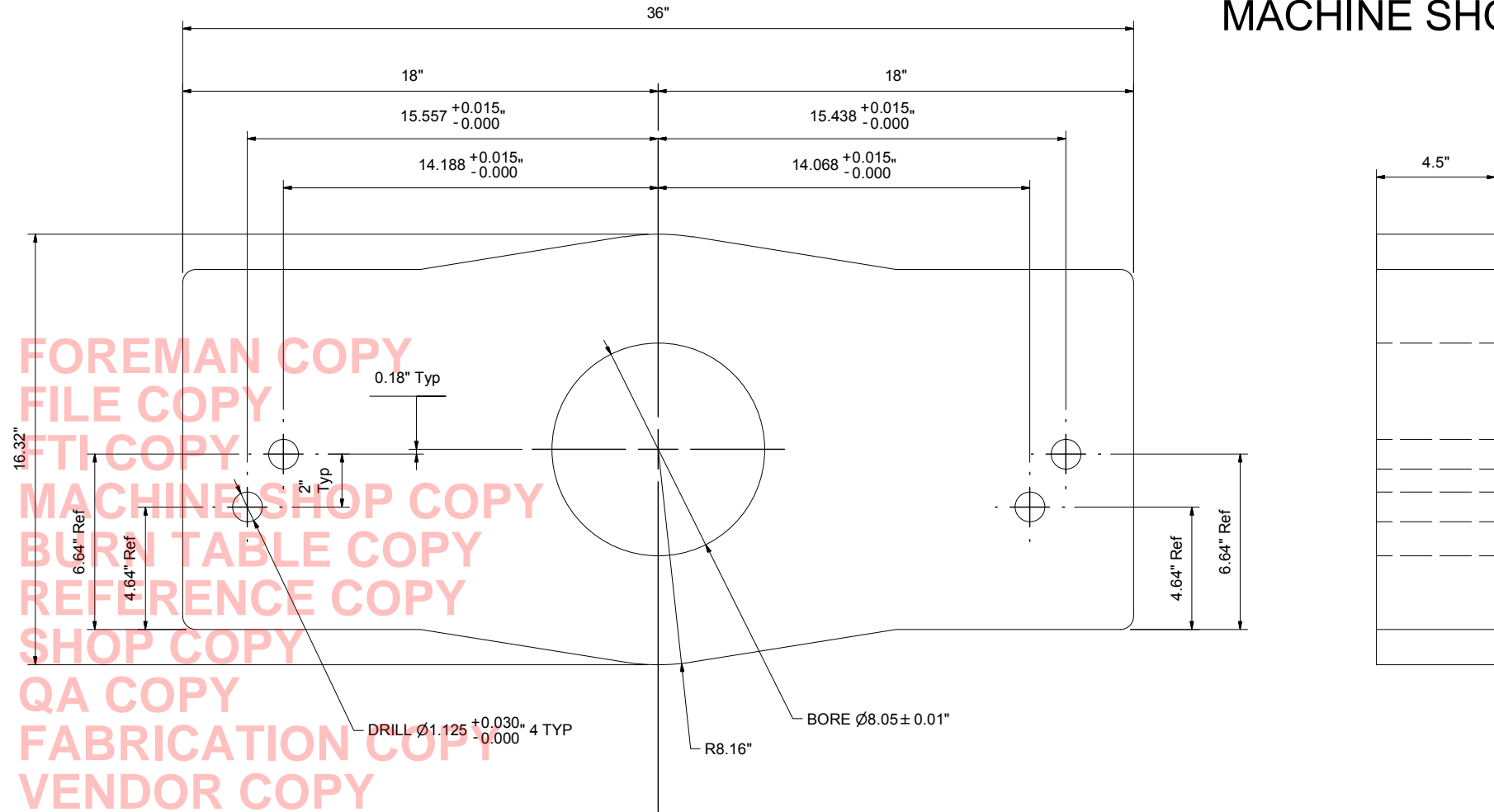


Machine Shop Copy
This is the machine shop

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p1	100-02861	PL 50W - 4 1/2"	1'-4 5/16"	3'-0"	1	590.04

DXF FILE #15520101
MACHINE SHOP



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BY
DATE 2014-12-21
(DESTROY PREVIOUS REVISION)

TOLERANCES AS PER QMF-03

WO# 15520
CONTROLLED DOCUMENT

CUSTOMER REFERENCE

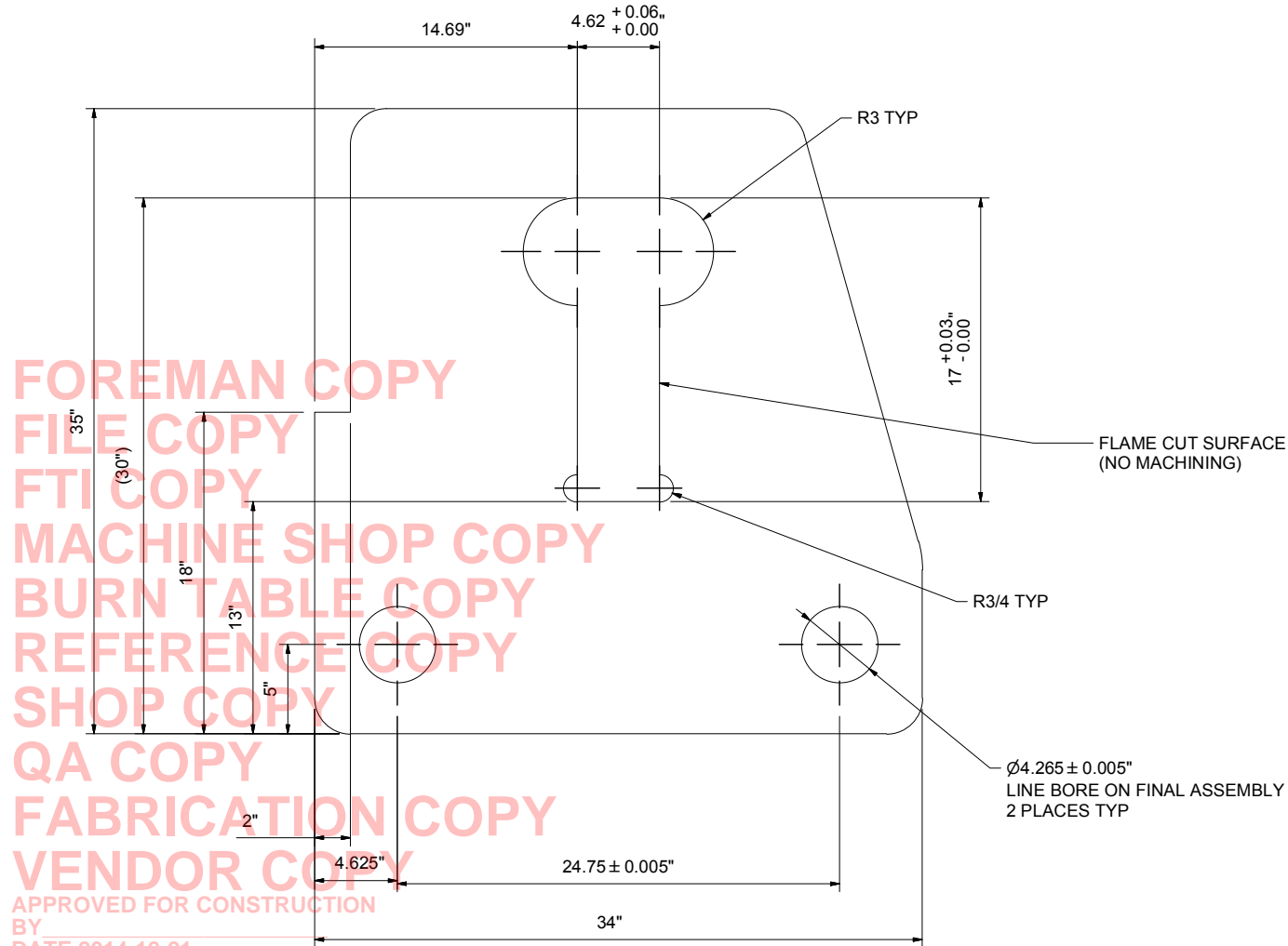
Ja-Co
Welding & Consulting Ltd.
1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433
email: ja-co@telusplanet.net website: jacoweld.com

CUSTOMER	Ja-Co	DRAWN	bmurphy	DATE
PROJECT	BECKET HOLDER	CHECKED		DATE
TITLE	Becket Holder	APPROVED		DATE
W.O. #	15520	SCALE	N.T.S.	DRAWING # / SHEET # eqt-1269-A-002 / 7 of 19
				0

IF IN DOUBT.....ASK!

