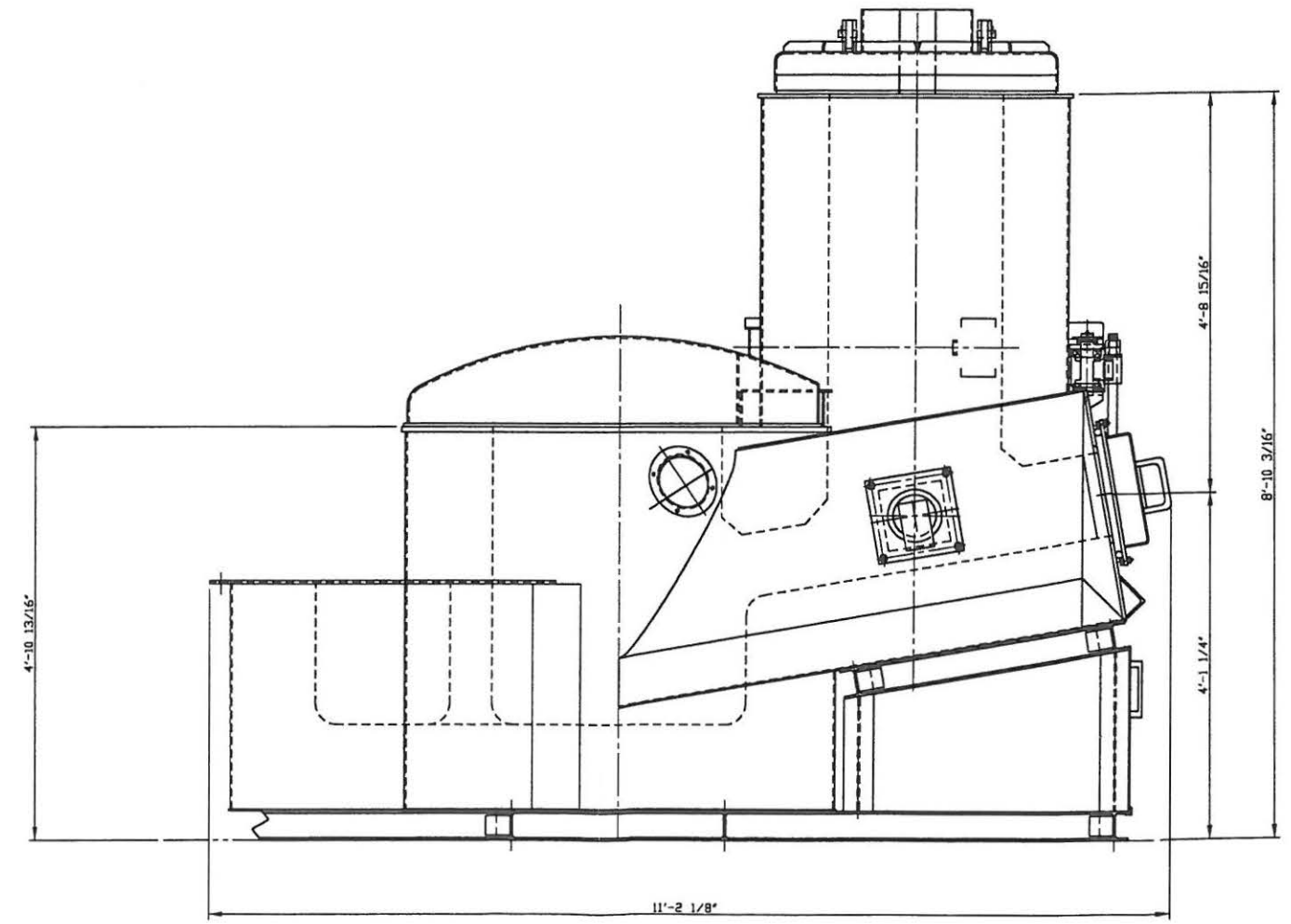
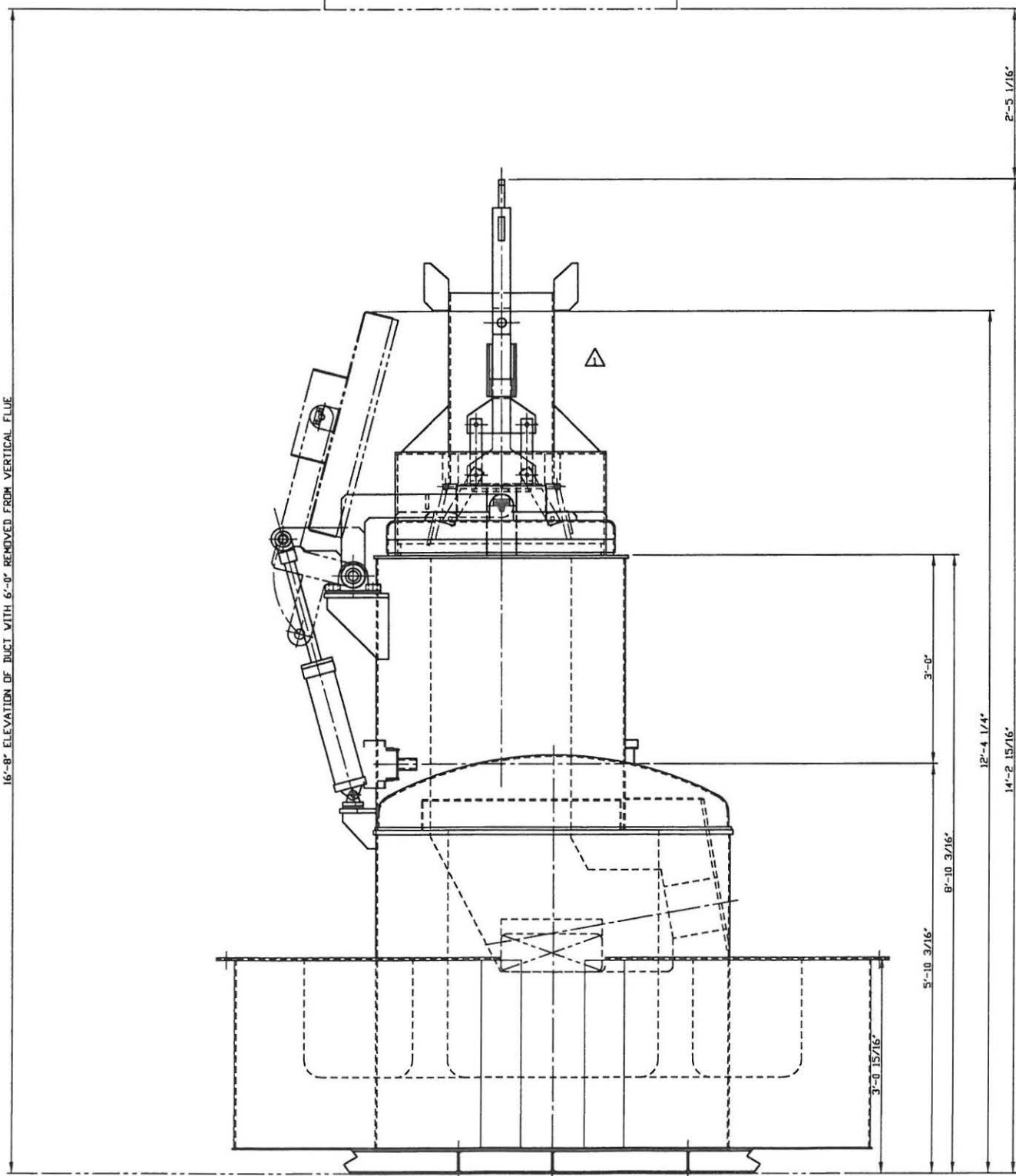


