PROPRIETARY AND CONFIDENTIAL
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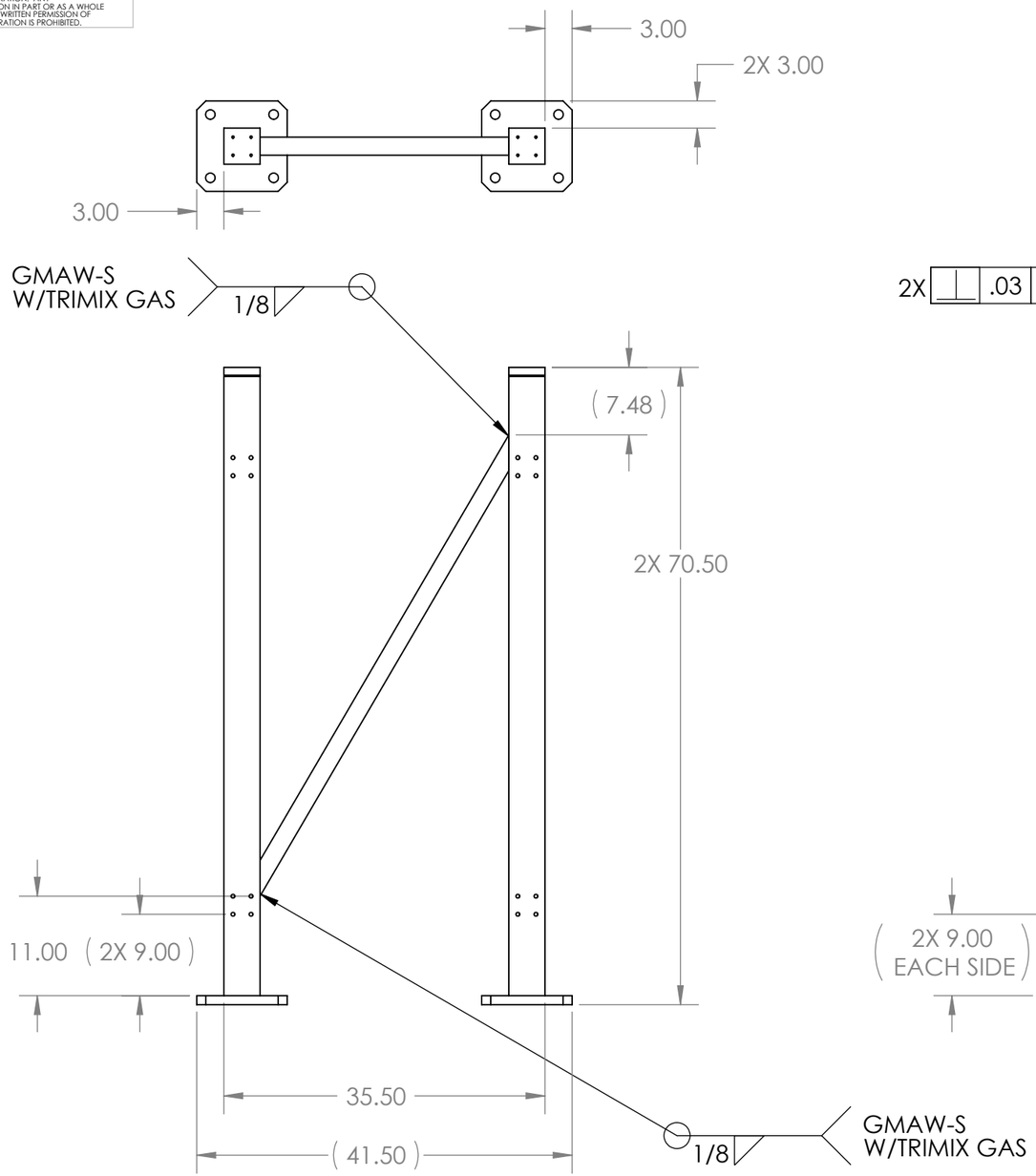
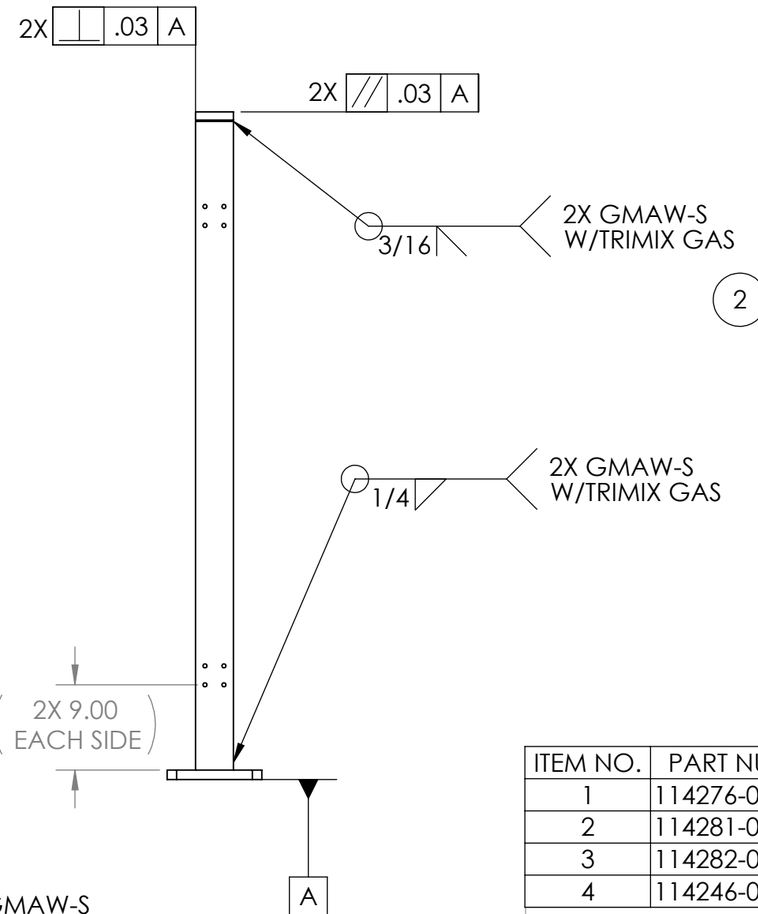
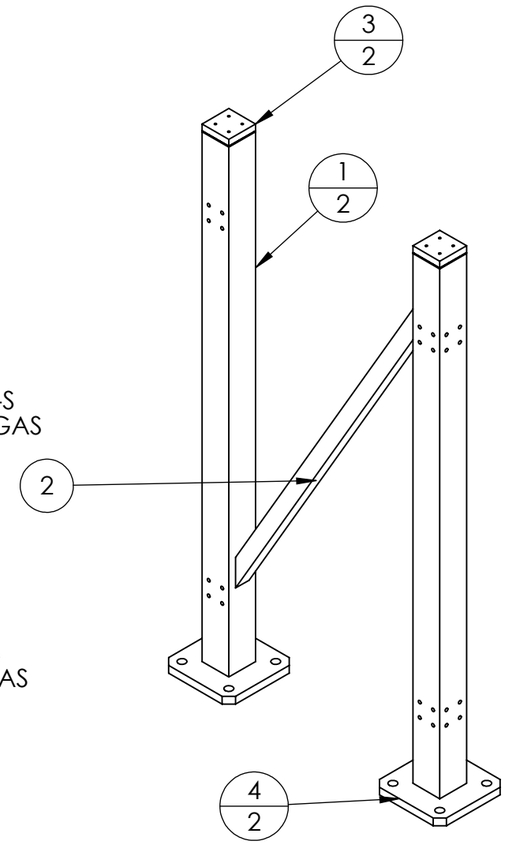
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	RELEASED TO PRODUCTION	8/24/2010	MKM2







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. PAINT AS FOLLOWS:
   SURFACE PREPARATION - SSPC SP-10 (NEAR WHITE) BLAST CLEANING
   PRIMER - 3-4 MILS DFT INORGANIC ZINC.
   FINISH COAT - 8-10 MILS DFT CARBOLINE 450-MEDIUM GREY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114276-00M	MEMBER, VERTICAL,	2
2	114281-00M	BRACE, STAND	1
3	114282-00M	PLATE, BOLT, STAND	2
4	114246-00M	PLATE, FOOT, MC-TUBE STAND	2

MATERIAL: ASTM A36 STEEL

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

WEIGHT: 363.20#

APPROVALS		DATE
DRAFTER	MKM2	8/2/10
CHECKER	ER	8/16/10
ENGINEER	MKM2	8/2/10

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916-395-3003 FAX: 916-395-3363
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TITLE:
WELDMENT, STAND
MIDSTATION SPOOL

DO NOT SCALE DRAWING

B DWG. NO. 114275-01WM REV A

SCALE: 1:16 SHEET 1 OF 1