ASSY OR PT NO & QTY				PC NO	DESCRIPTION	PATT NO	MATL SPEC	DWG PT OR PC NO
03	02	01	00					
			X	01	HEAD, SHAFT AND DISC (304 SST)			
		X		02	HEAD, SHAFT AND DISC (316 SST)			
		1		03	SHAFT, ROUGH MACHINED			D3376-419-00
			1	04	DISC, ROUGH MACHINED			C3325-405/01
		1		05	DISC, ROUGH MACHINED			C3325-405/02
	2		2	06	SLEEVE, SHAFT			B3186-400/01
	2			07	SLEEVE, SHAFT			B3186-400/02
1		1		08	KEY			A2001-400/01
36	36	36		09	INSERT, 5/8-11, SCREW LOCK HELICOIL 3585-10CN X 15/16 LG.	18-8	SST	WA44951
X				10	HEAD, SHAFT AND DISC (304)			
1				11	SHAFT, ROUGH MACHINED	1040	STL.	D3376-419-01

DETAIL C
SCALE: NTS

DETAIL F
SCALE: 1"=1"

81.1875 REF
48.25 HOLD
2.125
0.500
0.500
30.8125
27.8437
27.8437
20.1875
20.1875
6.6875
6.6875
7.6562 REF.
13.5 REF.
13.5 REF.
7.6562 REF.
4.25
8.5312
7.625
3.03125
0.28125
1.375
R 0.625
SEE DETAIL C
DO NOT WELD END OF SLEEVE
.0625 X 45°
.062 X 45°
2.969
5.1192 ±.0005
4 B.C.
30°
0.005MAX. X 45°
DRILL .4219 DIA. X 1.5625 DP.
.5 TAP 1" DP.
3 HOLES EQUALLY SPACED ON 4" B.C.
5.3825 ±.0025
SEE DETAIL E
5.380 ±.005
5.3955 ±.0005
34.000 ±.005
35°
38°
.031 R MAX
0.125 REF.
1.5625
.031R MAX
SEE DETAIL F
SEE DETAIL E
SEE DETAIL F
5.380 ±.005
5.3955 ±.0005
5.1192 ±.0005
4.9355 ±.0025
4.9165 ±.0005
5.1060-5.0948 OD
5.0519-5.0436 ID
12 TPI FOR AN 26 LOCKNUT
4.9375 UNDERCUT
0.1875
0.625
2
4.270 ±.004
4.891
1.250 ±.001
.5
SECTION B-B
SEE DETAIL B
09: INSTALL 18 INSERTS IN COUNTERSUNK HOLES ON NEAR SIDE. INSTALL 18 INSERTS IN COUNTERSUNK HOLES ON FAR SIDE. TOP END MUST BE .0625 TO .125 BELOW SURFACE. BREAK OFF TANG AFTER INSTALLATION
COVER ENDS OF KEY WITH SST WELD SO THAT NO CARBON STEEL IS EXPOSED
GRIND ENDS FOR TIGHT FIT IN KEYWAY OF SHAFT (08)
.187 MAX.
.06 R
.094 MAX.
2.625 REF.
6.25
SECTION A-A
DETAIL B
SCALE: .75"=1"
DETAIL E
SCALE: .5"=1"
5.3955 ±.0005
5.330
.02
ALL DIA. TO BE CONCENTRIC WITHIN .001 T.I.R. ALL SHOULDERS TO BE SQUARE WITH DIA. WITHIN .001 T.I.R. BREAK OUTSIDE CORNERS 1/64 & RADII ON INSIDE CORNERS TO BE 1/16 UNLESS OTHERWISE NOTED.
AFTER INSPECTION, BEFORE STORAGE, COAT SHAFT WITH RUST VETO 342
MAX. RUNOUT OF SHAFT AFTER RINNER HAS BEEN SWEATED ON SHAFT IS AS FOLLOWS:
CPLG. FIT .001 T.I.R.
BRG. FIT .001 T.I.R.
PKG. SLEEVE FIT .003 T.I.R.
REV A
* NOTE: PURCHASE 6 3/4 DIA (STEEL 1040) SHAFT MACHINE THIS AREA TO SUIT EXISTING ROTOR & SLEEVES, CUT KEYWAY TO SUIT ROTOR KEYWAY
#7 PM Oct 7/88
REF. DWG. D3376-412
5.0 MICROFILM
702.01-0
MFG. SPEC
A

DWG.	DESCRIPTION	DATE	BY	REV
F	ADDED DETAIL F	072988	DPH	
E	PC 10 & 11 ADDED	011387	GTS	
D	REDRAWN, SEE LAST REV.	081386	PHB	

ROUGH EST. WEIGHT 1210 LBS.
FINISH EST. WEIGHT LBS.
TOLERANCES - UNLESS OTHERWISE NOTED: LINEAR, ANGLE
MACHINING .X = ±.02, .XX = ±.005, .XXX = ±.000, ±30'
FABRICATION .XX = ±.03, .XXX = ±.015
CAST/FORGE .XX = ±.03, .XXX = ±.015
MACHINED FILLET RADII .047" ±.016"
MAX MACHINED SURFACE ROUGHNESS 125 MICROINCHES (AA)

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SPROUT-BAUER, INC.
A SUBSIDIARY OF CONNECTION ENGINEERING, INC.

	BY	NAME	DATE
DR.	WPG	122483	
CK.			
ENGR.	JLB	110183	
MFG.	FHH	091986	

SCALE .25"=1" ORDER NO
SHEET 1 OF 1
DRAWING NUMBER D3376-421
CADAM DRAWING DO NOT REVISE MANUALLY

HEAD, SHAFT & DISC, SPOKED, 34" T.F. REFINER

RSI 9174
M2-7673-A

#7 PM - SPROUT WALDRON REFINER
SHAFT DETAIL
REV A - 5 JUNE 91