

1. Scope: JON Q632 Sixcon Fuel Tank Frame
  - 1.1 Purpose: This document provides tape masking instructions for Sixcon Fuel Tank frame to eliminate grinding and prepping of painted surfaces prior to welding processes on tank braces.
  - 1.2 Applicability Sixcon fuel (JON Q632) and water tank (JON Q711) container frames
  - 1.3 Applicable Documents: None
  - 1.4 Definitions: None
  - 1.5 Instructions: See attached sheets.
  - 1.6 Author: Engineering and Integration CWC 640.

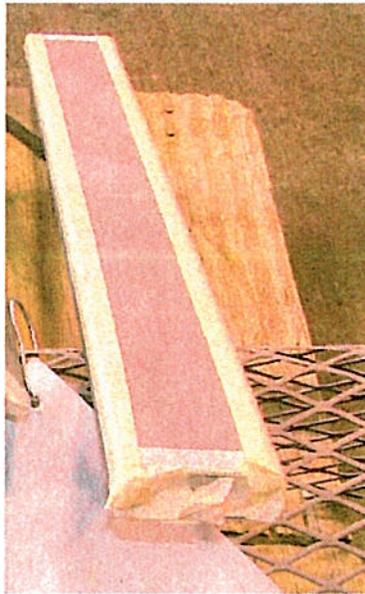
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## 1.7 Identification of parts

- 1) 4 Side Braces
- 2) 2 Spacers
- 3) 2 L brackets
- 4) 1 Plate
- 5) 1 Top Brace
- 6) 1 Vertical Side Support
- 7) 1 Top Tubing above Vertical Side Support
- 8) 2 Angle Braces
- 9) 1 Top Tubing 83.06 (non-sump end)
- 10) 2 sump end corner posts.
- 11) 2 top tubing 63.38 (sump end)
- 12) Bottom Brace

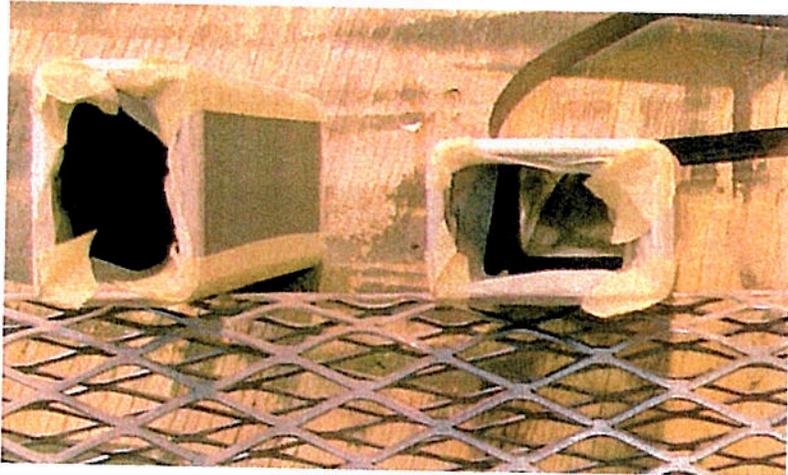
## 1.8 Locations to tape:

- 1) 1. To tape 4 side braces cap ends with 1" tape on all four sides.
2. Center tape over center of beam corners and tape the length of the beam covering a minimum of 1/2" on each side of the beam, for all four corners. For an example please see picture 1.



Picture 1: Taping of Side Brace

- 2) 1. To tape the spacers, start by tapping off a 1" segment at each end. See Picture 2.
2. Next center tape over the corners and tape the length of the spacer. Repeat this taping for all three corners.



