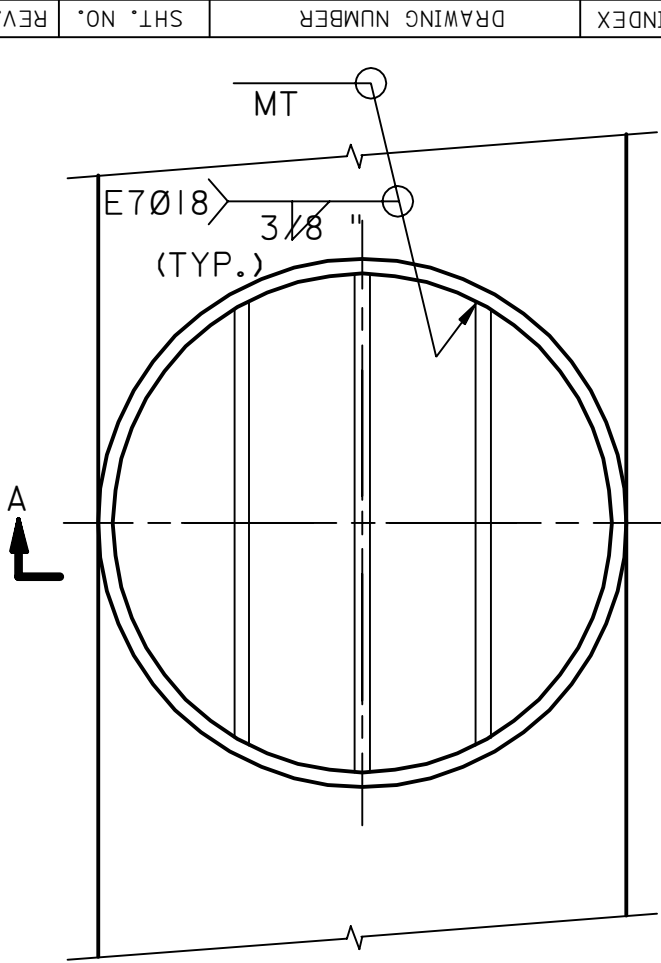
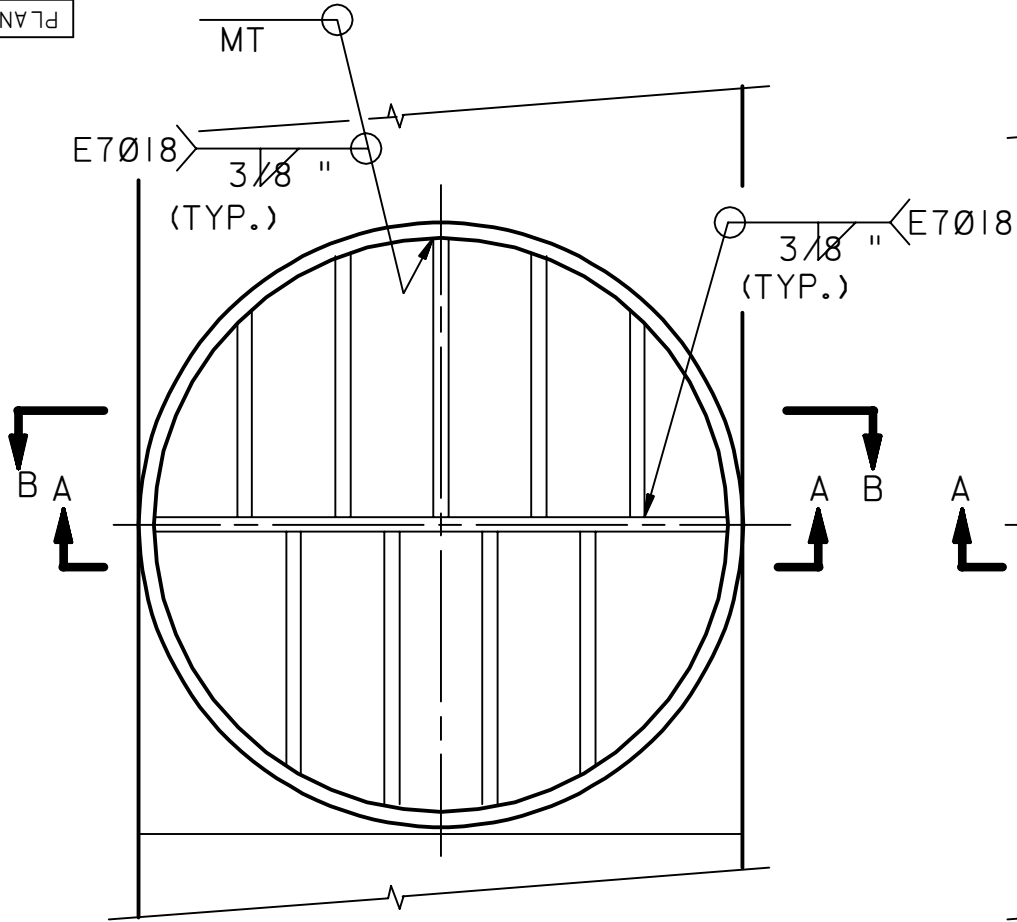


