181-60, 2 PL	AS 50-	19699	12/18 06											
M	REDRAWN FOR STANDARDIZAT		9927	4/17 00	N	ADDED "OR ENGRAVE" & HEAT CODE TO NOTE 6 AND VIEW OF FLANGE.	13602	6/6 02	P	NOTE 7 WAS DEGREASE.	16951	9/28 04			
LET	REVISIONS	E.R.#	DATE	LET	REVISIONS	E.R.#	DATE	LET	REVISIONS	E.R.#	DATE				
TOLERANCES .ΔΔ .ΔΔΔ		ANGLES MAT'L COMMERCIAL		DO NOT SCALE		SUPERSEDES		DRAWN		CHK.		E.R.#		USED 450# REF.	
NOT SHOWN ±.015 ±.005		±1°		DRAWING		11/4/92		Sagen				9927		ON DS-758	
ROCHESTER GAUGES, INC., OF TEXAS DALLAS, TEXAS, U.S.A.				SCALE FULL		DATE 4/17/00		PART NAME SR. WELDING ADAPTER				DRAWING NUMBER 0022-05210			