Picture 2: Taping of Spacers view 1

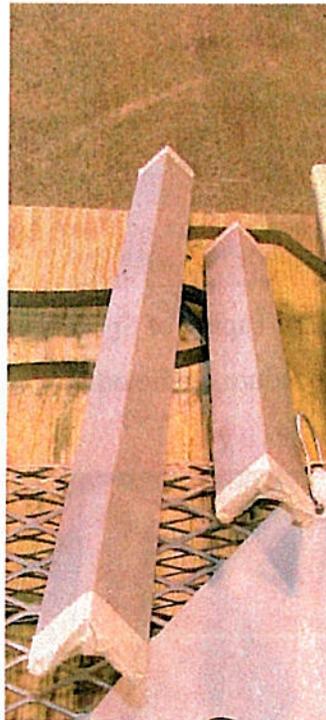
3. Follow the same taping procedure on the other spacer. For an example please see Picture 3.



Picture 3: Taping of Spacers.

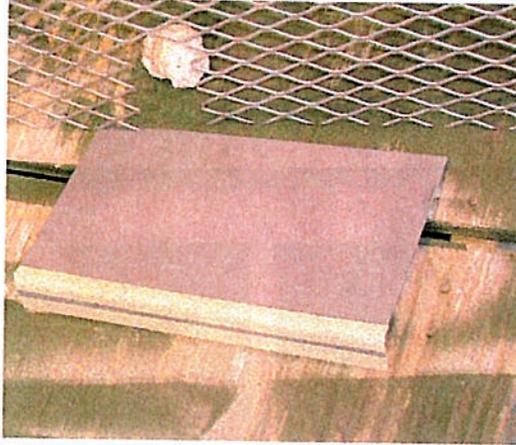
- 3) 1. To tape the L brackets first wrap the ends with 1" tape.
2. Next tape off one side of the L bracket. Repeat same procedure for the other bracket. For an example of which two sides of the L brackets to tape please see picture 4.

Note: In picture 4 the top face of the L bracket has not been taped, also it does not matter which side is taped so long as it is one of the sides shown in Picture 4.



Picture 4: Taping of L Brackets

- 4) 1. To tape the plate, tape the top portion of the bent lip as shown in the Picture 5.



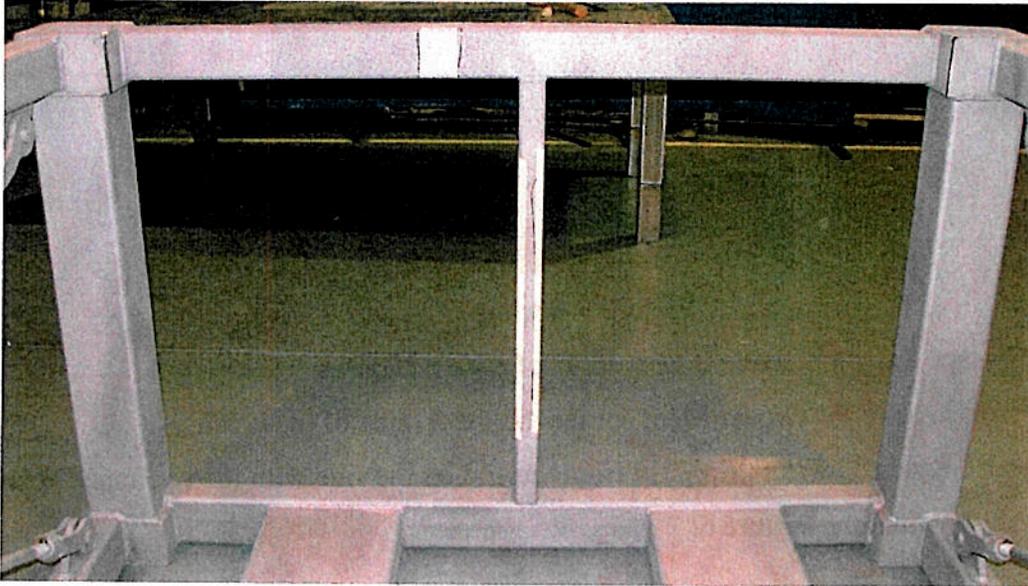
Picture 5: Taping of Plate

- 5) 1. To tape the top brace first tape off 1" of each end on all sides.  
2. Next tape of the two adjacent corners on the 3" side of the beam.  
3. Also tape a 3" wide strip 7" in from the end on the side with the two taped corners, as shown in the Picture 6.



