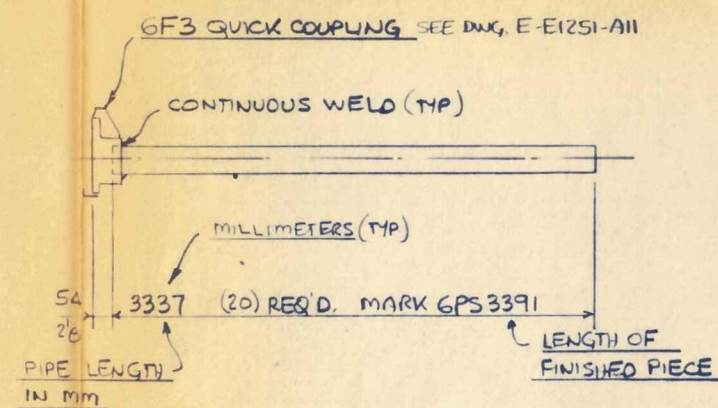
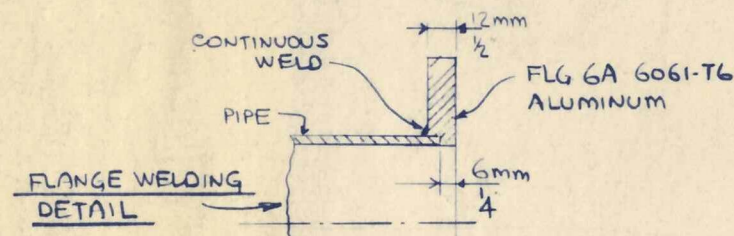


# GENERAL NOTES AND SPECIFICATIONS FOR FABRICATOR

- All spools are to be constructed of #6063-T6 aluminum pipe, the size and schedule indicated on the drawing. Unless otherwise indicated, this piping will be furnished in 20 ft. lengths, by National Conveyors Company.
- All flanges, or quick-disconnect couplings, are to be furnished by National Conveyors Company for your attachment.
- All pipe spools are to be made with ends cut perpendicular to the centerline axes. All ends are to have pipe burrs removed before attaching flanges or couplings.
- Dimensions shown for each pipe spool are to be held to a tolerance of  $\pm 1/8"$ .
- All flanges and couplings are to be butted snugly against the pipe spool end to provide a smooth continuous internal surface, and crevice free joint. Our flanges and couplings are machined to the appropriate inside diameters, therefore it is unlikely that grinding will be necessary to achieve this.
- Unless otherwise noted, one peripheral continuous weld is required in the location shown on the drawing. Welds must be structurally sound, as well as air tight. Welds are not to protrude on the internal of the pipe surface, and are to be ground smooth where they do. In the event the joint is not readily accessible to be dressed with a die grinder, care must be taken to insure 80% penetration of weld at these joints, thereby avoiding protrusions of stalactites on the internal of the pipe.
- While it will not in anyway affect the function of the spool, our customers also seek good looking equipment to enhance the installation. It is therefore requested that from the receipt of the piping until the completion of the work on each spool, care be used in the handling of these units to avoid unnecessary scratching or marring of the exterior surfaces.
- As soon as all work on the spools is complete, mark each one, neatly, with an indelible ink pen or paint stick, the proper identifying mark number shown on the drawing.

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

- (25) 20' 0" LENGTHS OF 6" SCH 10, 6063-T6 ALUMINUM PIPE. SEE SHOP CUTTING LIST.  
 (59) FLANGE 6A 6.357 I.D. 9 1/2 B.C. 11.0 D 5 1/8 HOLES - 6061-T6 ALUMINUM.  
 (20) 6F3 QUICK CPLG WITH GP COVER PLATE - (DWG. E-F1251-A11)



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

## SHOP CUTTING LIST FOR THE ABOVE PIPE SPOOLS

QUAN. REQ'D.	6" SCH 10, 6063-T6 ALUMINUM PIPE x (20'-0") 6096mm LONG FOR (79) SPOOLS	WASTE
(1)	XTRA 6096 mm (20'-0")	0
(2)	6096 mm	0
(1)	5314 mm (17'-5 1/4")	782
(12)	3337 mm (10'-11 3/8")	2759
(2)	3337 mm 1778 mm (5'-10")	981
(1)	2914 mm (9'-6 3/4") 2766 mm (9'-1 1/8")	416
(2)	3337 mm 610 mm (2'-0")	2149
(2)	3337 mm 1333 mm (4'-4 1/2") (5) 144	706
(2)	3337 mm (9) 144 (5' 1/8")	23
(25) LENGTHS		

## FLANGE 6A-6061-T6 ALUMINUM PLATE

PIPE LENGTH IN MM	LENGTH OF FINISHED PIECE
6096 (2) REQ'D. MARK GPS 6102	
5314 (1) REQ'D. MARK GPS 5320	
2914 (1) REQ'D. MARK GPS 2920	
2766 (1) REQ'D. MARK GPS 2772	
1778 (2) REQ'D. MARK GPS 1784	
1333 (2) REQ'D. MARK GPS 1339	
610 (2) REQ'D. MARK GPS 616	
144 (48) REQ'D. MARK GPS 150	

CERTIFIED FOR CONSTRUCTION  
 BY *[Signature]*  
 DATE 11-28-73

INVEST IMPORT CONTRACT NO. 71  
 FOSTER WHEELER REF NO. 15-1053-1351A  
 N.C. CO. NO. P1251

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		PRINT ISSUED DESTROY ALL PRINTS BEARING PREVIOUS DATES 4-4-74	
FABRICATED 6" SCH 10 TRANSPORT PIPE SPOOLS FOR HEMIJSKA		INDUSTRIJA PANČEVO		DATE PREVIOUS ISSUE NONE	
PETRO CHEMICAL COMPLEX PANČEVO, YUGOSLAVIA		DRAWN BY LFG DATE 11-27-73		SIZE C	
NO. REVISIONS		TRACED BY CKD. BY <i>[Signature]</i>		DRAWING NO. E1251-A28	
		SCALE NONE		REV. 0	

2-13-74  
 3-18-74