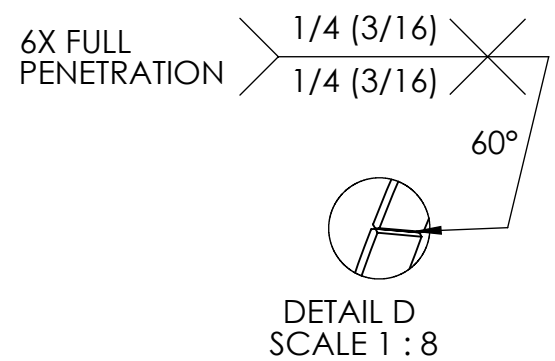
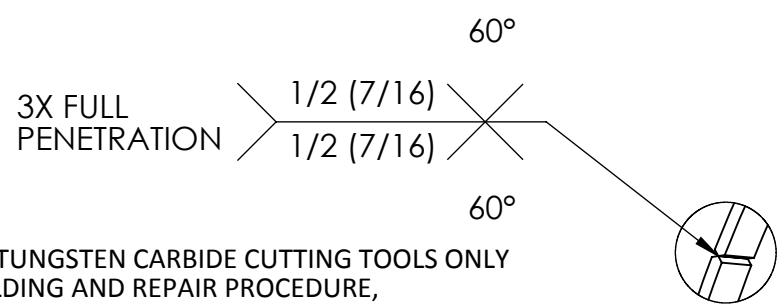
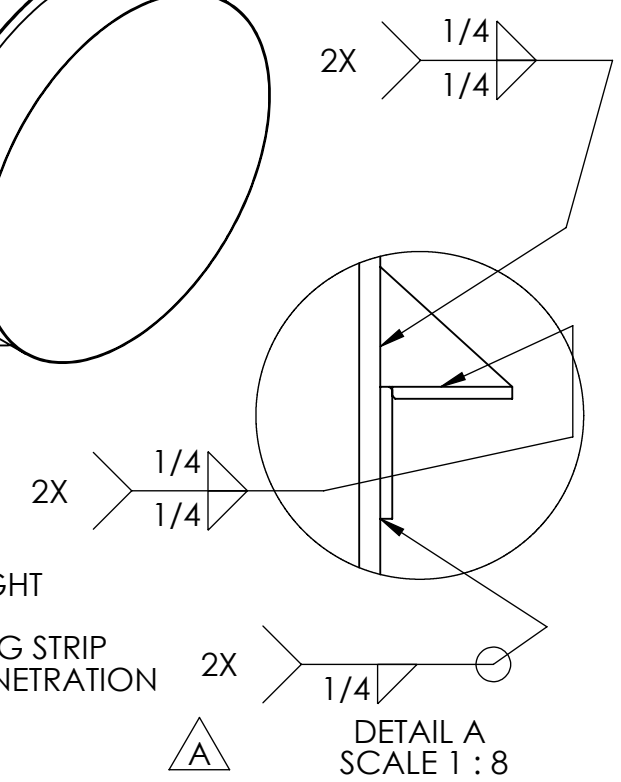
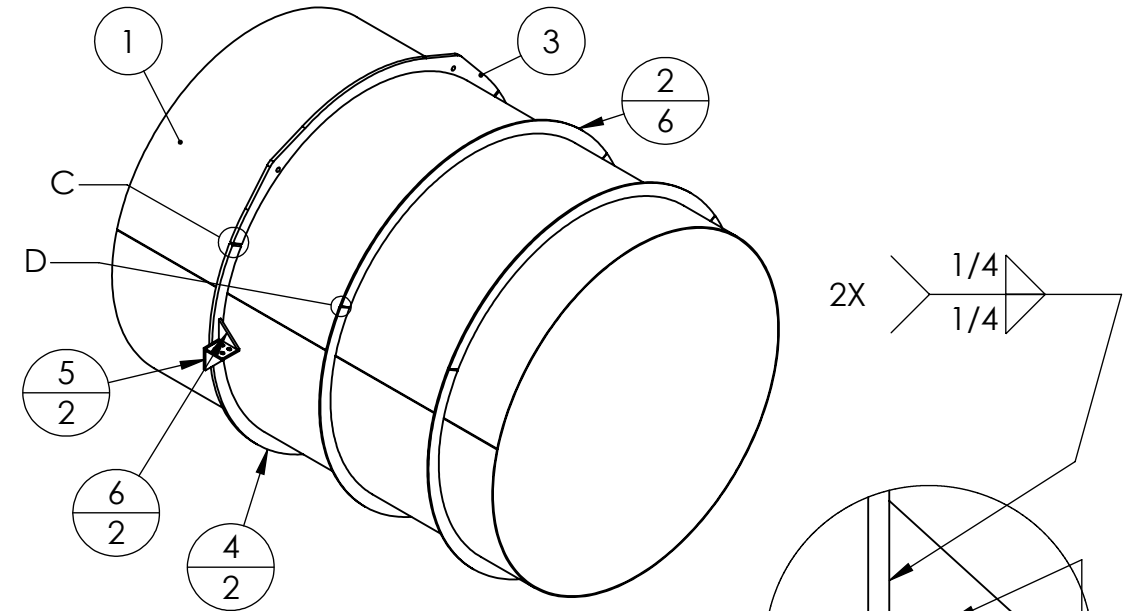
