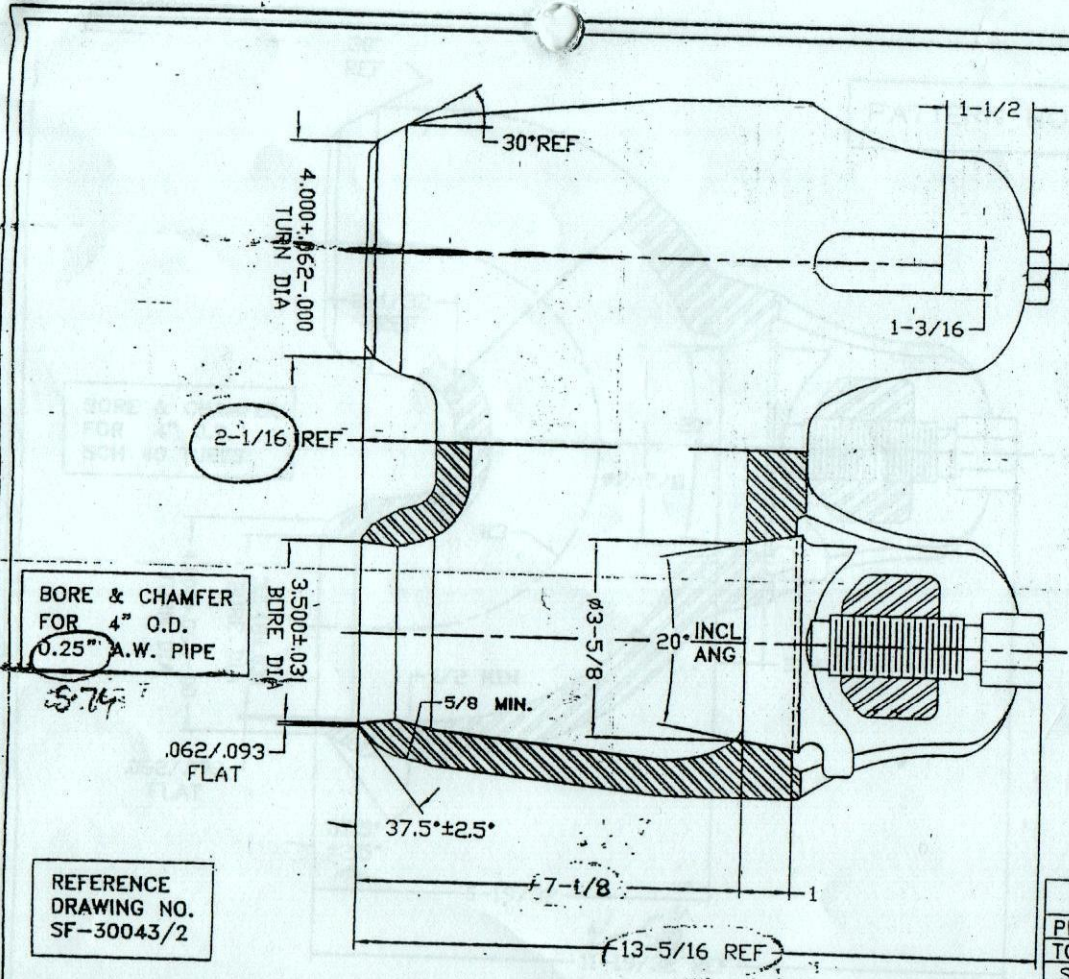


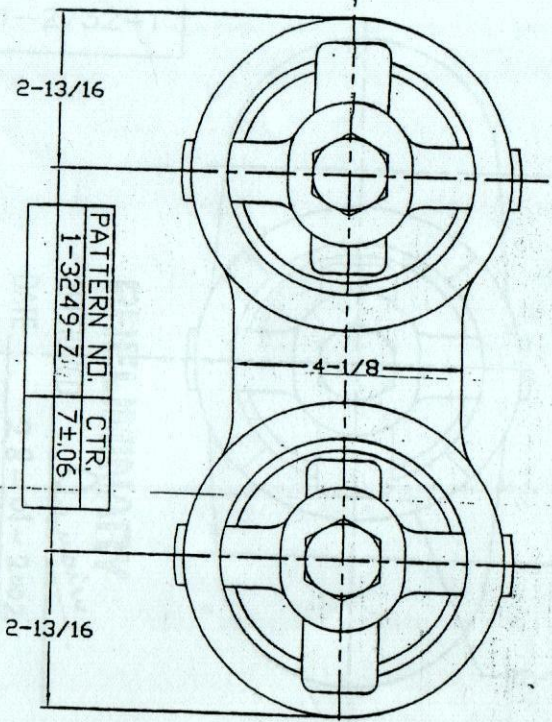
(5)



