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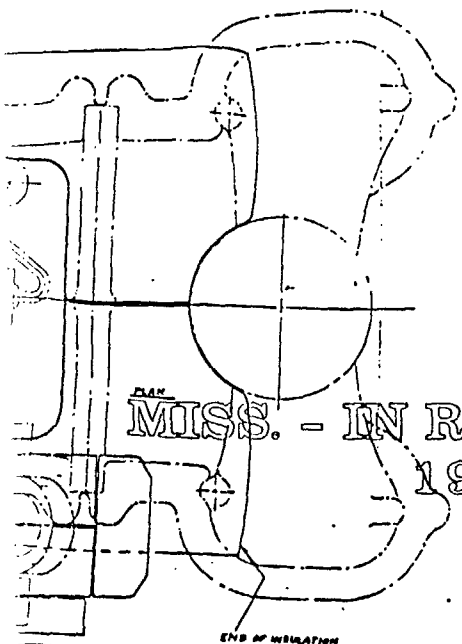

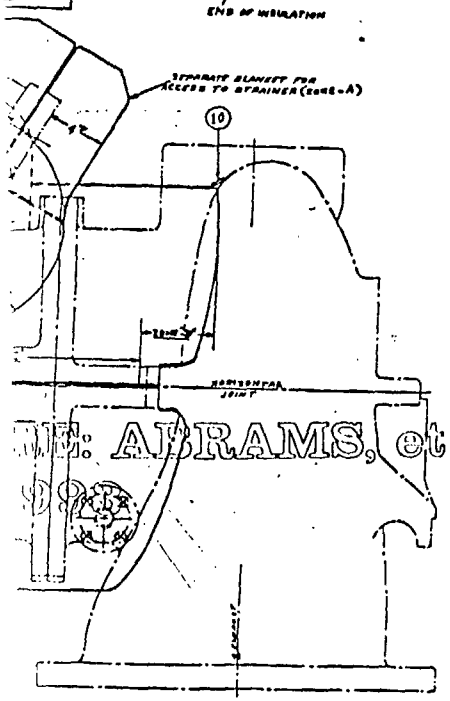

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TEMPERATURES FOR INSULA		
ZONE	TEMP °F	INSU
A	751°-855°	4
B	501°-750°	3
C	335°-500°	2
D	100°-334°	1

PLAINTIFF'S EXHIBIT
WH-029

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PROPOSED INSULATION ARRANGEMENT
INSULATION TO BE FURNISHED BY SHIPBUILDER
EXCEPT, PURCHASE ORDER P-23145 (SOLID-304) TO BE FURNISHED BY WESTINGHOUSE ELEC. CORP.

GENERAL NOTES

1- THIS PLAN TO BE FOLLOWED AS CLOSELY AS POSSIBLE. PLANNING SUCH MODIFICATIONS AS MAY BE NECESSARY TO PROVIDE FOR ACCESS TO VALVES, ETC.

2- INSULATION AND LAGGING TO BE NEATLY FITTED TO ACTUAL MACHINERY AND GROUND PIPING.

3- PRIOR TO INSULATING, ALL EXTERNAL SURFACES OF TURBO-GENERATOR, THROTTLE VALVE, STRAINER AND STEAM PIPE MANIFOLD SHALL BE THOROUGHLY CLEANED AND PAINTED WITH AT LEAST TWO (2) COATS OF ALUMINUM PAINT.

4- PORTABLE INSULATING FELT BLANKETS SHALL BE PROVIDED WHERE THROTTLE VALVE AND TURBINE CASING ARE TO BE INSULATED. THESE BLANKETS SHALL BE MADE UP OF TWO LAYERS OF 1" THICK FELT, WITH STAGGERED JOINTS. EACH LAYER OF FELT SHALL BE WRAPPED WITH ASBESTOS CLOTH AND THE WHOLE BLANKET SHALL BE STITCHED TOGETHER WITH ASBESTOS THREAD. BLANKETS TO BE FASTENED BY LACING THE OUTSIDE SURFACE WITH ASBESTOS CLOTH TAPE AND BRASS HOOKS AND EYES. THE INSIDE SURFACE WITH ASBESTOS CLOTH, TYPE TO BE AGREED UPON TO BE LACED TOGETHER WITH 1/4" BRASS CHAPTER RING AND GALVANIZED STEEL WIRE. ALL BLANKETS TO BE STITCHED TO BOTH SIDES OF CLOTH. BLANKETS TO BE SECURED IN ACCORDANCE WITH THE SKETCH AND TIED WITH SOFT ANNEALED IRON WIRE FASTENED TO STEEL WORK. WIRE NOT TO BE ALLOWED TO RUST.

5- ALL EXPOSED BOLTS, THROTTLE VALVE, CASING AS INDICATED, STRAINER AND STEAM PIPE MANIFOLD TO BE INSULATED WITH TWO LAYERS OF 1" THICK (TOTAL 2") ASBESTOS MATTRESS FOR LAGGING TO BE STRAIGHT.

6- PLASTIC CEMENT TO BE MIXED WITH U.S.P. PORTLAND CEMENT.

7- ALL SLING, COPPER WIRE AND ALL BE SUBSTITUTED AND THIS ITEM.

The turbine body, throttle valve... to be covered with 2 layers of 1" thick felt for a total of 4" of asbestos

Asbestos felt Staggered

Purchase order P-23145 is Sun Shipbuilding & Dry Dock Co.

21 22 23 24 25	MA-11	SUN SHIPBUILDING & DRY DOCK CO. (FEB. 14, 1983)	P-23145	333 334 335 336 337
6 7 8 9 10	MA-8	[illegible] SHIPBUILDING CORP. (APRIL 7, 1983)	P-23145	159 160 161 162 163
1 2 3 4 5	K1-7	NEWPORT NEWS SHIPBUILDING & D.D. CO.	P-23145	154 155 156 157 158
TYPE NO.	CONTRACT OR			DATE AND
U.S. MARITIME ADMINISTRATION		SHIPYARD		

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GENERAL NOTES

1 – SCREW HOLES SPACED TO SUIT WORK APPROX. 6" CENTER ON LAGGING APPROX. 6" CENTER ON FLOOR PLATES.

2 – ALL DIMENSIONS ARE TO INSIDE OF PLATES FOR LAGGING.

3 – SHOP TO PROVIDE NECESSARY HOLES & CUTOUTS IN ADDITION TO THOSE SHOWN.

4 – GRIND ALL EXPOSED EDGES & ROUGH SURFACES.

5 – PAINT ALL EXPOSED SURFACES.

6 – USE LAGGING SECTIONS SHOWN ON DWG. 12-E-632.

7 – CLEARANCE HOLES FOR SCREWS 3/8 DRILL
TAPPED HOLES "F" DRILL 5/16 18 TAP CL. 3 AN

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SF003336

TUBE

TUBE

ISSUED JUN 25 1957

I-J-4246

PLAINTIFF'S EXHIBIT WH-727