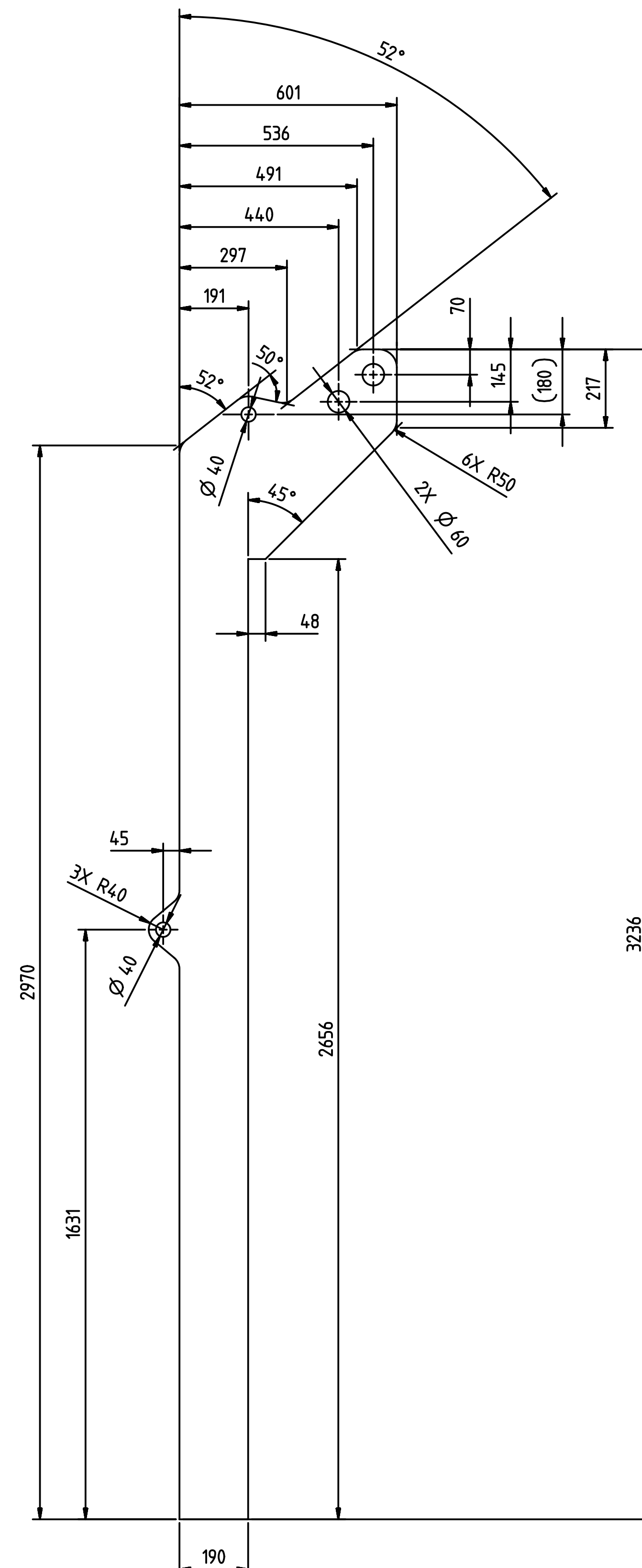
