



"Providing Quality Rubber Goods and Services Since 1958"

1602 Birchwood Avenue • Fort Wayne, Indiana 46803-2797 • Phone 260-424-2900 • FAX 260-422-7147

METAL FABRICATION REQUIREMENTS FOR RUBBER LINING

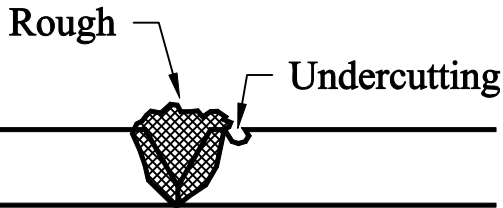
1. All metal fabrications intended for rubber or synthetic rubber lining will be continuously welded on all seams in areas to be lined with full, smooth, continuous weld beads free from sharp edges, porosity, pinholes, undercutting, slag pockets and other imperfections. Rough welds must be ground smooth, but not necessarily flush. All protrusions, sharp edges, and weld spatter must be removed by grinding.
2. All seams are to be butt-welded with full penetration. Corners are to be fillet welded. Misalignment of plates and seams must not exceed 25% of the plate thickness, and in no case, may exceed $\frac{1}{8}$ ". Lap welded construction is never acceptable.
3. Partitions, braces, supports, or other attachments to be rubber lined will be continuously welded on all sides. For vacuum service, see item 5 below for welding and fitting requirements.
4. Nozzles and manholes must be fully seal welded on the inside surface. Nozzles and manholes must not protrude on the interior of any vessel. (See item D on sheet 2).
5. If any vessel is to be used in vacuum service, the fabricator must eliminate all undercutting, voids or pits in welds and steel.
6. All closed vessels must have at least one access manhole of not less than 20" diameter.
7. Voids in porous cast metal must be welded and ground smooth. Sharp projections, basting fins, or burrs on the casting must be completely removed. Surfacing cements for porous metal or rough castings are not permitted. Cast Iron should not be used for vacuum service.
8. All internal corners to be rubber lined must have a minimum radius of $\frac{1}{4}$ ". All external corners to be rubber lined must be ground to a $\frac{1}{8}$ " minimum radius.
9. The condition of the interior must meet or exceed the above requirements and be acceptable to Protective Coatings, Inc. Examples of acceptable and unacceptable workmanship are shown on sheet 2 of this specification.

REVISIONS

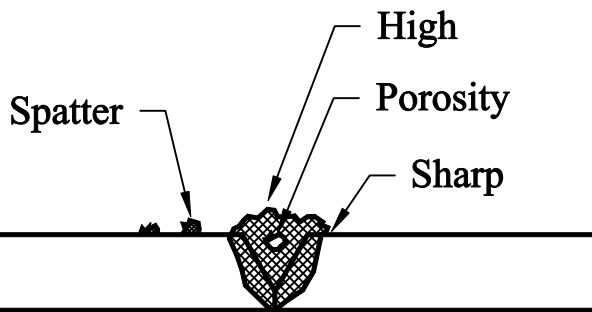
ZONE	REV	DESCRIPTION	DATE	APPROVED

Unacceptable Workmanship

A

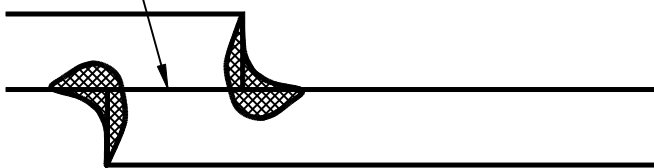


B



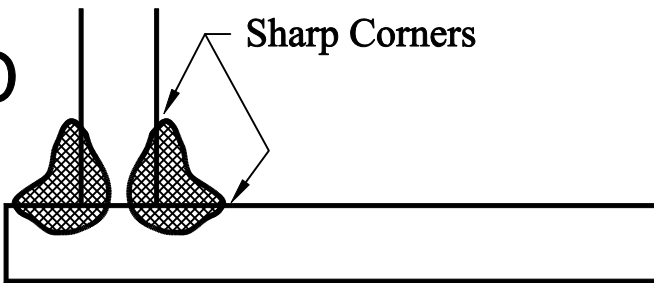
C

Lap Construction
(Never Acceptable)



D

Sharp Corners



Acceptable Workmanship

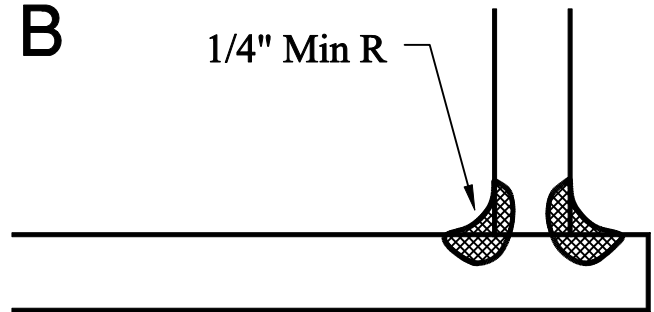
A

Smooth Blended Profile



B

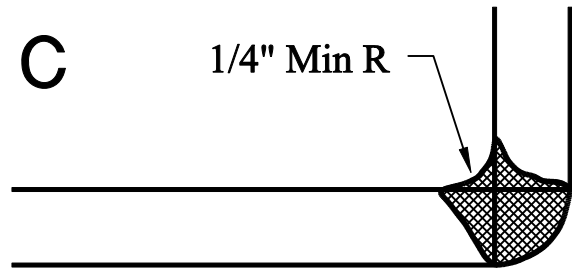
1/4" Min R



Typical Joints of Flat Bottom to Tank Shell

C

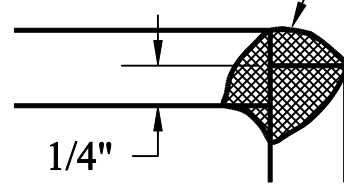
1/4" Min R



Nozzle to Tank Shell

D

1/8" Min R



TOLERANCES
(Unless Specified
Otherwise)

FRACTIONAL	± 1/32
ANGULAR	± 1/2°
ONE PLACE DECIMAL	± 0.06
TWO PLACE DECIMAL	± 0.03
THREE PLACE DECIMAL	± 0.003



Protective Coatings, Inc.
1602 Birchwood Ave.
Fort Wayne, IN 46803

SCALE	DRAWN BY: D. Dieringer	DATE: 07-22-96	USED ON: ALL METAL FABRICATIONS
	CHECKED BY:	DATE:	

TITLE
Metal Fab Requirements

CAD DWG NUMBER	TF - MR	SHEET	2	OF	2	REV.	-
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