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p2	100-01543	PL QT100 2 1/2"	2'-10"	2'-11"	2	659.00

DXF FILE #15520102
MACHINE SHOP



TOLERANCES AS PER QMF-03

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CUSTOMER REFERENCE

Ja-Co
Welding & Consulting Ltd.
1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433
email: ja-co@telusplanet.net website: jacoweld.com

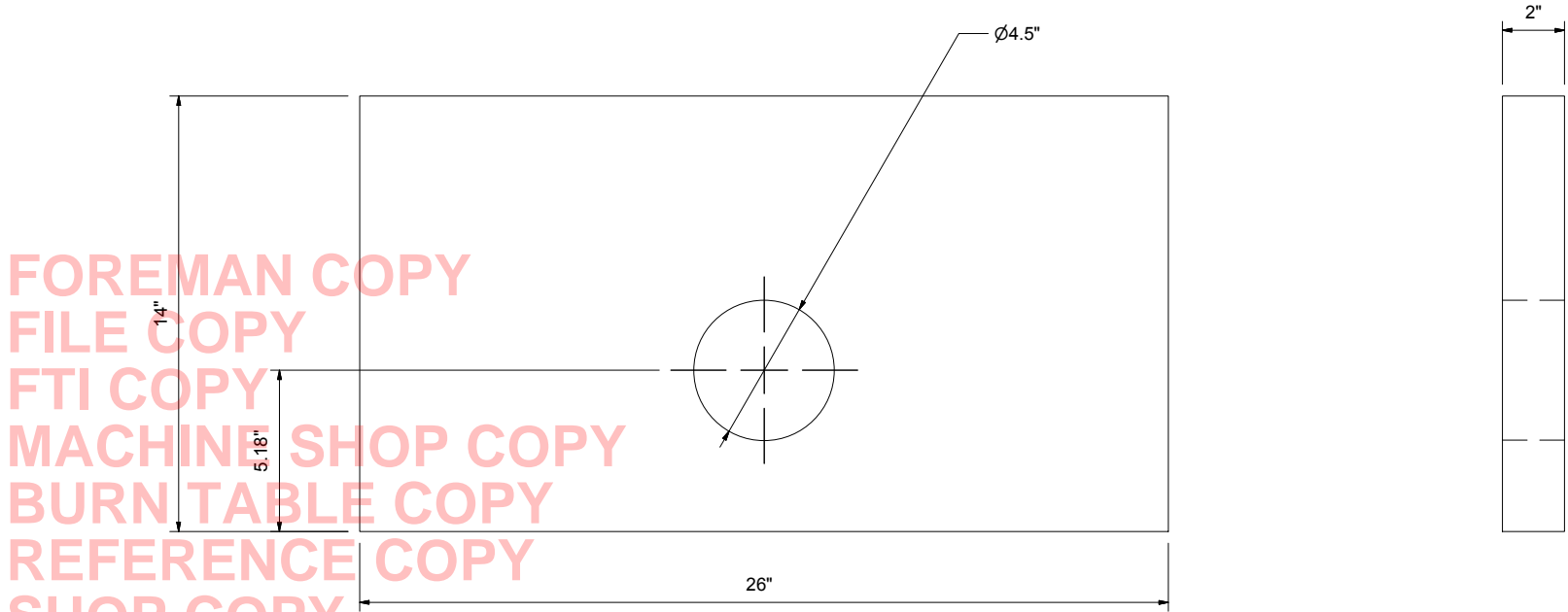
CUSTOMER	Ja-Co	DRAWN	bmurphy	DATE
PROJECT	BECKET HOLDER	CHECKED		DATE
TITLE	Becket Holder	APPROVED		DATE
W.O. #	15520	SCALE	N.T.S.	DRAWING # / SHEET # eqt-1269-A-002 8 of 19
				0

IF IN DOUBT.....ASK!

ALL SURFACES
FLAME CUT
(NO MACHINING)

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p3	100-02316	PL 50W - 2"	1'-2"	2'-2"	1	197.69

DXF FILE #15520103



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BY
DATE 2014-12-21
(DESTROY PREVIOUS REVISION)

TOLERANCES AS PER QMF-03
CONTROLLED DOCUMENT

CUSTOMER
REFERENCE

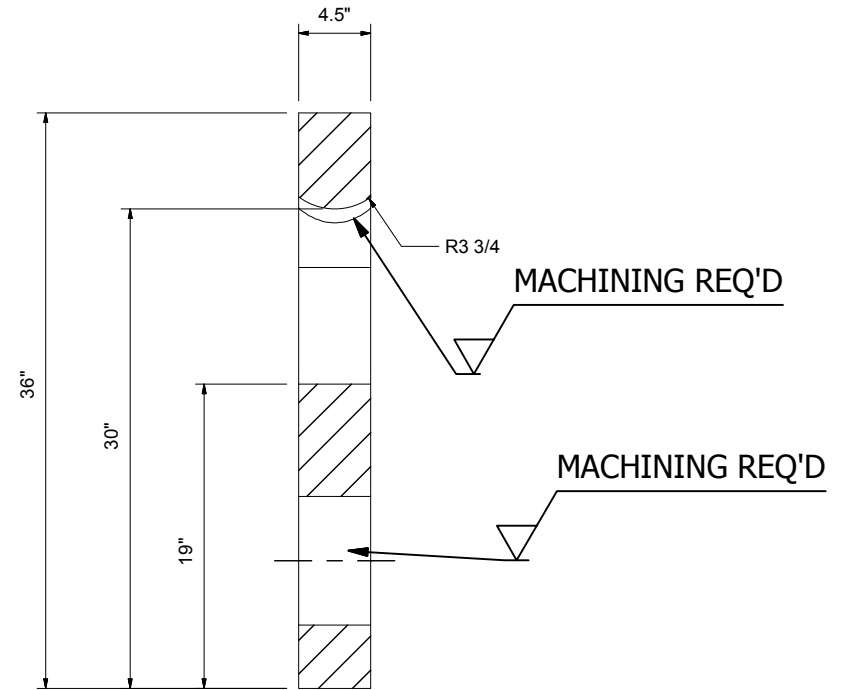
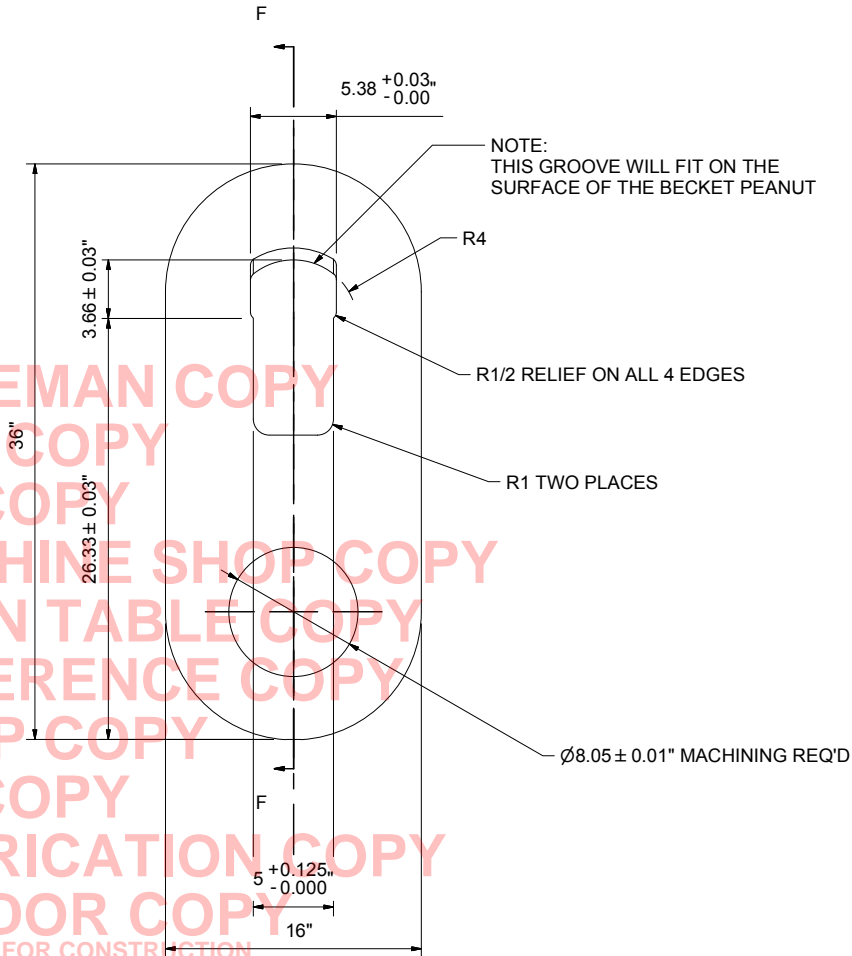
Ja-Co
Welding & Consulting Ltd.
1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433
email: ja-co@telusplanet.net website: jacoweld.com

