

3/32

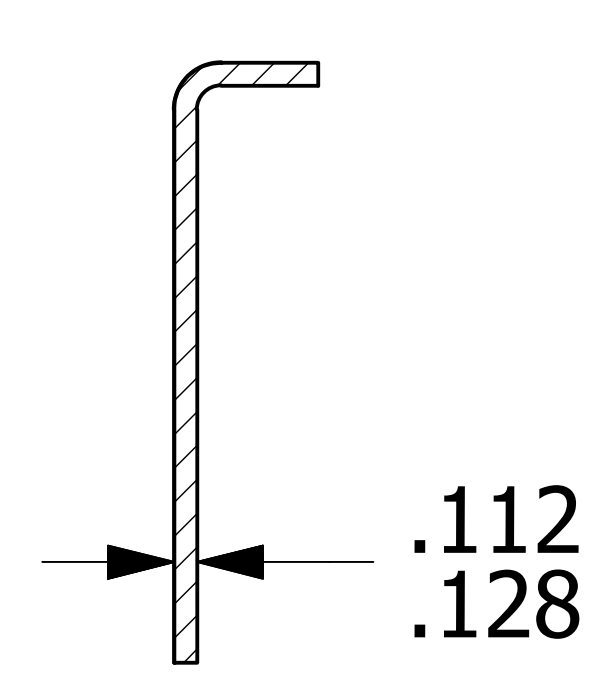


SEE NOTE 1

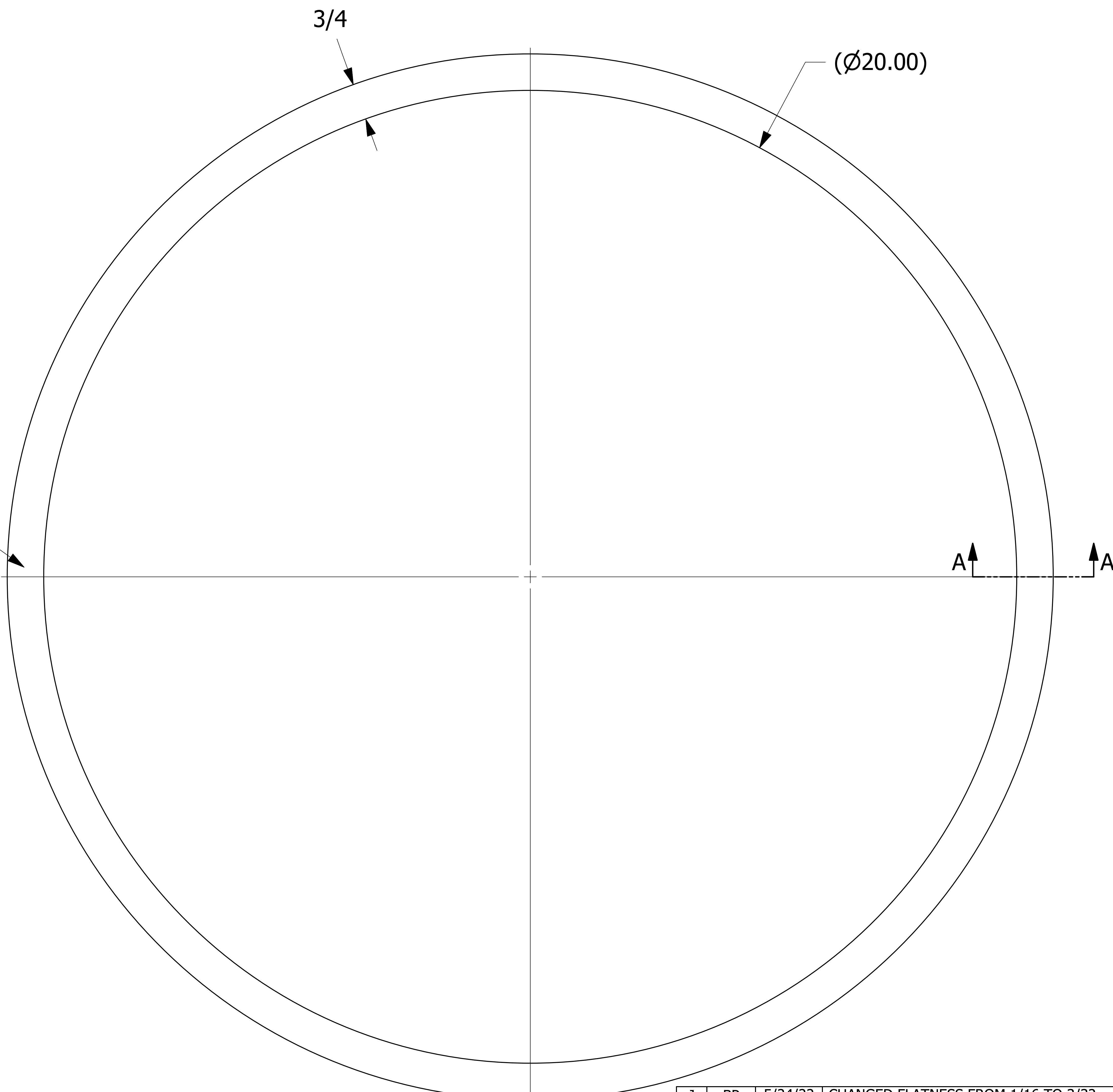
SEE NOTE 2

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

MARK DATE  
MM/DD/YY  
(SEE NOTE 3)



SECTION A-A  
SCALE 1 : 1



- NOTES:
- INSIDE & OUTSIDE WELD SEAMS FINISHED TO A SMOOTH AND CONTINUOUS CONTOUR WITH NO VISIBLE WELD EDGE, UNDERCUT, CRACKS AND/OR DEFECTS.
  - 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.
  - MARK DATE USING SHARPIE TEC MARKER. DATE TO BE LOCATED 90° FROM WELD SEAM, WITHIN AN INCH BELOW THE 1/8" RADIUS.

J	BP	5/24/22	CHANGED FLATNESS FROM 1/16 TO 3/32
I	CHL	12/9/20	DIM 3.13±.06 WAS 3.13
H	WEB	9/9/20	REMOVED Ø21.50 DIM; ADDED 3/4 DIM; UPDATED TITLE BLOCK
G	CHL	10/18/19	ADDED SECTION A-A, THICKNESS TOLERANCE & SEAM WELD LEADER NOTE
F	CHL	2/22/19	UPDATED NOTES, WELD SYMBOL NOTES, ADDED LEADER NOTE, DIM R1/8 WAS R.125
E	JG	12/27/17	Ø20.30/Ø20.18 WAS Ø20.24
