



Industrial Fiberglass Specialties, Inc.

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Technical Bulletin

Factory Manhours

Layout and Jigging for 0' - 10' Length Spools

Diameter	# of Alignments*					
	0	1	2	3	4	5
2" to 4"	.3	.6	.8	1.1	1.3	1.6
6" to 8"	.4	.8	1.2	1.6	2	2.4
10" to 16"	.7	1.5	2.2	3	3.7	4.5
18" to 22"	1.2	2.4	3.6	4.8	6	7.2
24" to 28"	1.5	3	4.5	6	7.5	9
30" to 34"	1.6	3.4	5.1	6.9	8.6	10.1
36" to 40"	2	4	6	8	10	12
42"	2.5	5	7.5	10	12.5	15

Layout and Jigging for 11' - 20' Length Spools

Diameter	# of Alignments*					
	0	1	2	3	4	5
2" to 4"	.4	.6	.9	1.1	1.4	1.6
6" to 8"	.8	1.2	1.6	2	2.4	2.8
10" to 16"	1.2	2	2.7	3.5	4.2	5
18" to 22"	1.6	2.8	4	5.2	6.4	7.6
24" to 28"	2.5	4	5.5	7	8.5	10
30" to 34"	2.7	4.5	6.2	8	9.7	11.5
36" to 40"	3.2	5.2	7.2	9.2	11.2	13.2
42"	4.2	6.7	9.2	11.7	14.2	16.7

*"0" alignment column represents jigging time for pipe with one fitting. Two fittings = one alignment, three fittings = two alignments, etc.

Shipping and Handling

Diameter	# of Open Ends				
	1	2	3	4	5
2" to 4"	.4	.5	.5	.6	.7
6" to 8"	.9	1	1.1	1.2	1.3
10" to 16"	1.4	1.6	1.8	2	2.1
18" to 22"	1.9	2.2	2.5	2.8	3.1
24" to 28"	2.9	3.3	3.6	4	4.4
30" to 34"	3.1	3.6	4	4.5	4.9
36" to 40"	3.7	4.2	4.7	5.2	5.7
42"	4.8	5.5	6.1	6.7	7.3

Drawing Preparation (Using Customer Isometric Drawings)

Diameter	# of Views and/or Details				
	1	2	3	4	5
2" to 12"	1.4	1.7	1.9	2.2	2.4
14" to 42"	1.6	2	2.4	2.8	3.2