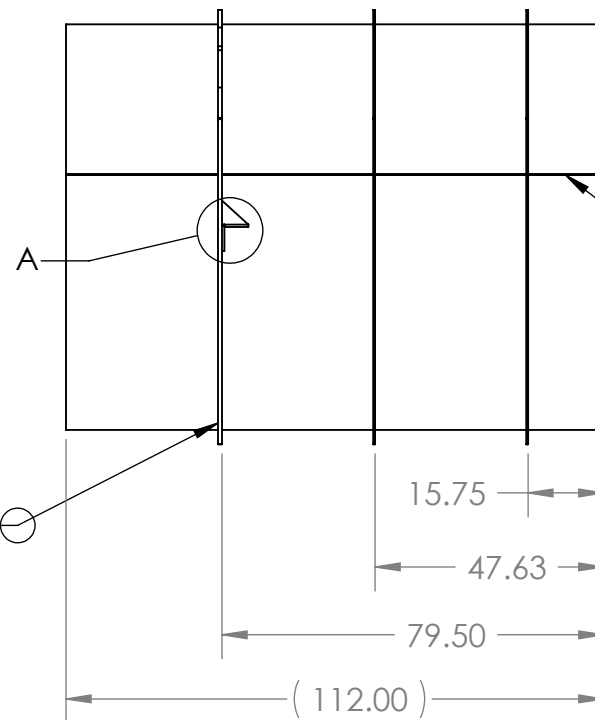
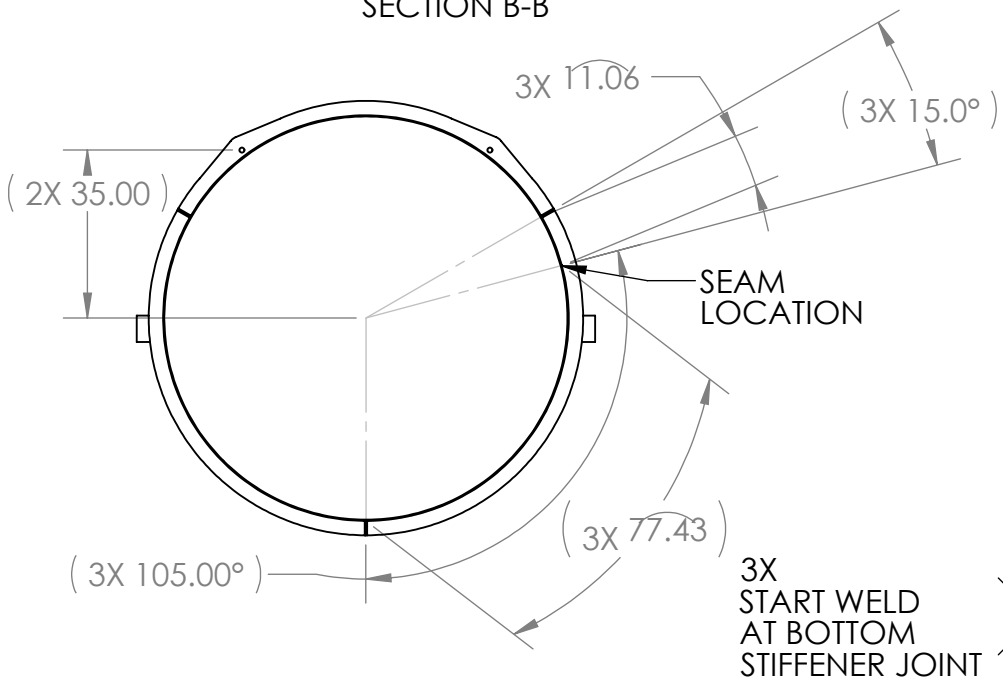
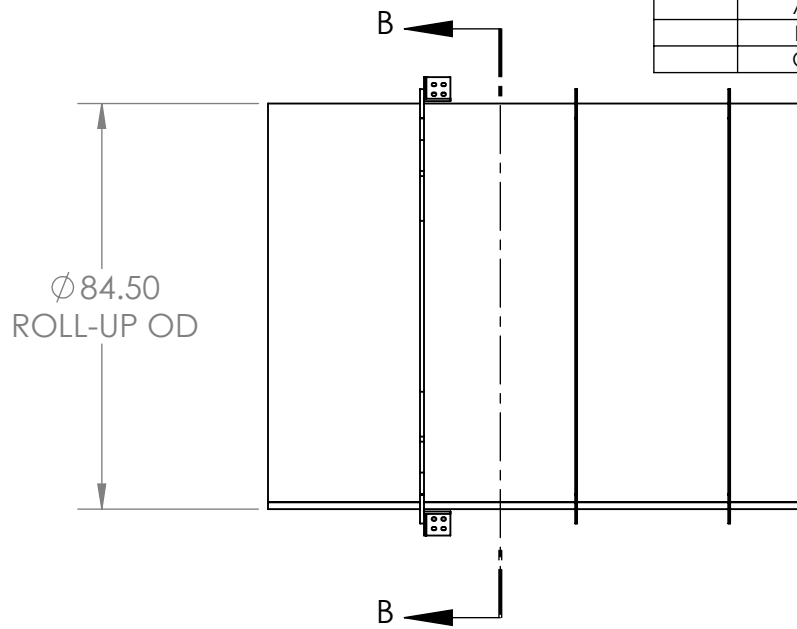
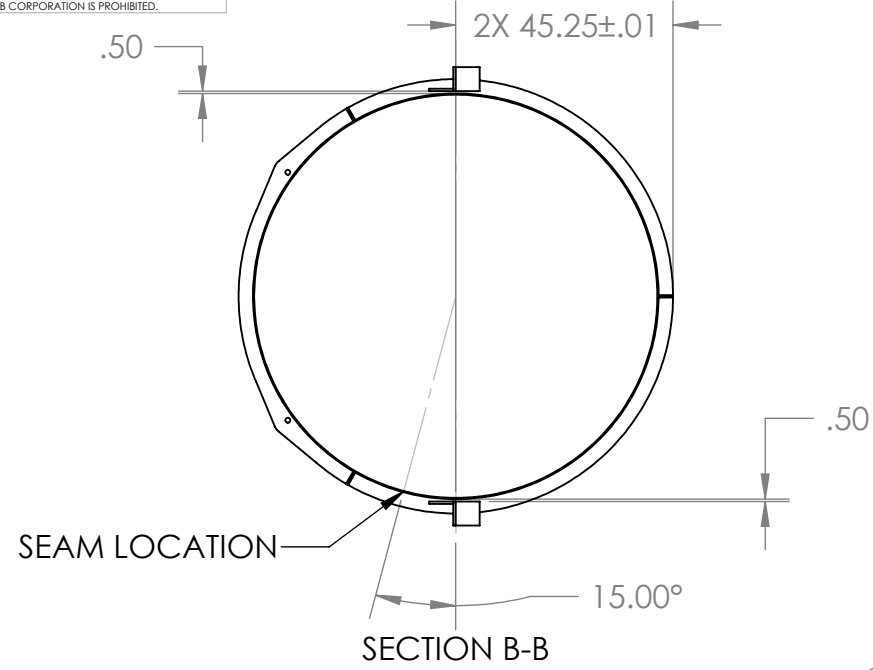


