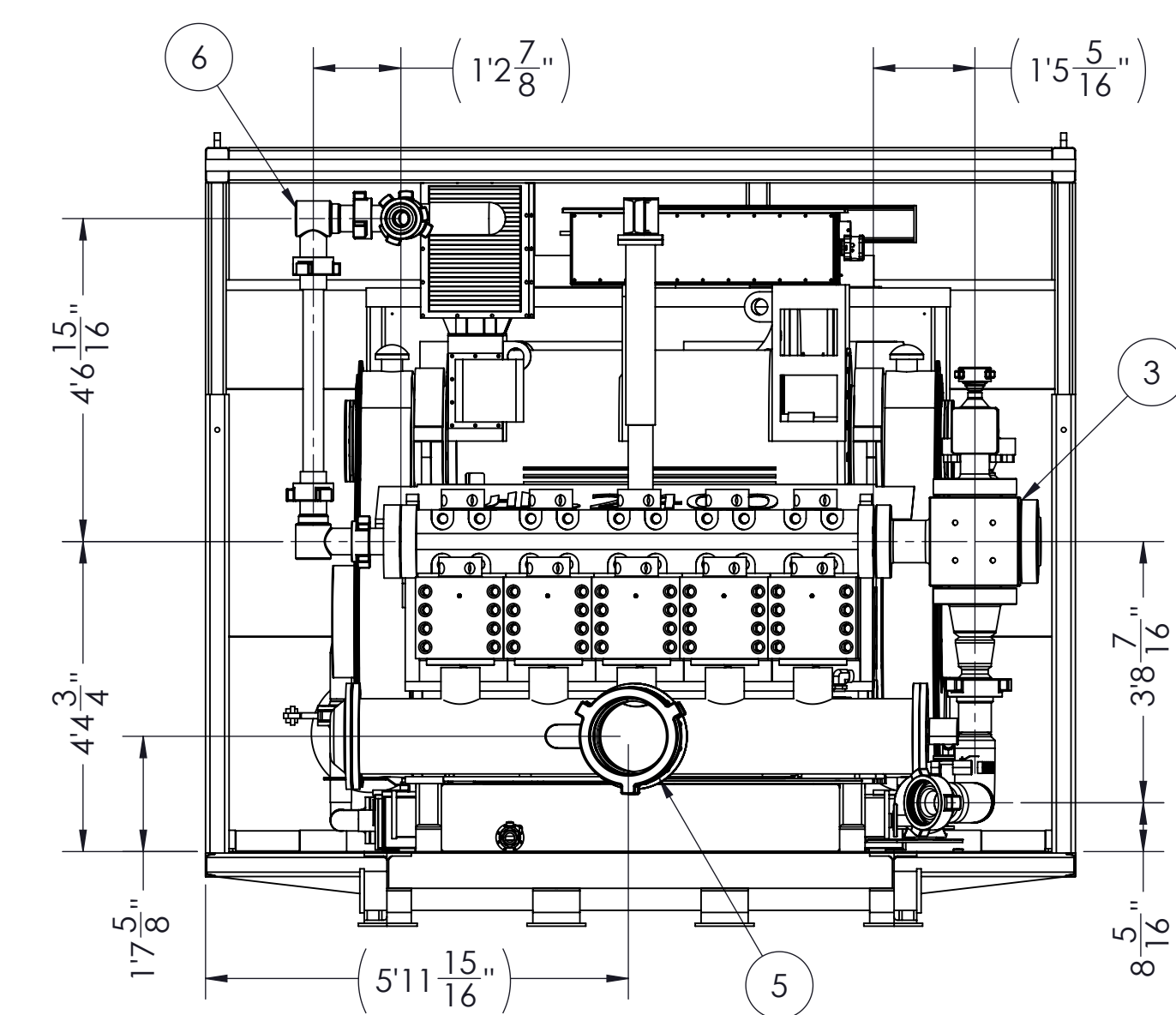
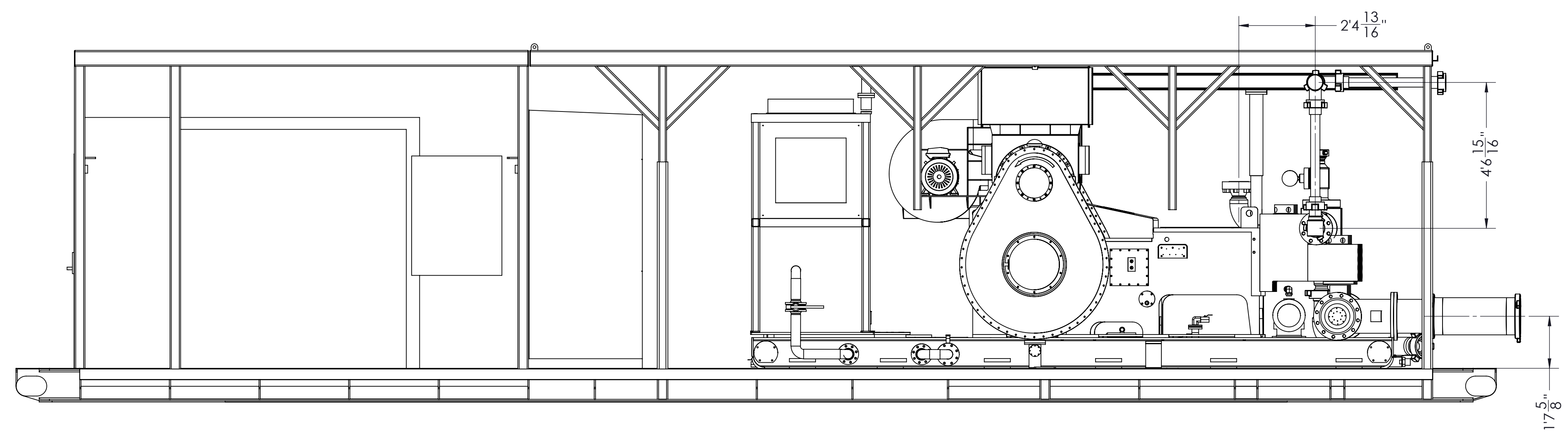
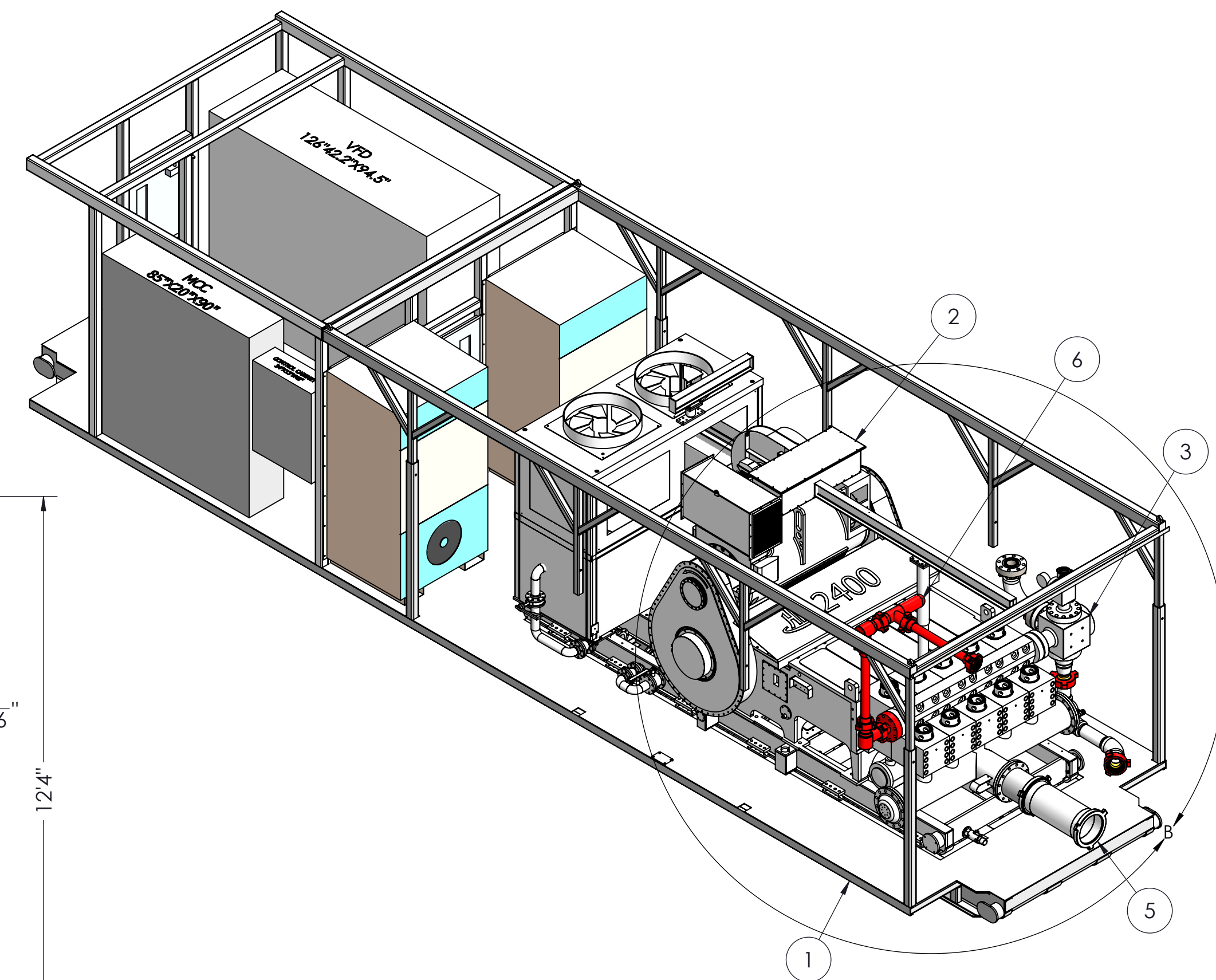
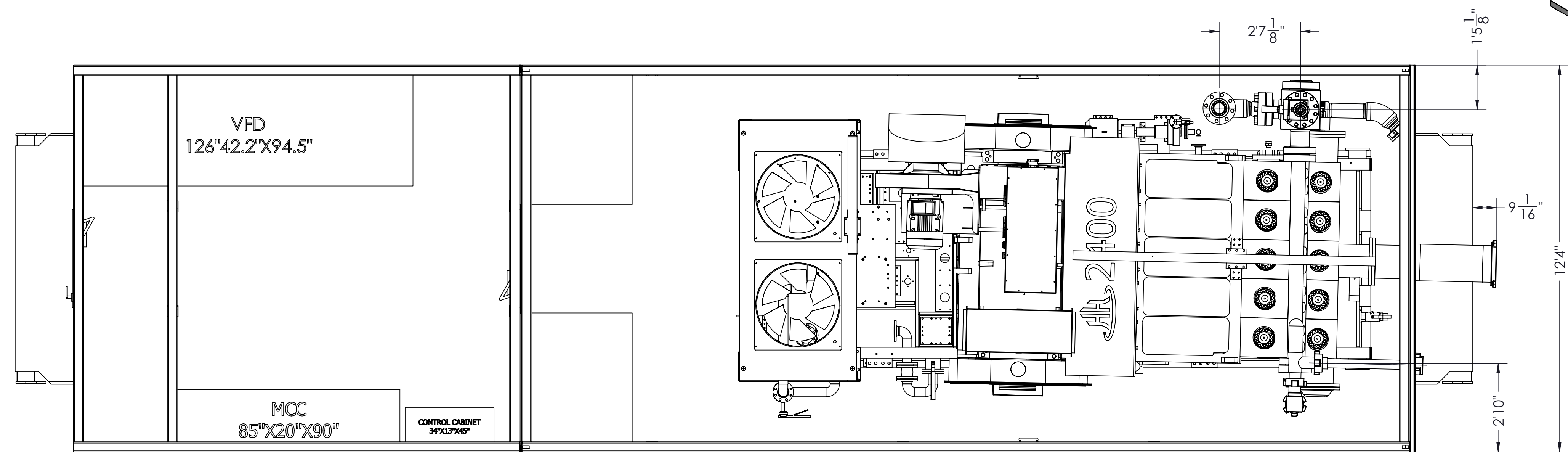


