6084-D-2

| NO. REQ'D FOR ONE UNIT | LIST OF PARTS | ITEM | MAT'L | MAT'L SPECS | PATTERN NO. AND REMARKS |
|---|---|---|---|---|---|
| | | 42 | | | |
| | | 41 | | | |
| | | 40 | | | |
| | | 39 | | | |
| | | 38 | | | |
| | | 37 | | | |
| 2 | 1" SQ. PACKING | 36 | GARLOCK | #326 | 38 FT. CUTS 2 RINGS INCLUDES 4 RINGS FOR SPARE |
| 2 RINGS | 1" SQ. PACKING | 35 | GARLOCK | #730 | 9 FT. CUTS 2 RINGS INCLUDES 1 RING FOR SPARE |
| 6 | 3/4-10 HEX. NUT | 34 | B.R. | COMM. | |
| 6 | 3/4 DIA. PLAIN WASHER | 33 | B.R. | COMM. | |
| 6 | 3/4-10 x 4 3/4 STUD | 32 | B.E. | COMM. | DWG. BN-6-4, T=3" |
| | | 31 | | | |
| 2 | 3/8 DIA. GASKET | 30 | RUBBER | | 14" LONG (VERTICAL FLG.) |
| 2 | 1 1/4"-8N DOWEL BOLT-7 1/2" LG | 29 | STL. | COMM. | DWG. BF-12-4 GRIP 5 1/2" |
| 8 | 1 1/2"-6N x 4 3/4" BOLT | 28 | STL. | COMM. | 4" MITERED LGTH. |
| 24 | 2"-8N x 7 7/8" STUD | 27 | STL. | COMM. | DRW. CG-16-4 GRIP-2 3/4 |
| 22 | 3/8-16NC x 1" 82° HEAD JAP SCREW | 26 | STL. | COMM. | "UNBLAKO" OR EQUAL |
| 2 | 1 1/4"-8 V DOWEL BOLT-7 3/4" LG | 25 | STL. | COMM. | "DWG. BF-12-4, GRIP 5 1/2" |
| 2 | #14-B-9 3/4 TAPER PIN | 30 | C.D.S. | SAE 1020 | DWG. NO. 4342-JF-4 |
| 2 | 2"-8N HEX NUT | 29 | STL. | COMM. | |
| 8 | 2"-8N BOLT, 8" LG | 23 | STL. | COMM. | GRIP 5, DRW. 4342-CH-4 |
| 128 | 2 1/4"-8N HEX NUT | 27 | STL. | COMM. | 8 FOR ITEM 28 |
| 60 | 2 1/4"-8N x 18" STUD BOLT | 26 | STL. | COMM. | DWG. BD-20-4 GRIP 10" |
| 140 | 1 1/2"-8N HEX NUT | 26 | STL. | COMM. | (FOR ITEMS 24 & 31) 35 |
| 68 | 1 1/2"-8N x 9" STUD BOLT | 24 | STL. | COMM. | DWG. BD-12-4 GRIP 5 1/2" |
| 4 | 2"-8N x 46" STUD BOLT | 23 | STL. | COMM. | DWG. BD-46-4 GRIP 41" |
| 16 | 2"-8N x 41" STUD BOLT | 22 | STL. | COMM. | DWG. BD-34-4 GRIP 34" |
| 64 | 2"-8N HEX NUT | 21 | STL. | COMM. | (FOR ITEMS 22 & 23) 33 |
| 2/2 | BUSHING (SPLIT) | 20 | BRZ. | 80-10-10. | DWG. NO. 6084-J-2 |
| 2/2 | TRUNNION BEARING | 19 | C.S. | A27-467 GR 60-30 | PATT. NO. 1840 DWG 6084-P-2 |
| 2/2 | 133" O.D. FLANGE AND DISHED HEAD | 18 | B.S. | A285-49T-A | (S.F.=4 1/2", IDD=23 1/2", OA=30" (10 1/2")) (R.OD.=130", T=2", ICR=8 3/4") |
| | | 17 | | | |
| | | 16 | | | |
| | | 15 | | | |
| | | 14 | | | |
| | | 13 | | | |
| 2 | 1 1/2" TK. PLATE | 12 | P.S. | A283-49T-A | CUT FROM ITEM 3/11 |
| 6 | 1 1/2" TK. PLATE | 11 | P.S. | A283-49T-A | (PC.-92" X 260" CUTS 18 P.S. FOR 3 UNITS 12 FOR 11A 6 FOR 11B (10,103#)) |
| 2 | 3 1/2" TK. PLATE | 10 | P.S. | A284-49T-A | CUT FROM ITEM 8 |
| 2 | 3 1/2" TK. PLATE | 9 | P.S. | A284-49T-A | CUT FROM ITEM 8 |
| 8 | 3 1/2" TK. PLATE | 8 | P.S. | A284-49T-A | (1 PC.-79" X 156" CUTS 4 POS (2000)) (2 EA. OF ITEMS 8, 9 & 10) |
| 4/4 | 6" TK. PLATE | 7 | P.S. | A284-49T-A | 1 PC.-81" X 112" CUTS 4 POS (3160#) |
| | | 6 | | | |
| 2/2 | HEAD | 5 | | | DEVELOPMENT |
| 2/2 | HEAD | 4 | | | NEUT. STRESS RELIEVE |
| 1/2 | HEAD LEFT HAND WITHOUT GROOVE | 3 | | | MACHINE |
| 1/2 | HEAD RIGHT HAND WITH GROOVE | 2 | | | MACHINE |
| 1 | ASSEM. HEAD | 1 | | | |
| NO. REQ'D FOR ONE UNIT | LIST OF PARTS | ITEM | MAT'L | MAT'L SPECS | PATTERN NO. AND REMARKS |

