



* MINIMUM TAPER
THREAD DISTANCE
SEE NOTE 4

NOTES:

- 1.) NO SHARP CORNERS, PARTICULARLY @ BORE H
- 2.) DIM. "H" .595 ϕ X .60 DEEP I.D. (REAM TO REMOVE FLASH IF NECESSARY)
- 3.) MAKE FROM BLANK CASTING M-9100 713 ALUM OR ALUMINUM ALLOY B380.1
- 4.) MACHINE FULL NPT THREAD WITHIN .050" OF BOTTOM OF HEX. VANISHING THREAD NOT PERMITTED

- 1.) CHECK MAJOR DIA. OF NPT THREAD USING FUNCTIONAL RING GAGE (.135 THK. X .800 I.D.) PLACE GAGE OVER NPT THREAD. GAGE SHOULD FIT APPROX FLUSH WITH END OF PART BUT NOT BEYOND
- 2.) THE FIT FOR 1/2-14 NPT RING GAGE IS $\pm 1/2$ TURN
- 3.) * INDICATES CRITICAL INSPECTION DIMENSIONS

REV.	DATE	CHANGE	<p>UNLESS OTHERWISE SPECIFIED</p> <p>3-PLC. DIM. $\pm .005$</p> <p>2-PLC. DIM. $\pm .010$</p> <p>1-PLC. DIM. $\pm .015$</p> <p>FRACTIONAL $\pm 1/64$</p> <p>ANGULAR $\pm 1^\circ$</p>	<p>BRIDGEPORT</p> <p>SCALE: APPROX. FULL</p> <p>MATERIAL: SEE NOTE 3</p> <p>FINISH: NATURAL/MACHINED</p> <p>PART NAME: BODY 90 DEGREE</p> <p>PART NUMBER: RSR-9100-B</p> <p>DRAWING DATE: 6-30-03</p>
A	6/30/03	DRAWING RELEASED		
B	8/26/03	REVISED P.D.'S FOR 1"-16 TH'D. GO PD .9550 WAS .9579 NO GO PD .9500 WAS .9529, OMIT DIM .575, NEW DIM. .560 WAS .533, $\phi .795$ WAS $\phi .785$ & $\phi .830$ WAS $\phi .825$, ALSO ADDED INSPECTION NOTES		
C	9/24/03	ADDED NOTE 4		
D	3/14/05	REVISED NOTE 4		