16'-8" ELEVATION OF DUCT WITH 6'-0" REMOVED FROM VERTICAL FLUE



- GENERAL ERECTION & ASSEMBLY NOTES**
- 1) ERECTOR TO FIELD CHECK AND VERIFY ACCURACY OF PLAN AND ELEVATION DIMENSIONS OF ALL CONCRETE AND/OR STEEL SUPPORTS FOR EQUIPMENT PRIOR TO START OF ERECTION.
 - 2) ERECTOR TO CHECK ALL PIECE MARKS ON EQUIPMENT AGAINST THOSE SHOWN ON ERECTION DRAWING TO ASSURE CORRECT UNDERSTANDING OF ASSEMBLY PRIOR TO START OF ERECTION.
 - 3) ERECTOR TO LOOSELY FIT UP ENTIRE ASSEMBLY AND ESTABLISH FINAL DESIGN SPECIFICATIONS PRIOR TO FINAL HOLY-UP FIELD WELDING AND/OR DRILLING IN ACCORDANCE WITH CURRENT AISC ERECTION STANDARDS.
 - 4) FABRICATOR TO ASSURE ACCURACY OF FABRICATED COMPONENTS, WITHIN ACCEPTED STRUCTURAL FABRICATION TOLERANCES.

- MATERIAL SPECIFICATION NOTES**
- 1) ALL STEEL SHALL CONFORM TO AISC 360 STANDARDS FOR MINIMUM MECHANICAL PROPERTIES, AND SHALL BE FABRICATED IN ACCORDANCE WITH THE RECOMMENDED PRACTICE OF THE AMERICAN INSTITUTE OF STEEL CONSTRUCTION.
 - 2) ALL STEEL SHALL CONFORM TO ANSI/ASTM A36 FOR LATEST EDITION STANDARDS FOR DIMENSIONAL TOLERANCE.
 - 3) ALL BOLTS SHALL CONFORM TO ASTM A325 STANDARDS FOR MINIMUM MECHANICAL PROPERTIES UNLESS OTHERWISE SPECIFIED.
 - 4) WELDING PROCEDURES TO CONFORM TO AISC FOR DESIGN, FABRICATION AND ERECTION OF STRUCTURAL STEEL FOR BUILDINGS.
 - 5) AISC STANDARD WELDING SYMBOLS WILL BE USED FOR THE DESIGNATION OF WELDS.
 - 6) ALL SHOP AND FIELD WELDED CONNECTIONS SHALL BE MADE WITH E70 RODS UNLESS OTHERWISE SPECIFIED.

OPEN HOLES - UNLESS OTHERWISE NOTED

DIMENSIONAL TOLERANCES - UNLESS OTHERWISE SPECIFIED -

SIZE	MACHINED	FRACTIONAL
UNDER 18"	010	± 1/32"
18" TO 24"	020	± 1/16"
24" TO 48"	032	± 3/32"
48" TO 72"	AS SPECIFIED	± 1/8"
72" TO 240"	AS SPECIFIED	± 1/4"
OVER 240"	AS SPECIFIED	± 3/8"

ALL MACHINED SURFACES 1/2°
CHAMFER AND WELD PREP'S ± 1/2°
CORNER RADIUS 60° MAX
BREAK ALL CORNERS AND REMOVE ALL BURRS

NO.	REVISIONS	DATE	BY

FILE NO. P\ACAD\5000\61294002.dwg
PLOT DATE 11/18/04
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FOR MARINETTE CASTINGS
LOCATION PESHTIGO, WI
DESCRIPTION NUM 500

DRAWN BY MTJ DATE 11/05/04 CHECKED BY DATE SHEET NO. 2
DWG. NO. 5000-6129-4-002 SCALE 1" = 1'-0" CONTRACT 046617

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