CUSTOMER Ja-Co	DRAWN bmurphy	DATE
PROJECT BECKET HOLDER	CHECKED	DATE
TITLE Becket Holder	APPROVED	DATE
W.O. # 15520	SCALE N.T.S.	DRAWING # / SHEET # eqt-1269-A-002 9 of 19

IF IN DOUBT.....ASK!

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p4	100-02861	PL 50W - 4 1/2"	1'-4"	2'-10"	1	528.72

DXF FILE #15520104 MACHINE SHOP



SECTION F-F
SCALE 1:12

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FTI COPY
MACHINE SHOP COPY
BURN TABLE COPY
REFERENCE COPY
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DATE 2014-12-21
(DESTROY PREVIOUS REVISION)

TOLERANCES AS PER QMF-03

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email: ja-co@telusplanet.net website: jacoweld.com

CUSTOMER	Ja-Co	DRAWN	bmurphy	DATE
PROJECT	BECKET HOLDER	CHECKED		DATE
TITLE	Becket Holder	APPROVED		DATE
W.O. #	15520	SCALE	N.T.S.	DRAWING # / SHEET # eqt-1269-A-002 10 of 19
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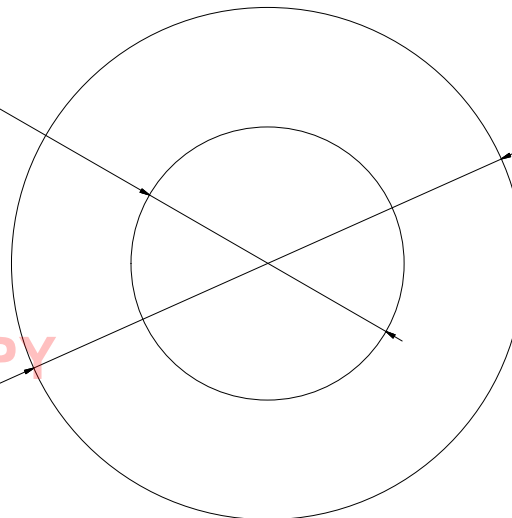
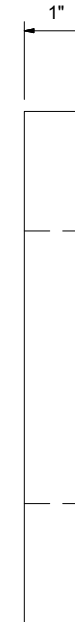
IF IN DOUBT.....ASK!

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p5	100-02313	PL 50W - 1"	8"	8"	2	10.23

DXF FILE #15520105

MACHINE SHOP

Ø4.26±0.005" LINE BORED AS PART
OF FINAL ASSEMBLY



Ø8±0.01"

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MACHINE SHOP COPY
BURN TABLE COPY
REFERENCE COPY
SHOP COPY
QA COPY
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VENDOR COPY

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DATE 2014-12-21
(DESTROY PREVIOUS REVISION
WO# 15458)

TOLERANCES AS PER QMF-03

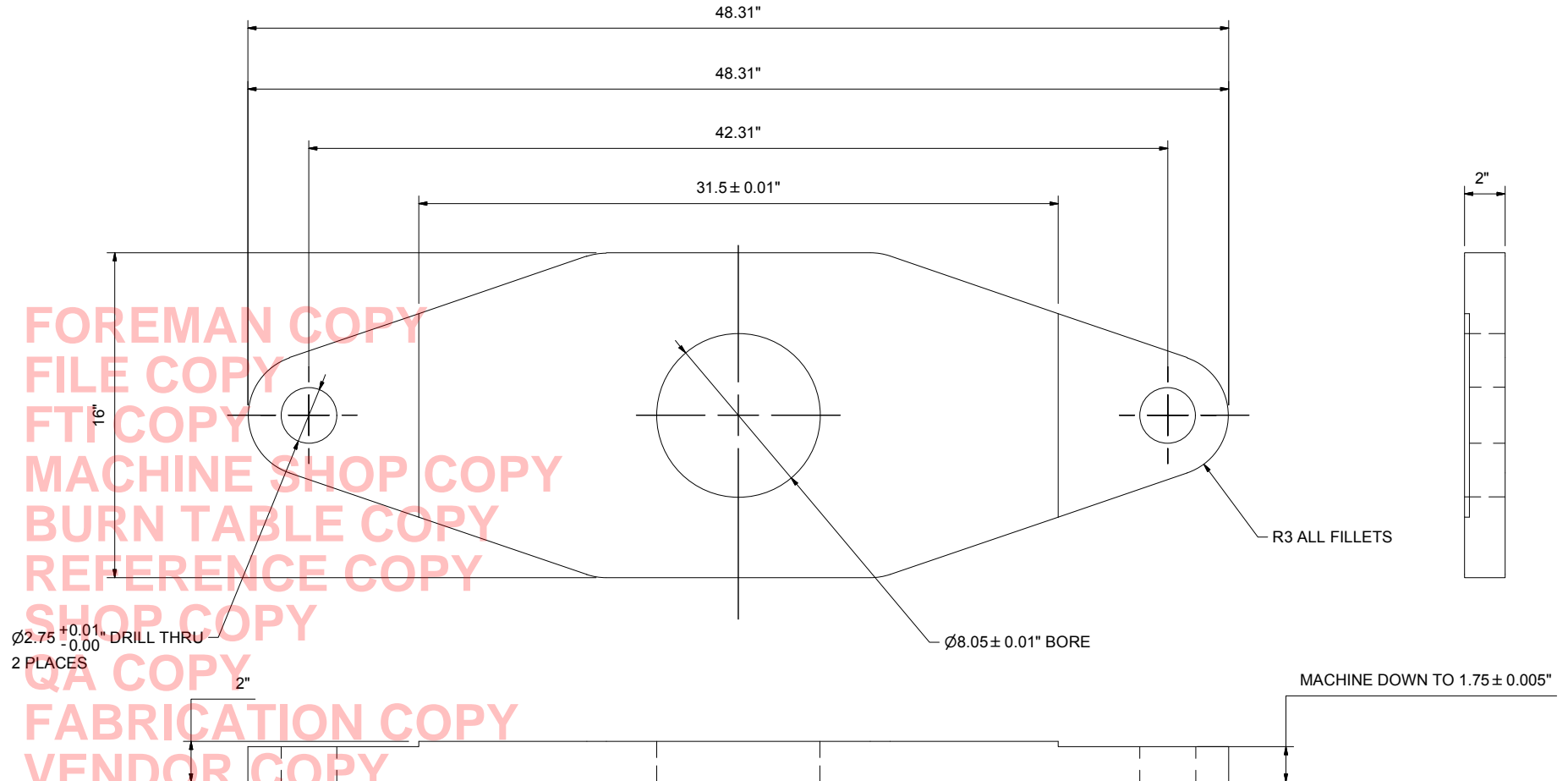
CONTROLLED DOCUMENT

IF IN DOUBT.....ASK!

