3-V-7809

NO. REQ'D FOR ONE UNIT	LIST OF PARTS	ITEM	MAT'L	MAT'L SPECS	PATTERN NO. AND REMARKS
12	⅜ DIA. GASKET	60	FIBER		110 FT. INCLUDES 1% SPARE
6	1¼ 8N HEX NUT	59	STL.	COMM.	FOR ITEM 58
6	1¼-8N-3 TAPER PIN	58	ALLOY	SAE 1020	DRW. NO. 4842-QP-4
40	2½ 8N NUT	57	STL.	COMM.	FOR ITEMS 55 & 54
44	4¾ 8N NUT	56	STL.	COMM.	
4	2½ 8N X 7¾ LG. BOLT	55	H.R.S.	COMM.	GRIP 4⅞ DRW. 4842-QB-4
68	2¾ 8N X 6 STUD BOLT	54	H.R.S.	COMM.	10" GRIP DRW. BD-20-4
38	2¾ 8N X 10½ STUD	53	H.R.S.	COMM.	8½ GRIP DRW. 4842-QS-4
4	2¾ 8N X 22 STUD BOLT	52	H.R.S.	COMM.	15½ GRIP DRW. 4842-ST-4
2	SEAT RING	51	MONEL METAL		(206#)
					ORDER 2-84" DIA. 125 P.S.I. AM. STD. FLANGE BLANKS
4½	84" DIA. AM. STD. FLANGE	50	STL.	A105-49 GRADE I	SEE DETAIL SKETCH VS-3811 FLANGES TO BE CUT, FACED & DRILLED BY S.M.S. CO. (5176)
		49			
		48			
		47			
8	1" PL.	46	P.S.	A283-49T-A	SEE ITEMS 33 TO 40
4	1" PL.	45	P.S.	A283-49T-A	FOR 3 UNITS
4	1" PL.	44	P.S.	A283-49T-A	1 PC. 100" X 216" CUTS 120 PCS. 92 PCS. FOR ITEM 41 2 SEATS EA. FOR 3 UNITS
4	1" PL.	43	P.S.	A283-49T-A	12 PCS. FOR ITEM 42
4	1" PL.	42	P.S.	A283-49T-A	12 PCS. FOR ITEM 43 8 PCS. FOR ITEM 44 12 PCS. FOR ITEM 45 (1000)
SEAT PAD	1" PL.	41	P.S.	A283-49T-A	DRW. 6084-AX-3
4	1" PL.	40	P.S.	A283-49T-A	
4	1" PL.	39	P.S.	A283-49T-A	
4	1" PL.	38	P.S.	A283-49T-A	
4	1" PL.	37	P.S.	A283-49T-A	1 PC. 50" X 185" CUTS 72 PCS. 16 EACH FOR ITEMS 34 & 35
8	1" PL.	36	P.S.	A283-49T-A	8 PCS. FOR ITEM 33 8 PCS. FOR ITEM 36 & 46
16	1" PL.	35	P.S.	A283-49T-A	4 PCS. EACH FOR ITEMS 37, 38, 39, & 40 (1958)
16	1" PL.	34	P.S.	A283-49T-A	
8	1" PL.	33	P.S.	A283-49T-A	
4	4½" PL.	32	P.S.	A284-49T-A	1 PC. 64" X 198" CUTS 4 PCS. 4 EACH ITEMS 31 & 32
4	4½" PL.	31	P.S.	A284-49T-A	FOR 3 UNITS (1540#)

NO. REQ'D FOR ONE UNIT	LIST OF PARTS	ITEM	MAT'L	MAT'L SPECS	PATTERN NO. AND REMARKS
1	1" PL.	30			
1	1" PL.	29			
1	1" PL.	28			
1	1" PL.	27			
1	1" PL.	26			
1	1" PL.	25			
1	1" PL.	24			
1	1" PL.	23			
1	1" PL.	22	P.S.	A283-49T-A	1 PC. 38" X 153" CUTS 4 (1160#)
¼	1" PL.	21	P.S.	A283-49T-A	1 PC. 32" X 44" CUTS 4 (1300#)
¼	1" PL.	20	P.S.	A283-49T-A	2 PCS. 40" X 185" CUTS ¼ (462#)
½	1" PL.	19	P.S.	A283-49T-A	2 PCS. 40" X 186" CUTS ½ (924#)
4	½" PL.	18	P.S.	A283-49T-A	2 PCS. 39" X 230" CUTS 12 PER SET (676#)
4	1¼" PL.	17	P.S.	A283-49T-A	1 PC. 36" X 196" CUTS 4 (2300#)
½	1½" PL.	16	P.S.	A283-49T-A	2 PCS. 53" X 195" CUTS ½ (894#)
½	1½" PL.	15	P.S.	A283-49T-A	2 PCS. 58" X 218" CUTS ½ (1090#)
¼	5½" PL.	14	P.S.	A284-49T-A	1 PC. 8" X 88" CUTS ¼ (2030#)
¼	6½" PL.	13	P.S.	A284-49T-A	1 PC. 81" X 112" CUTS ¼ (1560#)
¼	6" PL.	12	H.S.	A384-49T-A	1 PC. 86" X 100" CUTS ¼ (1460#)
¼	6" PL.	11	P.S.	A284-49T-A	1 PC. 96" X 88" CUTS ¼ (2300#)
1	MACH. BODY SEC. IV	10			
1	WELD BODY SEC. IV	9			WELD & STRESS RELIEVE
1	MACH. BODY SEC. III	8			GASKET GROOVE-VERT. FLANGE
1	WELD BODY SEC. III	7			WELD & STRESS RELIEVE
1	MACH. BODY SEC. II	6			
1	WELD BODY SEC. II	5			WELD & STRESS RELIEVE
1	MACH. BODY SEC. I	4			GASKET GROOVE-VERT. FLANGE
1	WELD BODY SEC. I	3			WELD & STRESS RELIEVE
1	MACH. BODY SEC. I II III IV	2			
1	ASSEM. BODY SEC. I II III IV	1			

DWG NO.	CROSS REFERENCES
6084-E-1	SECTIONAL ASSEMBLY #1
6084-F-1	SECTIONAL ASSEMBLY #2
6084-G-1	SECTIONAL PLAN
6084-U-1	LOWER BODY HALF
6084-V-1	UPPER BODY HALF
6084-W-1	BODY ASSEMBLY
6084-T-1	PLATE LAYOUT

NO.	S.O.	REVISION	APPRD.	CH'KD.	DR'WN.	DATE

NO.	S.O.	REVISION	APPRD.	CH'KD.	DR'WN.	DATE

APPROVED SEP 24 1952

SHOP ORDERS 69687

MASTER NO. 1

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 - .0005 FOR BORED HOLES
BREAK ALL CORNERS 1/64
SYMBOL Ⓡ DENOTES REFERENCE DIMENSION

102116

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

BILL OF MATERIAL
BODY
84 DIA. - 115 P.S.I. ROTOVALVE

SCALE —

6084-A-2

SEP 23 1952