



HEAT TREATMENT:
VACUUM SOLUTION ANNEALED AFTER WELDING.

1. Load Header and pump down to less than 1 micron vacuam level.
2. Increase Temperature at a rate of 25 deg. F./Hr. to 1925-1950 Deg. F.
3. Hold Temperature at 1925-1950 Deg. F. for 30-45 Min.
4. Nitrogen Gas Quench to below 150 Deg. F.

SPECIFICATIONS:
1. MINIMUM FLOW SPEC. 16 GAL/MIN @ 16 PSI.

REVISIONS					
ENN #	REV.	DESCRIPTION	BY	CHK'D	DATE
0158	A	RELEASED FOR PRODUCTION	JAK		4/09/2008
0173	B	UPDATED WITH REVISED INNER COLLECTOR	JAK		6/10/2008

	DEPARTMENT MARINE		CUSTOM MARINE INCORPORATED NEENAH, WI		
	PREPARED JAK	04/08/08	DESCR. SWEEPER HEADER 3" TALLER		
<small>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONAL TOLERANCING: 2 PLACE ±.03 3 PLACE ±.005 ANGLES ±1°</small>	CHECKED ENGINEER		SIZE C	WEIGHT LBS.	DWG. NO. 13205
<small>CUSTOM MARINE INCORPORATED RESERVES PROPRIETY RIGHTS TO THIS DRAWING AND THE DATA SHOWN THEREON. SAID DRAWING AND/OR DATA ARE CONFIDENTIAL AND ARE NOT TO BE USED OR REPRODUCED FOR ANY PURPOSE WITHOUT THE WRITTEN CONSENT OF CUSTOM MARINE INCORPORATED.</small>	THIRD ANGLE PROJECTION	SCALE 1:8	MATERIAL: Material <not specified>	SHEET 1	REV. B