



NOTE:
AFTER COMPLETE FABRICATION
& BEFORE MACHINING THE DISCH. HEAD
MUST BE STRESS RELIEVED

ALL WELDS TO BE FULL LENGTH
& FILLET WELDS, EXCEPT AS NOTED,
NOT LESS THAN SIZE OF THINNEST
ADJACENT SECTION

NOTE:
BREAK ALL CORNERS &
GRIND WELDS SMOOTH FOR
RUBBER LINING AT INTERIOR
SURFACES.

1" DRILL - 2 HOLES
ON 22 1/2" BOLT CIRCLE
STRADDLE VERT. C

1/8" 7-N.C. TAP - 6 3/4" TAP DRILL
24 HOLES ON 19 1/4" BOLT CIRCLE
DRILL & TAP THROUGH

16" OPENING MEASURE ON CIRCUM.
(SAME OPPOSITE SIDE)

7/8" DRILL - 8 HOLES
ON 27 1/4" B.C.

15°

22" OPENING MEASURE ON CIRCUMFERENCE
(SAME OPPOSITE SIDE)

14" R.

3/8" SKIPWELD TOTAL LENGTH

1/2" 11-N.C. TAP - 1 1/2" DEEP
3/8" TAP DRILL - 1 3/8" DEEP
6 HOLES ON 10 3/4" B.C.
DO NOT DRILL THRU.

1/8" DRILL - 6 HOLES
ON 44 1/2" BOLT CIRCLE

ITEM	SYMBOL	QUAN.	DESCRIPTION	MATERIAL
11	RING	1	1/2" M.S. PLT. X 45" DIA.	MILD STL.
10	LIFT LUGS	8	1" M.S. PLT. 13" X 22"	MILD STL.
9	RIBS	4	6" X 3 1/2" - 15.3" SHIP CHAN. 5' 3 1/2" LG.	STEEL
8	RIBS	7	4" X 4" X 3/8" - 91" ANGLES 23 1/2" LG.	STEEL
7	SUPPORT	1	16" O.D. PIPE X 3/8" WALL 25 1/2" LG.	STEEL
6	BODY	1	16" O.D. PIPE X 3/8" WALL 29 1/2" LG.	STEEL
5	RISER	1	1/2" M.S. PLT. 5' 3 5/8" X 10' 4 1/2"	MILD STL.
4	DISCH. FLG.	1	1 3/4" M.S. PLT. X 25 1/2" DIA.	MILD STL.
3	BOX PLT.	1	2" M.S. PLT. X 29" DIA.	MILD STL.
2	TOP PLT.	1	1 5/8" M.S. PLT. X 48" DIA.	MILD STL.
1	BASE PLT.	1	3" M.S. PLT. 60" X 60"	MILD STL.

ITEM	SYMBOL	QUAN.	DESCRIPTION	MATERIAL
12	RIB	1	4" X 2 1/2" - 31" ANGLE 19" LG.	STEEL

FINISH SYMBOLS	ALLOWABLE TOLERANCE
63-33 MICROINCHES	± 1/64 ALLOWABLE TOLERANCE ON FRACTIONAL FINISH DIMENSIONS
EXTRA SMOOTH FINISH	± 1/32 ALLOWABLE TOLERANCE ON SINGLE DECIMAL DIMENSIONS.
100-210 MICROINCHES	± .005 ALLOWABLE TOLERANCE ON SINGLE DECIMAL DIMENSIONS.
SMOOTH MACHINE FINISH	± .005 ALLOWABLE TOLERANCE ON SINGLE DECIMAL DIMENSIONS.
2-5-5-300 MICROINCHES	± .005 ALLOWABLE TOLERANCE ON SINGLE DECIMAL DIMENSIONS.
MEDIUM MACHINE FINISH	± .005 ALLOWABLE TOLERANCE ON SINGLE DECIMAL DIMENSIONS.
200-600 MICROINCHES	± .005 ALLOWABLE TOLERANCE ON SINGLE DECIMAL DIMENSIONS.
ROUGH MACHINE FINISH	± .005 ALLOWABLE TOLERANCE ON SINGLE DECIMAL DIMENSIONS.