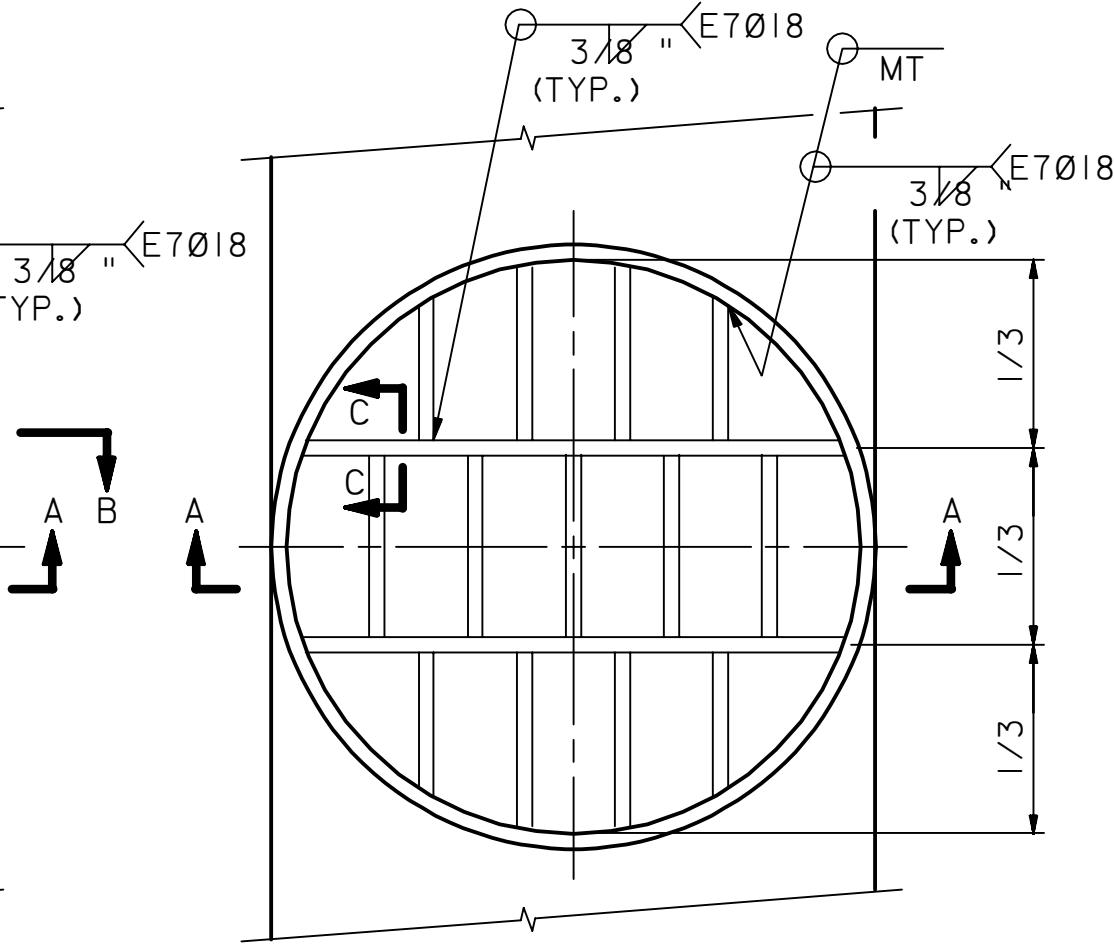
Ø 3	Ø 1	AC-Ø36548	L	990
REV. NO.	SHT. NO.	DRAWING NUMBER	INDEX	PLANT NO.



