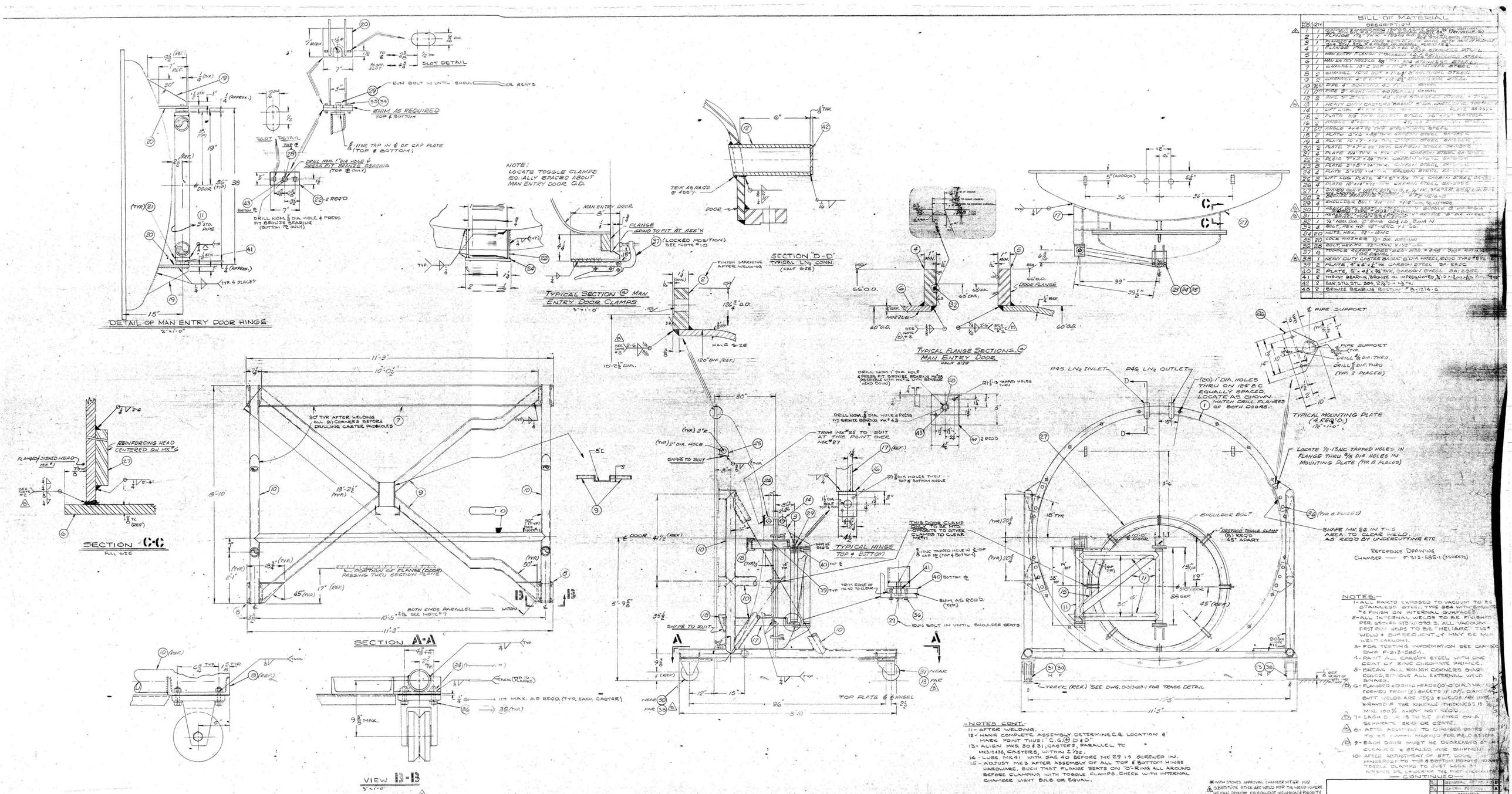

BILL OF MATERIAL

ITEM	QTY	DESCRIPTION
1	1	[illegible]
2	1	FLANGE 1/2" [illegible]
3	1	[illegible]
4	1	[illegible]
5	1	MAN ENTRY FLANGE 1/2" THK. [illegible] STAINLESS STEEL
6	1	MAN ENTRY NOZZLE 1/2" THK. 304 STAINLESS STEEL
7	1	CHANNEL 10"x2.5#/FT. STRUCTURAL STEEL
8	2	CHANNEL 10"x2.5#/FT. STRUCTURAL STEEL
9	2	CHANNEL 4"x5.4#/FT. STRUCTURAL STEEL
10	20	PIPE 4" SCHEDULE 40 (FLANGE CERAM)
11	1	PIPE 3" SCHEDULE 40 (SEAMLESS) CERAM.
12	2	PIPE 3" SCHEDULE 40 [illegible] STEEL [illegible]
13	1	HEAVY DUTY CASTORS BASIC 8" DIA. WHEEL, [illegible] TYPE #[illegible]
14	1	LIFT LUG [illegible] PLATE SA-285
15	6	PLATE 3/8" THK. [illegible] STEEL 70 KSI [illegible]
16	2	PLATE 4" [illegible] STRUCTURAL STEEL
17	20	ANGLE 4"x4"x1/2" THK. STRUCTURAL STEEL
18	2	PLATE 6"x6" x 3/8" THK. CARBON STEEL SA-285-C
19	4	PLATE 10"x7"x1/2" THK. x [illegible] STEEL SA-285-C
20	2	PLATE 7"x7"x1/2" THK. CARBON STEEL SA-285-C
21	4	PLATE 5/8" THK. x 8 1/2" DIA. CARBON STEEL SA-285-C