BORE & CHAMFER
FOR 4" O.D.
0.25" A.W. PIPE

5.74

REFERENCE
DRAWING NO.
SF-30043/2



PATTERN NO. CTR.
1-3249-Z
74.06

PRELIMINARY
APPROVED _____
DATE 7.11.2002

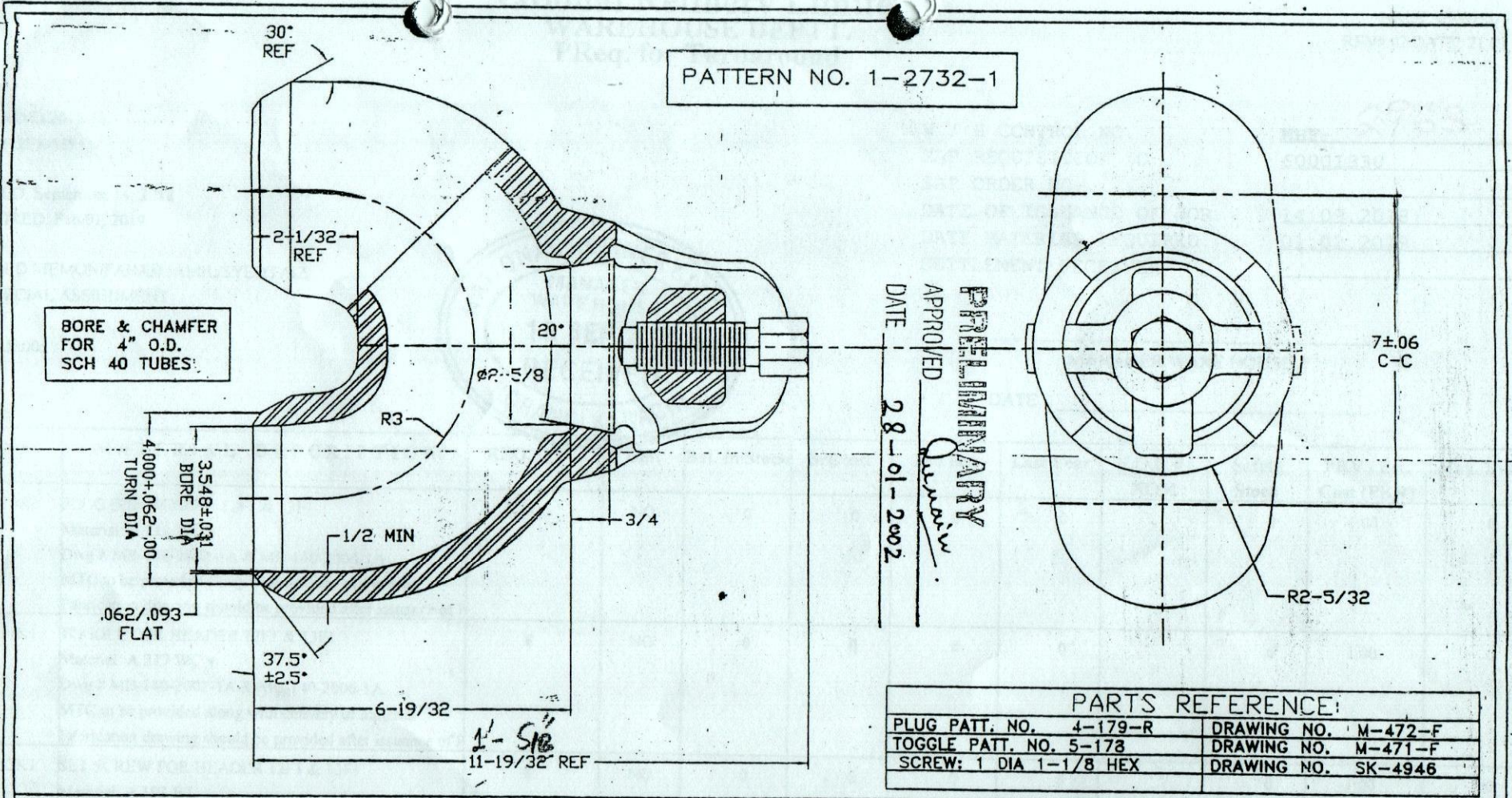
PARTS REFERENCE:	
PLUG PATT. NO. 4-612-R	DRAWING NO. M-1067-B
TOGGLE PATT. NO. 5-1996-1	DRAWING NO. M-6991-F
SCREW: 1-1/4 DIA 1-3/8 HEX	DRAWING NO. SK-6993

