



OF HEMISPHERES
 SQUARE TO -A- WITHIN 0° 30'
 PRIOR TO WELDING (REF)

.178 ± .006 TYP EXCEPT
 IN AREAS CODED B
 REF

12° TYP REF

7.473 ± .005 R
 SPHER TYP REF

PORT PER AND 10050-B
 REF

20° REF

1.125 DIA REF

.50 R REF

11.909 SPHER R REF

1.456 REF

APPLY IDENTIFICATION DATA AS FOLLOWS:
 MFD BY PRESSURE SYSTEMS INC.
 LOS ANGELES, CALIFORNIA
 PART NO. 80186-1
 SERIAL NO. []

2.617 REF

4.827 REF

12.566 R SPHER
 REF

1.026 REF

80-186040-1 HEMISPHERE-PORTED
 1 REQD

80-186020-1 HEMISPHERE-MACHINED
 1 REQD

TANGENCY PT
 TYP REF

1.591 TYP REF

.06 MAX WELD
 PROJECTION

PRESSURE SYSTEMS, INC.	
LOS ANGELES, CALIFORNIA	
VESSEL PRESSURE	
CODE IDENT NO.	SIZE
18229	E
80186	
SCALE 1/1	SHEET 1