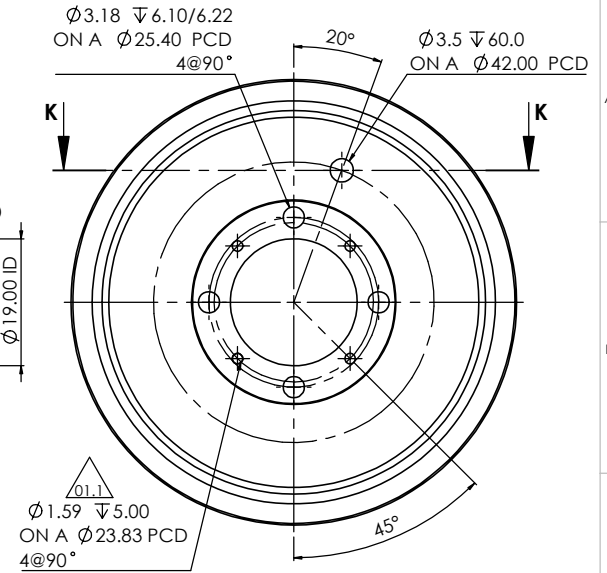
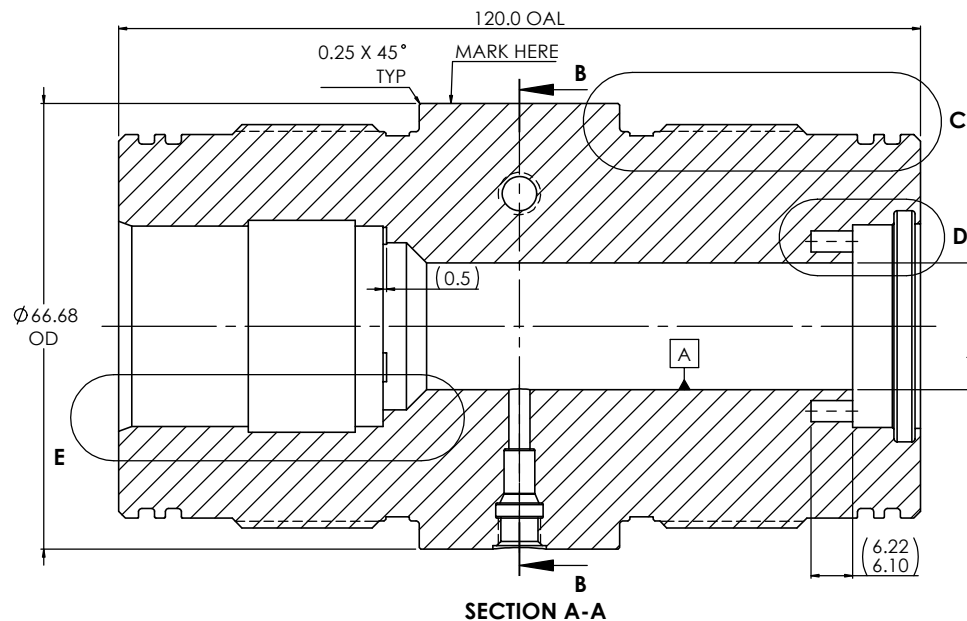
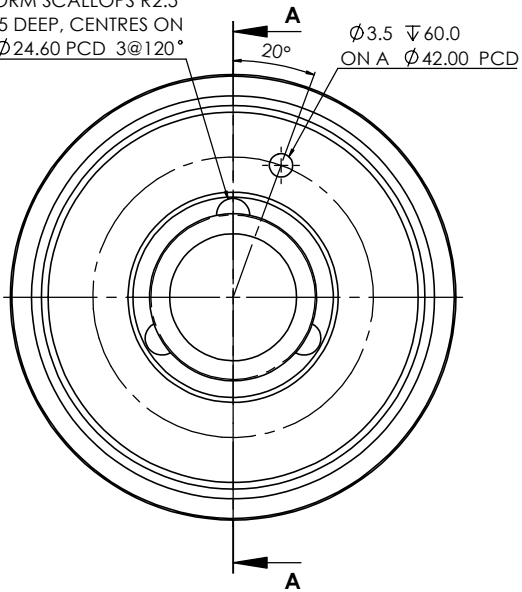
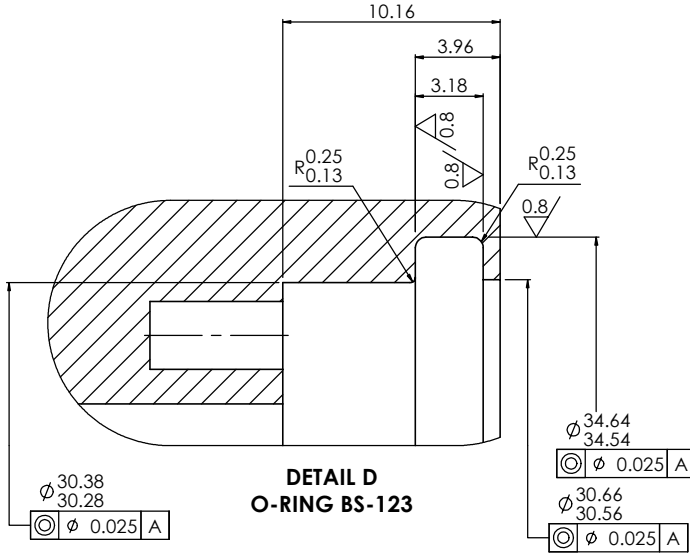


