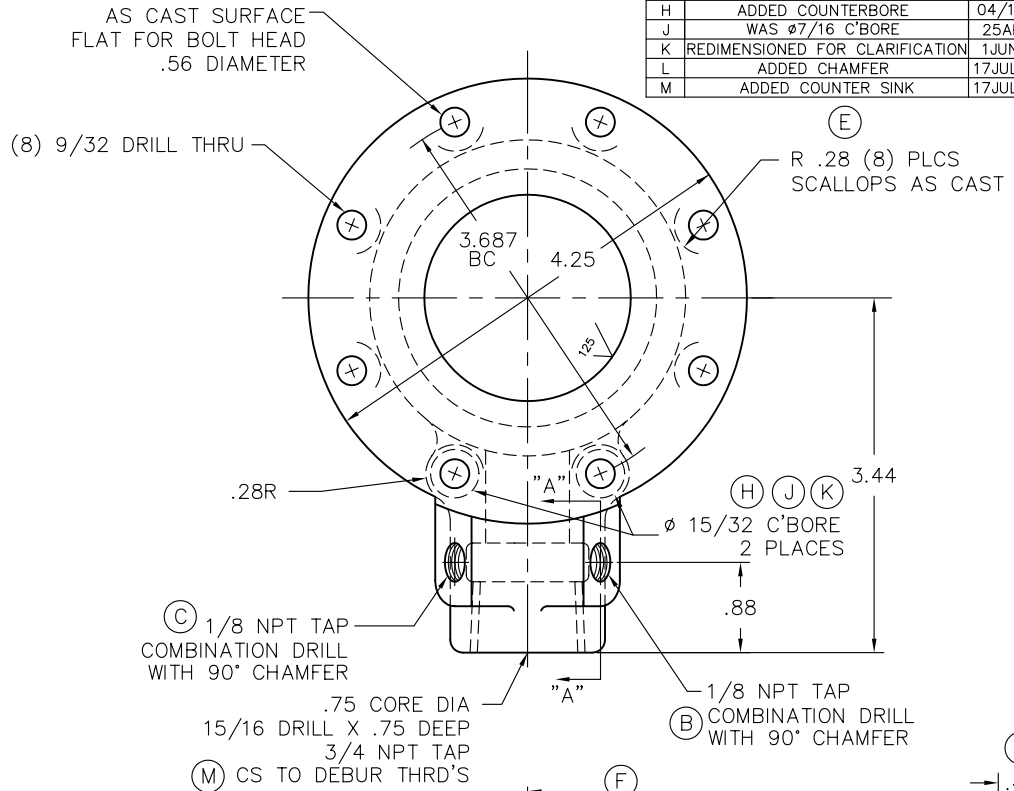
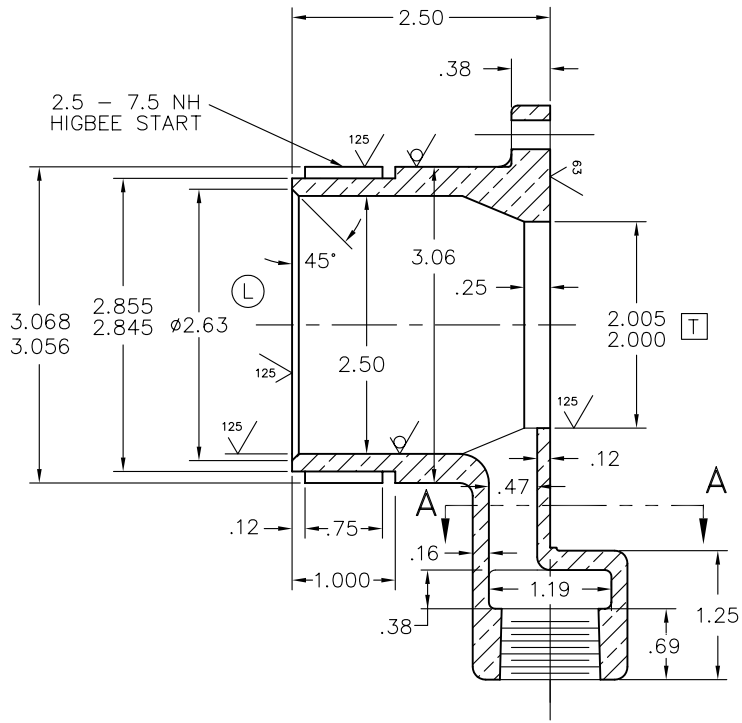


