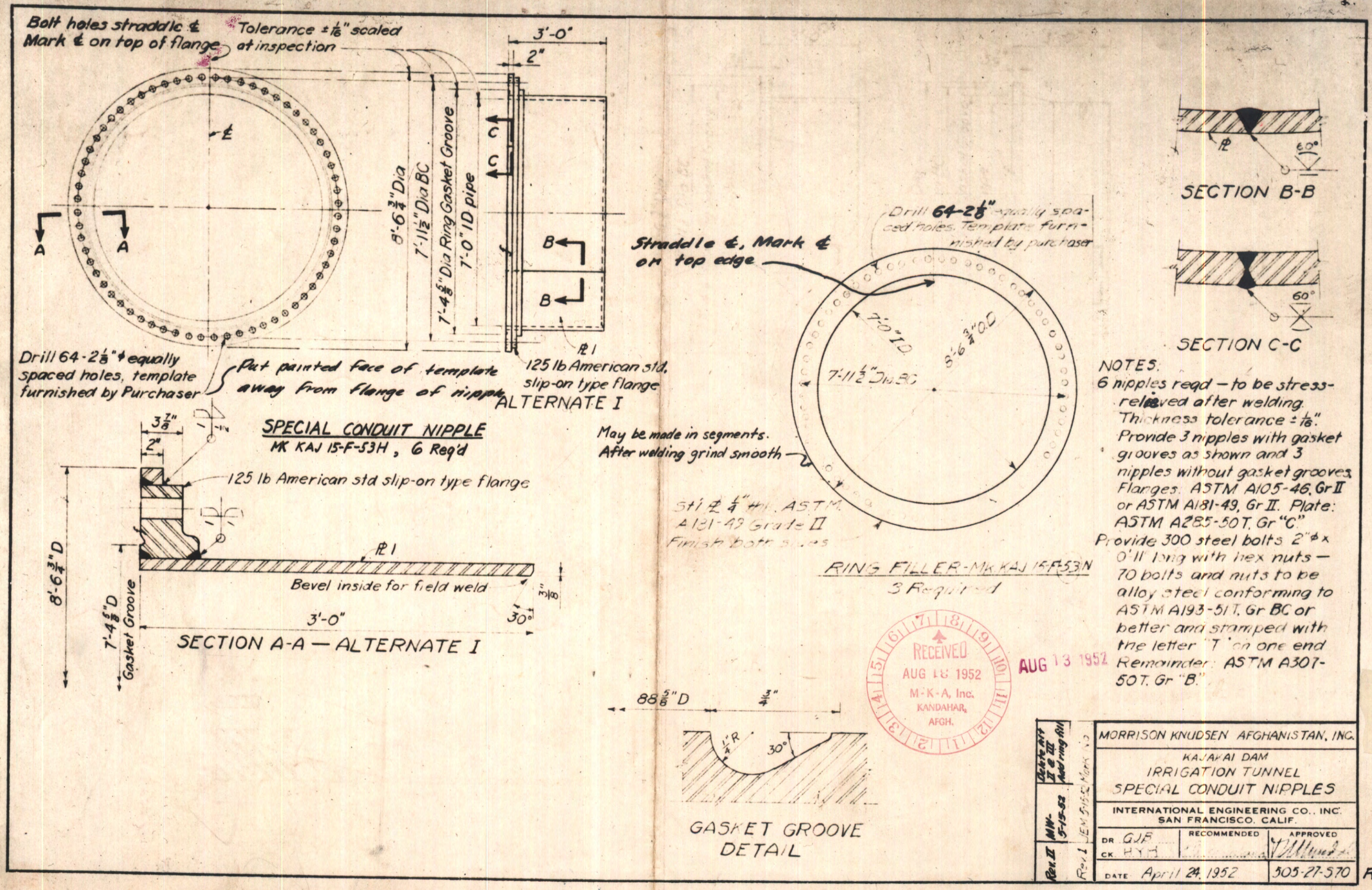

Bolt holes straddle ℄
Mark ℄ on top of flange
Tolerance ± 1/16" scaled at inspection
3'-0"
2"
℄
A
A
8'-6 3/4" Dia
7'-11 1/2" Dia BC
7'-4 5/8" Dia Ring Gasket Groove
7'-0" ID pipe
C
C
B
B
PL 1
Drill 64-2 1/8" ϕ equally spaced holes, template furnished by Purchaser
Put painted face of template away from flange of nipple
125 lb American std. slip-on type flange
ALTERNATE I
SPECIAL CONDUIT NIPPLE
MK KAJ 15-F-53H, 6 Req'd
3 7/8"
2"
125 lb American std slip-on type flange
PL 1
Bevel inside for field weld
3/8"
30°
3'-0"
8'-6 3/4" D
7'-4 5/8" D
Gasket Groove
SECTION A-A — ALTERNATE I
Straddle ℄, Mark ℄ on top edge
Drill 64-2 1/8" equally spaced holes. Template furnished by purchaser
7'-0" ID
8'-6 3/4" O.D
7'-11 1/2" Dia BC
May be made in segments. After welding grind smooth
Stl PL 1/4" thk. ASTM A181-49 Grade II
Finish both sides
RING FILLER-MK KAJ 15-F-53N
3 Required
PL
60°
SECTION B-B
60°
SECTION C-C
NOTES.
6 nipples reqd — to be stress-relieved after welding.
Thickness tolerance ± 1/16".
Provide 3 nipples with gasket grooves as shown and 3 nipples without gasket grooves.
Flanges: ASTM A105-46, Gr II or ASTM A181-49, Gr II. Plate: ASTM A285-50T, Gr "C".
Provide 300 steel bolts 2" ϕ x 0'-11" long with hex nuts — 70 bolts and nuts to be alloy steel conforming to ASTM A193-51T, Gr BC or better and stamped with the letter "T" on one end.
Remainder: ASTM A307-50T, Gr "B".
88 5/8" D
3/4"
1/4" R
30°
GASKET GROOVE DETAIL
RECEIVED
AUG 18 1952
M-K-A, Inc.
KANDAHAR, AFGH.
AUG 13 1952
MORRISON KNUDSEN AFGHANISTAN, INC.
KAJAKAI DAM
IRRIGATION TUNNEL
SPECIAL CONDUIT NIPPLES
INTERNATIONAL ENGINEERING CO., INC.
SAN FRANCISCO, CALIF.
DR GJB
CK HYH
RECOMMENDED
APPROVED
DATE April 24, 1952
505-27-S70
Rev. II
MW-5-15-52
Delete Mt II & III Add ring fill
Rev. 1
JEM 5-15-52 Mark No