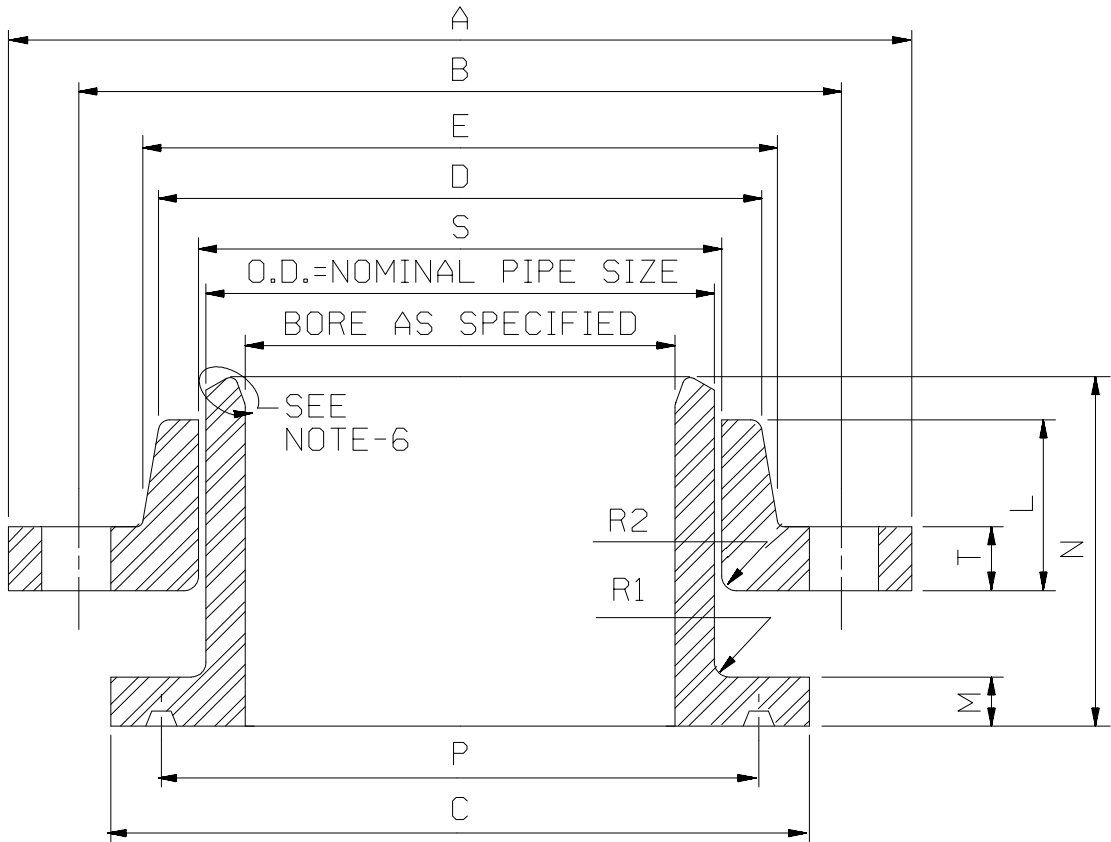
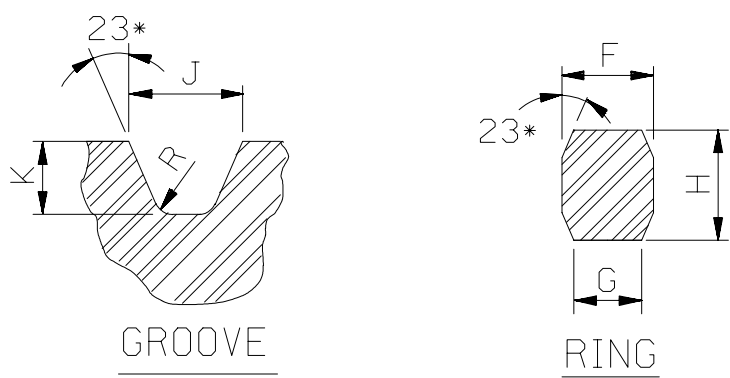
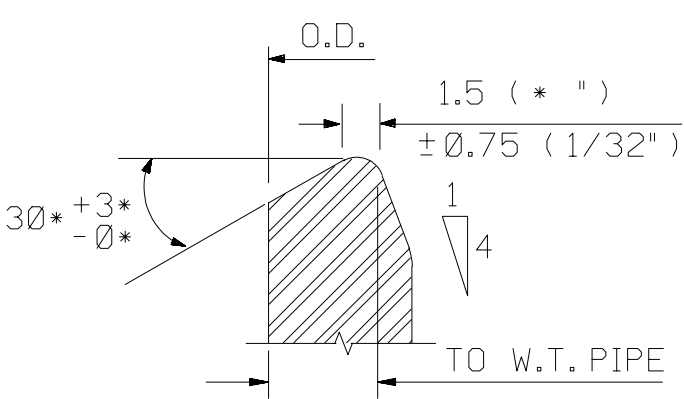


