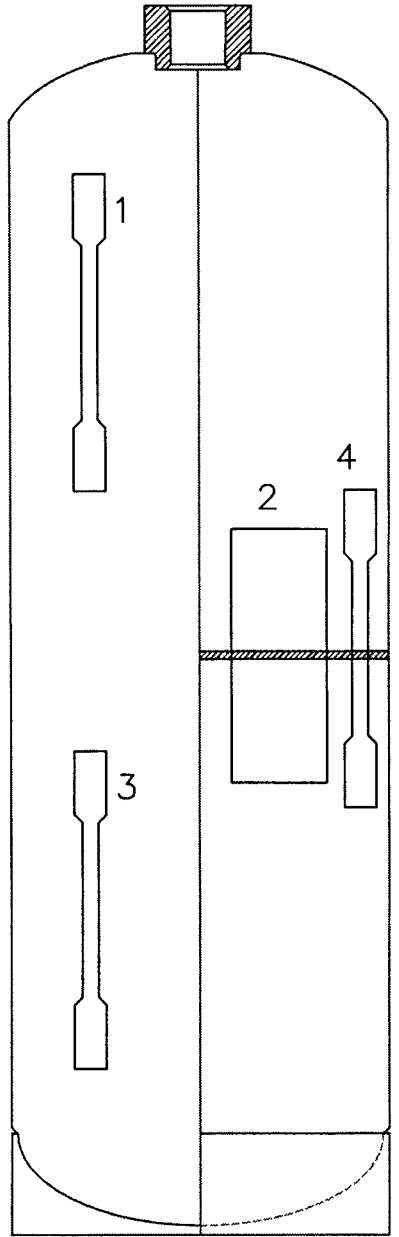
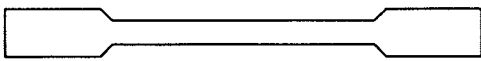


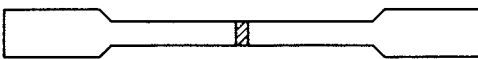
SEAMLESS SIDEWALL
CONSTRUCTION



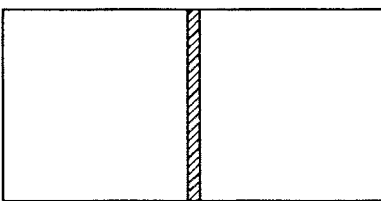
TWO PIECE
CONSTRUCTION



PARENT MATERIAL TEST
SAMPLE 1 & 3



WELD TENSILE TEST
SAMPLE 4



WELD BEND TEST
SAMPLE 2

THIS FIGURE ILLUSTRATES THE PROPER TENSILE
LOCATION FOR A 2 PIECE CYLINDER THAT HAVE DEEP
DRAWN HEADS.

FIGURE #4