REVISIONS	DATE	DESCRIPTION
1	5-14-59 J.J.R.	24 TAP HOLES IN BASE PLT.
2	5-14-59 J.J.R.	1/8" 7-N.C. WAS
3	5-14-59 J.J.R.	1/8" 7-N.C. WAS
4	5-14-59 J.J.R.	1/8" 7-N.C. WAS
5	5-14-59 J.J.R.	1/8" 7-N.C. WAS
6	5-14-59 J.J.R.	1/8" 7-N.C. WAS
7	5-14-59 J.J.R.	1/8" 7-N.C. WAS
8	5-14-59 J.J.R.	1/8" 7-N.C. WAS
9	5-14-59 J.J.R.	1/8" 7-N.C. WAS
10	5-14-59 J.J.R.	1/8" 7-N.C. WAS
11	5-14-59 J.J.R.	1/8" 7-N.C. WAS
12	5-14-59 J.J.R.	1/8" 7-N.C. WAS
13	5-14-59 J.J.R.	1/8" 7-N.C. WAS
14	5-14-59 J.J.R.	1/8" 7-N.C. WAS
15	5-14-59 J.J.R.	1/8" 7-N.C. WAS
16	5-14-59 J.J.R.	1/8" 7-N.C. WAS
17	5-14-59 J.J.R.	1/8" 7-N.C. WAS
18	5-14-59 J.J.R.	1/8" 7-N.C. WAS
19	5-14-59 J.J.R.	1/8" 7-N.C. WAS
20	5-14-59 J.J.R.	1/8" 7-N.C. WAS
21	5-14-59 J.J.R.	1/8" 7-N.C. WAS
22	5-14-59 J.J.R.	1/8" 7-N.C. WAS
23	5-14-59 J.J.R.	1/8" 7-N.C. WAS
24	5-14-59 J.J.R.	1/8" 7-N.C. WAS
25	5-14-59 J.J.R.	1/8" 7-N.C. WAS
26	5-14-59 J.J.R.	1/8" 7-N.C. WAS
27	5-14-59 J.J.R.	1/8" 7-N.C. WAS
28	5-14-59 J.J.R.	1/8" 7-N.C. WAS
29	5-14-59 J.J.R.	1/8" 7-N.C. WAS
30	5-14-59 J.J.R.	1/8" 7-N.C. WAS
31	5-14-59 J.J.R.	1/8" 7-N.C. WAS
32	5-14-59 J.J.R.	1/8" 7-N.C. WAS
33	5-14-59 J.J.R.	1/8" 7-N.C. WAS
34	5-14-59 J.J.R.	1/8" 7-N.C. WAS
35	5-14-59 J.J.R.	1/8" 7-N.C. WAS
36	5-14-59 J.J.R.	1/8" 7-N.C. WAS
37	5-14-59 J.J.R.	1/8" 7-N.C. WAS
38	5-14-59 J.J.R.	1/8" 7-N.C. WAS
39	5-14-59 J.J.R.	1/8" 7-N.C. WAS
40	5-14-59 J.J.R.	1/8" 7-N.C. WAS
41	5-14-59 J.J.R.	1/8" 7-N.C. WAS
42	5-14-59 J.J.R.	1/8" 7-N.C. WAS
43	5-14-59 J.J.R.	1/8" 7-N.C. WAS
44	5-14-59 J.J.R.	1/8" 7-N.C. WAS
45	5-14-59 J.J.R.	1/8" 7-N.C. WAS
46	5-14-59 J.J.R.	1/8" 7-N.C. WAS
47	5-14-59 J.J.R.	1/8" 7-N.C. WAS
48	5-14-59 J.J.R.	1/8" 7-N.C. WAS
49	5-14-59 J.J.R.	1/8" 7-N.C. WAS
50	5-14-59 J.J.R.	1/8" 7-N.C. WAS

CYLINDRICAL SURFACES AND THREAD PITCH
DIAMETERS MARKED WITH ARE TO BE CONGEN-
TIVE WITHIN THE TOLERANCES SPECIFIED
BELOW.

DIA. THRU	1 1/2"	3"	6"	12"	24"	48"
TOL. T.I.R.	.001	.002	.003	.004	.005	.008

BREAK ALL SHARP CORNERS 1/32"

MACHINED FACES MARKED WITH ARE TO BE PAR-
ALLEL WITHIN THE TOLERANCES SPECIFIED
BELOW. DIAMETER IS MINIMUM DIAMETER FACE.

DIA. THRU	3"	6"	12"	24"	48"
TOL. T.I.R.	.003	.005	.008	.012	.020

5P2B 311-1
Fairbanks, Morse & Co.
POMONA PUMP WORKS
48" X 16" SURF. DISCH. HEAD
ASKAM SHAFT PA.

5'-3 5/8"
5'-8" SEAT TO SEAT
5'-8 1/4"

SECTION "A-B-C-D-E"