D	CHL	10/3/17	UPDATED VIEW, ADDED DATE MARKINGS, UPDATED WELD SYMBOL, UPDATED NOTE #1, ADDED NOTES 2, 3, 4 & 5, UPDATED MATERIAL, & DESCRIPTION
C	CHL	4/19/16	REMOVED CYLINDRICITY TOLERANCE, DIM Ø20.00 WAS MADE REFERENCE, UPDATED WELD SYMBOL
B	WEB	3/21/16	UPDATED TO CURRENT DRAFTING STANDARDS
A	CHL	5/29/07	NEW PART ADDED TO SYSTEM
REV	BY	DATE	DESCRIPTION

UNLESS OTHERWISE SPECIFIED DIMENSIONAL TOLERANCES FRACTIONAL: ±1/16 X.XX: ±.03 X.XXX: ±.015 ANGULAR: ±1° DEBURR ALL SHARP EDGES. ALL MACHINED SURFACES TO HAVE A 125 RMS FINISH UNLESS NOTED OTHERWISE. THIRD ANGLE PROJECTION	DRAWN BY: PJG	CHECKED BY: ACC	PROTOTYPE DATE: 11/5/2003	APPROVED FOR PRODUCTION BY: ACC	PRODUCTION DATE: 5/28/2007	SIZE: E	DRAWING #: 18603
--	---------------	-----------------	---------------------------	---------------------------------	----------------------------	---------	------------------

**SALCO PRODUCTS, INC.**

PART NAME: **HATCH RING 20"**

MATERIAL: **316L SS 11 GAUGE**

PROJECT #: **WAG0093** SHEET #: **1 OF 1** SCALE: **1:1**

PART #: **HCR20NH2**