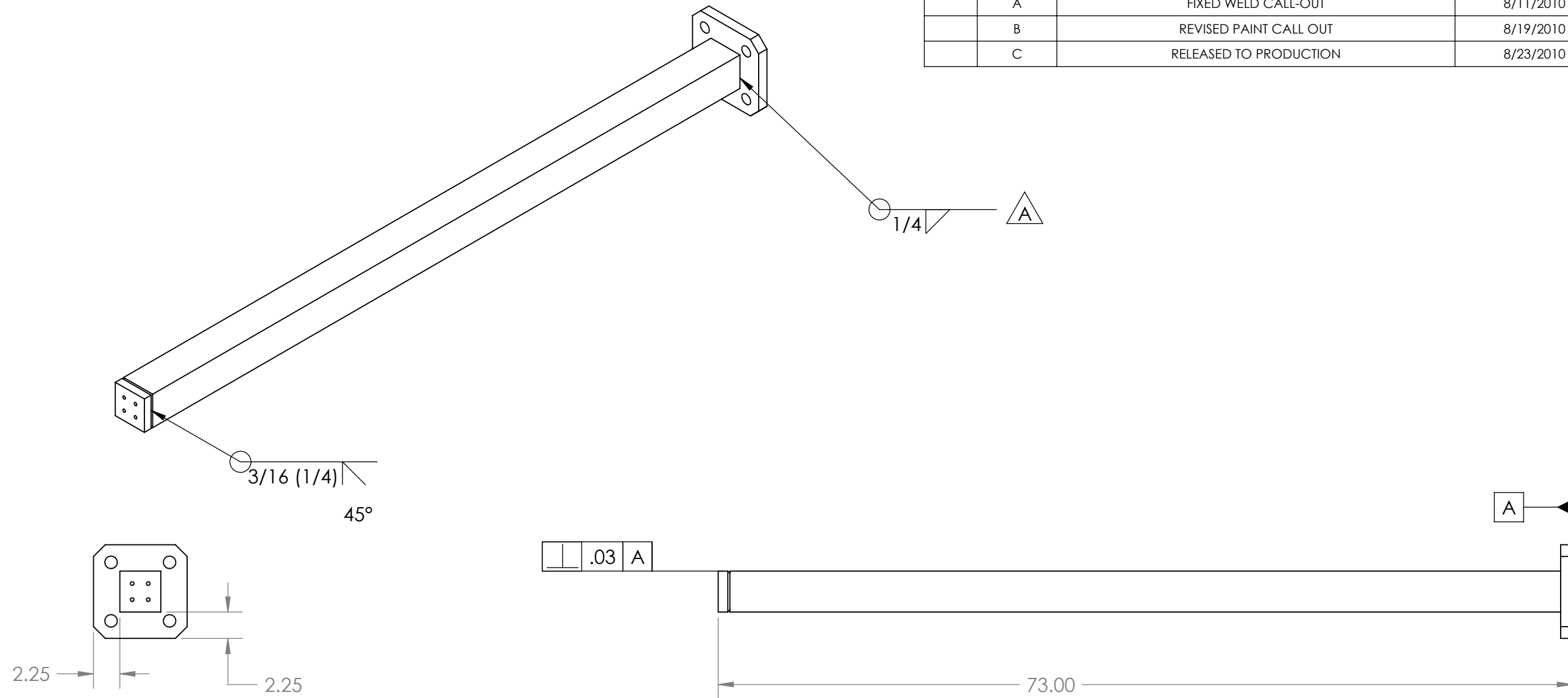


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	FIXED WELD CALL-OUT	8/11/2010	MKM2
	B	REVISED PAINT CALL OUT	8/19/2010	MKM2
	C	RELEASED TO PRODUCTION	8/23/2010	MKM2



NOTES:

1. WELD PER QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE, LATEST REVISION
2. ALL WELDS TO BE GMAW-S, TRIMIX GAS
3. NO POST WELD HEAT TREATMENT IS REQUIRED
4. PLACE SCREWS IN THE TAPPED HOLES TO PREVENT PAINT FROM GETTING IN THE HOLES.
5. PRIOR TO PAINTING, PREPARE SURFACE TO SSPC SP-10 (NEAR WHITE) BLAST CLEANING
6. REFER TO QP112, SECTIONS 1.4, 1.5, AND 1.6
7. PRIMER WITH INORGANIC ZINC PAINT, LOW VOC. DFT SHOULD BE BETWEEN .003 AND .004"
8. FINISH COAT WITH .008"- .010" DFT CARBOLINE 450, GRAY COLOURED

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114440-00M	MEMBER, STAND, A-18	1
2	114441-00M	PLATE, FOOT, STAND, A-18	1
3	114442-00M	PLATE, BOLT, STAND, A-18	1

MATERIAL: ASTM A36 STEEL

UNLESS OTHERWISE SPECIFIED:  
 DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 ANGULAR: ±0°30'  
 .XX ± .03  
 .XXX ± .005  
 UNSPECIFIED FILLETS: R.015  
 BREAK EDGES .010x45°  
 REMOVE ALL BURRS

//, □, ⊥ WITHIN .03

THIRD ANGLE PROJECTION



WEIGHT: 102.09#

APPROVALS	DATE
DRAFTER MKM2	7/30/10
CHECKER ER	8/16/10
ENGINEER MKM2	7/30/10

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TITLE:

STAND, A-18

DO NOT SCALE  
 DRAWING

DWG. NO. 114443-00WM	REV C
SCALE: 1:10	SHEET 1 OF 1