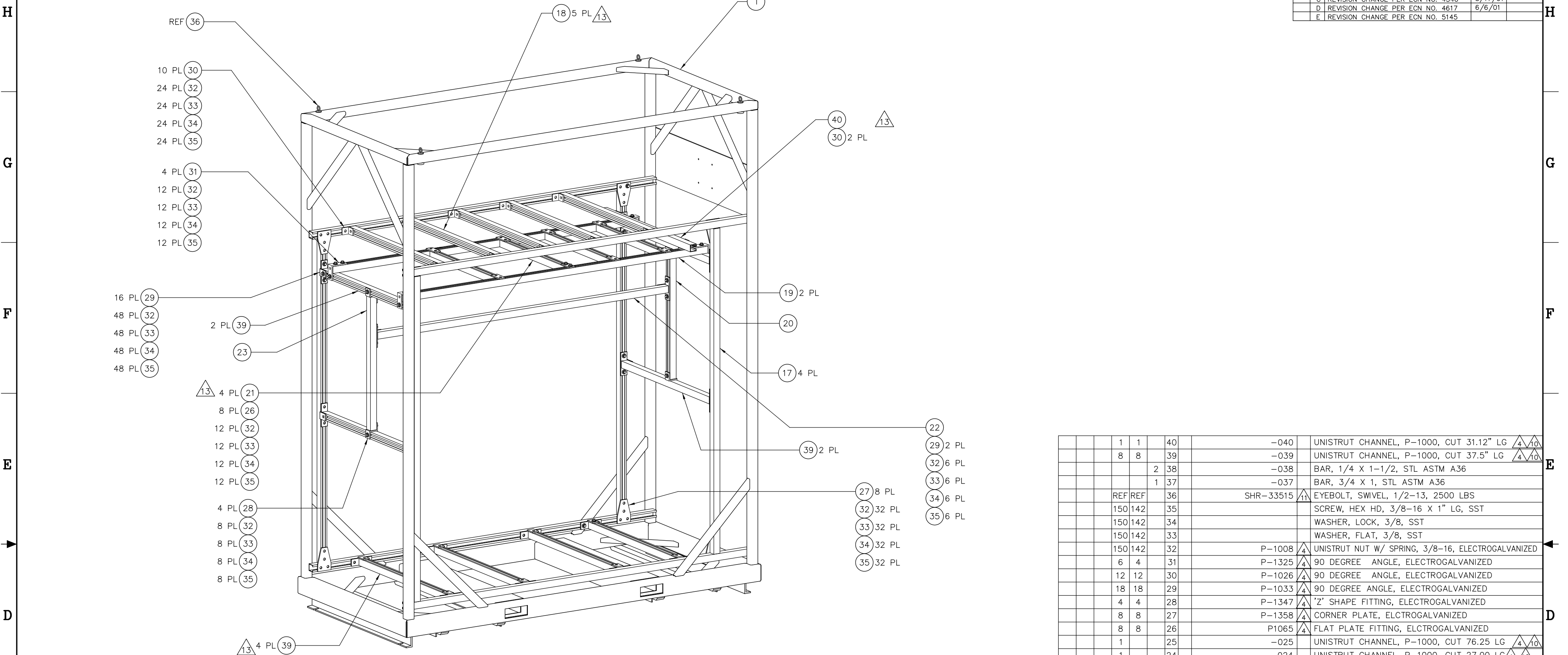


ZONE	LTN	DESCRIPTION	REVISIONS	DATE	APPROVED
A		INITIAL DRAWING RELEASE ECN NO. 4423		4/17/01	
B		REVISION CHANGE PER ECN NO. 4520		4/26/01	
C		REVISION CHANGE PER ECN NO. 4546		5/17/01	
D		REVISION CHANGE PER ECN NO. 4617		6/6/01	
E		REVISION CHANGE PER ECN NO. 5145			



-502 ASSY
(UNISTRUT FRAME DETAILS AND ASSY)
(805 MHz TRANSMITTER)

7 FINISH:
DEGREASE ALL FRAME (-501 ASSY) SURFACES, EXCEPT FOR SURFACES OF ITEM 16 AND THOSE IDENTIFIED IN NOTE 6. GRIT BLAST CLEANED SURFACES TO SPC #10 NEAR WHITE BLAST. BLOW FREE OF ALL DUST, CLEAN AND DRY PRIOR TO APPLICATION OF FINISH. APPLY IN ACCORDANCE WITH MANUFACTURER'S SPECIFICATIONS PROLINE ZINC #221, (3 TO 4 MILS DRY FILM THICKNESS). APPLY PROLINE #4001 WHITE EPOXY PRIMER (DRY FILM THICKNESS 5 TO 6 MILS). OVERCOAT TIME TO BE 4 HOURS. FINAL COAT TO BE PROLINE #4800 POLYURETHANE SEMIGLOSS BLUE. COLOR TO BE PER FED STD 595, PAINT CHIP #25102, (DRY FILM THICKNESS 1.5 TO 2 MILS). OVERSPRAY PERMITTED ON ADJACENT SURFACES. FINISH TO BE MEDIUM TEXTURE.

