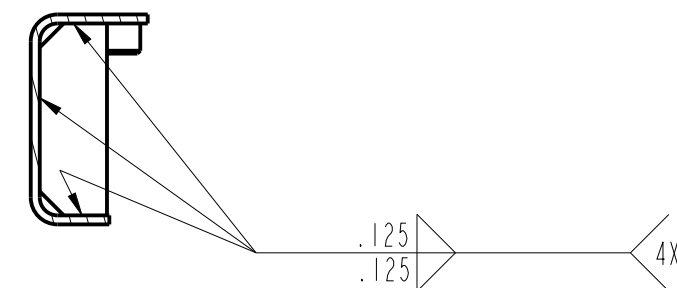
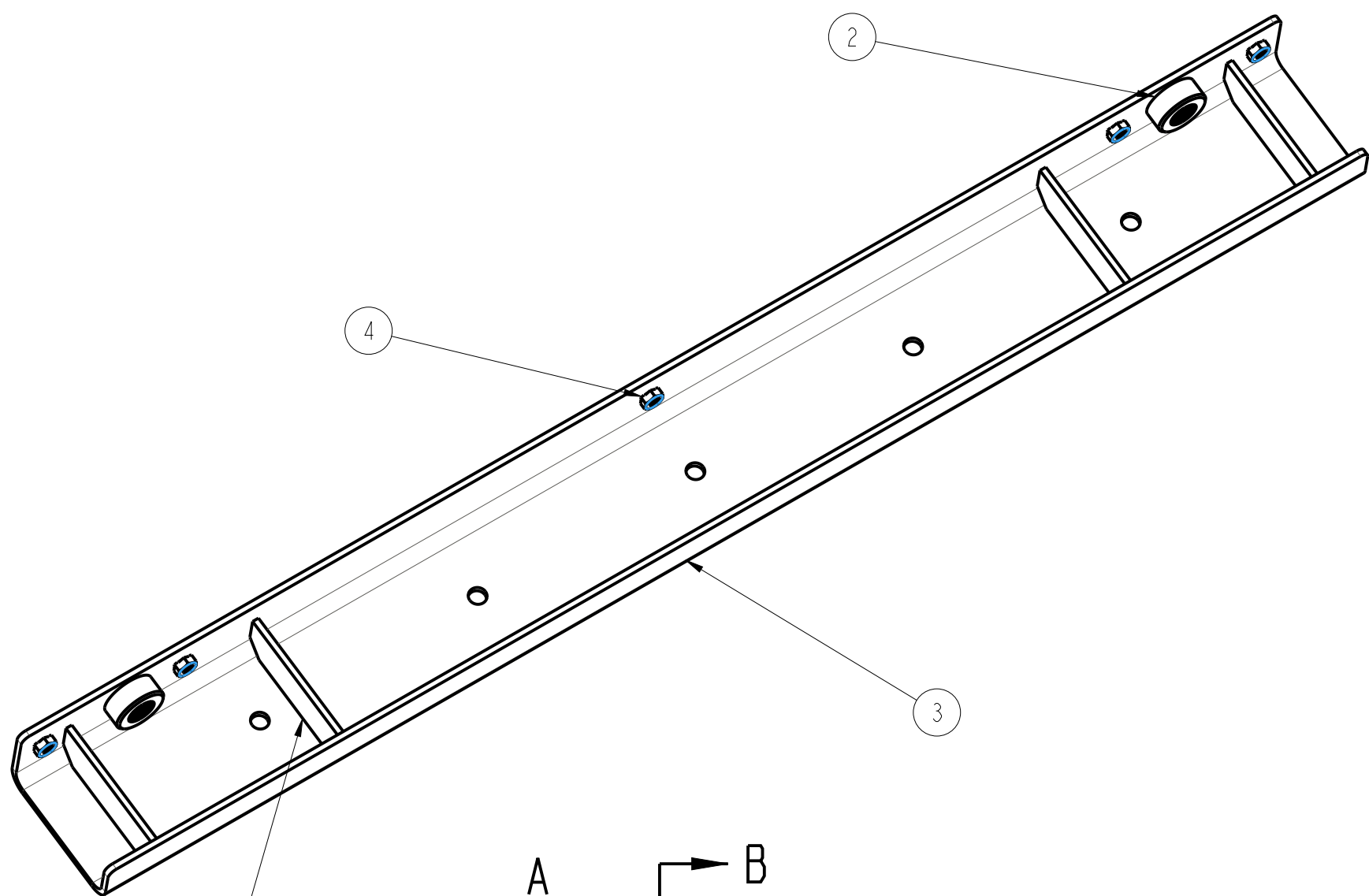


