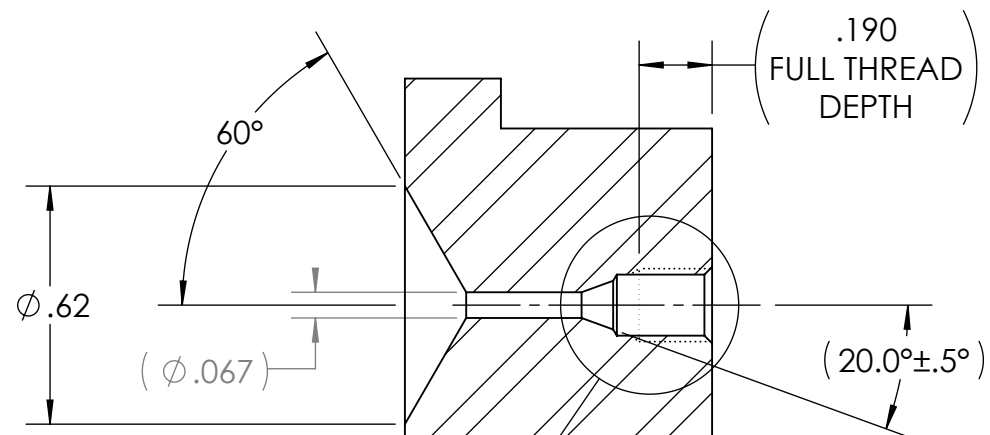




SECTION A-A

$\phi .094$
(GAGE BALL)

A

20.0°±.5°

32/C

.252
.248
GAGE BALL DIM

TAP #10-32 UNF-2B

$\phi .008$ A

.020 X 45°

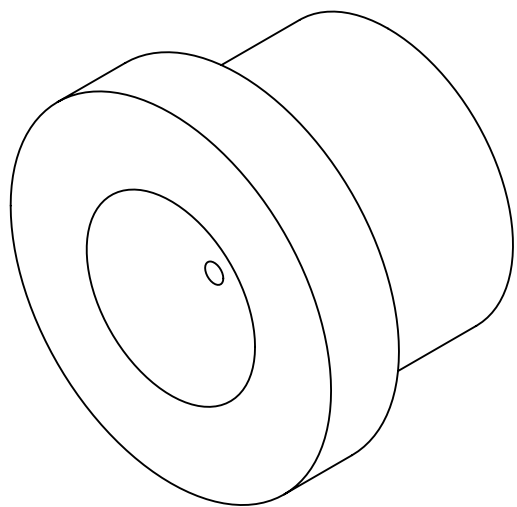
$\phi .130$
 $\phi .126$
($\phi .159$)
DRILL

$\phi .004$ A

.190
FULL THREAD
DEPTH

.248
DRILL DEPTH

1	1	SS-12-VCO-3_UpChurch_MOD	Swagelok
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NOTES: (CONT. FROM TITLE BLOCK)

1	1	SS-12-VCO-3_UpChurch_MOD	Swagelok VCO UpChurch MODIFIED	MBARI	AIISI 316
ITEM NO.	QTY.	Part_Number	DESCRIPTION	Vendor	MATERIAL

BILL OF MATERIALS						
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:			APPROVALS	DATE
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°	Monterey Bay Aquarium Research Institute MBARI 7700 Sandholdt RD. Moss Landing, CA 95039 PH: (831) 775-1700 
Shop Foreman		1. DIMENSIONS ARE IN INCHES 2. DIMENSION LIMITS HELD AFTER PLATING. 3. REMOVE BURRS AND SHARP EDGES .015 MAX. 4. MACHINED FILLET RADII .0150-.030.				
Engineer		5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005 6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH, MAX .012 INCHES FOR SINGLE SURFACE.				
NEXT ASSY Description	NEXT ASSY Number	PROJECT NO. 901217 PROJECT CHEM S.				
Application		DO NOT SCALE DRAWING			WEIGHT	0.178

EQUITECH PRESS. TEST	
Swagelok VCO UpChurch MODIFIED	
SIZE B	DWG. NO. SS-12-VCO-3_UpChurch_MOD.DWG
SCALE 2:1	CAD FILE: MECH ENG ON TORNADO SHEET 1 OF 1