6 ALL SEPARATE UNISTRUT CHANNEL PIECES, ITEMS 16 THRU 25, AND ITEM 39, FINISH AS FOLLOWS:
MASK INDICATED SURFACES TO PROTECT ELECTROGALVANIZED FINISH. REMOVE ALL SURFACE CONTAMINATES. SURFACE TO BE CLEAN AND DRY PRIOR TO FINISH. PRIME AND PAINT INDIVIDUALLY PER NOTE 7.

5. REMOVE ALL WELD SPLATTER.

4 UNISTRUT
WAYNE, MI. 48184
313-721-4040
NOTE: FINISH FOR ALL UNISTRUT ITEMS- ELECTROGALVANIZED
ALTERNATE SUPPLIER:
THOMAS & BETTS - SUPERSTRUT (EQUIVALENT PART NUMBERS)
MEMPHIS, TN 38125
888-862-3289

3. WELD AND INSPECT PER BEST COMMERCIAL STANDARDS.

2 STEEL STAMP IDENTIFICATION NUMBERS AS FOLLOWS:
LINE 1: S/N 001 - XXX
LINE 2: P/N M355300204 REV A
USING 1/4" HIGH CHARACTERS. APPROXIMATELY WHERE SHOWN.

1. REMOVE ALL BURRS AND SHARP EDGES .03 MAX.
NOTES: UNLESS OTHERWISE SPECIFIED