NOTES:

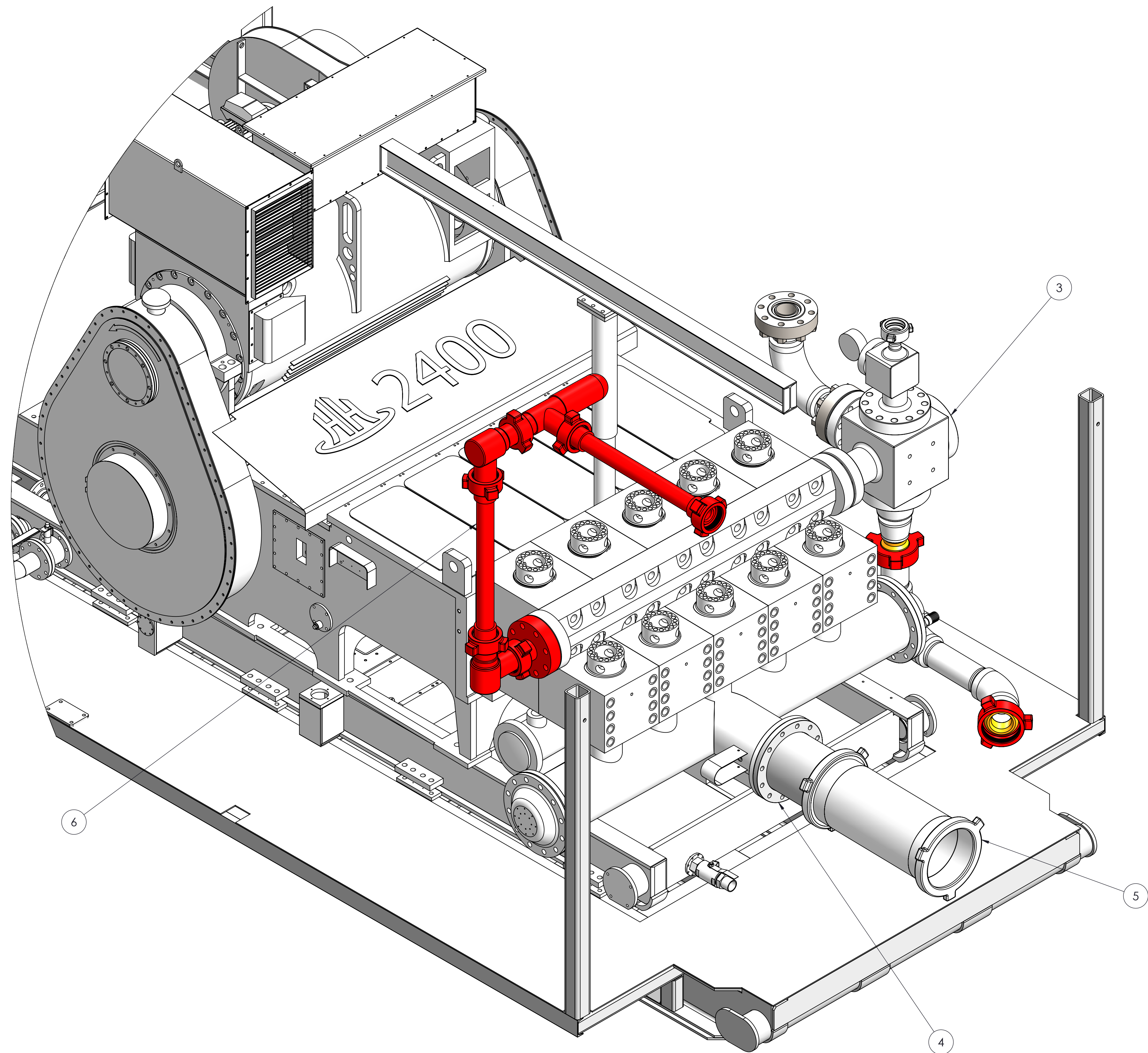
1. U.N.O. ALL FILLET WELDS TO BE 1/4" CONTINUOUS
2. U.N.O. ALL GROOVE WELDS TO BE 1/4" CONTINUOUS
3. U.N.O. ALL STRUCTURAL MATERIAL G40.21-50W
4. U.N.O. ALL TUBING MATERIAL G40.21-50W
5. U.N.O. ALL PLATE MATERIAL G40.21-50W
6. WELD SHOULD NOT EXCEED MATERIAL THICKNESS
7. STICK AND FLUX CORE WELDING PROCEDURES ARE INTERCHANGEABLE ON AN EQUIVALENT BASIS
8. ALL WELDING SHOULD COMPLY WITH CSA-W59
9. SEAL WELD ALL TUBING
10. REMOVE ALL BURRS AND SHARP CORNERS