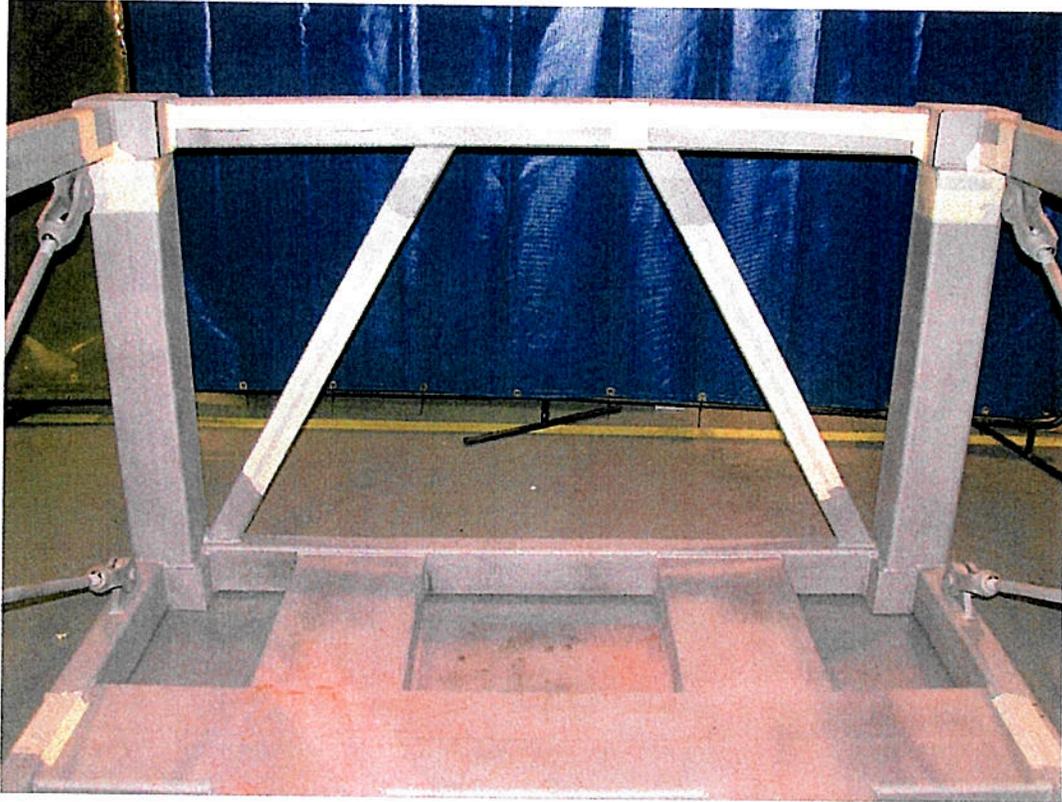
Picture 6: Taping of Top Brace

- 6) 1. To tape the vertical side support measure down 6.5" and center 1" tape over the center of the beam corner and tape a 25" section making sure to cover at least 1/2" on either side of the corner. Copy the same procedure on the adjacent corner on the 4" side of beam as shown in Picture 7.