13 INDICATED ITEMS POSITIONS MAY VARY DUE TO VARIATIONS IN PIPING DUE TO WELD AND BOLT JOINT FLEXURES.

12 ASSEMBLE ONLY AFTER PAINTING ITEMS 17 THRU 25 SEPARATELY. DO NOT PAINT ITEMS 26 THRU 32.

11 REID TROOL AND SUPPLY
MUSKEGON, MI 49444
800-253-0421

10 MASK INDICATED SURFACES OF UNISTRUT CHANNELS AND OTHER INDICATED SURFACES PRIOR TO PAINTING AS NOTED.

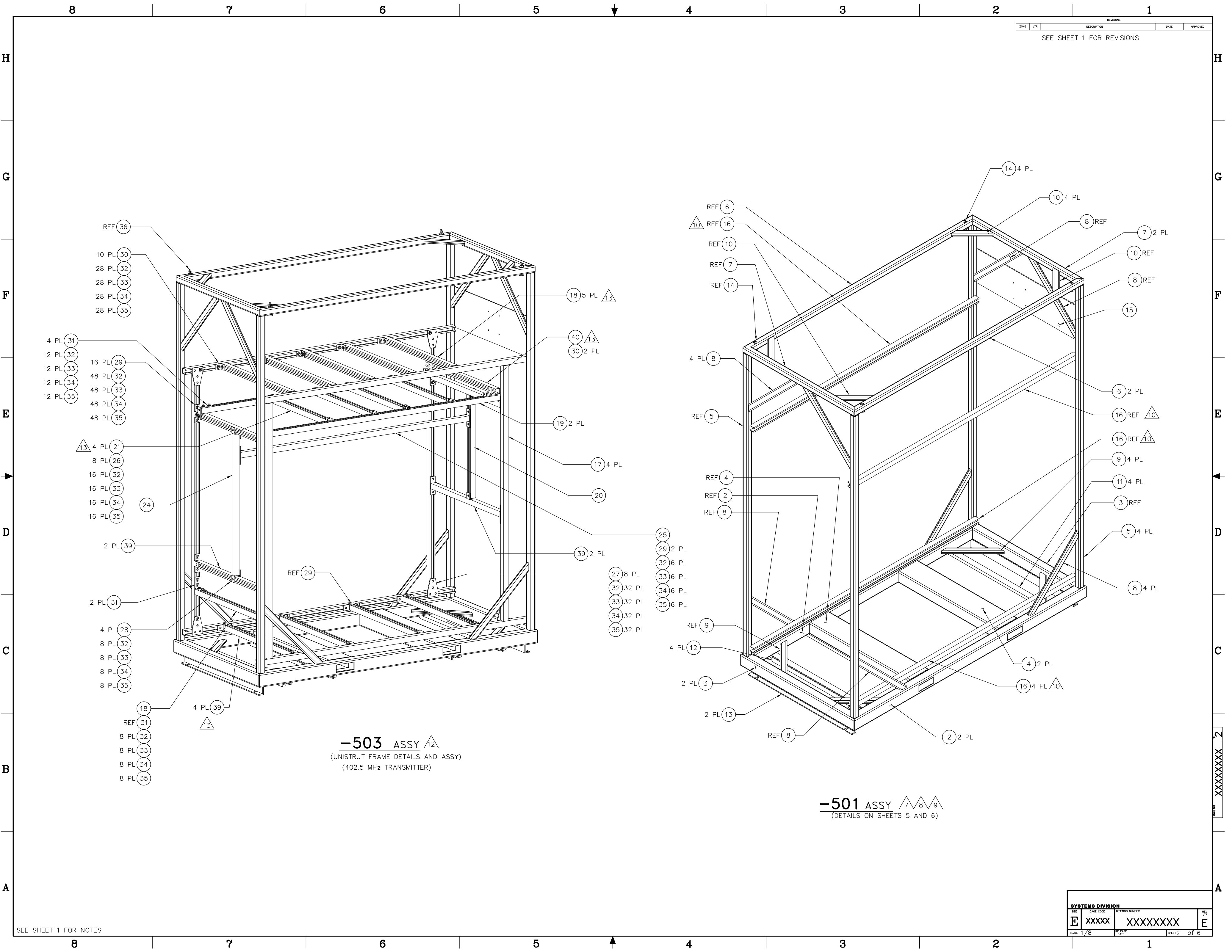
9 CONDUCTIVE COATING:
COAT INDICATED AREAS WITH ELECTRODAG #442, (OR CONDUCTIVE NICKEL COATING - FLAMESPRAY) PER MANUFACTURER'S SPECIFICATIONS, ACHENSON COLLOIDS CO, PORT HURON, MICHIGAN 48061. STEEL SURFACES TO BE GRIT BLASTED OR IRON PHOSPHATE WASHED, AND ACID ETCHED PRIOR TO CONDUCTIVE COAT APPLICATION. REMOVE ALL SURFACE CONTAMINATES. SURFACE TO BE CLEAN AND DRY PRIOR TO COATING. COATING THICKNESS TO BE 3 MILS MINIMUM. OVERSPRAY NOT PERMITTED ON ADJACENT SURFACES.