ITEM NO.	NO SHEET METAL/QTY.	PART NUMBER	DESCRIPTION
1	1	STRUCTURE PUMP	
2	1	Quint Pump 3D model	PUMP 24 hp
3	1	PLUMBING DISCHARGE PUMP 1	PLUMBING PUMP DISCHARGE
4	1	FLANGE QUINT SUCTION	FLANGE QUIT SUCTION
5	1	DRESSER SLEEVE	DRESSER SLEEVE
6	1	PLUMBING RELIEF MUD PUMP	PLUMBING RELIEF MUD PUMP



TOLERANCES FABRICATION .X ±0.1 .XX ±0.06 .XXX ±0.031 FRACTION ±1/16 ANGLE ±1° <small>CORNER RADIUS .06" UNLESS OTHERWISE SPECIFIED</small>		MACHINING .X ±0.030 .XX ±0.015 .XXX ±0.005 FRACTION ±1/16 ANGLE ±0.5° FINISH 125 RMS <small>DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED</small>		DRAWN BY: MC DATE: 2019-09-10 CHECKED BY: DATE: APPROVED BY: DATE:		THE INFORMATION INCLUDED IN THIS DOCUMENT IS PROPRIETARY AND SHALL NOT BE REPRODUCED, TRANSFERRED, OR DISCLOSED TO OTHERS FOR ANY PURPOSE WHATSOEVER, WITHOUT THE WRITTEN AUTHORIZATION OF TRIUMPH INDUSTRIAL PROCESS LTD.		QTY: PUMP - MUD 1 PIPING LAYOUT Material: Weight: 253673.509 lbs Drawing Number: T19-0048A-04 Page: 1/5 Rev:	
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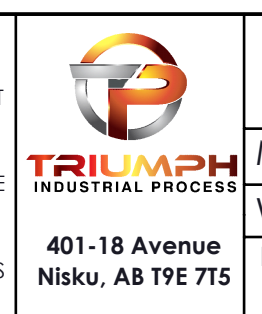


DETAIL B

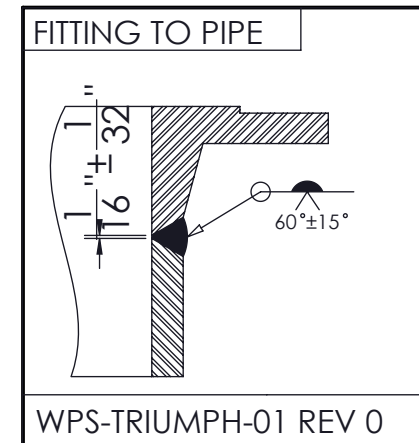
TOLERANCES	
FABRICATION	MACHINING
.X ±0.1	.X ±0.030
.XX ±0.06	.XX ±0.015
.XXX ±0.031	.XXX ±0.005
FRACTION ±1/16	FRACTION ±1/16
ANGLE ±1°	ANGLE ±0.5°
	FINISH 125 RMS

DRAWN BY:	MC
DATE:	2019-09-10
CHECKED BY:	
DATE:	
APPROVED BY:	
DATE:	