Picture 7: Taping of Vertical Support

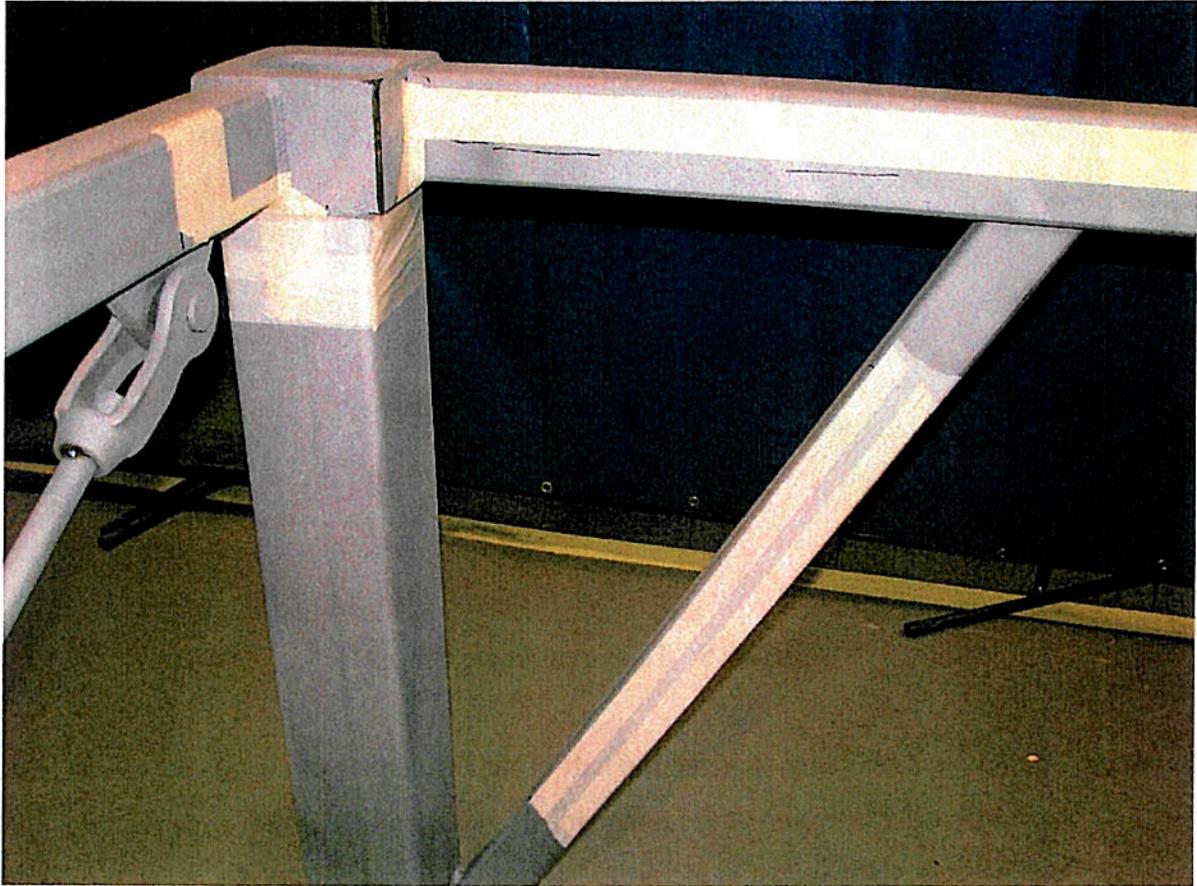
- 7) 1. To tape the top tubing above the vertical side support tape a 3" section locate 7" to the left of the center line from the top corner to the bottom corner as shown in Picture 7
- 8) 1. To tape the angle braces measure 6.5" down on the broad side of the angel brace and tape 28" leaving 6.5" exposed at the bottom.  
2. Repeat procedure for second brace. For an example please see picture 8.



Picture 8: Taping of Angle Braces.

- 9) 1. Top tubing 83.06 long, tape the top half of the inside face of the beam.
2. Next tape off the section of the underside of the beam located between the two angle braces. (Not shown in picture)
3. After taping the section between the angle braces tape a 3" wide section 7" from the center located to the left when looking from the inside out on the opposite beam. For an example please refer to picture to Picture 8.