8 MASK ALL THREADS PRIOR TO ACID ETCH, PRIMING AND PAINTING. DO NOT TREAT THESE SURFACES.

QTY	REF	ITEM	SIZE	DRAWING/PART NUMBER	CAGE CODE	NOMENCLATURE / DESCRIPTION / MATERIAL	QTY	REF	ITEM	SIZE	DRAWING/PART NUMBER	CAGE CODE	NOMENCLATURE / DESCRIPTION / MATERIAL
	1	1	40			-040 UNISTRUT CHANNEL, P-1000, CUT 31.12" LG	4	10					
	8	8	39			-039 UNISTRUT CHANNEL, P-1000, CUT 37.5" LG	4	10					
			2	38		-038 BAR, 1/4 X 1-1/2, STL ASTM A36							
			1	37		-037 BAR, 3/4 X 1, STL ASTM A36							
	REF	REF	36		SHR-33515	13) EYEBOLT, SWIVEL, 1/2-13, 2500 LBS							
	150	142	35			SCREW, HEX HD, 3/8-16 X 1" LG, SST							
	150	142	34			WASHER, LOCK, 3/8, SST							
	150	142	33			WASHER, FLAT, 3/8, SST							
	150	142	32			P-1008 UNISTRUT NUT W/ SPRING, 3/8-16, ELECTROGALVANIZED	4						
	6	4	31			P-1325 90 DEGREE ANGLE, ELECTROGALVANIZED	4						
	12	12	30			P-1026 90 DEGREE ANGLE, ELECTROGALVANIZED	4						
	18	18	29			P-1033 90 DEGREE ANGLE, ELECTROGALVANIZED	4						
	4	4	28			P-1347 'Z' SHAPE FITTING, ELECTROGALVANIZED	4						
	8	8	27			P-1358 CORNER PLATE, ELECTROGALVANIZED	4						
	8	8	26			P1065 FLAT PLATE FITTING, ELECTROGALVANIZED	4						
	1		25			-025 UNISTRUT CHANNEL, P-1000, CUT 76.25 LG	4	10					
	1		24			-024 UNISTRUT CHANNEL, P-1000, CUT 27.00 LG	4	10					
		1	23			-023 UNISTRUT CHANNEL, P-1000, CUT 31.12 LG	4	10					
		1	22			-022 UNISTRUT CHANNEL, P-1000, CUT 77.25 LG	4	10					
	4	4	21			-021 UNISTRUT CHANNEL, P-1000, CUT 27.75 LG	4	10					
	1	1	20			-020 UNISTRUT CHANNEL, P-1000, CUT 29.12 LG	4	10					
	2	2	19			-019 UNISTRUT CHANNEL, P-1000, CUT 79.62 LG	4	10					
	6	5	18			-018 UNISTRUT CHANNEL, P-1000, CUT 38.00 LG	4	10					
	4	4	17			-017 UNISTRUT CHANNEL, P-1000, CUT 75.88 LG	4	10					
		4	16			-016 UNISTRUT CHANNEL, P-1000	4	10					
		1	15			-015 PLATE, 1/4 THK, STL							
		4	14			-014 BAR, 1.500 DIA, STL							
		2	13			-013 CHANNEL, 3 X 6 LB, STL							
		4	12			-012 BAR, 1 1/2 X 2, STL							
		4	11			-011 BAR, 1 X 2, STL							
		4	10			-010 TUBE, 1 X 2 X 3/16, STL							
		4	9			-009 TUBE, 1 X 2 X 3/16, STL							
		8	8			-008 TUBE, 1 X 2 X 3/16, STL							
		2	7			-007 TUBE, 2 X 2 X 3/16, STL							
		2	6			-006 TUBE, 2 X 2 X 3/16, STL							
		4	5			-005 TUBE, 2 X 2 X 3/16, STL							
		2	4			-004 TUBE, 4 X 8 X 3/16, STL							
		2	3			-003 TUBE, 3 X 4 X 3/16, STL							
		2	2			-002 TUBE, 3 X 4 X 3/16, STL							
		1	1			-501 FRAME, WELDED - WATER SYSTEM							
						-503 FRAME ASSEMBLY, 402.5 MHz COOLING CART							
						-502 FRAME ASSEMBLY, 805 MHz COOLING CART							
						-501 WELDED FRAME AND ASSEMBLY							

QUANTITY REQ'D PER DASH NO. 503 502 501		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES HOLE DIA UP TO .500 .001 HOLE DIA ABOVE .500 .003 ANGLES & 90° W/ MACHINED SURFACES		PROPRIETARY INFORMATION NOT TO BE COPIED, USED, OR DISCLOSED WITHOUT WRITTEN PERMISSION FROM SYSTEMS DIVISION XXXXXXXXXXXXXXXXXXXX XXXXXXXXXXXXXXXXXXXX WELDED FRAME AND ASSEMBLY	
M355300103 NEXT ASSEMBLY	M355300103 USED ON	CAD/CAM DRAWING DO NOT MANUALLY REVISE OR UPDATE	SCALE 1/8	DRAWING NUMBER XXXXXX	SHEET 1 OF 6