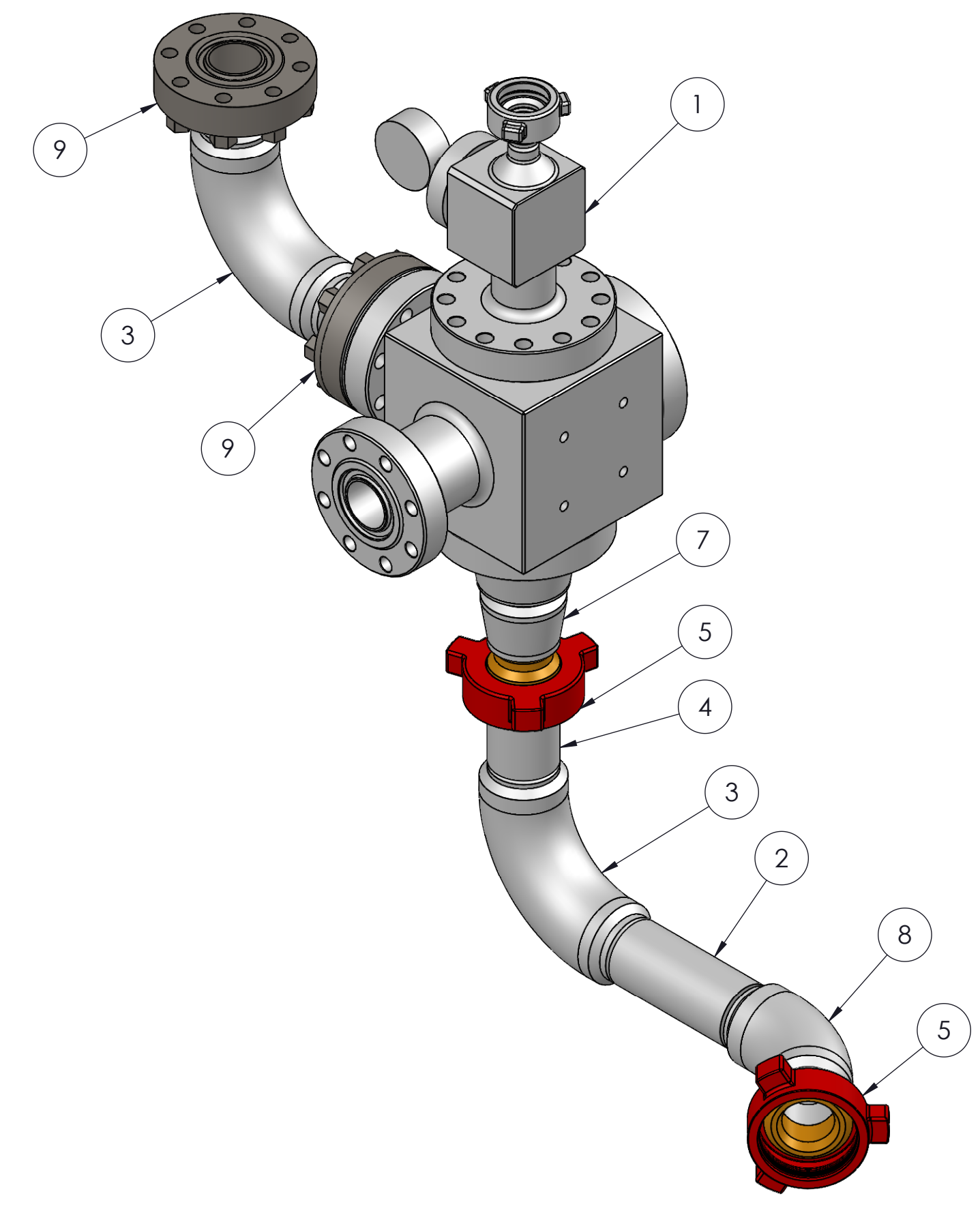
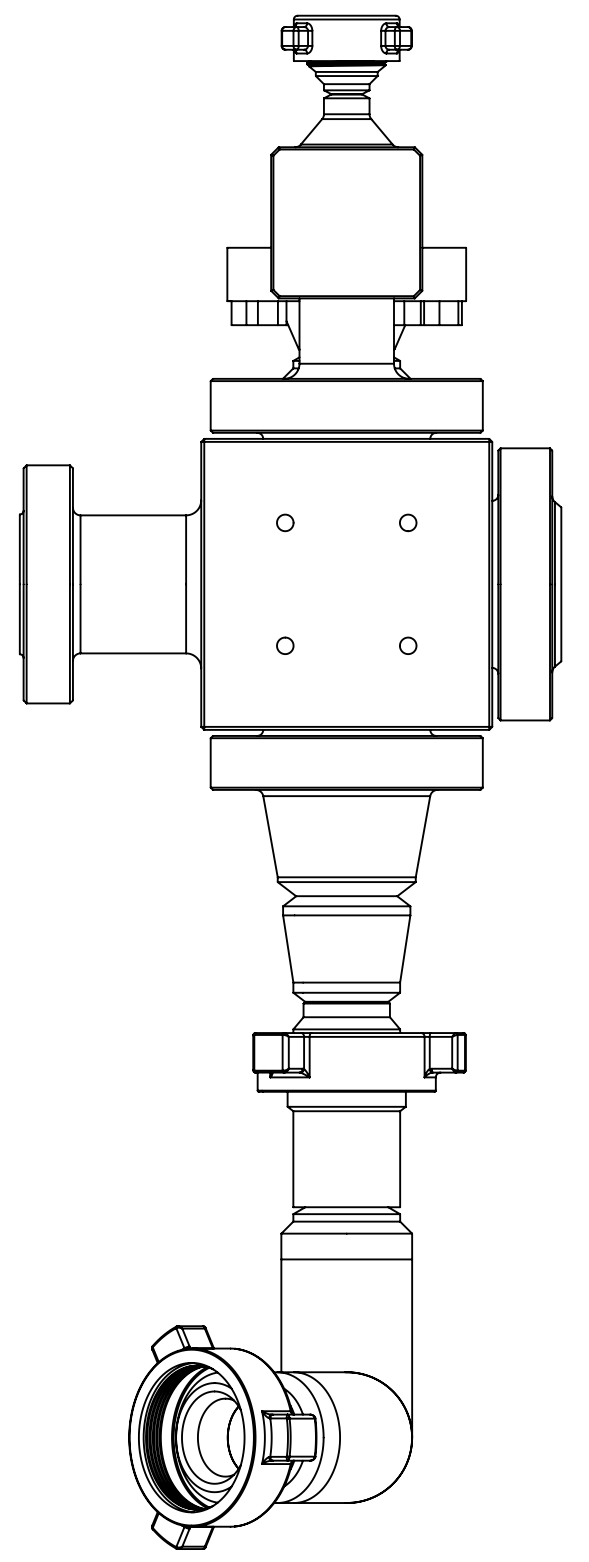
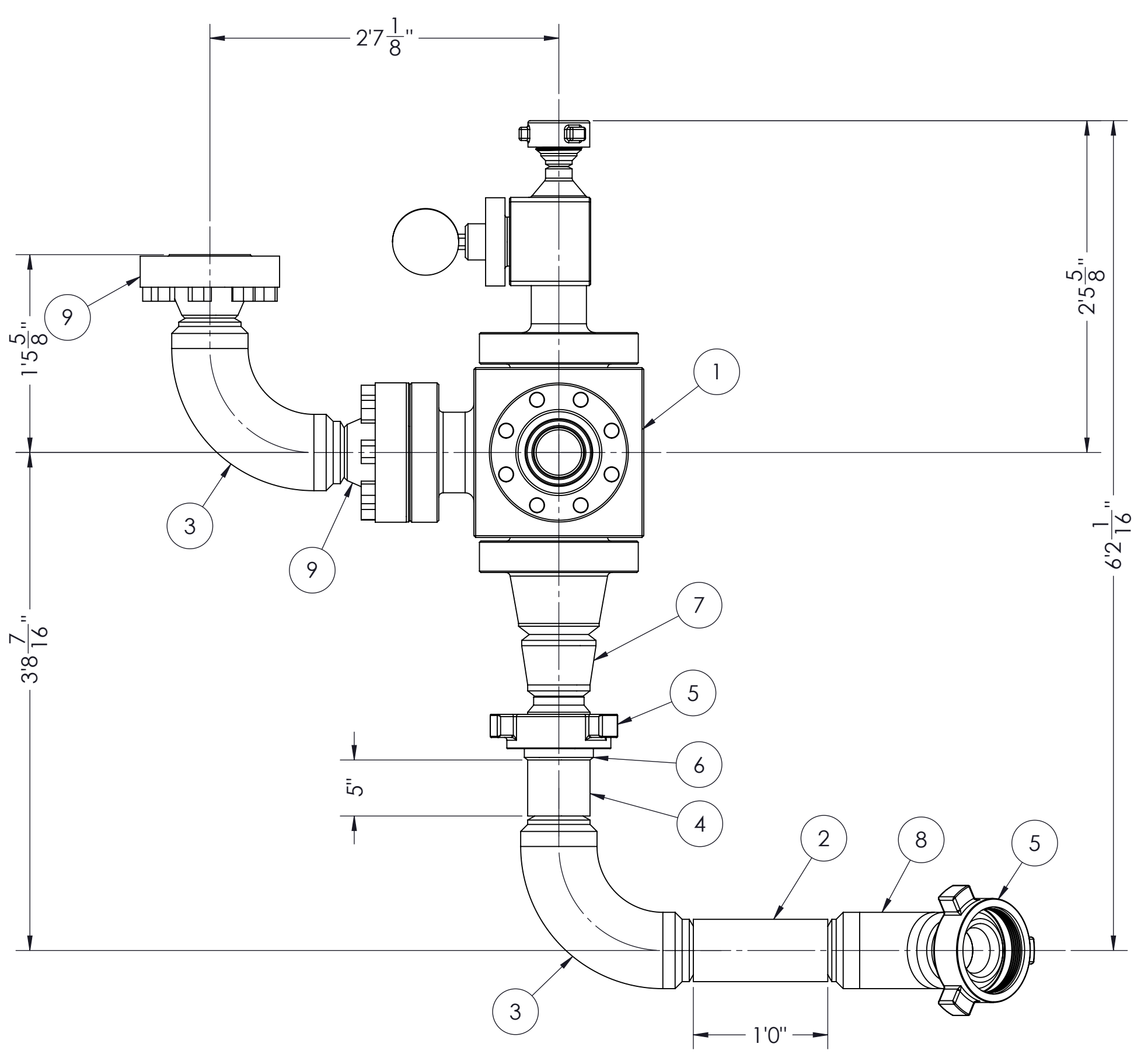
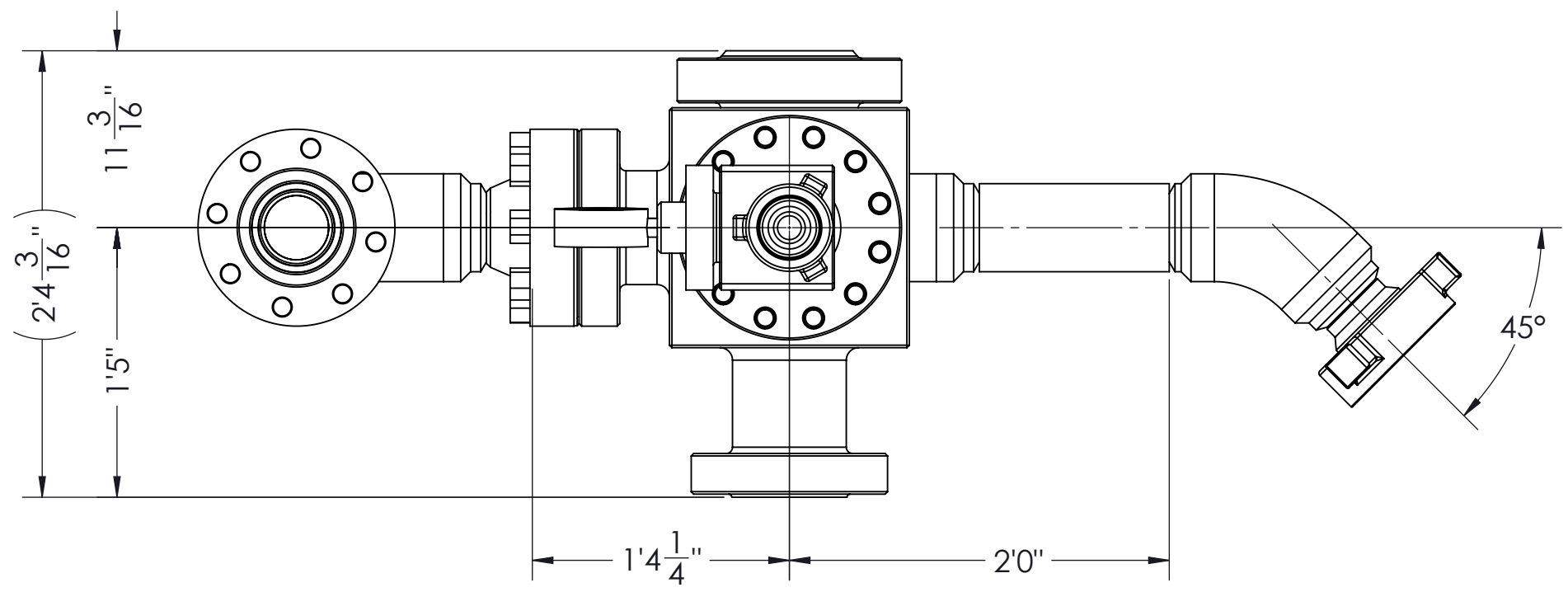
THE INFORMATION INCLUDED IN THIS DOCUMENT IS PROPRIETARY AND SHALL NOT BE REPRODUCED, TRANSFERRED, OR DISCLOSED TO OTHERS FOR ANY PURPOSE WHATSOEVER, WITHOUT THE WRITTEN AUTHORIZATION OF TRIUMPH INDUSTRIAL PROCESS LTD.