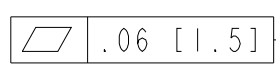
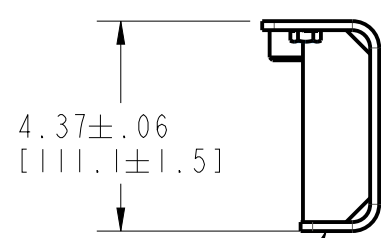
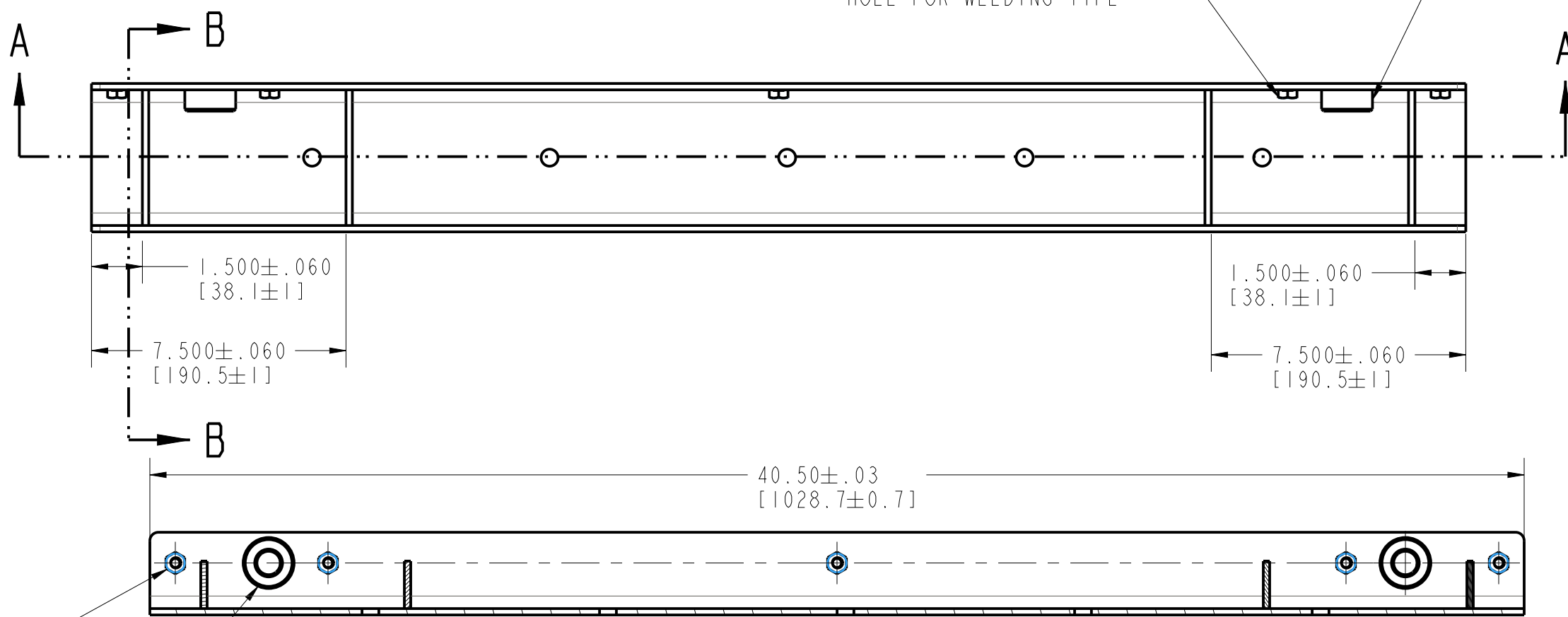
REVISIONS					
RELEASE	LTR	DESCRIPTION	DRAWN/REV. BY	ENGINEER	DATE
ER0182	A	RELEASE FOR PRODUCTION	S.PANIGRAHI	J.KOONCE	08-DEC-2017
					APPROVALS ON FILE



SECTION B-B

LEAD IN
DIAMETER ON WELD NUT
MUST BE INSERTED INTO
HOLE FOR WELDING TYPE

STEPPED DOWN DIAMETER
ON BUSHING MUST BE
INSERTED IN HOLES FOR
WELDING TYPE



2 TACKS 180° APART - 5X
.130/.25

2X
.130/.75"-1.7"

SECTION A-A

- NOTES:
1. FINISH: NONE
 2. ALL WELDING IS TO BE IN ACCORDANCE WITH AWS D 1.6 STANDARDS USING 308L SS FILLER ROD/WIRE ONLY.
 3. OUTSIDE SEAMS TO BE BACK-WELDED 100% OR OUTSIDE CORNER-FILLET WELDED WITH 100% WELD PENETRATION.
 4. ALL WELDS TO BE VISUALLY INSPECTED.
 5. REMOVE ALL WELD SPATTER.
 6. UNLESS OTHERWISE SPECIFIED, BLOCK TOLERANCES DO NOT APPLY TO REFERENCE DIMENSIONS.

4	5	999-0859-M8X125	NUT, WELD, SS, M8 X 1.25	STAINLESS STEEL-18-8	A
3	1	908-1869-17	BRACKET	STAINLESS STEEL-316L	A
2	2	908-1404-25	BOSS, THREADED M20X2.5	STAINLESS STEEL-304L	B
1	4	908-1404-12	PLATE, STIFFNER	STAINLESS STEEL-316L	A
ITEM NO.	QTY. REQD	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	REVISION

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TOLERANCES (UNLESS OTHERWISE NOTED)

DECIMALS	ANGLES	MM
.XX ±.030 ±1/2°	.X ±.76	
.XXX ±.010	.XX ±.254	

REMOVE ALL BURRS AND SHARP EDGES TO .010 R MAX.

MACHINED SURFACES SHALL HAVE A 125 MICRO-FINISH OR BETTER.

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES.

DIMENSIONS DESIGNATED [XX] ARE IN MILLIMETERS.

DRAWING SCALE: 0.250 SHOWN FOR REFERENCE ONLY DO NOT SCALE DRAWING

NEXT ASSY 908-1869-01	E-JOB 4659
MANUFACTURING DRAWING	
CUSTOMER REFERENCE	
ORIGINAL RELEASE DATE 08-DEC-2017	
THIS DRAWING CONFORMS TO ASME Y14.5-2009 AND SHAW DEVELOPMENT ES-2030	
THIRD ANGLE PROJECTION	

SHAW DEVELOPMENT

25190 Bernwood Dr., Bonita Springs, Florida 34135 WWW.SHAWDEV.COM

TITLE
BRACKET WELDMENT

CODE IDENT NO. 59647	SIZE C	DRAWING NO. 908-1870-01	REVISION A
DRAWING STATE Released			SHEET 1 OF 1