CUSTOMER REFERENCE	CUSTOMER Ja-Co	DRAWN bmurphy	DATE
 1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433 email: ja-co@telusplanet.net website: jacoweld.com	PROJECT BECKET HOLDER	CHECKED	DATE
	TITLE Becket Holder	APPROVED	DATE
	W.O. # 15520	SCALE N.T.S.	DRAWING # / SHEET # eqt-1269-A-002 11 of 19

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p6	100-01569	PL 50W - 2"	1'-4"	4'- 5/16"	1	279.86

DXF FILE #15520106
MACHINE SHOP



Ø2.75 ± 0.01 DRILL THRU
-0.00
2 PLACES

Ø8.05 ± 0.01 BORE

R3 ALL FILLETS

MACHINE DOWN TO 1.75 ± 0.005 "

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TOLERANCES AS PER QMF-03

CONTROLLED DOCUMENT

CUSTOMER
REFERENCE

CUSTOMER
Ja-Co

DRAWN
bmurphy

DATE

PROJECT
BECKET HOLDER

CHECKED

DATE

TITLE
Becket Holder

APPROVED

DATE

W.O. #
15520

SCALE
N.T.S.

DRAWING # / SHEET #
eqt-1269-A-002 12 of 19



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1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433
email: ja-co@telusplanet.net website: jacoweld.com

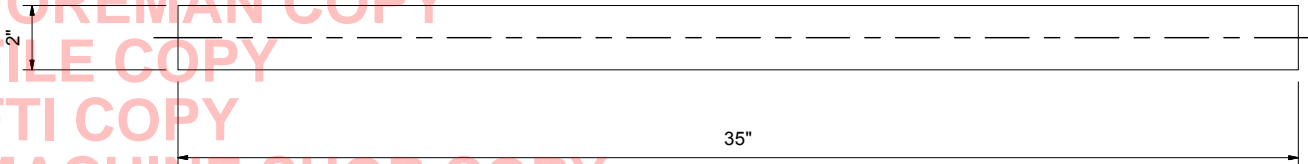
IF IN DOUBT.....ASK!

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p7	100-02316	PL 50W - 2"	2"	2'-11"	2	39.75

DXF FILE #15520107

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DATE 2014-12-21
(DESTROY PREVIOUS REVISION)



TOLERANCES AS PER QMF-03

WD# 15456
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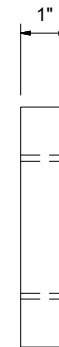
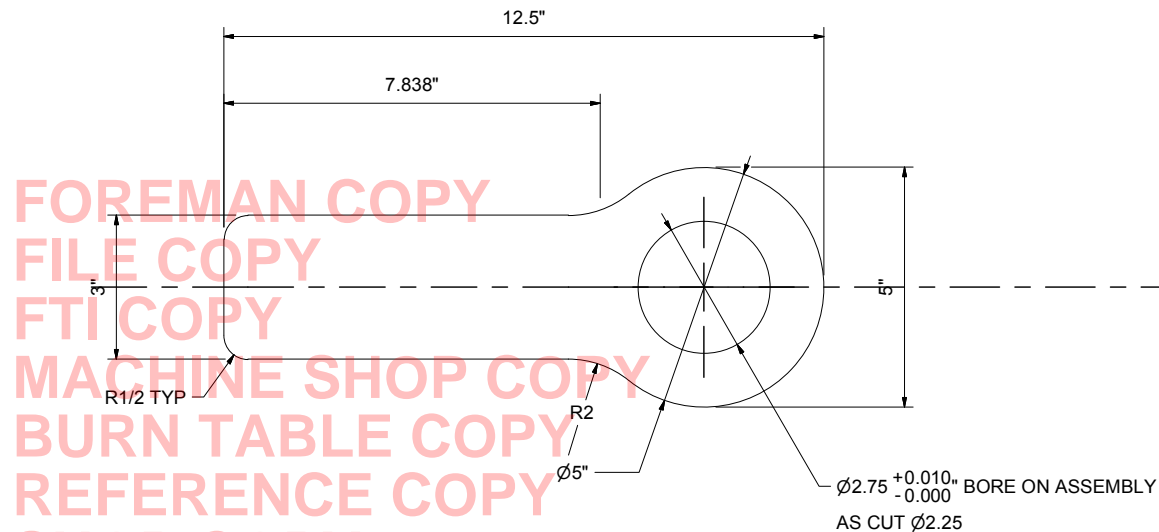
CUSTOMER REFERENCE	
1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433 email: ja-co@telusplanet.net website: jacoweld.com	

CUSTOMER Ja-Co	DRAWN bmurphy	DATE
PROJECT BECKET HOLDER	CHECKED	DATE
TITLE Becket Holder	APPROVED	DATE
W.O. # 15520	SCALE N.T.S.	DRAWING # / SHEET # eqt-1269-A-002 13 of 19

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p8	100-02313	PL 50W - 1"	5"	1'- 1/2"	8	10.43

DXF FILE #15520108

MACHINE SHOP



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REFERENCE COPY
SHOP COPY
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TOLERANCES AS PER QMF-03

WO# 15456
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1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433
email: ja-co@telusplanet.net website: jacoweld.com

CUSTOMER	Ja-Co	DRAWN	bmurphy	DATE
PROJECT	BECKET HOLDER	CHECKED		DATE
TITLE	Becket Holder	APPROVED		DATE
W.O. #	15520	SCALE	N.T.S.	DRAWING # / SHEET # eqt-1269-A-002 14 of 19
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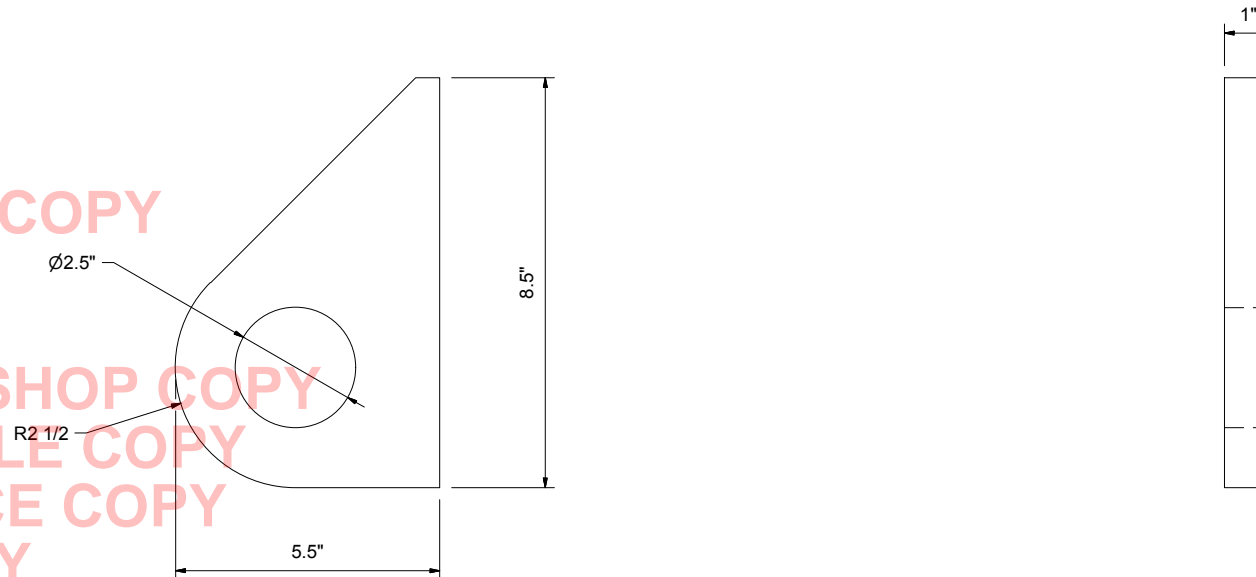
IF IN DOUBT.....ASK!