PUMP - MUD 1 PIPING LAYOUT	
Material:	Weight: 253673.509 lbs Page: 2/5
401-18 Avenue Nisku, AB T9E 7T5	Drawing Number: T19-0048A-04
QTY:	Rev:



ITEM NO.	QTY.	MATERIAL	PART NUMBER	DESCRIPTION
1	1		BLOCK DISCHARGE	DISCHARGE BLOCK
2	1	AISI 4130, Annealed	PIPE 5IN XXH A519 GR 4130^PLUMBING DISCHARGE PUMP 1	PIPE 5", XXH, A519 GR. 4130 (MIN YIELD 65KSI)
3	2	ASTM A487 GR. 4D	MANIFOLD FITTING LONG SWEEP ELBOW 5in X BW SCH XXS_7500 PSI MAX PRESSURE - OTECO	ELBOW, 5" XXS, LONG SWEEP 90° X R12", 7,500 PSI, AISI 4130
4	1	AISI 4130, Annealed	PIPE 5IN XXH A519 GR 4130 (2)^PLUMBING DISCHARGE PUMP 1	PIPE 5", XXH, A519 GR. 4130 (MIN YIELD 65KSI)
5	2		13152	HAMMER UNION, 5 FIG 1502, BW SCH XXS
6	1		13152	HAMMER UNION, THREADED HALF, 5 FIG 1502, BW SCH XXS
7	1	AISI 4130, Annealed	MANIFOLD FITTING REDUCER 6in X 5in X BW SCH XXS_7500 PSI MAX PRESSURE	REDUCER, 6" X 5", BW SCH XXS, 7,500 PSI, AISI 4130
8	1	ASTM A487 GR. 4D	MANIFOLD FITTING LONG SWEEP 45 DEG. ELBOW 5in X BW SCH XXS_7500 PSI MAX PRESSURE - OTECO	ELBOW, 5" XXS, LONG SWEEP 45° X R6 X 11.50 LG, 7,500 PSI, AISI 4130
9	2		4-10M Weld Flange	4-10M Weld Flange