22	2	PLATE 7"x5"x3/8" THK. CARBON STEEL SA-285-C
23	8	PLATE 5"x5"x1/4" THK. CARBON STEEL SA-285-C
24	4	PLATE 5"x5"x1/4" THK. CARBON STEEL SA-285-C
25	8	LIFT LUG PLATE 4"x5"x3/4" THK. CARBON STEEL SA-285-C
26	4	PLATE 10"x14"x1/2" THK. CARBON STEEL SA-285-C
27	1	[illegible]
28	2	[illegible]
29	4	SHOULDER BOLT 5/8" THK. x 1 1/2" LONG, 5/8-11TPDC
30	1	HEAVY DUTY CASTER BASIC 8" DIA. WHEEL, [illegible] TYPE #[illegible]
31	1	[illegible]
32	1	1/4" NOM. DIA. 0° RING SOL I.D. [illegible]
33	4	BOLT, HEX HD. 1/2"-13NC x 2 LG.
34	20	NUTS, HEX, 1/2"-13NC
35	20	LOCK WASHER 1/2" DIA. (REGULAR)
36	28	BOLT, HEX HD. 1/2"-13NC x 1 1/2" LG.
37	8	TOGGLE CLAMPS DESTACO, [illegible]
38	1	HEAVY DUTY CASTER BASIC 8" DIA. WHEEL, [illegible] TYPE #[illegible]
39	2	PLATE, 4"x4"x1/2" THK. CARBON STEEL SA-285-C
40	2	PLATE, 5"x4 1/2"x3/8" THK. CARBON STEEL SA-285-C
41	1	THRUST BEARING BRONZE OIL IMPREGNATED, [illegible]
42	2	BAR STL STL 304, 2 1/2" DIA x 3" LG.
43	2	BRONZE BEARING BOSTON #B-1214-6