NOTE:
ALL SURFACES FLAME CUT

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p9	100-02313	PL 50W - 1"	5 1/2"	8 5/8"	2	7.96

DXF FILE #15520109

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MACHINE SHOP COPY
BURN TABLE COPY
REFERENCE COPY
SHOP COPY
QA COPY
FABRICATION COPY
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DATE 2014-12-21
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WO# 15458

TOLERANCES AS PER QMF-03

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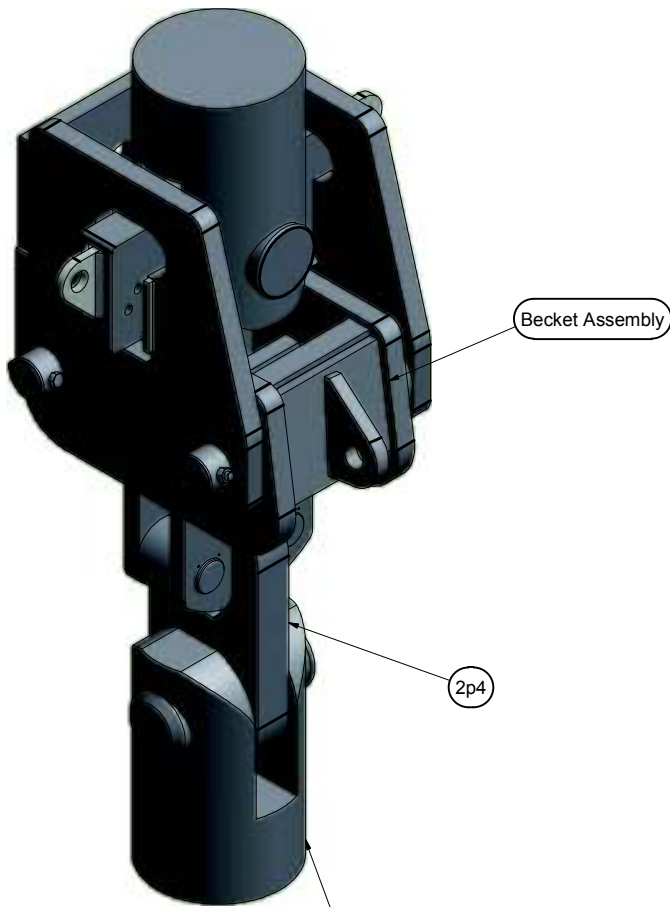
CUSTOMER REFERENCE	CUSTOMER Ja-Co	DRAWN bmurphy	DATE
 1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433 email: ja-co@telusplanet.net website: jacoweld.com	PROJECT BECKET HOLDER	CHECKED	DATE
	TITLE Becket Holder	APPROVED	DATE
	W.O. # 15520	SCALE N.T.S.	DRAWING # / SHEET # eqt-1269-A-002 / 15 of 19

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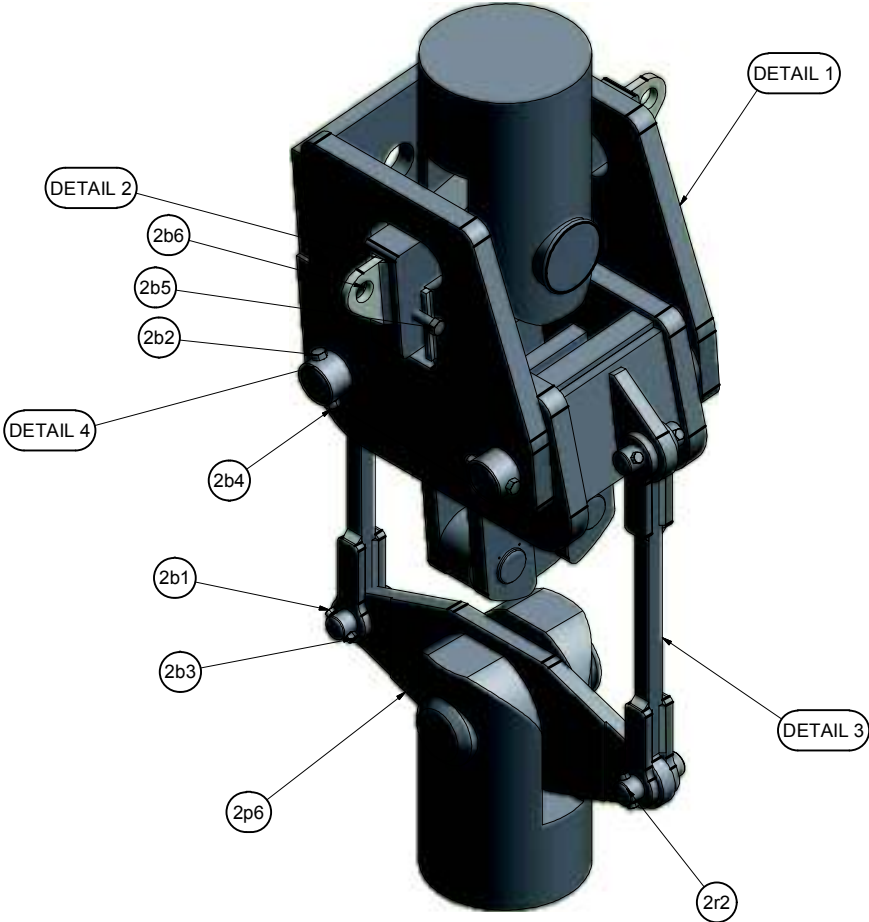
This is foreman copy

IF IN DOUBT.....ASK!