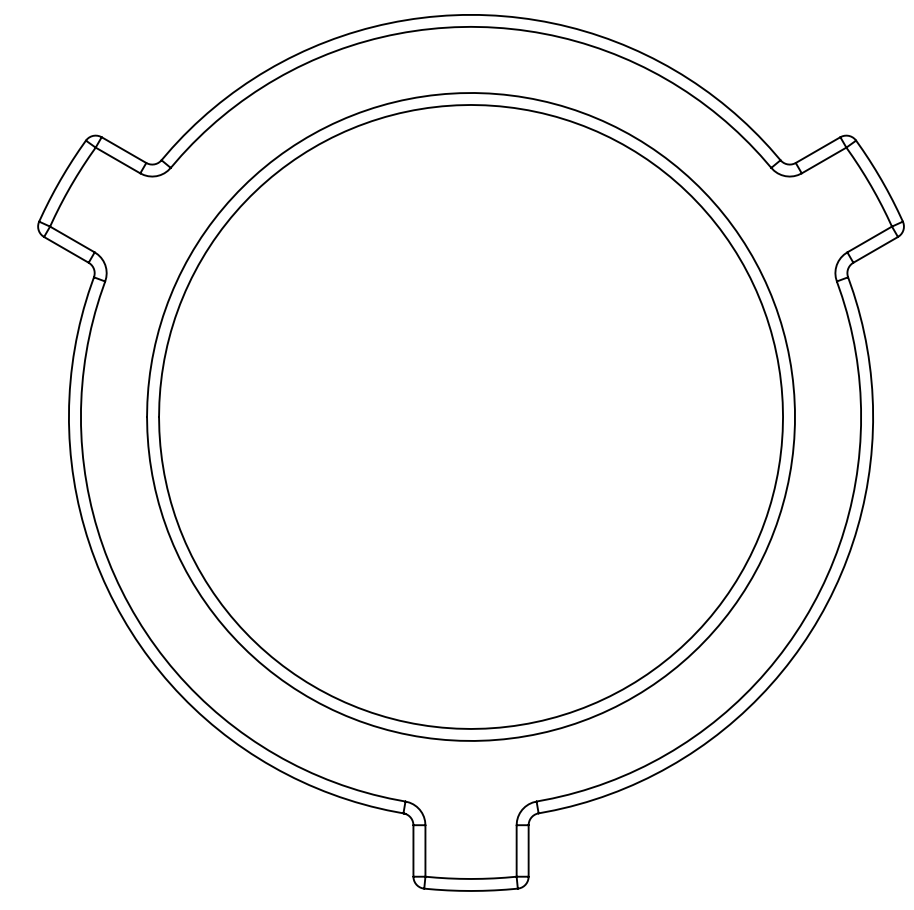
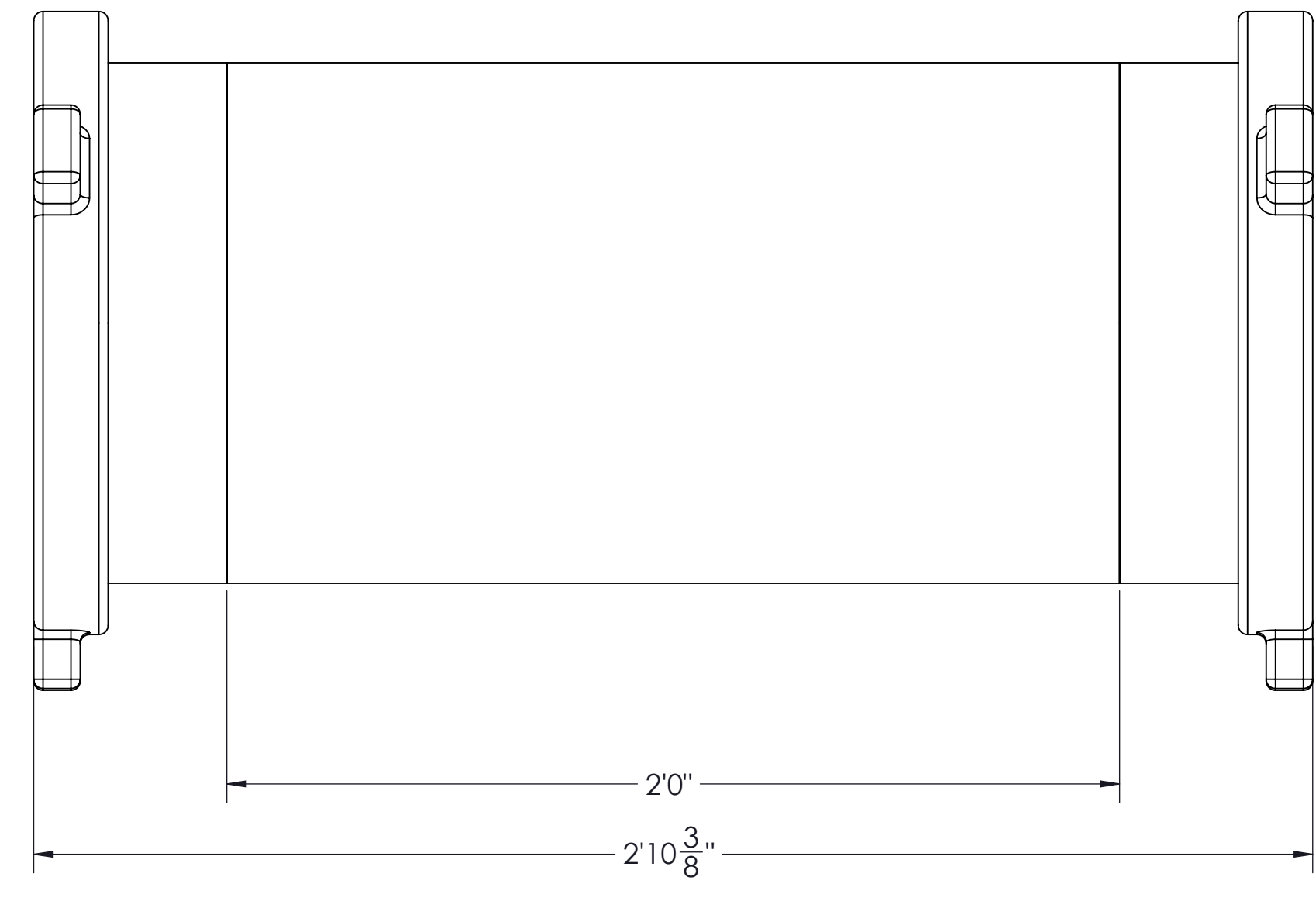
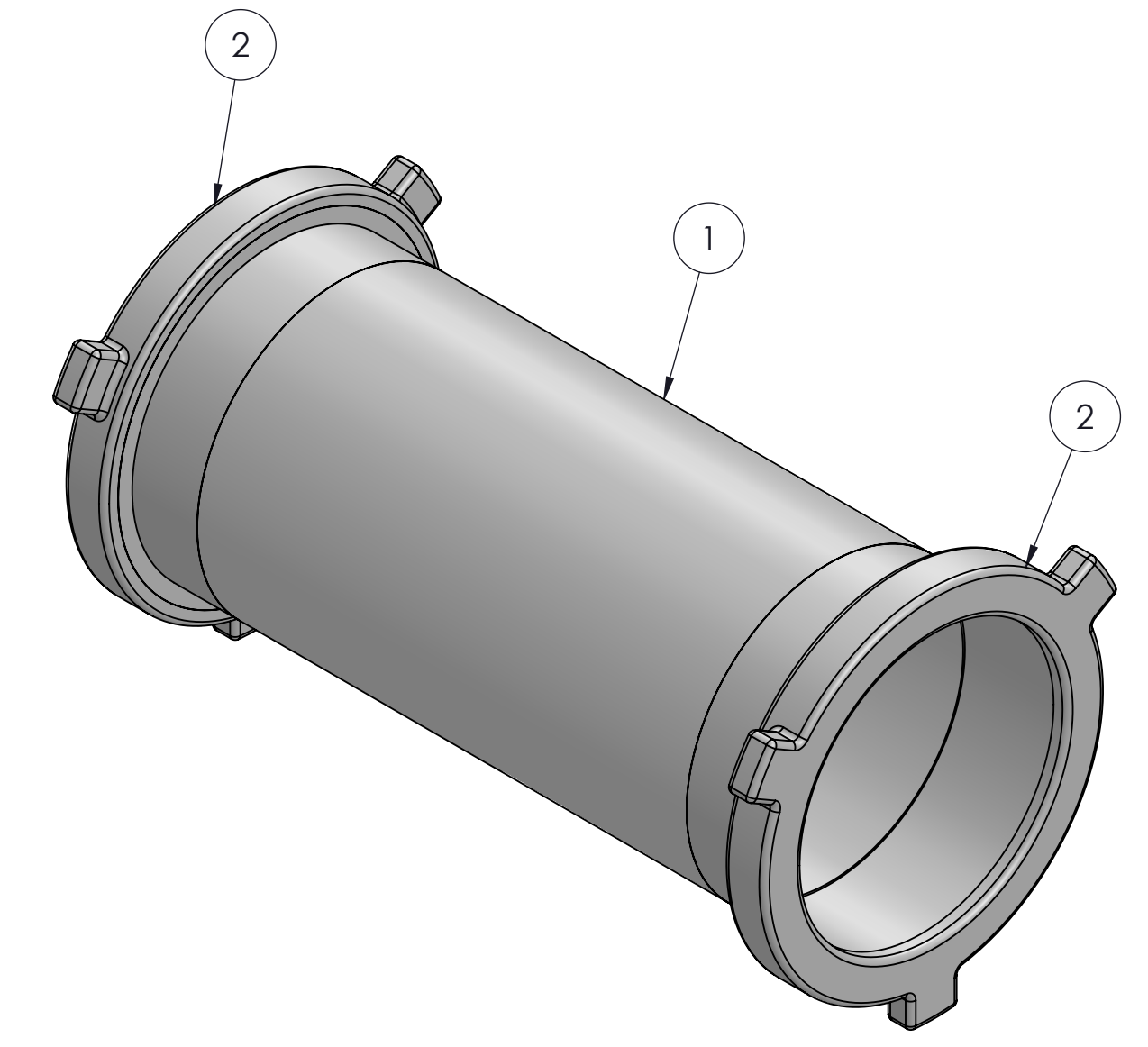
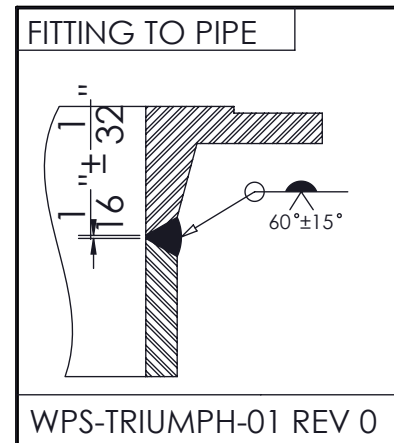
- NOTES:
1. U.N.O. ALL FILLET WELDS TO BE 1/4" CONTINUOUS
 2. U.N.O. ALL GROOVE WELDS TO BE 1/4" CONTINUOUS
 3. U.N.O. ALL STRUCTURAL MATERIAL G40.21-50W
 4. U.N.O. ALL TUBING MATERIAL G40.21-50W
 5. U.N.O. ALL PLATE MATERIAL G40.21-50W
 6. WELD SHOULD NOT EXCEED MATERIAL THICKNESS
 7. STICK AND FLUX CORE WELDING PROCEDURES ARE INTERCHANGEABLE ON AN EQUIVALENT BASIS
 8. ALL WELDING SHOULD COMPLY WITH CSA-W59
 9. SEAL WELD ALL TUBING
 10. REMOVE ALL BURRS AND SHARP CORNERS

ITEM 3 ON SHEET 1 - PLUMBING PUMP DISCHARGE

TOLERANCES FABRICATION .X ±0.1 .XX ±0.06 .XXX ±0.031 FRACTION ±1/16 ANGLE ±1° <small>CORNER RADIUS .06" DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED DO NOT SCALE DRAWING</small>		MACHINING .X ±0.030 .XX ±0.015 .XXX ±0.005 FRACTION ±1/16 ANGLE ±0.5° FINISH 125 RMS		DRAWN BY: MC DATE: 2019-09-10 CHECKED BY: DATE: APPROVED BY: DATE:	THE INFORMATION INCLUDED IN THIS DOCUMENT IS PROPRIETARY AND SHALL NOT BE REPRODUCED, TRANSFERRED, OR DISCLOSED TO OTHERS FOR ANY PURPOSE WHATSOEVER, WITHOUT THE WRITTEN AUTHORIZATION OF TRIUMPH INDUSTRIAL PROCESS LTD.	PLUMBING PUMP DISCHARGE Material: Weight: 83473.082 lbs Drawing Number: T19-0048A-04 Page: 3/5 Rev:
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QTY: 1

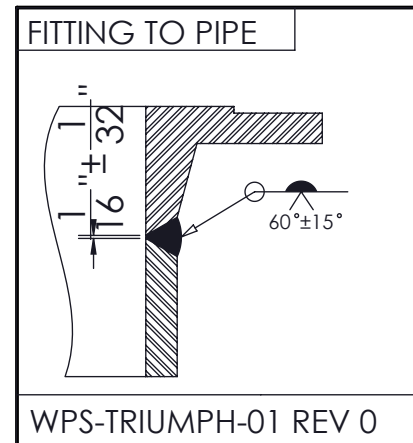
ITEM NO.	QTY.	MATERIAL	PART NUMBER	DESCRIPTION
1	1	ASTM A53B	PIPE 14IN SCH 40^DRESSER SLEEVE	PIPE 12 SCH 40
2	2	Material <not specified>	HAMMERSEAL UNION 12IN	HAMMERSEAL UNION 12IN