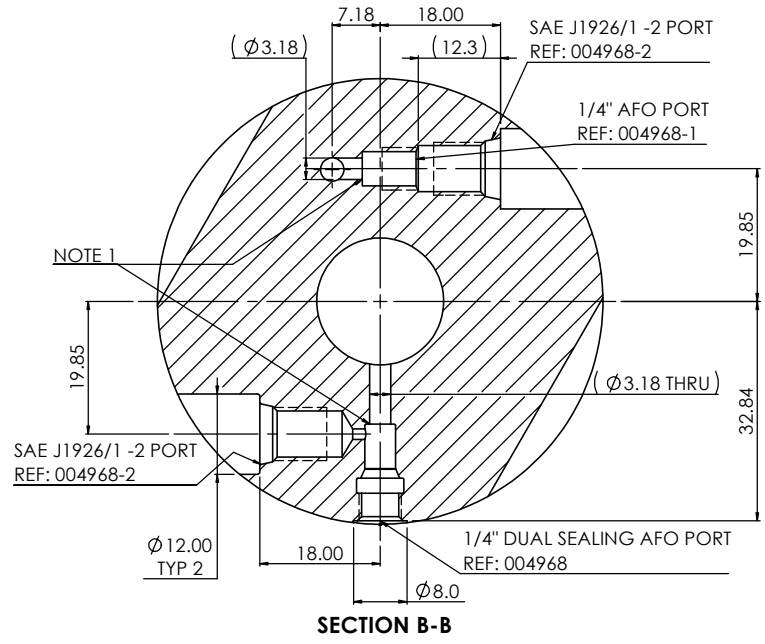
FORM SCALLOPS R2.5
0.5 DEEP, CENTRES ON
Ø24.60 PCD 3@120°



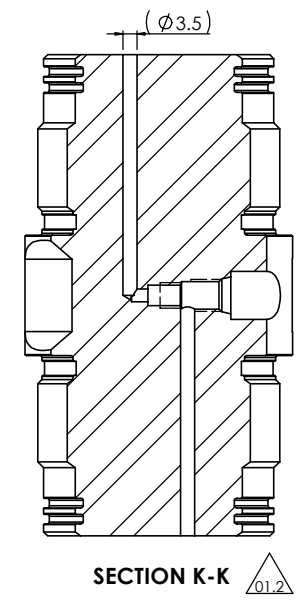
SECTION A-A



DETAIL D
O-RING BS-123



SECTION B-B



SECTION K-K

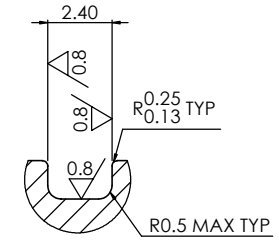
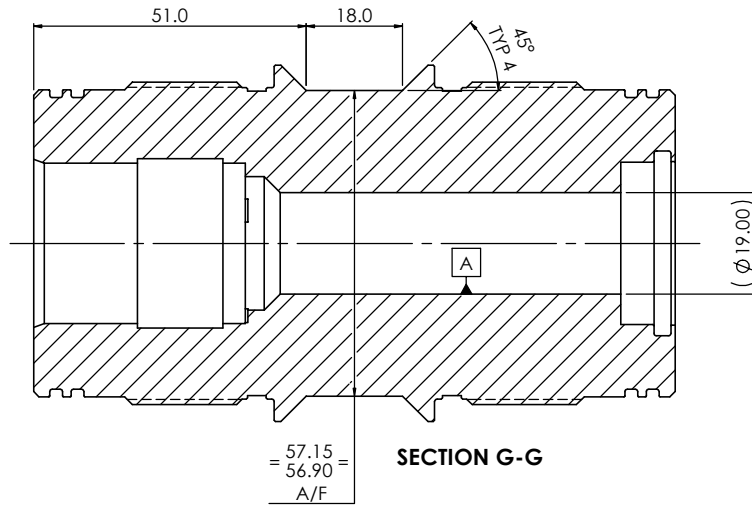
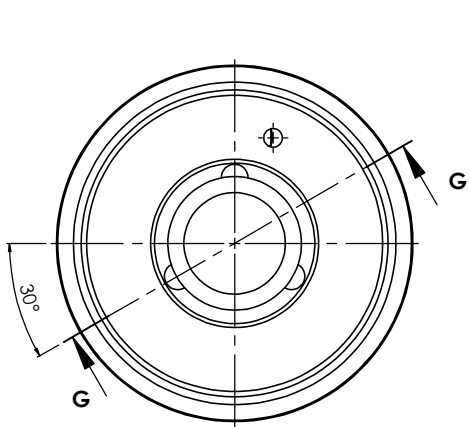
NOTES:
1. MACHINE SEAL SEAT TO SHARP CORNER ON 1/4" AFO & 1/4" DUAL SEAL AFO PORTS THEN COIN SEAT PRIOR TO QPQ. REF: LEE PRODUCTS PROCESS SPEC SP 1013 & COINING TOOL CUTA2500263A.

| Rev | ECN No | Description | Date | Designed by | Checked by |