NOTE: THESE ARE THE GENERAL ASSEMBLIES OF A BECKET IN A PULL TEST APARATUS.
THE BECKET AND YOKES ARE PRE-EXISTING.
GENERAL ASSEMBLY 1 SHOWS THE PULL TEST OF THE BECKET
GENERAL ASSEMBLY 2 SHOWS THE PULL TEST OF THE SIDE EARS
WE ARE ONLY MAKING THE HOLDING UNIT THAT ATTACHES THE BECKET TO THE YOKES



PULL TEST YOKE (ALL EXISTING)



GENERAL ASSEMBLY 2
EARS PULL TEST

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2b1	200-00997	BOLT Gr.5-3/4" x 3 1/2"			8	0.61
2b3	200-00965	NUT Gr.5-3/4"			8	0.14
2p4	100-02861	PL 50W - 4 1/2"	1'-10"	2'-10"	1	528.72
2p6	100-01569	PL 50W - 2"	1'-4"	4'- 5/16"	1	279.86
DETAIL 1		TOP HOLDER			1	1541.36
2p2	100-01543	PL QT100 2 1/2"	1"	2'-11"	2	659.00
2p3	100-02316	PL 50W - 2"	1'-2"	2'-2"	1	197.69
2p5	100-02313	PL 50W - 1"	8"	8"	2	10.23
2z2	100-02318	KEY STOCK - 3/4"		9"	4	0.18
DETAIL 2		SLIDING PLATE			1	606.77
2p1	100-02861	PL 50W - 4 1/2"	1'-4 5/16"	3'-0"	1	590.04
2p9	100-02313	PL 50W - 1"	5 1/2"	8 5/8"	2	7.96
DETAIL 3		ROD ASSEMBLY			2	128.55
2b2	200-01314	BOLT Gr.5-1" x 6 1/2"			1	1.87
2b4	200-00967	NUT Gr.5-1"			1	0.33
2r1	100-02674	4140 1 1/2" (HTSR)		2'-6 1/2"	1	122.03
2z1	100-02329	MECHANICAL TUBE - 5"od x 4.124"id (C1026)		3"	1	4.32
DETAIL 4		DOG BONE ARM			2	83.80
2p7	100-02316	PL 50W - 2"	2"	2'-11"	1	39.75
2p8	100-02313	PL 50W - 1"	5"	1'- 1/2"	4	10.43
2b5	400-01736	BOLT Gr.8-1" x 9"			2	3.46
2b6	400-01736	NUT Gr.8-1"			2	0.47

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BY
(Signature)
DATE

GENERAL ASSEMBLY 1
BECKET PULL TEST

NOTES:

WELD NOTES:
1) ALL WELDS TO BE 1/4" FILLET U.N.O.
2)
3)

FINISH SPECIFICATIONS
SANDBLASTING: _____
PRIMER: _____
FINISH COAT: _____
GALVANIZING: _____

CUSTOMER
REFERENCE

Ja-Co
Welding & Consulting Ltd.
1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433
email: ja-co@telusplanet.net website: jacoweld.com

CUSTOMER
Ja-Co

PROJECT
BECKET HOLDER

TITLE
Becket Holder

W.O. #
15520

SCALE
N.T.S.

DRAWING NUMBER
eqt-1269-A-002

DRAWN
bmurphy

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APPROVED

SHEET #
1 of 19

DATE

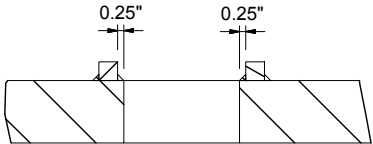
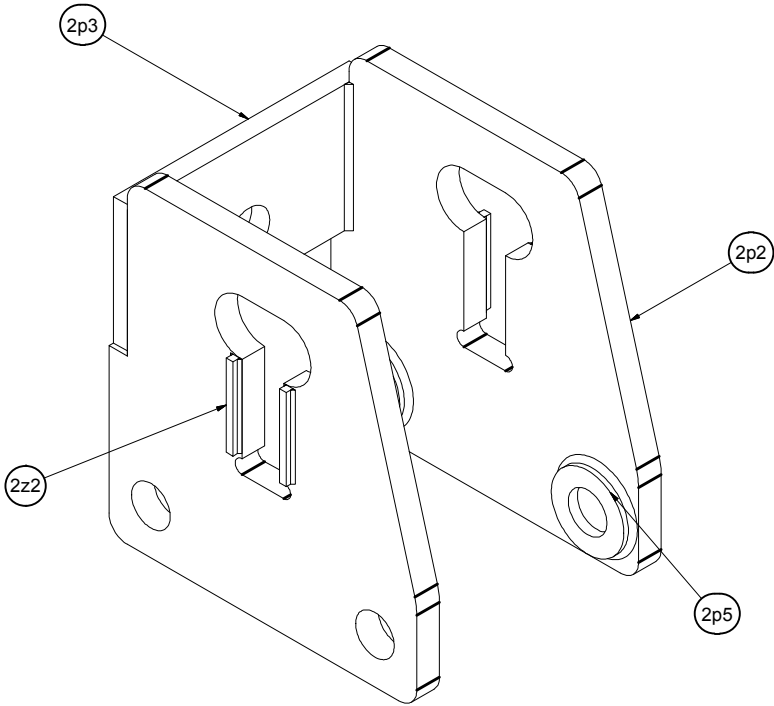
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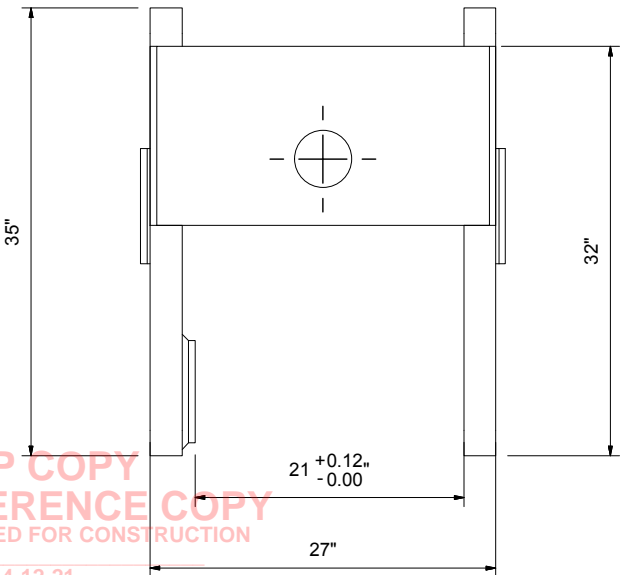
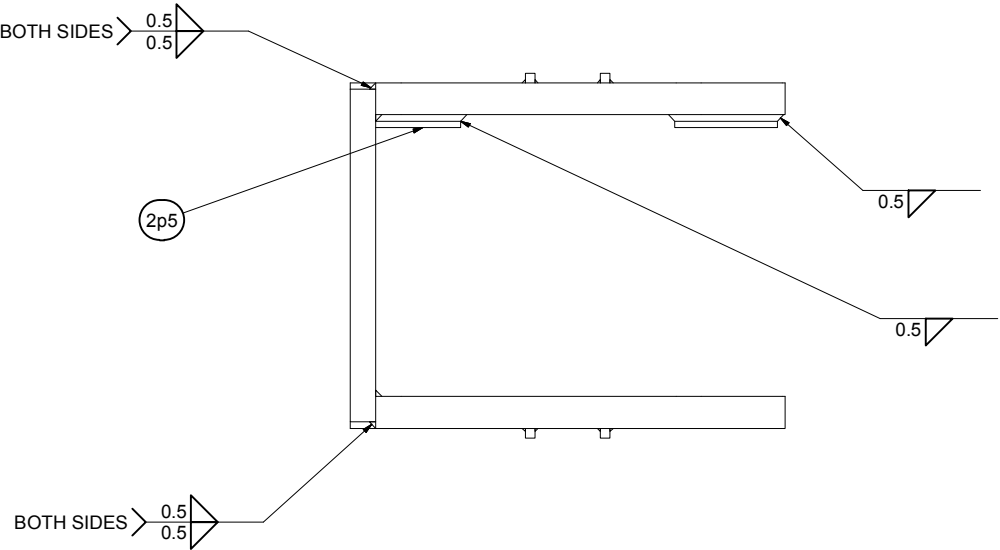


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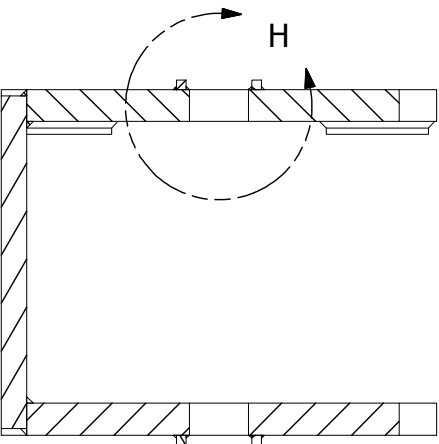
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MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p3	100-02316	PL 50W - 2"	1'-2"	2'-2"	1	197.69
2p5	100-02313	PL 50W - 1"	8"	8"	2	10.23
2z2	100-02318	KEY STOCK - 3/4"		9"	4	0.18
2p2	100-01543	PL QT100 2 1/2"	1"	2'-11"	2	659.00