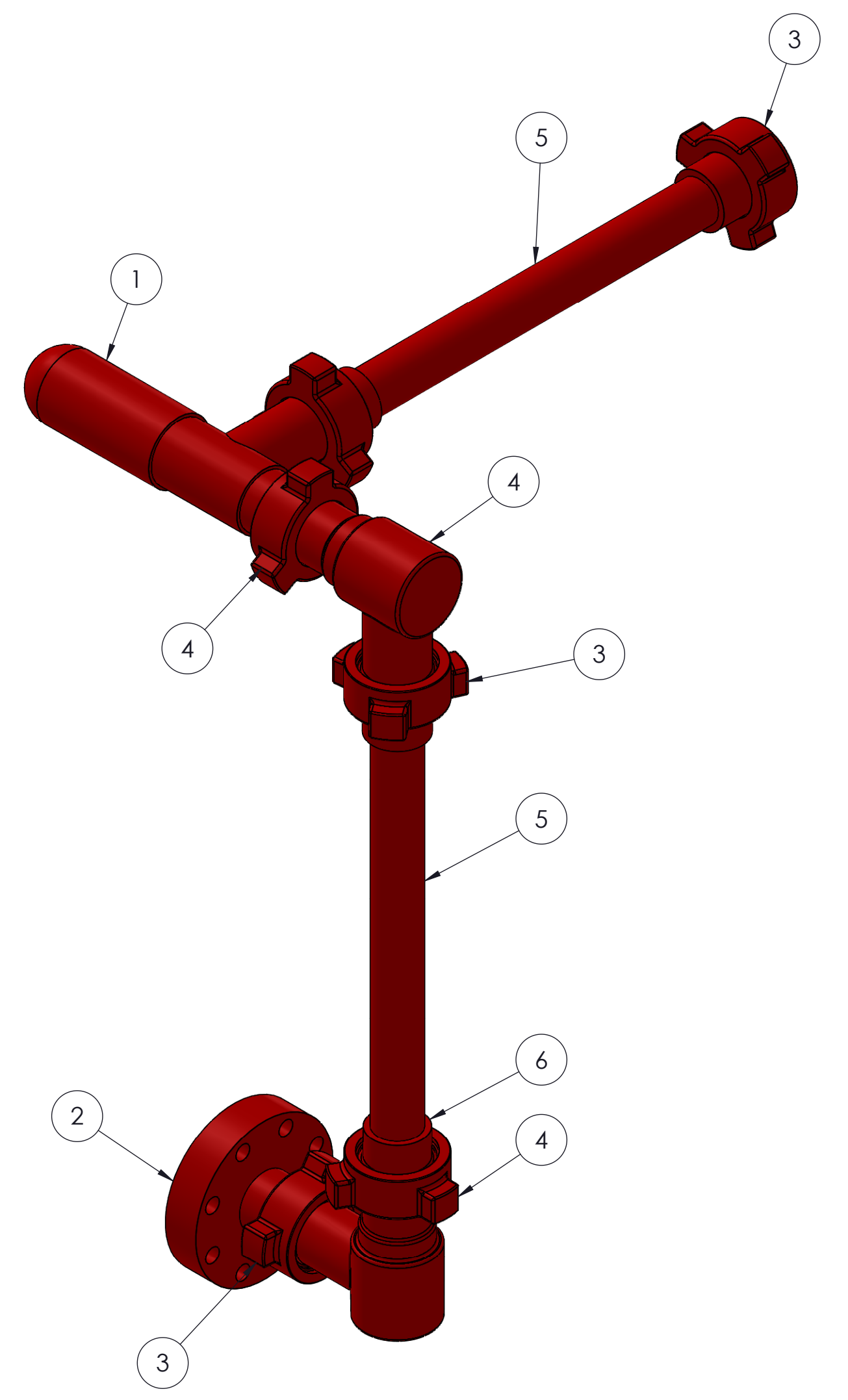
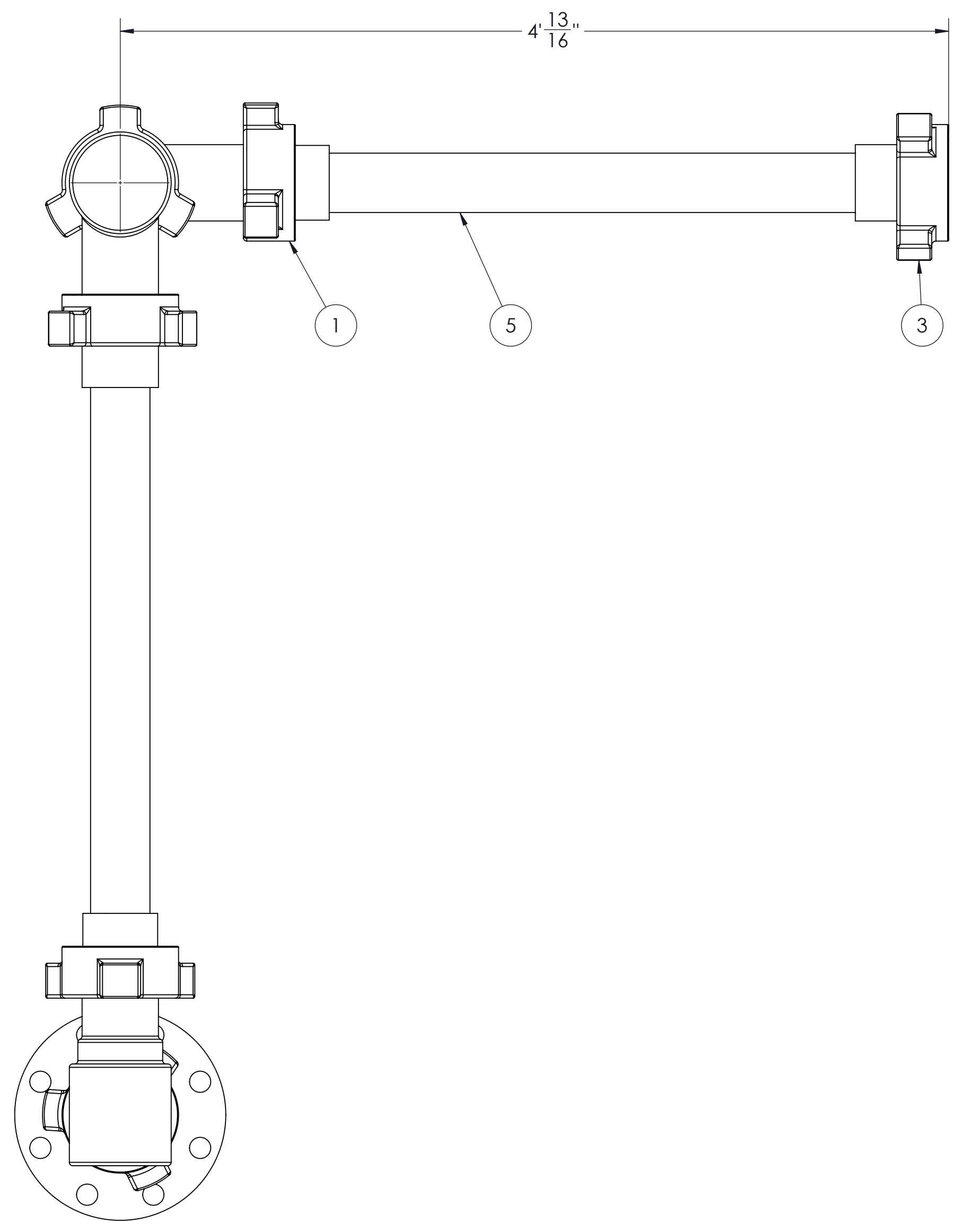
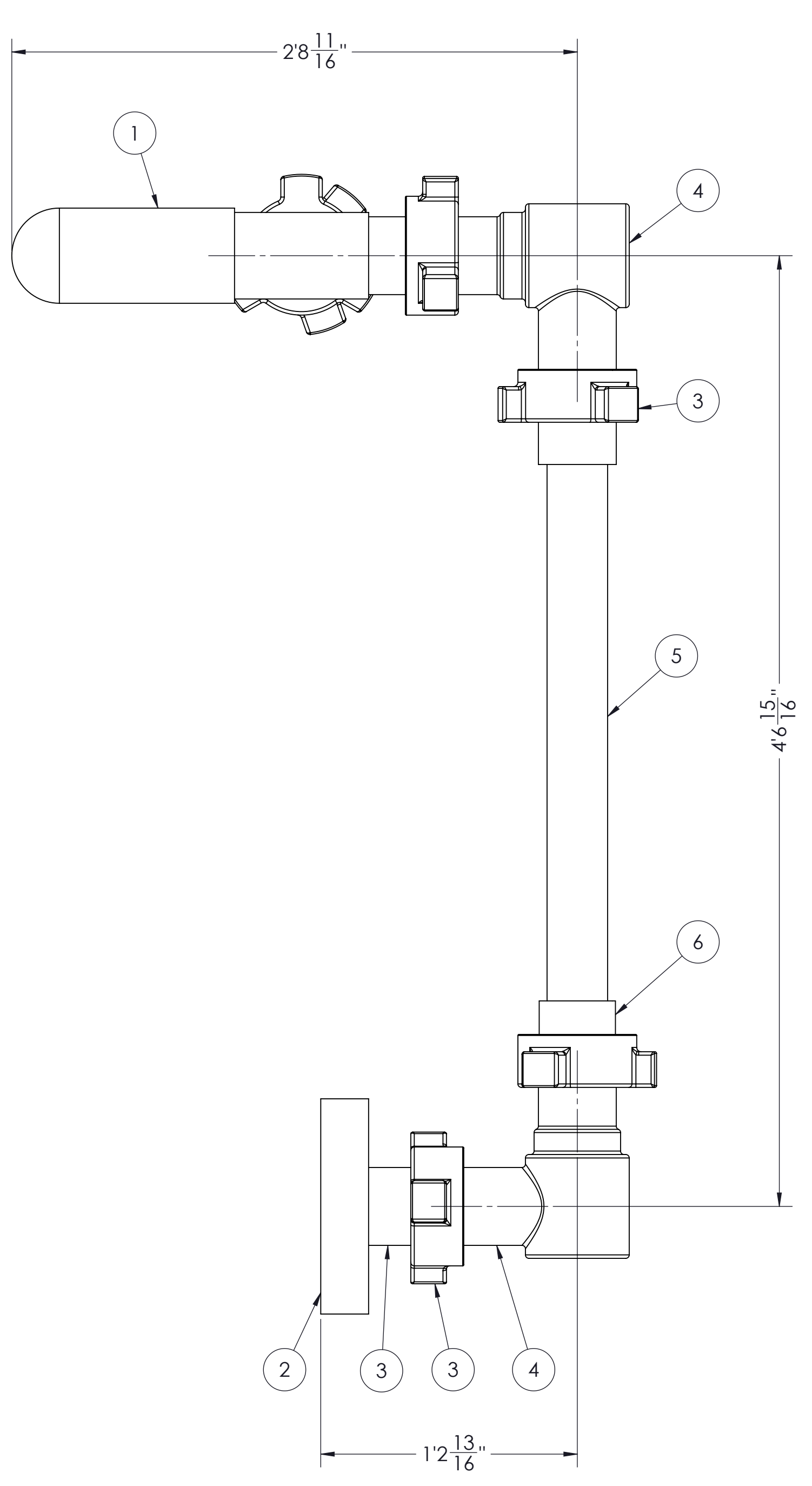
- NOTES:
1. U.N.O. ALL FILLET WELDS TO BE 1/4" CONTINUOUS
 2. U.N.O. ALL GROOVE WELDS TO BE 1/4" CONTINUOUS
 3. U.N.O. ALL STRUCTURAL MATERIAL G40.21-50W
 4. U.N.O. ALL TUBING MATERIAL G40.21-50W
 5. U.N.O. ALL PLATE MATERIAL G40.21-50W
 6. WELD SHOULD NOT EXCEED MATERIAL THICKNESS
 7. STICK AND FLUX CORE WELDING PROCEDURES ARE INTERCHANGEABLE ON AN EQUIVALENT BASIS
 8. ALL WELDING SHOULD COMPLY WITH CSA-W59
 9. SEAL WELD ALL TUBING
 10. REMOVE ALL BURRS AND SHARP CORNERS

