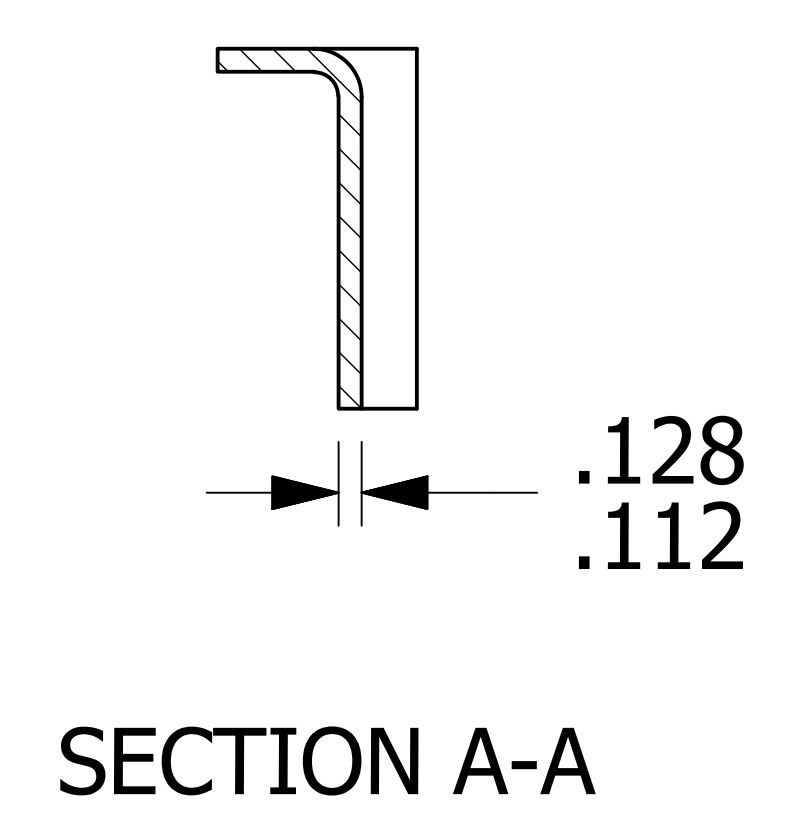


- NOTES:**
1. INSIDE & OUTSIDE WELD SEAMS FINISHED TO A SMOOTH AND CONTINUOUS CONTOUR WITH NO VISIBLE WELD EDGE, UNDERCUT, CRACKS AND/OR DEFECTS.
 2. TOP FLANGE WELD SEAM TO BE FLUSH AND SMOOTH WITH NO UNDERCUT, DISCONTINUOUS WELD EDGE, CRACKS OR ANY OTHER VISIBLE DEFECT. NO WELD REINFORCEMENT IS ALLOWED ON THE TOP SEALING SURFACE.
 3. MARK DATE USING SHARPIE TEC MARKER. DATE TO BE LOCATED 90° FROM WELD SEAM, WITHIN AN INCH BELOW THE 1/8" RADIUS.



SEE NOTE 2

MUST NOT GO BELOW
.106" WITHIN 1.5"
ON EACH SIDE OF WELD

3/32

REV	BY	DATE	DESCRIPTION
E	BP	5/24/22	CHANGED FLATNESS FROM 1/16 TO 3/32
D	CHL	1/27/20	UPDATED NOTES, MATERIAL, ADDED SECTION A-A, UPDATED WELD SYMBOL, ADDED LEADER NOTE
C	JG	4/28/17	UPDATED WELD NOTE TO DSS 12, WELD SYMBOL; Ø20.486/Ø20.394 WAS Ø20.44; Ø22.00/Ø21.88 WAS Ø21.94; Ø20.74/Ø20.62 WAS Ø20.68; REMOVED CIRCULARITY TOLERANCE
B	CHL	5/29/07	UPDATED WELD SYMBOL
A	ACC	2/3/04	ADDED PART INTO THE SYSTEM

UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCES	DRAWN BY:	ACC
FRACTIONAL: ±1/16	CHECKED BY:	
X.XX: ±.03	PROTOTYPE DATE:	8/22/2003
X.XXX: ±.015	APPROVED FOR PRODUCTION BY:	ACC
ANGULAR: ±1°	PRODUCTION DATE:	2/3/2004
DEBURR ALL SHARP EDGES. ALL MACHINED SURFACES TO HAVE A 125 RMS FINISH UNLESS NOTED OTHERWISE.	SIZE:	E
THIRD ANGLE PROJECTION	DRAWING #:	18334

SALCO PRODUCTS, INC.

PART NAME: **HATCH RING 20 7/16"**

MATERIAL: **316L SS 11 GAUGE**

PROJECT #: **030604** SHEET #: **1 OF 1** SCALE: **1:1**

PART #: **HCR2044NH**