

NOTES: UNLESS OTHERWISE SPECIFIED

100. ALL DIMENSIONS ARE INCHES AND VALUES ARE IN U.S. CUSTOMARY UNITS.

102. APPLICABLE STANDARDS AND SPECIFICATIONS:
ASME Y14.5M-1994, DIMENSIONING AND TOLERANCING
ASME Y14.1, ABBREVIATIONS
ASME Y14.36, SURFACE TEXTURE SYMBOLS
ANSI/ AWS A2.4, STANDARD SYMBOLS FOR WELDING

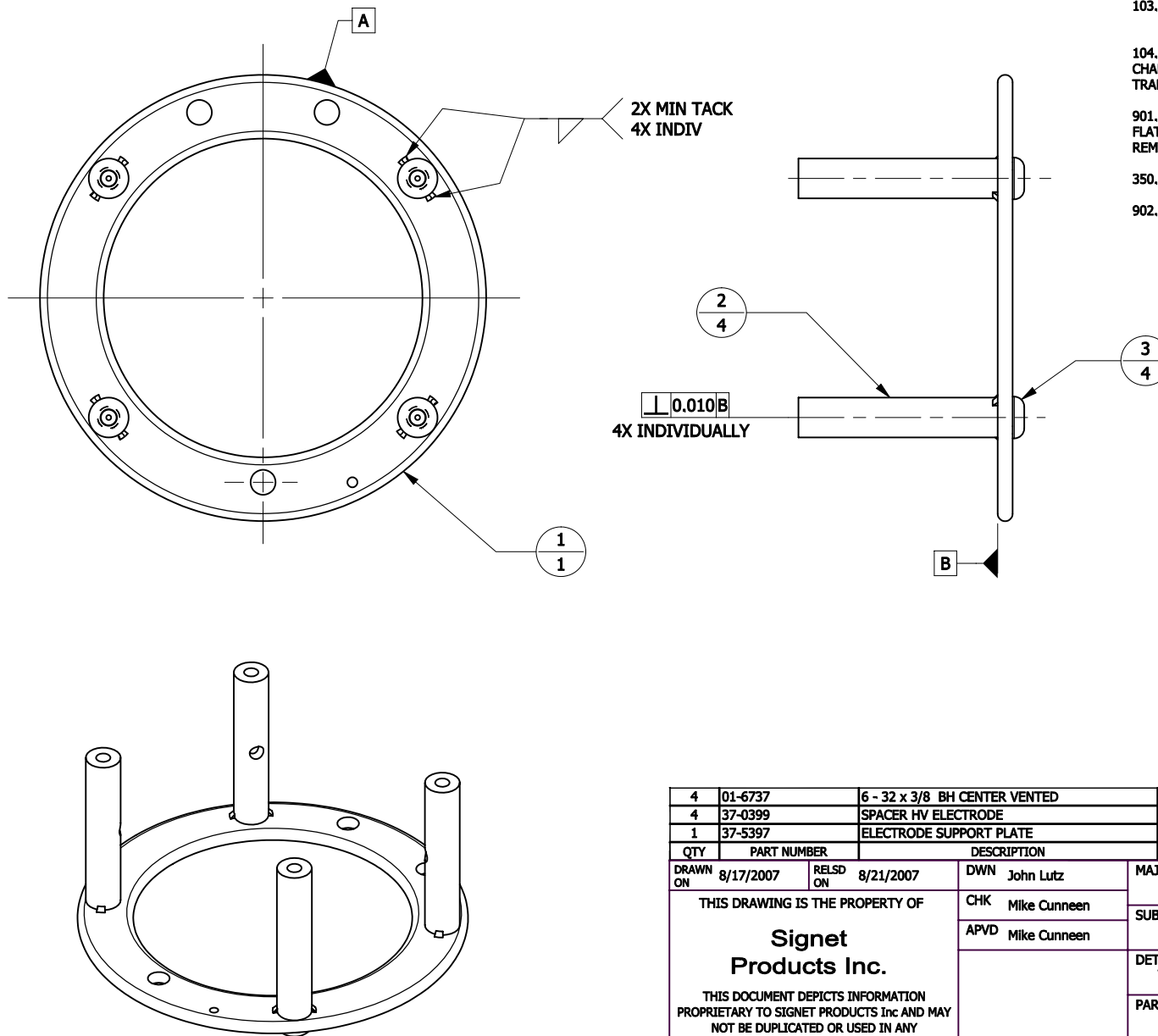
103. $\sqrt{63}$ FINISH ALL MACHINED SURFACES PER ASME B46.1, SURFACE TEXTURE.

104. REMOVE ALL BURRS AND BREAK EDGES 0.010 TO 0.025 CHAMFER OR RADIUS. RADII MUST MAKE A SMOOTH TRANSITION WITH ADJACENT SURFACES.

901. TACK WELD ITEMS 2 TO ITEM 1 WHERE SHOWN. USE FLAT HEAD SCREWS TO LOCATE ITEMS 2 DURING WELDING. REMOVE SCREWS PRIOR TO BEAD BLASTING.

350. BEAD BLAST ASSEMBLY.

902. ASSEMBLE ITEM 3.



4	01-6737	6 - 32 x 3/8 BH CENTER VENTED	STAINLESS STEEL, 18-8	6-32-0.375 BH.lpt	3		
4	37-0399	SPACER HV ELECTRODE	STAINLESS STEEL, 18-8	S-P_00033_A07.lpt	2		
1	37-5397	ELECTRODE SUPPORT PLATE	STAINLESS STEEL, 304	S-P_00034_A07.lpt	1		
QTY	PART NUMBER	DESCRIPTION	MATERIAL	FILE NAME	ITEM		
DRAWN ON	8/17/2007	RELSN ON	8/21/2007	DWN	John Lutz		
THIS DRAWING IS THE PROPERTY OF Signet Products Inc. THIS DOCUMENT DEPICTS INFORMATION PROPRIETARY TO SIGNET PRODUCTS Inc AND MAY NOT BE DUPLICATED OR USED IN ANY MANNER DETRIMENTAL TO SIGNET PRODUCTS Inc.			CHK	Mike Cunneen	MAJOR UNIT EXTRACTION ASSEMBLY		
			APVD	Mike Cunneen		SUB-ASSY ELECTRODE SUPPORT PLATE	
						DETAIL WELDMENT	
						PART NO 30-5397	
			FILE NO		S-P_00029_A07.lam	SHEET 1	OF 1