NOTES:—

1- ALL PARTS EXPOSED TO VACUUM TO BE STAINLESS STEEL TYPE 304 WITH SMOOTH "4 FINISH ON INTERNAL SURFACES.
2- ALL INTERNAL WELDS TO BE FINISHED PER STAMPS STD 1/070 3. ALL VACUUM FIRST PASS WELDS TO BE "HELIARC" TIG* WELD & SUBSEQUENTLY MAY BE MIG WELD (ARGON).
3- FOR TESTING INFORMATION SEE DIAGRAM DWG F-313-SS5-1.
4- PAINT ALL CARBON STEEL WITH ONE COAT OF ZINC CHROMATE PRIMER.
5- BREAK ALL ROUGH CORNERS SHARP EDGES, REMOVE ALL EXTERNAL WELD SPLASHES.
6- G- FLANGED & DISHED HEADS (60" O.D.A.) MAY BE FORMED FROM (2) SHEETS IF 100% DIAMETER BUTT WELDS ARE USED & WELDS ARE 100% X-RAYED IF THE NOMINAL THICKNESS IS 1/2" MIN. 100% X-RAY NOT REQ'D.
7- EACH DOOR IS TO BE SHIPPED ON A SEPARATE SKID OR CRATE.
8- APPLY EQUALLY TO CHAMBER DOORS, TO BE FIRMLY MARKED FOR FIELD ASSY.
9- EACH DOOR MUST BE DEGREASED & CLEANED & SEALED FOR SHIPMENT.
10- AFTER ADJUSTMENT OF SFT. LOCK HINGE PIN TO TOP & BOTTOM HINGE HOUSING TOGGLE CLAMPS TO JUST LOCK BY KNUCKLE OR LOWERING THE PIN.

CONTINUED

NOTES CONT.

11- AFTER WELDING.
12- HANG COMPLETE ASSEMBLY. DETERMINE C.G. LOCATION & MARK POINT THUS: "C.G. @ D & D"
13- ALIGN MK# 30 & 31, CASTERS, PARALLEL TO MK# 13 & 38, CASTERS, WITHIN 1/32.
14- LUBE MK# 41 WITH SAE 40 BEFORE MK 29 IS SCREWED IN.
15- ADJUST MK# 3 AFTER ASSEMBLY OF ALL TOP & BOTTOM HINGE HARDWARE, SUCH THAT FLANGE SEATS ON "O"-RING ALL AROUND BEFORE CLAMPING WITH TOGGLE CLAMPS. CHECK WITH INTERNAL CHAMBER LIGHT BULB OR EQUAL.

* WITH STONES APPROVAL CHAMBER MT&R (VW)
SUBSTITUTE STICK ARC WELD FOR THE WELD (WHERE USE CAN) PROVIDE EQUIVALENT INCLUSION & POROSITY FREE QUALITY WELDS

TOLERANCES UNLESS OTHERWISE NOTED		FRACTIONS ± 1/64 UNLESS OTHERWISE NOTED
WELDING & BURNING DIMENSIONS ± 1/8, 1/16 GRIND ±		± 1/32 OR 30 MICRONICS
MACHINING DIMENSIONS ± .005	ANGLES ± 0°-30'	± .1 OR 25 MICRONICS
FRACTIONS ± .005	ANGLES ± 0°-30'	± .01 OR 5 MICRONICS
DECIMALS ± .005	ANGLES ± 0°-30'	± .001 OR 1 MICRONICS
ANGLES ± 0°-30' ± 1/8 UNF ± 1/16 ROUND		
PART SIZES AND FINISHES TO BE AS NOTED		
PARTS MUST FIT & FUNCTION AS QUANTIFIED		

DESCRIPTIVE TITLE	REMOVABLE CHAMBER FULLY PROT. [illegible]		
DRAWN BY	DATE 7/31/[illegible]	SCALE 1/4"=1'-0"	
CHECKED BY	DATE		
APPROVED BY	DATE		
APPROVED BY	DATE		
	PRODUCT CODE NO.		

SYM	DATE	REVISIONS	
		GENERAL REVISION	B
		GENERAL REVISION	A

DWG. NO. F-313-SS5-1B
SHEET 1 OF 2