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD SIZES	8/11/2010	MKM2
	B	RELEASED TO PRODUCTION	8/25/2010	MKM2
	C	REVISED STIFFENER WELDMENT	8/25/2010	MKM2



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114203-00S	ROLL-UP, MC-B TUBES	1
2	114204-00S	STIFFENER, 1/3, PLAIN, MC TUBE	6
3	114205-00S	STIFFENER, LIFTING, MC TUBES	1
4	114206-00S	STIFFENER, THICK, MC TUBES	2
5	114207-00WS	WELDMENT, BRACKET, MC TUBE	2
6	114427-00S	PLATE, BRACKET, BRACE	2

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH 125
 ANGULAR: ± 0°30'
 .XX ± .03
 .XXX ± .005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS

//, □, ⊥ WITHIN .03

THIRD ANGLE PROJECTION



WEIGHT: 2550.84#

APPROVALS	DATE
DRAFTER MKM2	7/9/10
CHECKER RW	7/22/10
ENGINEER MKM2	7/9/10

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TITLE: **WELDMENT, TUBE, RIGHT, MCB TUBE**

DO NOT SCALE DRAWING	B DWG. NO. 114211-00WS	REV. C
SCALE: 1:40	SHEET 1 OF 1	

- NOTES:
1. ALL WELD PREPS TO BE DONE BY TUNGSTEN CARBIDE CUTTING TOOLS ONLY
 2. WELD PER QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE, LATEST REVISION
 3. CLEAN WELD WIRE AND SURFACE TO BE WELDED WITH CO2 SCRUBBING
 4. INTERNAL WELD SURFACE TO BE SMOOTH BUT NOT GROUND
 5. ALL WELDS TO BE GTAW UNLESS OTHERWISE NOTED
 6. ALL VACUUM BOUNDARY WELDS TO BE CONTINUOUS AND VACUUM TIGHT
 7. NO POST WELD HEAT TREATMENT IS REQUIRED