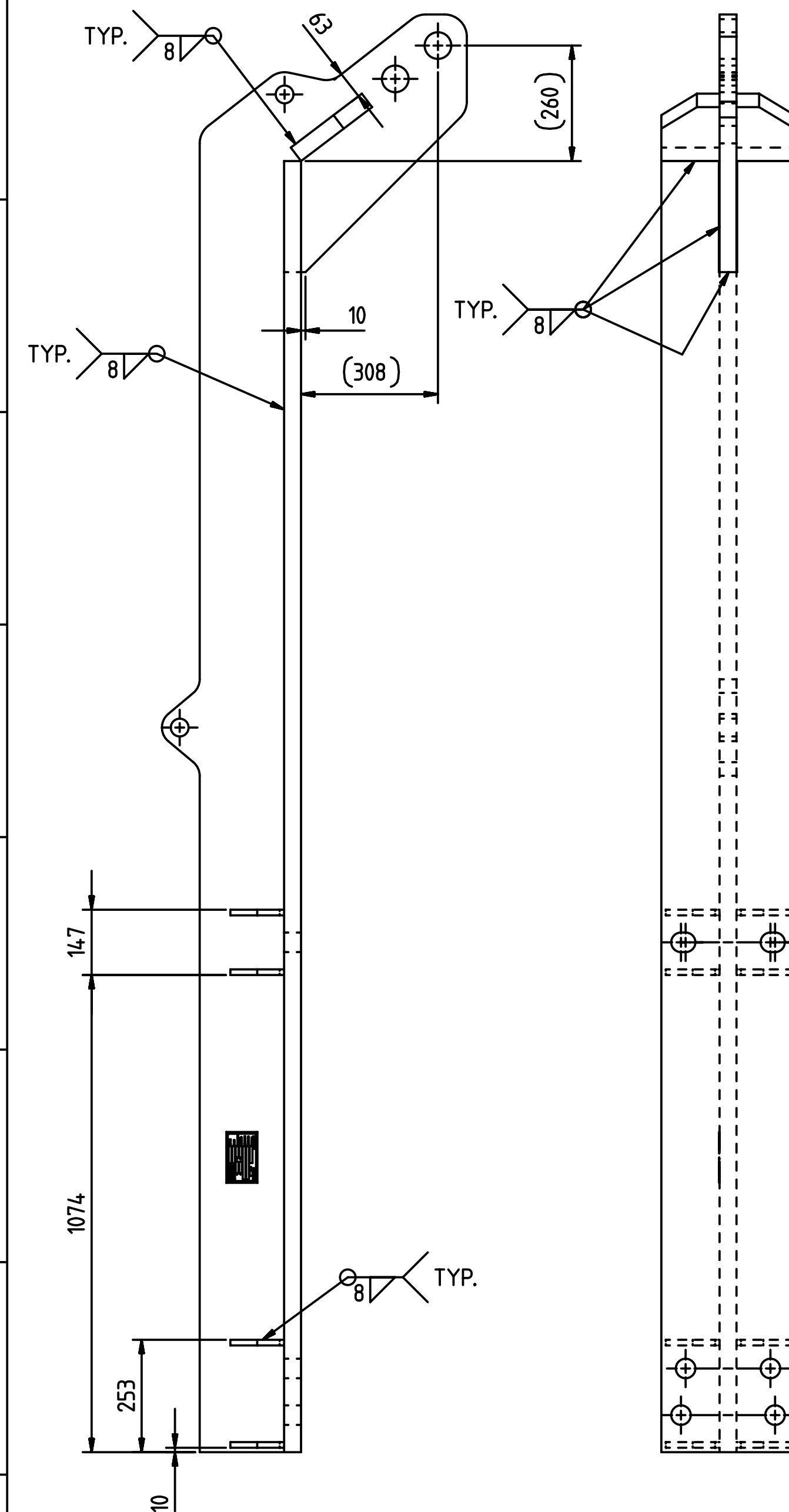