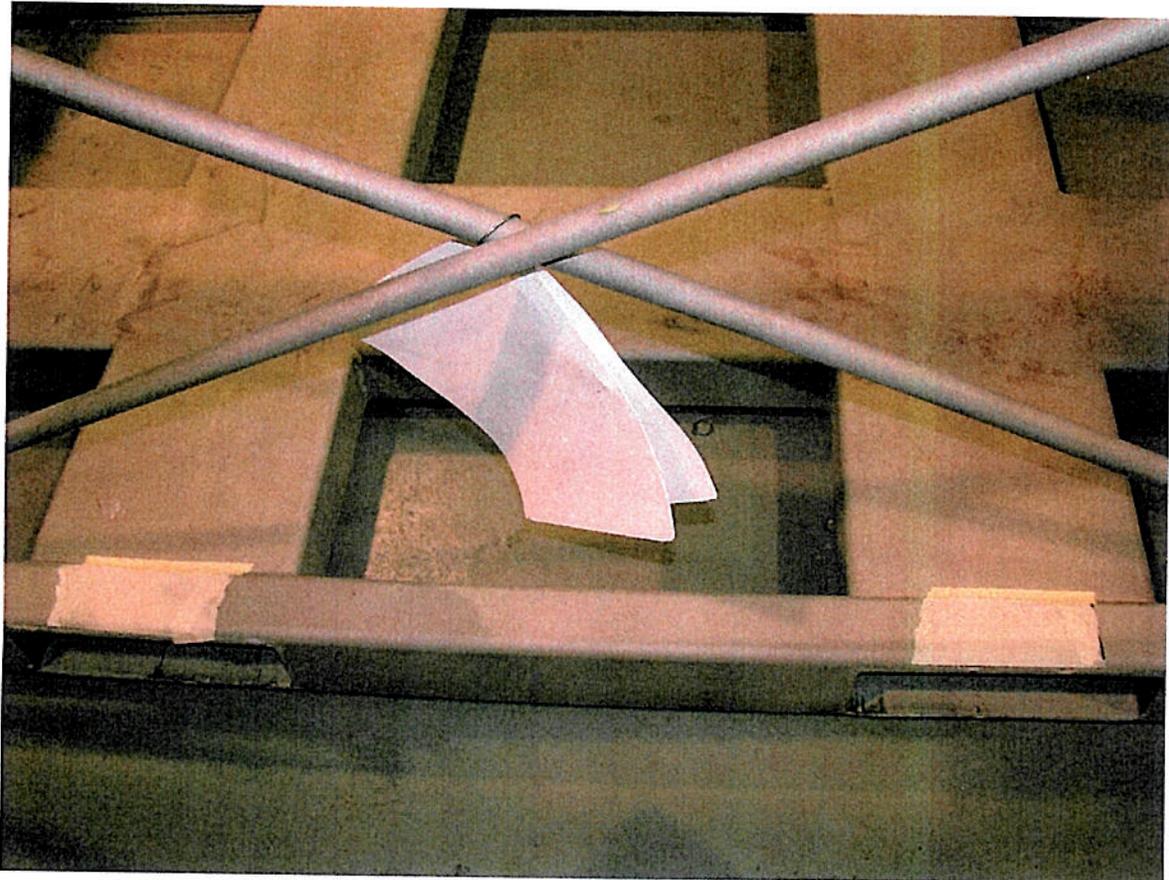
- 10) 1. To tape the corner posts tape a 4" section of the beam starting just below the weld on the inner facing surfaces as shown in Picture 9.



Picture 9: Taping of Sump End Corner Posts Close-up View

- 11) 1. Tape the top Tubing 63.38" beam starting at the end of the beam closest to the front by centering the 1" wider tape over the corner taping 1/2" on each side of the beam for 3." At the end of the 3" section use the 3" tape to cover the beam from corner to corner creating an L shape. See picture 9 for an example.  
2. On same beam tape two 7" sections on the underside of the beam located 21" in from the corner posts. See Picture 8.  
3. Repeat the same procedure for the top beam on the opposite side of the frame.

11) 1. To tape off the bottom beam measuring 63.38" long, tape off two 7" sections with the 3" wide tape 21" in from each of the corner posts. See picture 10 for an example.



Picture 10: Taping of Bottom Brace. Note: Be sure to tape the opposite side as well.

END OF INSTRUCTION