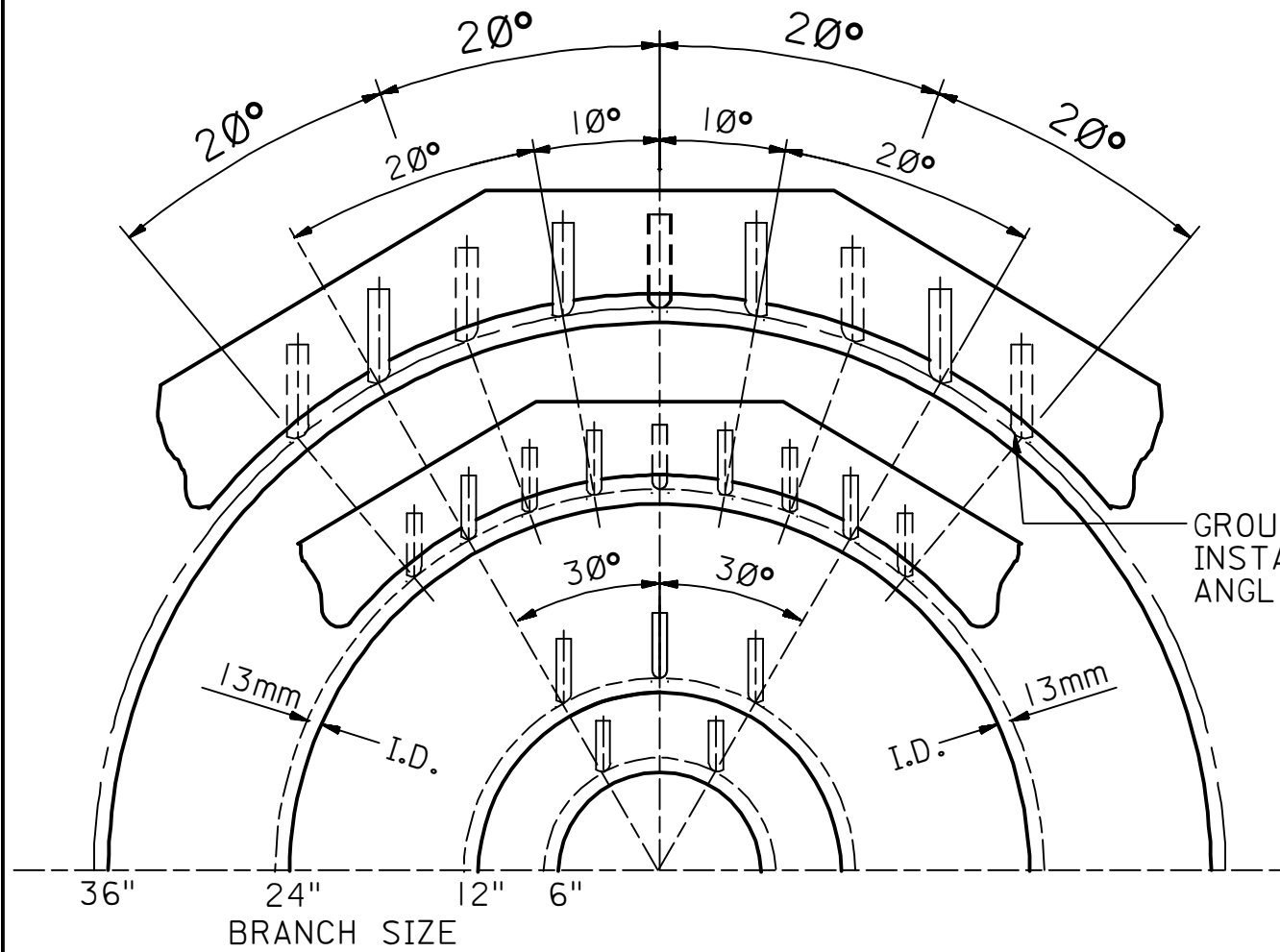
BRANCH SIZE 6" TO 12"



