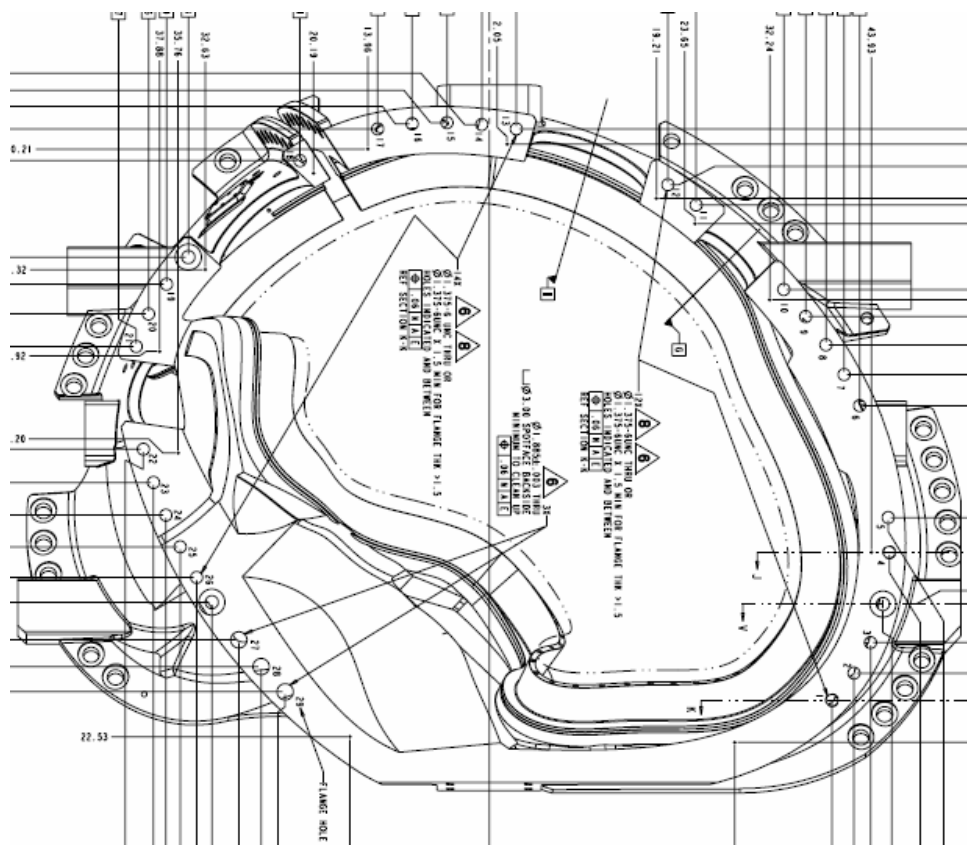




SE141-115 Type B2 Flange Hole Rework Proposal

Rework Proposal for Holes 19 thru 26:

- Oversize holes for a Ø2.50-6 UN insert.
- Inserts will be manufactured complete with the Ø1.375-6 ID thread.
- For 5 Blind Holes: bottom out insert in hole (approx. 1.6' deep) and tack weld in 4 places on flange.
- For 3 Thru Holes: install insert and tack weld in 4 places on flange face and 4 places on back side of flange.
- All inserts will be faced off flush with Datum -E- flange.



5

4

3

2

1

MTM REVISIONS

SYMBOL	ZONE	DESCRIPTION	DATE	BY
-		INITIAL RELEASE	8/13/08	MJB

Ø 1.375-6 UNC2B

Ø2.50-6 UN-2B

1.625

.06" CHAMFER

			8
			7
			6
			5
			4
			3
			2
			1
QTY	PART NUMBER/MATERIAL	DESCRIPTION	ITEM

LIST OF MATERIAL

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

.X Ø6	.XX Ø20	.XXX Ø10
FRACTIONS	ANGLES	

MATERIAL

STELLALLOY

Major
TOOL & MACHINE, ENGINEERING
INCORPORATED, PEORIA, ILLINOIS

MCWF FLANGE INSERT

SIZE A NUMBER SE141-INSERT-MTM

SCALE, ANVIL, SHEET 1 OF 1

DRWN BY: MIKE GRIFFITH

CHKD BY: NATHAN HIRSCHY

This document and all information thereon is the
property of MAJOR TOOL AND MACHINE, INC.
and is confidential and must not be made public
without written consent of MAJOR TOOL AND MACHINE, INC.
Page 1 of 1

5

4

3

2

1

D

C

B

A

D

C

B

A