90	100	AC-036443	7	066
PLANT NO.	INDEX	DRAWING NUMBER	SHT. NO.	REV. NO.



NOTES:

- DIMENSIONAL TOLERANCES NOT SHOWN, MARKING, FINISHES AND SPOT FACING SHALL CONFORM TO ANSI B16.5 LATEST EDITION, EXCEPT TOLERANCE ON WALL AND LAP THICKNESS OF STUB END TO BE + 1.5MM (* "), -Ø.
- DRILLING DIMENSIONS FOR SIZES LARGER THAN 36" ARE EXTRAPOLATED FROM MSS-SP-44 AND DO NOT CORRESPOND WITH MSS-SP-44-1982; GROOVE AND RING DIMENSIONS ARE TAKEN FROM TAYLOR FORGE.
- MATERIALS:
WELDING ENDS SHALL BE F52 IN ACCORDANCE WITH Ø2-SAMSS-Ø11.
BACKING FLANGES SHALL BE ASTM A694 F52.
- GROOVE RADIUS "R" IS 1.5 (* ").
- RADIUS AT STUB END "R1"=13MM (* "), RADIUS AT LOOSE FLANGE "R2"=13MM (* ").
- TAPER TO MATCH PIPE BORE TO BE IN ACCORDANCE WITH ANSI B 31.4.
- BOLT HOLE DIAMETER=BOLT DIAMETER +3MM (* ").
- BOLT LENGTHS SHOWN ARE FOR CONNECTION TO WELDING NECK FLANGES PER DRAWING AC-Ø36442.
- MARKINGS IN ACCORDANCE WITH Ø2-SAMSS-Ø11 (NPS IN INCHES).

REVISION NOTE - 1 :

CONSOLIDATED SHEET NOS.1 & 2 INTO SHEET NO.1
COMPLETELY REDRAWN AND REVISED.CHANGE DRAWING SIZE
FROM E TO C.