ZONE		LTR		DESCRIPTION	DATE	APPROVED
SEE SHEET 1 FOR REVISIONS						



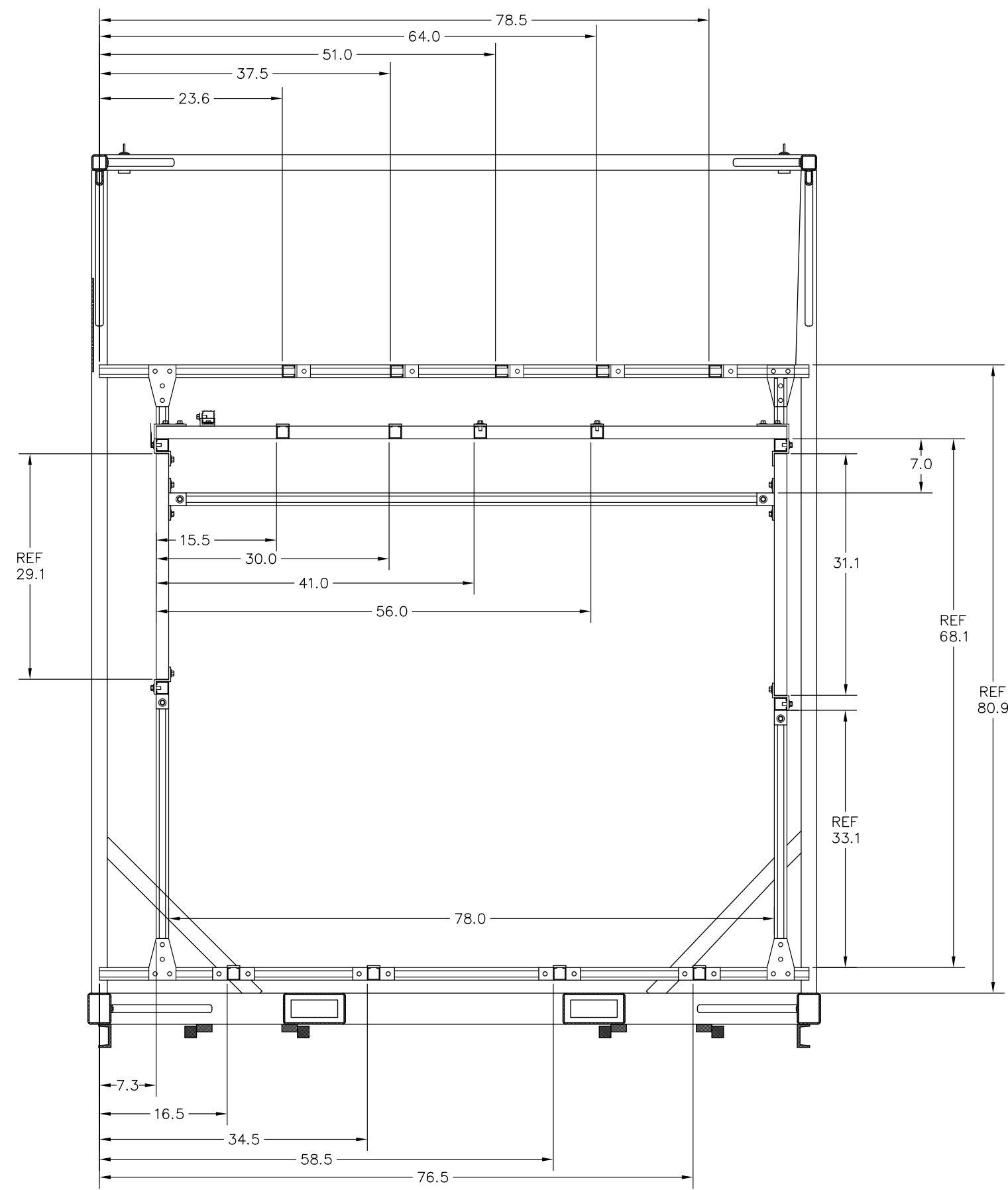
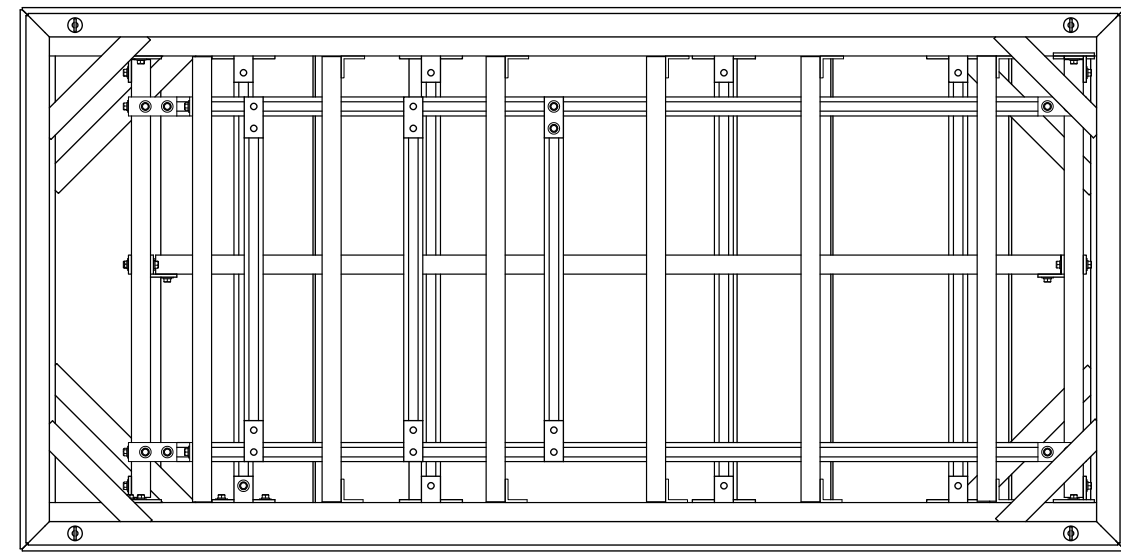
-503 ASSY 
 (UNISTRUT FRAME DETAILS AND ASSY)
 (402.5 MHz TRANSMITTER)

