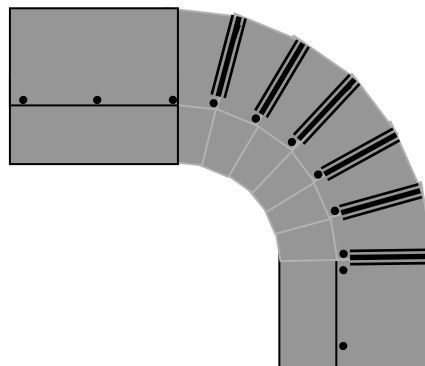


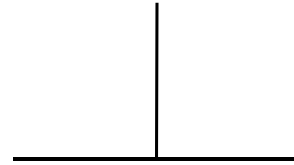
International Association of Heat and Frost Insulators and Asbestos Workers



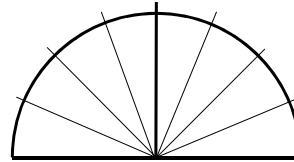
Elbow Gore



Step 1: Start with a horizontal baseline and a vertical line rising from the center.

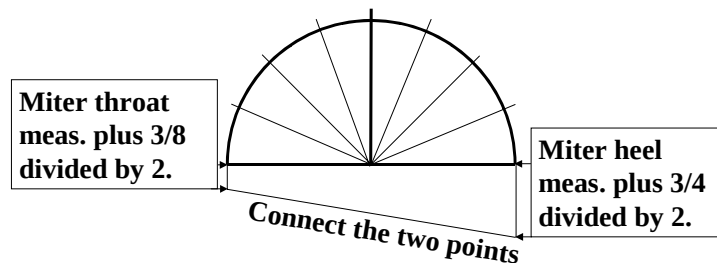


Step 2: Draw a half circle the size of the outside diameter of the pipe insulation from the center of the baseline.

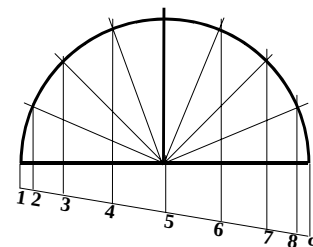


Step 3: Divide each quarter into 4 equal parts.

Step 4: On the left side of the half circle, measure down the miter throat measurement plus $\frac{3}{8}$ " divided by 2. On the right side of the half circle, measure down the miter heel measurement plus $\frac{3}{4}$ " divided by 2. Connect these two points.



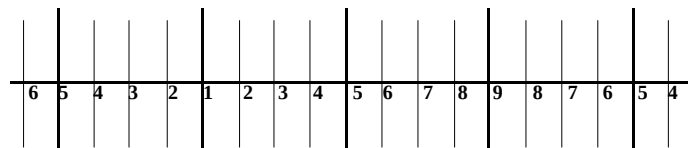
Step 5: Project the lines (using a square) from the equal divisions of the arc down to the diagonal line and number 1 thru 9..



Reference
Drawing

Step 6: Draw a line the length of the pipe insulation circumference. This is called the layout line. Divide the circumference line into 16 equal segments.

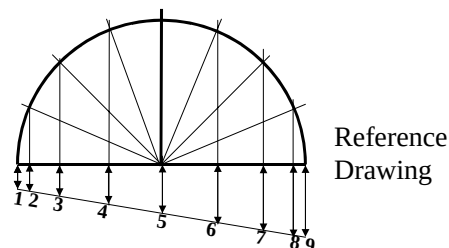
Step 7: Add one segment each direction to provide for a lap and number as shown. Number the lines starting with #6 and descend to #1 then back up to #9 then descend to #4. Draw perpendicular lines thru each mark.



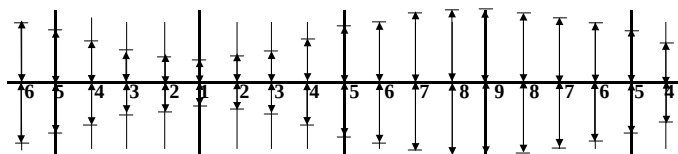
Layout Line



Step 8: Using dividers, transfer the measurements as shown from the reference drawing to the corresponding numbers above and below the layout line.



Reference Drawing



Layout Line

Step 9: Connect the scribe marks to produce the pattern. If the laps are more than 2 inches each, trim back leaving 2 inches on each end

Step 10: Mark the #5's for the bead & crimp start and stop locations and the #9 for the center mark.