|------|--------|--------------------------------------|------------|-------------|------------|
| 01.2 | -- | SECTION K-K ADDED TO CLARIFY PORTING | 04/09/2017 | CCr | RLG |
| 01.1 | -- | DIMENSION ERROR UPDATED | 31/08/2017 | IMI | IMI |
| 1.0 | -- | ISSUED | 28/04/2017 | CCr | IMI |

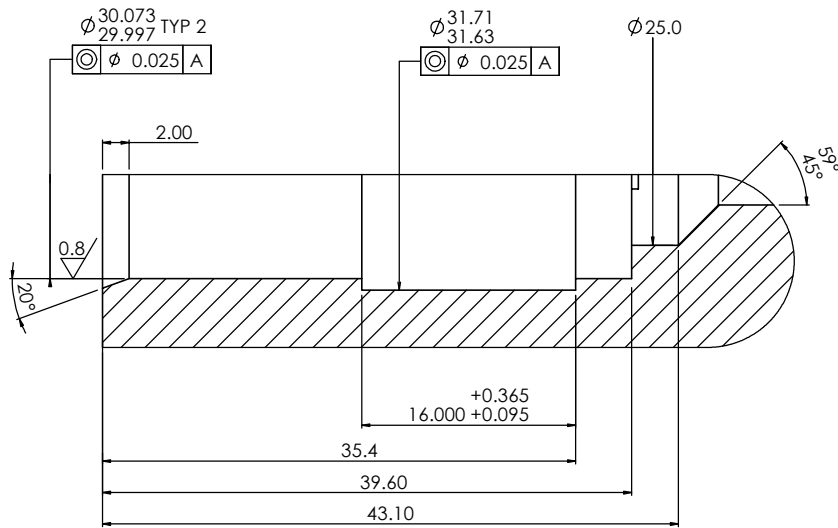
General Limits
unless otherwise stated

| | |
|--------------------------|---------------------|
| Break Sharp Corners 0.25 | x.xxx [x.xxx] ±0.02 |
| Fillet Radii 0.8 | x.xx [x.xxx] ± 0.1 |
| T.I.R. 0.25 | |
| Parallelism 1 in 250 | x.x [x.xxx] ± 0.25 |
| Squareness 1 in 250 | |
| Angular Degree ±0.5 | |
| Surface 1.6 RA | x [x.xxx] ± 0.5 |