CUSTOMER: NATIONAL REFINERY LIMITED		ORDER: 6116		JOB:		WF REPCO WALKESHA FOUNDRY, INC. WALKESHA, W 53188	
FOR: KARACHI, PAKISTAN STEEL FOUNDERS SOCIETY OF AMERICA (SFSA) GRADE 13 CAST TOLERANCES APPLY		ORDER ITEM NO.	FTG. ITEM OR MARK	QTY	TUBE CENTER	MATERIAL SPECIFICATION	REMARKS
NOTES: WF-REPCO 60-5, REV. 5 100% LIQUID PENETRANT INSPECTION 10% RADIOGRAPHIC INSPECTION SHOP HYDRO TEST FOR 5 MINUTES EACH AT 1800 P.S.I.G.		5		2	7±.06	BODY & PLUG ASTM A216- GRADE WCB	TOGGLE: ASTM- A217 GRADE WCB
		7		2	7±.06	BODY & PLUG ASTM A217 GRADE C5	SET SCREW ASTM A193 GRADE B7
						RETURN BENDS, SPECIAL FITTINGS ALLOY TUBE SUPPORTS	
						4" O.D. WELD-END MULE EAR. RETURN BEND, TYPE 10-W2. 500# - 850# SERIES	
DRWN.	T.R.	1/9/02		SCALE:		NONE	
CHK'D.				DRAWING NO.		REV.	
APPR.				MB-140-2000-1A		B	

01-F1

12-P1

57-104-005



BORE & CHAMFER
FOR 4" O.D.
SCH 40 TUBES

PATTERN NO. 1-2732-1

DATE 28-01-2002
APPROVED *[Signature]*
PRELIMINARY

PARTS REFERENCE:	
PLUG PATT. NO. 4-179-R	DRAWING NO. M-472-F
TOGGLE PATT. NO. 5-178	DRAWING NO. M-471-F
SCREW: 1 DIA 1-1/8 HEX	DRAWING NO. SK-4946

CUSTOMER: NATIONAL REFINERY LIMITED		ORDER: 6116		JOB:		WF REPCO WALKESSHA FOUNDRY, INC. WALKESSHA, WI 53106	
FOR: KARACHI, PAKISTAN STEEL FOUNDERS SOCIETY OF AMERICA (SFSA) GRADE 13 CAST TOLERANCES APPLY		ORDER ITEM NO.	FTG. ITEM OR MARK	QTY	TUBE CENTER	MATERIAL SPECIFICATION	REMARKS
NOTES: WF-REPCO 60-5, REV. 5 100% LIQUID PENETRANT INSPECTION 10% RADIOGRAPHIC INSPECTION SHOP HYDRO TEST FOR 5 MINUTES EACH AT 1250 P.S.I.G.		22		4	7±.06	BODY & PLUG ASTM A216 GRADE WCB TOGGLE: ASTM A217 GRADE WC9	SET SCREW ASTM A193 GRADE B7 13-F1 12-F1
		RETURN BENDS, SPECIAL FITTINGS ALLOY TUBE SUPPORTS		4" O.D. WELD-END MULE EAR RETURN BEND, TYPE 10-WY 500# SERIES		DRWN. T.R. 1/9/02	SCALE: NONE
		DRAWING NO. MB-140-2002-1A		REV. -		CHK'D:	APPR.