13		14		15		16	
ITEM	QTY.	DESCRIPTION			MASS	PART No.	
1	1	3236	X 686	X 38	HR PL	664	WPL1.50X96X120
2	1	2906	X 300	X 38	HR PL	261	WPL1.50X96X120
3	2	201	X 131	X 38	HR PL	16	WPL1.50X96X120
4	8	121	X 121	X 13	HR PL	12	WPL50
5	1	ASSEMBLY TOOL INFO TAG				-	NPL701725C22

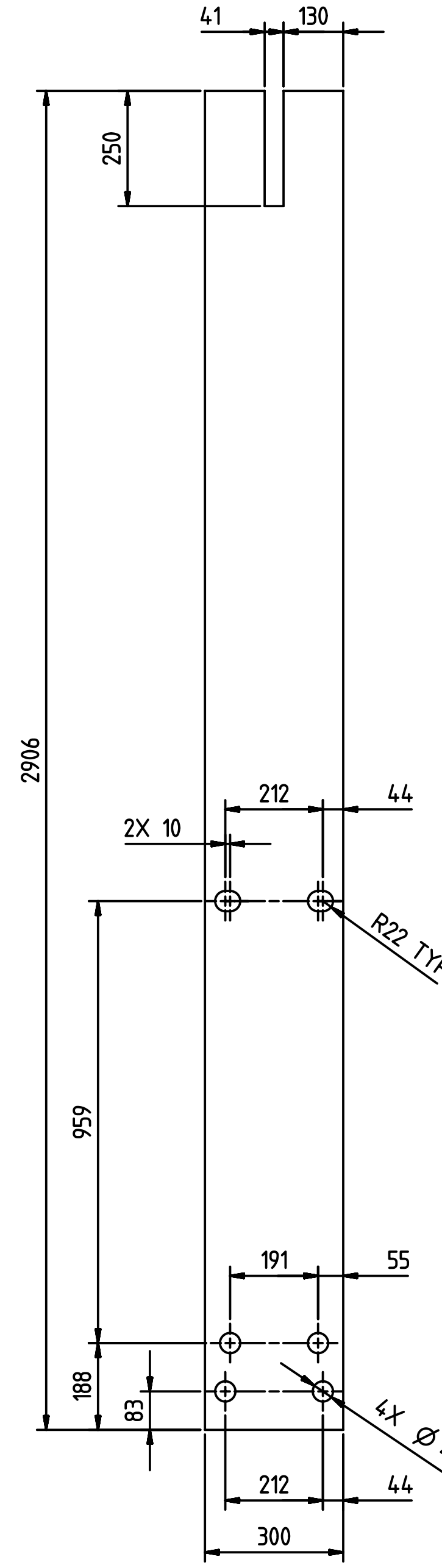
MATERIAL: WARMAN CODE E02 UNLESS OTHERWISE SPECIFIED.
ESTIMATED MASS: 494 kg.
ENCUMBRANCE: 3236 X 686 X 300

NOTES:

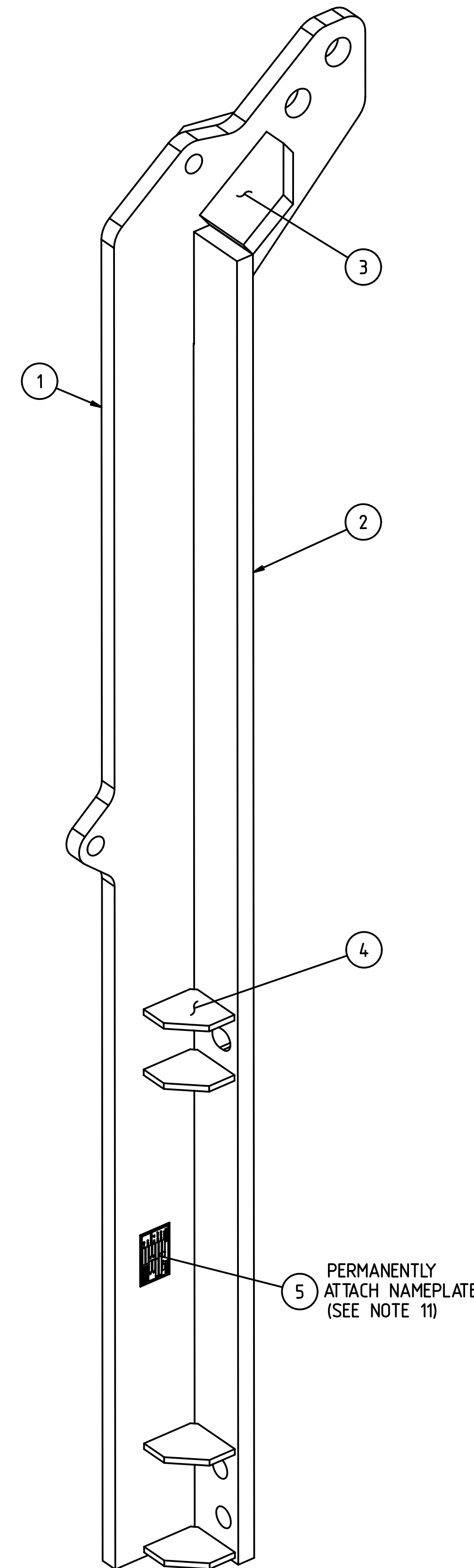
- 1.) ALL STEEL TO BE ASTM A36 EXCEPT AS NOTED.
- 2.) WELDING MUST CONFORM TO CYCLICALLY (DYNAMICALLY) LOADED STRUCTURES OF THE AWS D1.1/D1.1M CODE.
- 3.) ONLY QUALIFIED OR PREQUALIFIED WELDING PROCEDURE SPECIFICATIONS (WPS) MAY BE USED IN WELDING.
- 4.) WELDERS MUST BE CERTIFIED FOR THE PROCESS AND POSITION BEING USED.
- 5.) THE INSPECTIONS/TESTING AGENCY SHALL MEET AND FOLLOW THE REQUIREMENTS OF AWS QC1 STANDARD FOR AWS CERTIFICATION OF WELDING INSPECTORS.
- 6.) ALL WELDMENTS MUST BE VISUALLY INSPECTED BY A C.W.I., ASNT-TC-1A LEVEL 2 MINIMUM OR WEIR APPROVED EQUIVALENT
- 7.) SURFACE PREPARATION AND PAINTING PROCEDURE SHOULD BE IN ACCORDANCE WITH APPLICABLE SECTIONS OF THE STRUCTURAL STEEL PAINT COUNCIL SPECIFICATIONS.
- 8.) STAMP WORK ORDER NO. OR SERIAL NO. USING 8 [31] HIGH NUMERALS.
- 9.) REMOVE ALL BURRS AND SHARP EDGES, WELD SLAG AND SPATTER TO BE REMOVED, ALL WELDS AND ADJACENT BASE MATERIAL TO BE BRUSHED CLEAN.
- 10.) QA DOCUMENTATION REQUIREMENTS
SERIAL NUMBER AND DATE OF MANUFACTURE
VISUAL AND MPI INSPECTION REPORTS
MATERIAL CERTIFICATIONS (AS REQUIRED)
DIMENSIONAL REPORT (AS REQUIRED)
- 11.) STAMP ITEM NPL701725C22 USING MINIMUM 4mm HIGH CHARACTERS AS FOLLOWS:
TOOL PART #: UMC55309E02
REV: 2
USED ON PART: UMCR55190 & UMC55083
UMCR55190 & UMCR55083
301089 & 301081
UMCU65013 & UMC65083
UMCR65190 & UMC65083
USED ON PUMP: 550 / 650 MCR/MCU
TOOL WEIGHT: 494 kg.
RATED LOAD CAP: 6450 kg.
SERIAL #: WO*****
MFG DATE: MO/YEAR