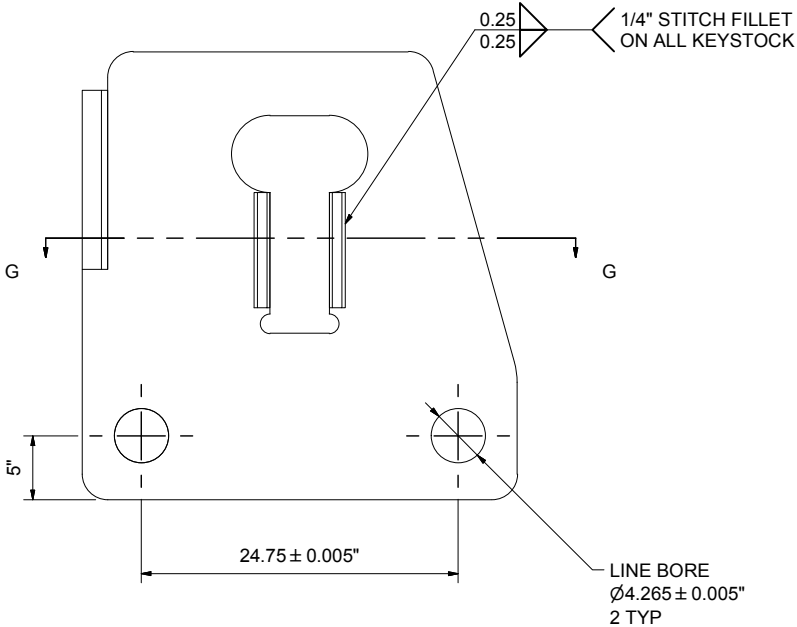
DETAIL H
SCALE 0.13 : 1



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WO# 16456



SECTION G-G
SCALE 1:15



DETAIL 1
TOP HOLDER

NOTES:

WELD NOTES:
1) ALL WELDS TO BE 1/4" FILLET U.N.O.
2)
3)

FINISH SPECIFICATIONS
SANDBLASTING: _____
PRIMER: _____
FINISH COAT: _____
GALVANIZING: _____

CUSTOMER
REFERENCE

Ja-Co
Welding & Consulting Ltd.
1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433
email: ja-co@telusplanet.net website: jacoweld.com

CUSTOMER
Ja-Co

PROJECT
BECKET HOLDER

TITLE
Becket Holder

W.O. #
15520

SCALE
N.T.S.

DRAWING NUMBER
eqt-1269-A-002

SHEET #
2 of 19

DRAWN
bmurphy

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DATE

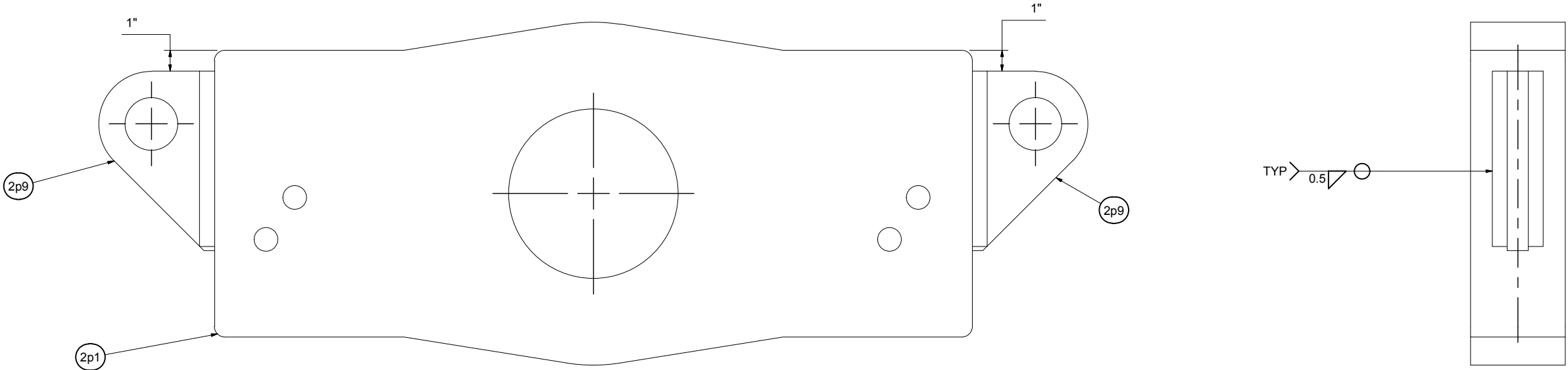
DATE

DATE

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IF IN DOUBT.....ASK!

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2p1	100-02861	PL 50W - 4 1/2"	1'-4 5/16"	3'-0"	1	590.04
2p9	100-02313	PL 50W - 1"	5 1/2"	8 5/8"	2	7.96



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WO# 16456

DETAIL 2
SLIDING PLATE

NOTES:

WELD NOTES:

1) ALL WELDS TO BE 1/4" FILLET U.N.O.
2)
3)

FINISH SPECIFICATIONS

SANDBLASTING: _____
PRIMER: _____
FINISH COAT: _____
GALVANIZING: _____

CUSTOMER
REFERENCE

Ja-Co

Welding & Consulting Ltd.

1304-8th Street, Nisku, Alberta, T9E 7M1 phone 780 955 2251 fax 780 955 3433
email: ja-co@telusplanet.net website: jacoweld.com

CUSTOMER
Ja-Co

PROJECT
BECKET HOLDER

TITLE
Becket Holder

W.O. #
15520

DRAWN
bmurphy

CHECKED

APPROVED

SCALE
N.T.S.