NOM. PIPE SIZE IN.	A		B		C		D		E		F		G		H		J		K		L		M		N		P		S		T		BORE STUB END		NO.OF BOLT HOLES	STUD BOLT SIZE				APPROX. MASS	
	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.	IN.		MM.	IN.	MM.	IN.	MM.	IN.
26	1015	40	914	36	810	31*	706	27-13/16	770	30*	19	*	12.3	.485	24	15/16	20	25/32	13	*	225	8*	50	1-15/16	355	14	750	29*	667	26*	115	4*	587	23*	28	47	1*	405	16	700	1540
28	1075	42*	965	38	860	33*	760	29-15/16	824	32*	19	*	12.3	.485	24	15/16	20	25/32	13	*	235	9*	50	2	355	14	800	31*	718	28*	120	4*	635	25	28	51	2	420	16*	794	1750
30	1130	44*	1022	40*	920	36*	814	32*	878	34*	19	*	12.3	.485	24	15/16	20	25/32	13	*	250	9*	54	2*	380	15	857	33*	768	30*	125	4*	680	26*	28	51	2	430	17	920	2030
32	1195	47	1080	42*	985	38*	865	34*	940	37*	22	*	14.8	.583	27	1*	23	29/32	14	*	260	10*	60	2*	380	15	915	36	820	32*	127	5	725	28*	28	57	2*	460	18	1066	2350
34	1245	49	1130	44*	1035	40*	922	36*	990	39	22	*	14.8	.583	27	1*	23	29/32	14	*	270	10*	60	2*	405	16	965	38	870	34*	135	5*	772	30*	28	57	2*	470	18*	1197	2640
36	1315	51*	1194	47	1090	43	976	38*	1048	41*	22	*	14.8	.583	27	1*	23	29/32	14	*	285	11*	64	2*	405	16	1022	40*	920	36*	147	5*	815	32*	28	63.5	2*	500	19*	1397	3080
38	1370	54	1251	49*	1100	43*	1030	40*	1105	43*	19	*	12.3	.485	24	15/16	20	25/32	13	*	300	11*	64	2*	430	17	1030	40*	972	38*	153	6	865	34	28	63.5	2*	515	20*	1542	3400
40	1420	56	1295	51	1135	44*	1083	42*	1137	44*	19	*	12.3	.485	24	15/16	20	25/32	13	*	315	12*	66	2*	430	17	1067	42	1022	40*	180	7*	910	35*	28	69.9	2*	560	22	1715	3780
42	1490	58*	1365	53*	1185	46*	1137	44*	1202	47*	19	*	12.3	.485	24	15/16	20	25/32	13	*	325	12*	67	2*	455	18	1118	44	1073	42*	185	7*	960	37*	28	69.9	2*	570	22*	1964	4330
44	1560	61*	1422	56	1265	49*	1190	46*	1250	49*	19	*	12.3	.485	24	15/16	20	25/32	13	*	345	13*	70	2-11/16	485	19	1195	47	1125	44*	197	7*	1005	39*	28	76	3	600	23*	2277	5020
46	1620	63*	1480	58*	1300	51*	1240	48*	1305	51*	19	*	12.3	.485	24	15/16	20	25/32	13	*	355	14	70	2*	485	19	1232	48*	1175	46*	200	7*	1055	41*	28	76	3	610	24	2404	5300
48	1665	65*	1537	60*	1355	53*	1295	51	1362	53*	19	*	12.3	.485	24	15/16	20	25/32	13	*	360	14*	72	2-13/16	485	19	1283	50*	1225	48*	205	8	1102	43*	28	76	3	620	24*	2595	5720

MANDATORY DRAWING

06	06-11-97	ESSD MAQ		DRAWING REVISED AS PER MARK-UP			
05	03-20-94	ESSD CAC		REVISED NOTES 3 AND 9.			
04	04-21-90	RLO		REVISED NOTES AND ADDED NOTE 9.	ORIGINAL SIGNED	ORIGINAL SIGNED	ORIGINAL SIGNED
03	07-05-88	RLO		SEE REVISION NOTE 1.	ORIGINAL SIGNED	ORIGINAL SIGNED	ORIGINAL SIGNED
REV. NO.	DATE	BY	JO/EWO	DESCRIPTION	CHKD.	CERT.	APPD.

SAUDI ARABIAN OIL COMPANY

DRAWN BY	H.D.	CHECKED BY		SCALE	NONE
DATE STARTED		DATE COMPLETED		09-06-74	
OPR'G. DEPT.		ENG. DEPT.		ORIGINAL SIGNED	
APP'D FOR CONSTR.				09-12-74	
THIS DRAWING IS NOT TO BE USED FOR CONSTRUCTION OR FOR ORDERING MATERIAL UNTIL CERTIFIED AND DATED				CERTIFIED BY	DATE

LAP JOINT FLANGES AND STUB ENDS

LARGE SIZE

CLASS 600 RING JOINT

STD. DWG.

PLANT NO.	INDEX	DRAWING NUMBER	SHT. NO.	REV. NO.
990	L	AC-036443	001	06