REVISIONS				
LTR	DESCRIPTION	DATE	CHG NO.	APPR'D
A	WAS .63	6/7/96	96-67	-
B	ADDED 90° CHAMFER	11/26/97	-	DLW
C	ADDED (1) NPT	1/22/98	98-17	DLL
D	ADDED CAST BOSS 2-PLCS	1/22/98	98-17	DLL
E	ADDED SCALLOPS 8-PLCS	1/22/98	98-17	DLL
F	WAS 45° (2-PLCS)	11/30/98	98-257	DLL
G	WAS .53	11/30/98	98-257	DLL
H	ADDED COUNTERBORE	04/11/00	2000-76	DMD
J	WAS Ø7/16 C'BORE	25APR01	2001-101	DMD
K	REDIMENSIONED FOR CLARIFICATION	1JUNE04	-	DAB
L	ADDED CHAMFER	17JUL2006	2006-248	MWE
M	ADDED COUNTER SINK	17JUL2006	2006-248	MWE



(8) 9/32 DRILL THRU

AS CAST SURFACE FLAT FOR BOLT HEAD .56 DIAMETER

R .28 (8) PLCS SCALLOPS AS CAST

3.687 BC 4.25

.28R

Ø 15/32 C'BORE 2 PLACES

.88

"A"

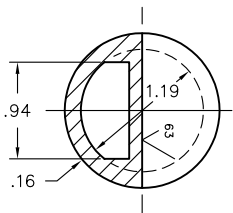
1/8 NPT TAP COMBINATION DRILL WITH 90° CHAMFER

1/8 NPT TAP COMBINATION DRILL WITH 90° CHAMFER

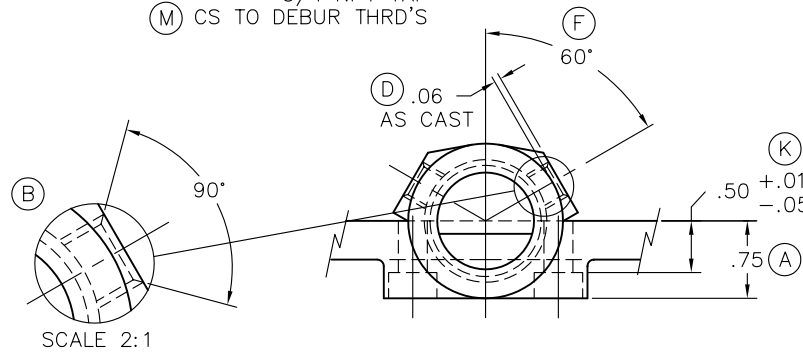
1/8 NPT TAP COMBINATION DRILL WITH 90° CHAMFER

.75 CORE DIA 15/16 DRILL X .75 DEEP 3/4 NPT TAP

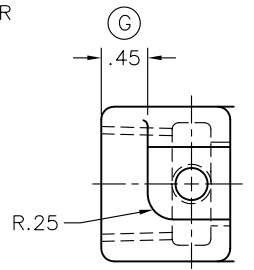
CS TO DEBUR THRD'S



SECTION A-A



SCALE 2:1



CAST DETAIL "A" TYP. 2 PLCS

REMOVE SHARP EDGES

INCH [MILLIMETER] THIRD ANGLE PROJECTION

RESIN OR MOGUL IMPREGNATE AFTER MACHINING

MATERIAL DESCRIPTION: CAST BRASS 81-3-7-9	MATERIAL NO. 2100492	PATTERN NO. G1247-6 G1247 CORE	TOLERANCE EXCEPT AS NOTED .00 ±.03 .000 ±.010 ANGLES ±1°	DR'N SEITZ CHKD TRCD MCR	DATE OCT08,90	SCALE 1/1	2100406
THIS DESIGN IS THE PROPERTY OF W.S. DARLEY AND CO. - UNAUTHORIZED REPRODUCTION IS PROHIBITED			ALL DIMENSIONS IN INCHES UNLESS NOTED			DO NOT SCALE PRINT	

OLD PART NO. G1247-6
TOLERANCE EXCEPT AS NOTED
W.S. DARLEY & Co. MELROSE PARK, IL - CHIPPEWA FALLS, WI
NIPPLE - BALL VALVE, 2.50 NHM SHORT NOSE, 2.50 LONG