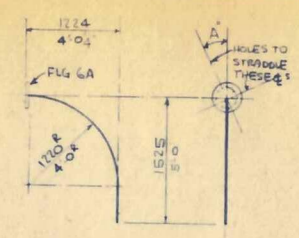
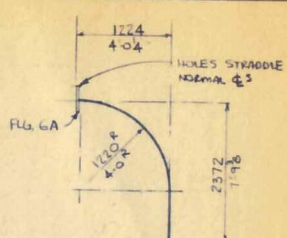


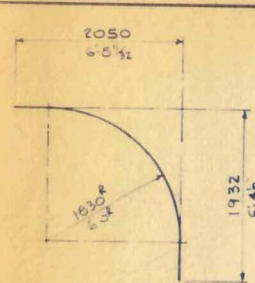
6 90° ELBOW (2B) REQ'D.
MARK GEB90-1



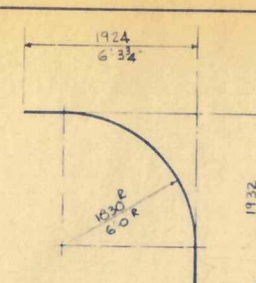
6 90° ELBOW
(1) REQ'D. A 32° MARK GEB90-2
(1) REQ'D. A 25° MARK GEB90-3
(1) REQ'D. A 17° MARK GEB90-4
(1) REQ'D. A 7° MARK GEB90-5