APPROVED

SUBJECT TO THE CONTRACT REQUIREMENTS AND CORRECTIONS NOTED MAY BE NOTED HEREON, THIS DOES NOT RELEASE THE MANUFACTURER FROM RESPONSIBILITY FOR ANY OMISSIONS OR INCORRECTIONS BUT INDICATES AGREEMENT WITH THE DESIGN SHOWN AND THAT THE MATERIALS TO BE USED ARE SUITABLE FOR PROPER FIT OF PARTS. THE MANUFACTURER SHALL BE FULLY RESPONSIBLE FOR PROPER FIT OF PARTS AND FOR SATISFACTORY PERFORMANCE. ALSO FOR CORRECTNESS OF DIMENSIONS OF MATERIALS NOT SPECIFICALLY SET FORTH IN THE DESIGN AND SPECIFICATIONS ENCLOSED FOR THIS WORK. APPROVAL DOES NOT CONSTITUTE AUTHORIZATION TO DO ANY WORK CONSTRUCTED OR FABRICATED BY THE MANUFACTURER IN CONNECTION WITH THIS WORK.

INTERNATIONAL ENGINEERING CO., INC.

By _____ Date SEP 24 1952

| NO. | S.O. | REVISION | APPR'D | CH'K'D | DRAWN | DATE |
|---|---|---|---|---|---|---|
| III | 69687 | ITEMS 41 & 42 ADDED | CMW | SW | LLG | 6-1-52 |
| II | 69687 | ITEM 11 REVISED TO READ 6 FOR 11A, 6 FOR 11B | EMM | JW | LLG | 5-16-52 |
| I | 69687 | ITEM 27 WAS 120 REQ'D. REF. DRW. ADDED TO ITEM 28 | EMM | E.W.M. | LLG | 5-8-52 |
| | | | CMW | E.W.M. | J.W. | 4-3-52 |

| DWG. NO. | CROSS REFERENCES |
|---|---|
| 6084-J-2 | TRUNNION BUSHINGS |
| 6084-P-2 | UPPER HEAD TRUNNION BEARING |
| 6084-O-2 | UPPER HEAD DETAIL #2 |
| 6084-N-1 | UPPER HEAD DETAIL #1 |
| 6084-G-1 | SECTIONAL PLAN |
| 6084-F-1 | SECTIONAL ASSEMBLY #2 |
| 6084-E-1 | SECTIONAL ASSEMBLY #1 |

SHOP ORDERS 69687

MASTER NO. 4

NO. OF UNITS REQ'D 3

SHOP NOTES

UNLESS OTHERWISE NOTED
MACHINING TOLERANCES TO BE
± 1/64 ON FRACTIONAL DIMENSIONS
+ .0015 - .0005 FOR REAMED HOLES
+ .001 - .0008 FOR BORED HOLES
BREAK ALL CORNERS 1/64
SYMBOL ⊕ DENOTES REFERENCE DIMENSION

102119

S. MORGAN SMITH CO.,
YORK, PENNSYLVANIA, U. S. A.

BILL OF MATERIAL
UPPER HEAD
34" DIA. - 115 P.S.I. ROTOVALVE

SCALE —

6084-D-2