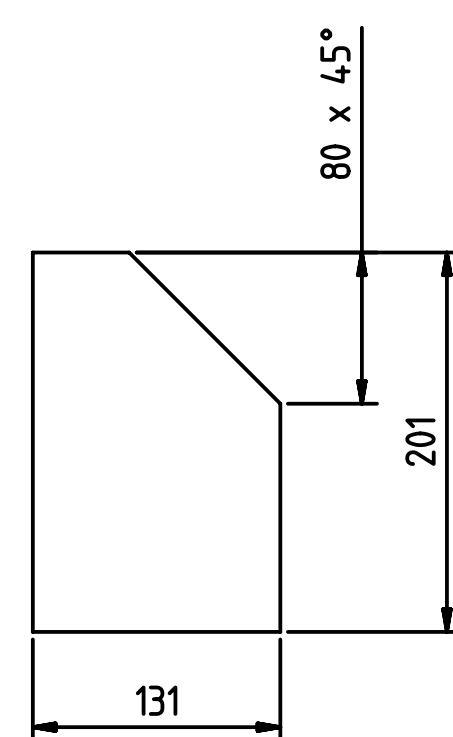
DETAIL ITEM 1



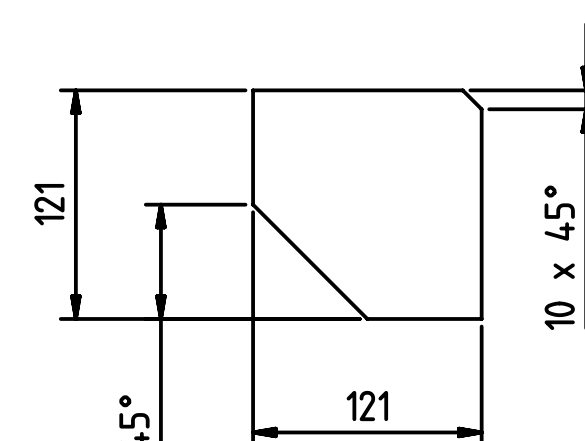
DETAIL ITEM 2







PERMANENTLY
ATTACH NAMEPLATE
(SEE NOTE 11)



DETAIL ITEM 3
SCALE 1:4



DETAIL ITEM 4
SCALE 1:4

UNLESS OTHERWISE SPECIFIED: (FABRICATION)		UNLESS OTHERWISE SPECIFIED: (MACHINING)		WEIGHT IN KG		ALL DIMENSIONS IN MM		PRODUCT	
TOLERANCE ON FABRICATION DIMENSIONS	{ LESS THAN 1219 ± 3 1219 TO 3048 ± 6 OVER 3048 ± 9.5	TOLERANCE ON MACHINING DIMENSIONS { 0.1X ± 1500 0.2X ± 0.750 0.3XX ± 0.250 0.5XXX ± 0.125 ANGULAR ± 1°	ALL CONCENTRIC CIRCLES:  0.25 T.J.R.		BREAK OR DEBURR ALL SHARP EDGES INTERNAL CORNERS 0.000 10/813 R.		OFFICE OF ORIGIN : MADISON		WARMAN® Centrifugal Slurry Pumps
			ALL PERPENDICULAR SURFACES:  0.05 / 25mm		MACHINED SURFACES 				
						Copyright © Weir Slurry Group, Inc. 2016. Weir Slurry Group, Inc. (the "Company") is the owner of the copyright and all confidential information in this drawing.		TITLE	
				SCALE: 1:10		APP: RB		SUCTION COVER LIFTING BEAM	
2 COMPLETE BEAM REDESIGN		09APR2015 DR120364MAD		TME ARW		CHK: MJV		FABRICATION DETAILS	
1 ITEM 6 WAS LIFTING EYE, ITEM 6 DESIGNED INTO ITEMS 1 AND 2, ADDED ITEM 9, ITEMS 4 AND 5 WERE FORMED NOW 3 PIECES, ADDED DETAIL ITEM 2, UPDATED WELD SYMBOLS		15OCT2008 DR106539MAD		JKS KDS		DRN: JVLN		'UMCS5309E02*	
REV	DESCRIPTION	DATE	REF NO	BY	CHK	DATE:	06FEB2007	SHEET 1 OF 1	SHEET SIZE DRAWING No
									A1 A384-903
									REVISION
									2