DRAWING NUMBER
eqt-1269-A-002

SHEET #
3 of 19

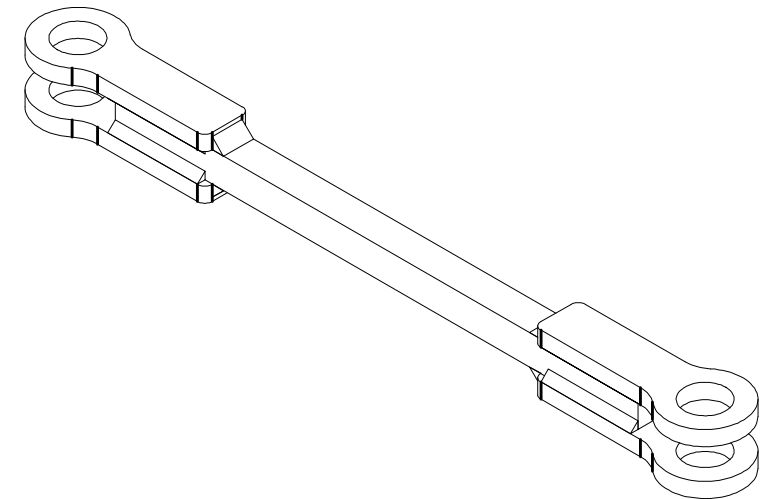
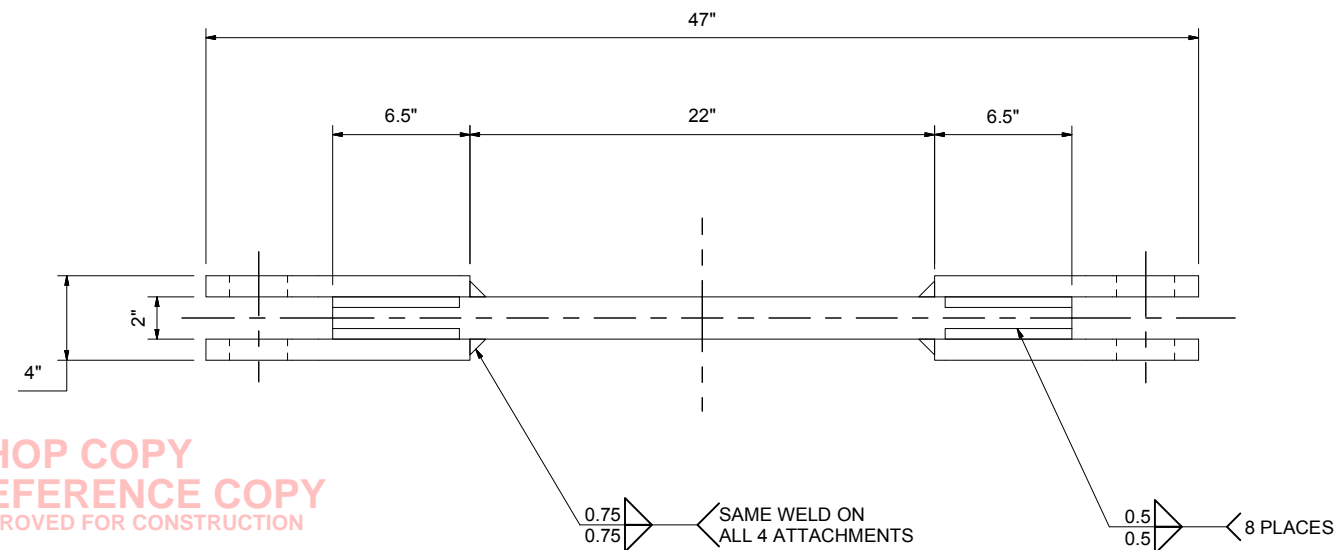
DATE

DATE

DATE

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NOTE: TWO OF THESE ASSEMBLIES ARE REQUIRED



DETAIL 3

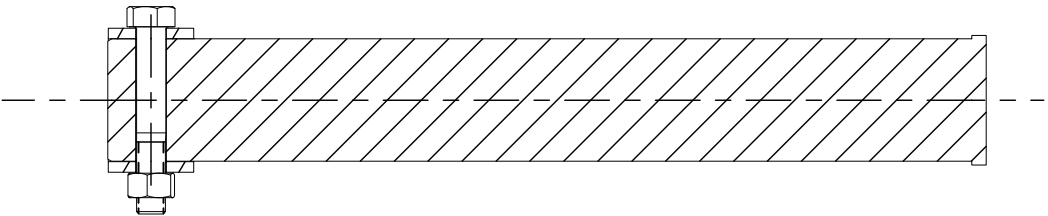
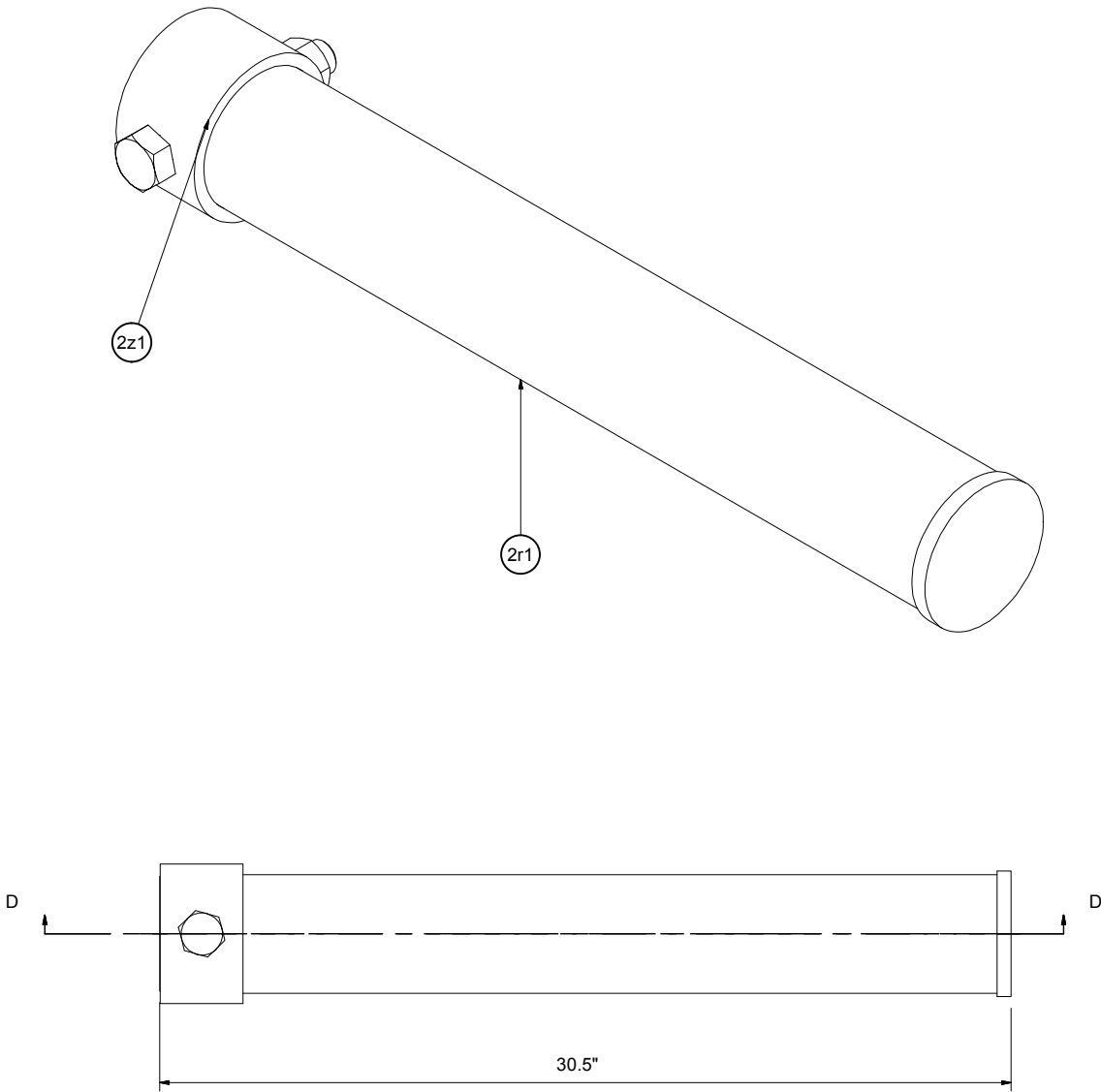
ROD ASSEMBLY

 $\triangle 0$

IF IN DOUBT.....ASK!

BILL OF MATERIALS						
MARK	STOCK #	DESCRIPTION	WIDTH	LENGTH	QTY	UNIT WEIGHT
2r1	100-02674	4140 1 1/2" (HTSR)		2'-6 1/2"	1	122.03
2z1	100-02329	MECHANICAL TUBE - 5"od x 4.124"id (C1026)		3"	1	4.32
2b2	200-01314	BOLT Gr.5-1" x 6 1/2"			1	1.87
2b4	200-00967	NUT Gr.5-1"			1	0.33

NOTE: TWO ASSEMBLIES ARE REQUIRED



SECTION D-D
SCALE 0.15 : 1

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WO# 16456

DETAIL 4
DOG BONE ARM

NOTES:

WELD NOTES:
1) ALL WELDS TO BE 1/4" FILLET U.N.O.
2)
3)

FINISH SPECIFICATIONS
SANDBLASTING: _____
PRIMER: _____
FINISH COAT: _____
GALVANIZING: _____

CUSTOMER
REFERENCE

Ja-Co
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