ITEM 5 ON SHEET 1 - DRESSER VALVE

TOLERANCES		DRAWN BY: MC	THE INFORMATION INCLUDED IN THIS DOCUMENT IS PROPRIETARY AND SHALL NOT BE REPRODUCED, TRANSFERRED, OR DISCLOSED TO OTHERS FOR ANY PURPOSE WHATSOEVER, WITHOUT THE WRITTEN AUTHORIZATION OF TRIUMPH INDUSTRIAL PROCESS LTD.	DRESSER SLEEVE		QTY: 1	
FABRICATION .X ±0.1 .XX ±0.06 .XXX ±0.031	MACHINING .X ±0.030 .XX ±0.015 .XXX ±0.005	DATE: 2019-09-10			Material:	Weight: 257.852 lbs	Page: 4/5
FRACTION ±1/16 ANGLE ±1°	FRACTION ±1/16 ANGLE ±0.5° FINISH 125 RMS	CHECKED BY:			401-18 Avenue Nisku, AB T9E 7T5	Drawing Number:	Rev:
CORNER RADIUS .06" CONCENTRIC WITH .002 DIA		APPROVED BY:			T19-0048A-04		
DIMENSIONS IN INCHES UNLESS NOTED OTHERWISE DO NOT SCALE DRAWING		DATE:					



ITEM NO.	QTY.	MATERIAL	PART NUMBER	DESCRIPTION
1	1	Cast Alloy Steel	VALVE PRESURE RELIEF 6300-10000 PSI FIG 1502 MxF	VALVE PRESURE RELIEF 3in 3750-7000 PSI FIG 1502 MxF
2	1	44W	FLANGE ADAPTOR 3IN	FLANGE ADAPTER 3IN
3	3	Material <not specified>	NUT WING 3in 1502	NUT WING 3in 1502
4	2	Cast Alloy Steel	ELBOW 90 3in 1502 MxF	ELBOW 90 3in 1502 MxF
5	2	AISI 4130, Annealed	PIPE 5 XXH A519 GR4130^PLUMBING RELIEF MUD PUMP	-
6	2	Cast Alloy Steel	3-1502 THREAD X FPT UNION HALF	3" FIGURE 1502 THREAD SUB FPT



- NOTES:
- U.N.O. ALL FILLET WELDS TO BE 1/4" CONTINUOUS
 - U.N.O. ALL GROOVE WELDS TO BE 1/4" CONTINUOUS
 - U.N.O. ALL STRUCTURAL MATERIAL G40.21-50W
 - U.N.O. ALL TUBING MATERIAL G40.21-50W
 - U.N.O. ALL PLATE MATERIAL G40.21-50W
 - WELD SHOULD NOT EXCEED MATERIAL THICKNESS
 - STICK AND FLUX CORE WELDING PROCEDURES ARE INTERCHANGEABLE ON AN EQUIVALENT BASIS
 - ALL WELDING SHOULD COMPLY WITH CSA-W59
 - SEAL WELD ALL TUBING
 - REMOVE ALL BURRS AND SHARP CORNERS

ITEM 6 ON SHEET 1 - PLUMBING RELIEF MUD PUMP

QTY: 1

TOLERANCES FABRICATION .X ±0.1 .XX ±0.06 .XXX ±0.031 FRACTION ±1/16 ANGLE ±1° <small>CORNER RADIUS .06" DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED DO NOT SCALE DRAWING</small>		MACHINING .X ±0.030 .XX ±0.015 .XXX ±0.005 FRACTION ±1/16 ANGLE ±0.5° FINISH 125 RMS		DRAWN BY: MC DATE: 2019-09-10 CHECKED BY: DATE: APPROVED BY: DATE:	THE INFORMATION INCLUDED IN THIS DOCUMENT IS PROPRIETARY AND SHALL NOT BE REPRODUCED, TRANSFERRED, OR DISCLOSED TO OTHERS FOR ANY PURPOSE WHATSOEVER, WITHOUT THE WRITTEN AUTHORIZATION OF TRIUMPH INDUSTRIAL PROCESS LTD.	PLUMBING RELIEF MUD PUMP Material: Weight: 555.184 lbs Drawing Number: T19-0048A-04	Page: 5/5 Rev:
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