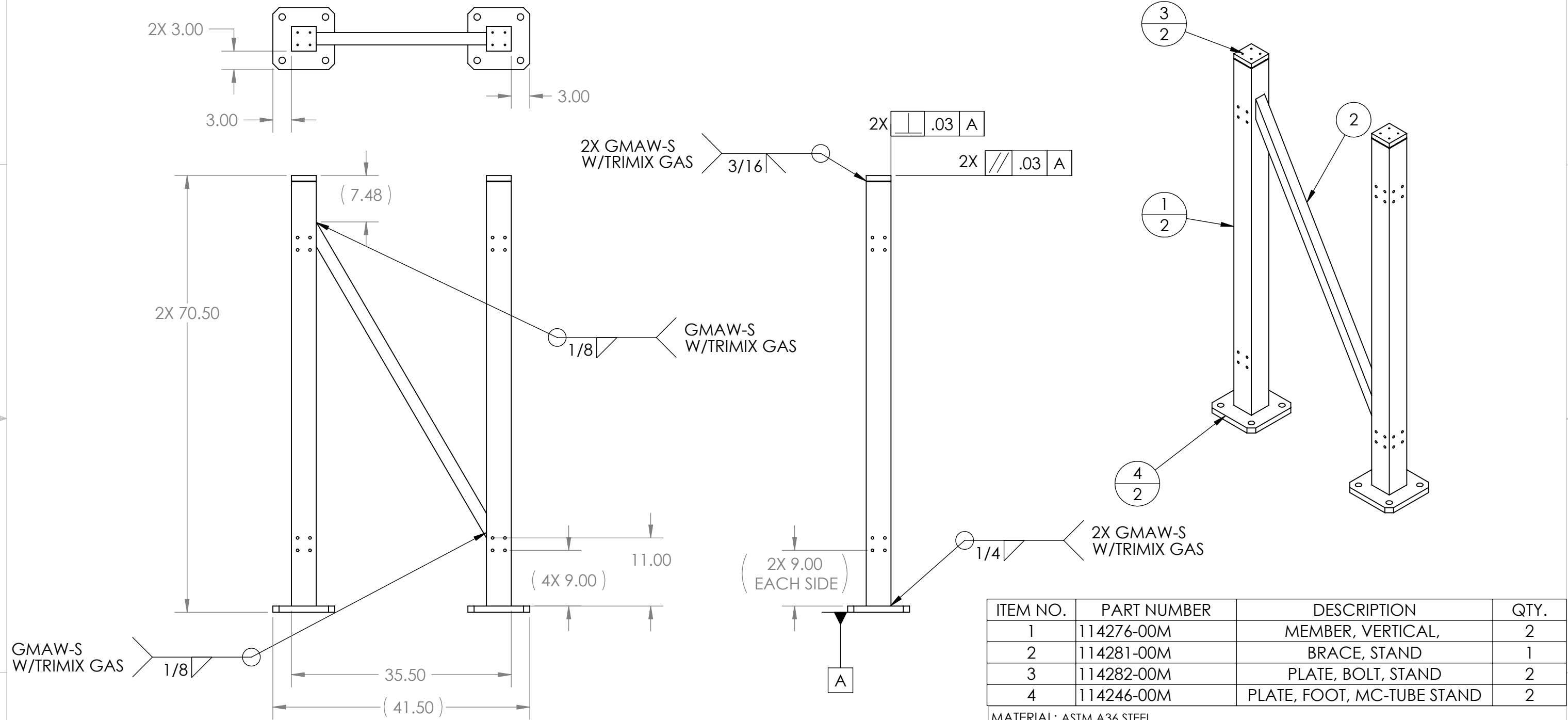


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	RELEASED TO PRODUCTION	8/23/2010	MKM2



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

- 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

MATERIAL: ASTM A36 STEEL

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

WEIGHT: 363.20#

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

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TITLE: WELDMENT, STAND
 MIDSTATION SPOOL

DO NOT SCALE DRAWING

SCALE: 1:16

DWG. NO. 114275-00WM

SHEET 1 OF 1

REV A