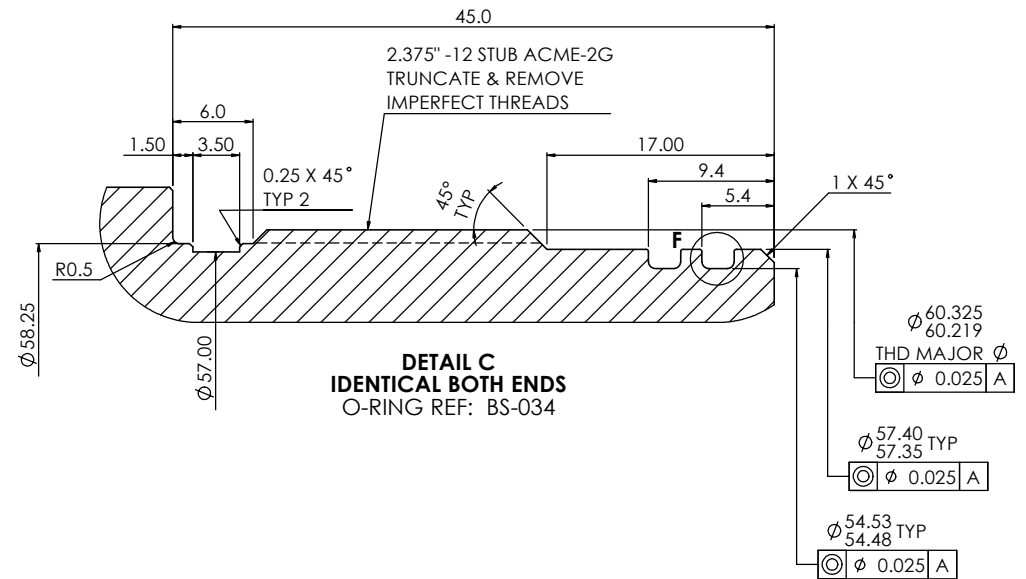
| | | | | | |
|-----------------------------------|--|---|-------------------|---------------------------------|--|
| MATERIAL/B.O.M. ZMS-010 | | FINISH ZTS-001 / QPQ | | HEAT TREATMENT NONE | |
| DRAWN BY | | CHECKED BY | | DATE DRAWN 28/04/2017 | |
| PROJECT | | | TITLE/NAME | | |
| PROJECTION | | SHEET SIZE A3 PRINT FULL SIZE | | DRAWING NUMBER 005728 | |
| REVISION 01.2 | | | | SHEET 1 of 2 | |



DETAIL F
TYP SEAL GROOVE DETAIL
4 POS



DETAIL E



DETAIL C
IDENTICAL BOTH ENDS
O-RING REF: BS-034

| Rev | ECN No | Description | Date | Designed by | Checked by |
|------|--------|--------------------------------------|------------|-------------|------------|
| 01.2 | -- | SECTION K-K ADDED TO CLARIFY PORTING | 04/09/2017 | CCr | RLG |
| 01.1 | -- | DIMENSION ERROR UPDATED | 31/08/2017 | IMI | IMI |
| 1.0 | -- | ISSUED | 28/04/2017 | CCr | IMI |

General Limits
unless otherwise stated

| | |
|--------------------------|----------------------|
| Break Sharp Corners 0.25 | x.xxx [x.xxx] ± 0.02 |
| Fillet Radii 0.8 | x.xx [x.xxx] ± 0.1 |
| T.I.R. 0.25 | |
| Parallelism 1 in 250 | x.x [x.xxx] ± 0.25 |
| Squareness 1 in 250 | |
| Angular Degree ± 0.5 | x [x.xxx] ± 0.5 |
| Surface 1.6 RA | |

| | | | | |
|-----------------------------------|-------------------------|---------------------------------|-------------------------------|---------------------------------|
| MATERIAL/B.O.M. ZMS-010 | | FINISH ZTS-001 / QPQ | HEAT TREATMENT NONE | |
| DRAWN BY | | CHECKED BY | | DATE DRAWN 28/04/2017 |
| PROJECT | | TITLE/NAME | | |
| PROJECTION | SHEET SIZE A3 | DRAWING NUMBER 005728 | REVISION 01.2 | SHEET 2 of 2 |
| PRINT FULL SIZE | | | | |