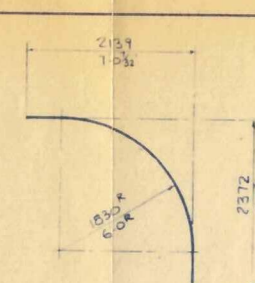
6 90° ELBOW (4) REQ'D.
MARK GEB90-6



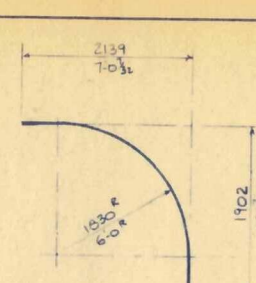
6 90° ELBOW (40) REQ'D.
MARK GEB90-7



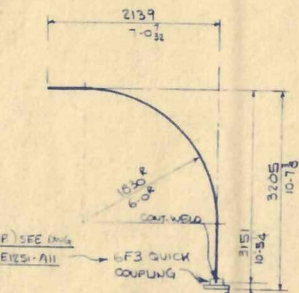
6 90° ELBOW (8) REQ'D.
MARK GEB90-8



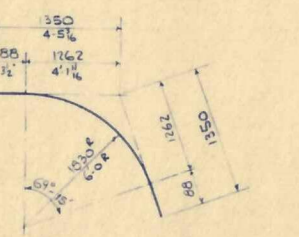
6 90° ELBOW (20) REQ'D.
MARK GEB90-9



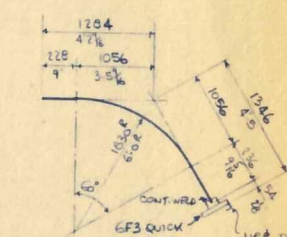
6 90° ELBOW (3) REQ'D.
MARK GEB90-10



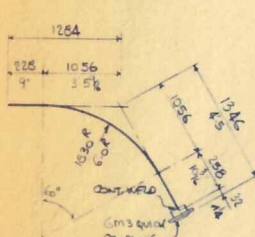
6 90° ELBOW (2) REQ'D.
MARK GEB90-11



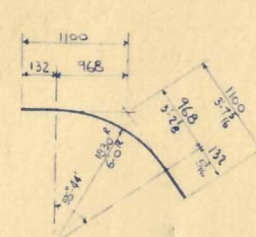
6 69.15° ELBOW (1) REQ'D.
MARK GEB69-1



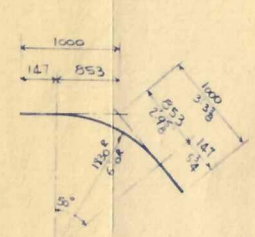
6 60° ELBOW (20) REQ'D.
MARK GEB60-1



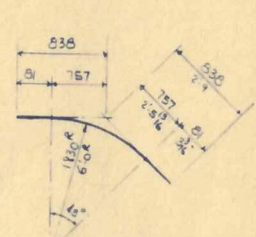
6 60° ELBOW (3) REQ'D.
MARK GEB60-2



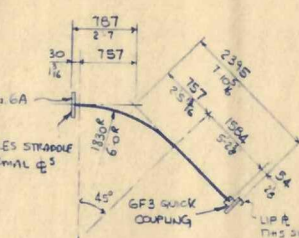
6 55.44° ELBOW (2) REQ'D.
MARK GEB55-1



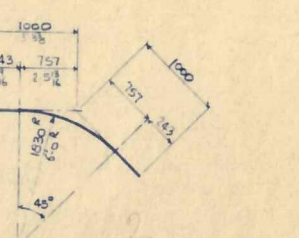
6 50° ELBOW (1) REQ'D.
MARK GEB50-1



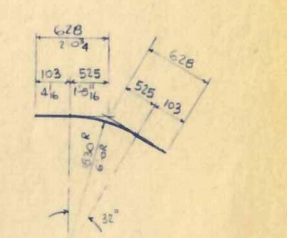
6 45° ELBOW (3) REQ'D.
MARK GEB45-1



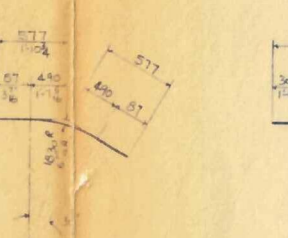
6 45° ELBOW (4) REQ'D.
MARK GEB45-2



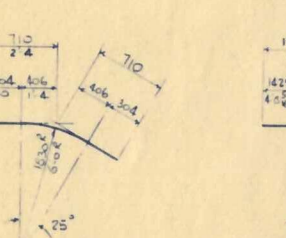
6 45° ELBOW (2) REQ'D.
MARK GEB45-3



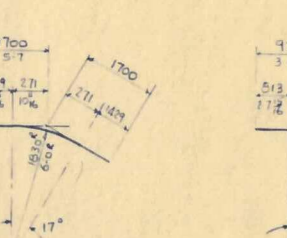
6 32° ELBOW (6) REQ'D.
MARK GEB32-1



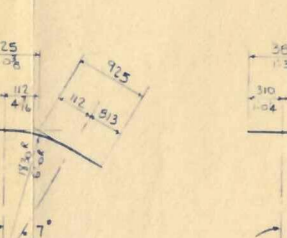
6 30° ELBOW (1) REQ'D.
MARK GEB30-1



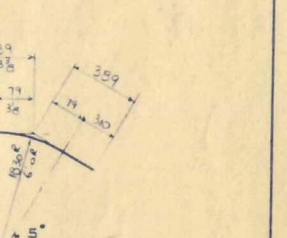
6 25° ELBOW (6) REQ'D.
MARK GEB25-1



6 17° ELBOW (6) REQ'D.
MARK GEB17-1



6 7° ELBOW (6) REQ'D.
MARK GEB7-1



6 5° ELBOW (20) REQ'D.
MARK GEB5-1

CUSTOMER NOTE: INTERNAL TREATMENT REQUIRED FOR ALL BENDS (BY OTHERS)

SHOP CUTTING LIST FOR THE ABOVE PIPE BENDS

6 SCH10 6063-T6 ALUMINUM PIPE 1200 LONG FOR 303-BELOW.

REQ'D.

QUANTITY

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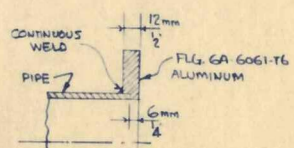
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THE FOLLOWING MATERIAL WILL BE FURNISHED TO FABRICATOR BY NATIONAL CONVEYORS CO., INC.

- (1) 200 LENGTHS OF 6" SCH 10, 6063-T6 ALUMINUM PIPE. SEE SHOP CUTTING LIST.
- (2) FLANGE 6A, 6357 I.D. 8 1/4" B.C. 11 I.D. 8 3/4" HOLES - 6061-T6 ALUMINUM
- (3) 6F3 QUICK CPLG WITH 6P COVER PLATE LONG E-ELBOW-ALL
- (3) 6M3 QUICK CPLG WITH 6C CAP
- (3) GASKET FOR 6M3 CPLG (BOND TO 6M3 AFTER WELDING)
- (1) DINT PRECISION TECH PROD. ADHESIVE #155 A BRUSH



TYPICAL FLANGE WELDING DETAIL

GENERAL NOTES AND SPECIFICATIONS FOR FABRICATOR

- All bends are to be made of 6063-T6 aluminum pipe, the size and length to be indicated on the drawing. Unless otherwise indicated, the drawing will be finished in 20 ft. lengths, by National Conveyor Company.
- All flanges, gaskets, and covers are to be furnished by National Conveyor Company for your attachment.
- All pipe ends are to be cut in a square fashion as shown in the drawing. All pipe ends are to be cut square before attaching flanges or covers.
- Center to center dimensions shown for each pipe bend are to be held to a tolerance of $\pm 1/16$ ". Pipe bend degree is to be held to a tolerance of $\pm 1/2$ ".
- All flanges are to be bolted snugly against the pipe with continuous internal welds, and provide free joint. One flange and cover are to be attached to the appropriate inside diameter. Therefore, it is unlikely that grinding will be necessary to achieve this.
- Unless otherwise noted, one peripheral joint means weld is required on the drawing. Welds are not to be structurally air tight. Welds are not to protrude on the pipe surface, and are to be ground smooth where the joint is not readily accessible to be ground. Care must be taken to insure 75% penetration at these joints, thereby avoiding protrusions of the internal of the pipe.
- While it will not affect the function of the bends, our good looking equipment to enhance the installation. It is recommended that the welds on each bend, once they are in the pipe, are to be ground smooth to avoid unnecessary scratching or marking of the pipe.
- As soon as all work on the bends is complete, mark each one, neatly, with an indelible ink pen or paint stick. The proper identifying mark number shown on the drawing. In certain instances we request the marking of the bend to show direction of flow.

THIS DRAWING IN DESIGN AND DETAIL IS THE PROPERTY OF THE NATIONAL CONVEYORS CO., INC. AND MUST NOT BE USED EXCEPT IN CONNECTION WITH OUR WORK. ALL RIGHTS OF DESIGN AND INVENTION ARE RESERVED.		NATIONAL CONVEYORS CO., INC. FAIRVIEW, BERGEN COUNTY, NEW JERSEY 6 SCH10 PIPE BENDS FOR HEMIJSKA INDUSTRIJA PANJEVO PETROCHEMICAL COMPLEX PANJEVO, YUGOSLAVIA		PRINT ISSUED DESTROY ALL PRINTS BEARING PREVIOUS DATES 4-4-74 DATE PREVIOUS DATES DRAWING NO. REV. A E125A270	
DRAWN BY: JFG		DATE: 11-21-73		SCALE: NONE	
CHECKED BY: JFG		DATE: 11-21-73		SCALE: NONE	
NO. REVISIONS					

INVESTMENT CONTRACT NO. 71
POSTER - 4-4-74
N.C. CO. NO. P125