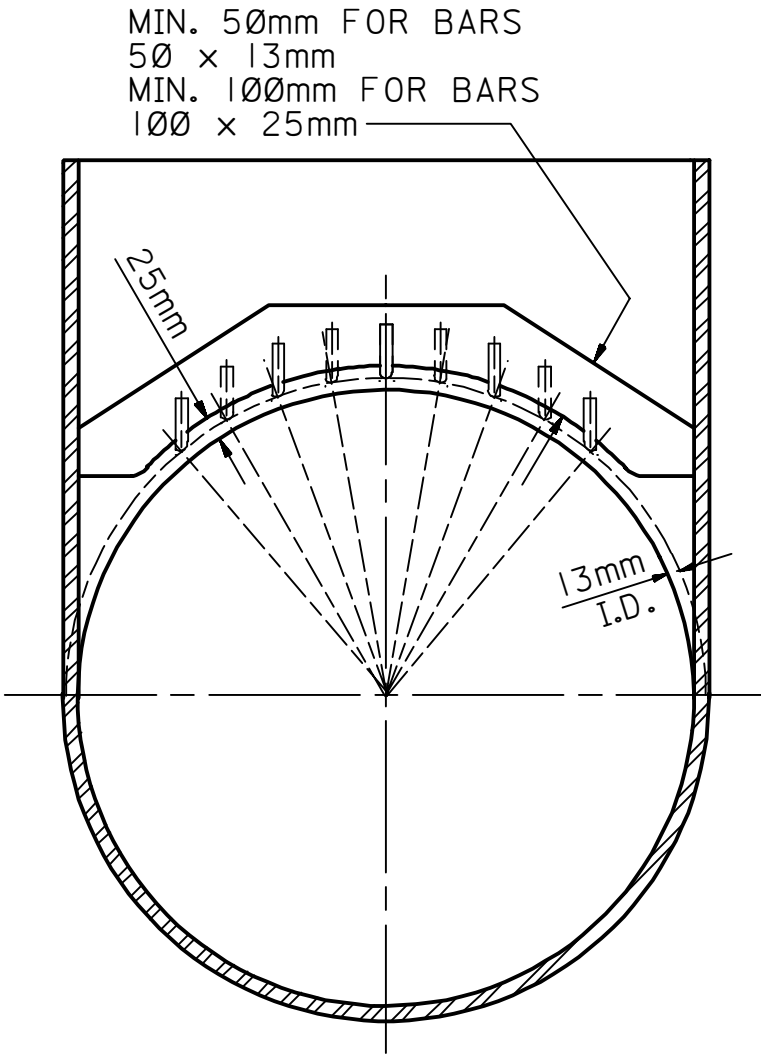
BRANCH SIZE 14" TO 30"



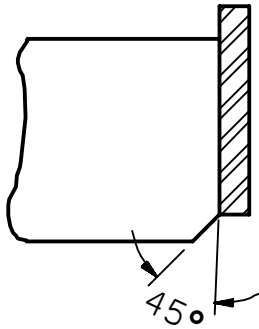
BRANCH SIZE 32" AND LARGER



SECTION A-A
TYPICAL LOCATION OF GUIDE BARS



SECTION B-B
TYPICAL FOR 14" SIZE
BRANCHES AND LARGER



SECTION C-C

- NOTES:**
1. BARS-ASTM A36 FLAT BAR, TRIM TO MATCH CONTOUR OF TEE OR FABRICATED BRANCH, GRIND ROUGH EDGES SMOOTH, IMPROPERLY INSTALLED BARS WILL CAUSE UNNECESSARY DAMAGE TO SCRAPER.
 2. STIFFENING PLATES-ASTM A36 PLATE, 13mm THICK FOR SIZES UP TO 30" AND 25mm THICK FOR SIZES 32" AND LARGER. TRIM TO MATCH CONTOUR OF TEE OR FABRICATED BRANCH, GRIND ROUGH EDGES SMOOTH.
 3. MT SHALL BE IN ACCORDANCE WITH ASME SECTION VIII, DIVISION 1, APPENDIX 6.

MATERIAL LIST		
NOMINAL BRANCH SIZE	NUMBERS OF BARS	BAR SIZE
4" TO 8"	2	50 x 13mm
10" TO 12"	3	50 x 13mm
14" TO 30"	5/4	50 x 13mm
32" AND LARGER	4/5/4	100 x 25mm

TYPICAL INSTALLATION DRAWING

REV. NO.	DATE	BY	JO/EWO	DESCRIPTION	CHKD.	CERT.	APPD.
Ø3	02-28-98		HRD	ADDED NOTE 3			
Ø2	06-20-89		RLO	ADDED WELDING SYMBOLS AND NOTES 3-5. DELETED WELD DETAIL.			
Ø1	09-13-88		RLO	REDRAWN, ADDED TYPICAL INSTALLATION NOTE AND DELETED INDEX A.			

SAUDI ARABIAN OIL COMPANY

DRAWN BY A.R. CHECKED BY _____ SCALE NONE

DATE STARTED _____ DATE COMPLETED _____

OPR'G. DEPT. _____ ENG. DEPT. E.Z. (12/83)

APP'D FOR CONSTR. _____

THIS DRAWING IS NOT TO BE USED FOR CONSTRUCTION OR FOR ORDERING MATERIAL UNTIL CERTIFIED AND DATED

CERTIFIED BY JAB DATE 12/20/83

GUIDE BAR DETAILS FOR TEES AND BRANCHES IN PIPELINES WITH SCRAPING FACILITIES				
STD. DWG.	METRIC			
PLANT NO.	INDEX	DRAWING NUMBER	SHT. NO.	REV. NO.
990	L	AC-Ø36548	ØØ1	Ø3