-501 ASSY 
 (DETAILS ON SHEETS 5 AND 6)

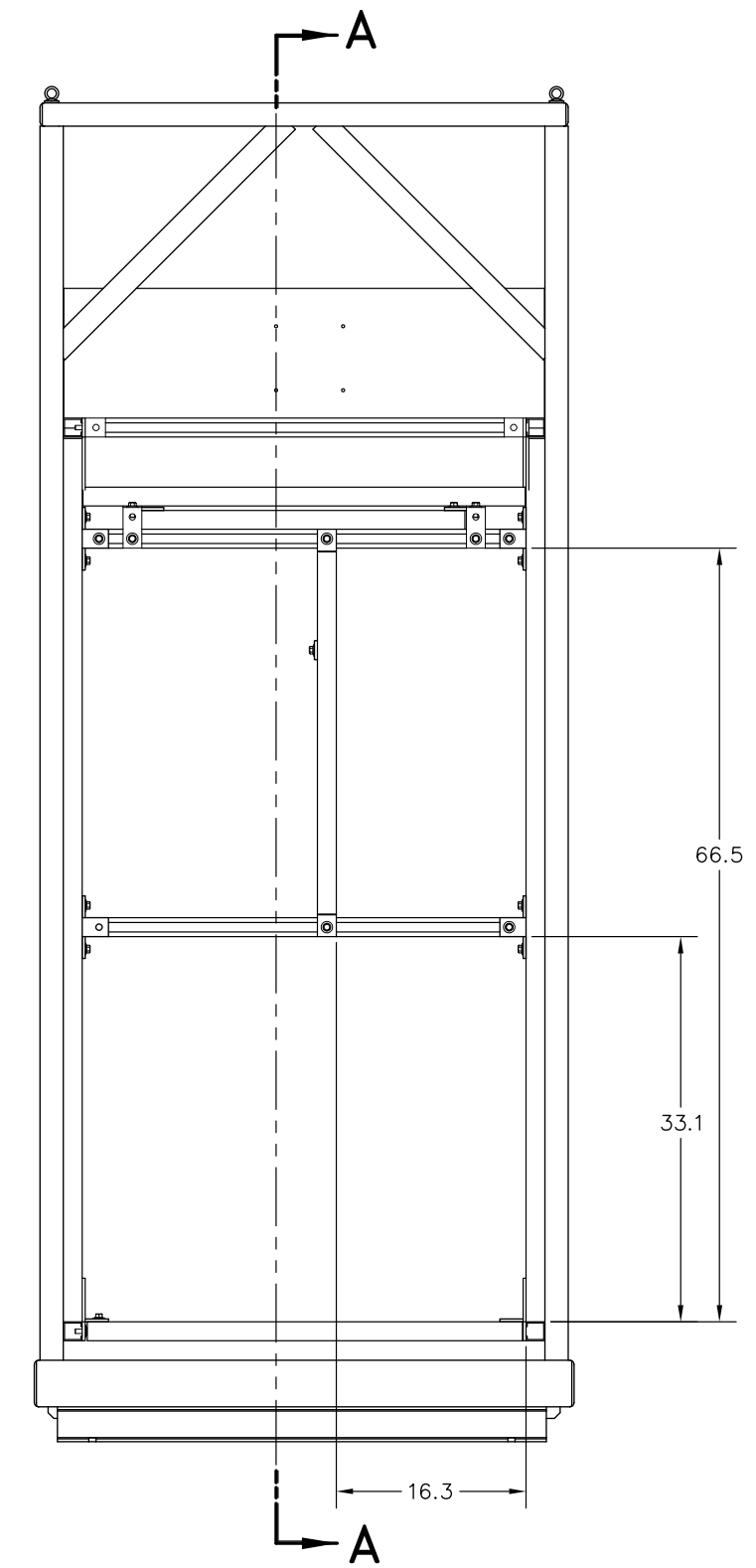
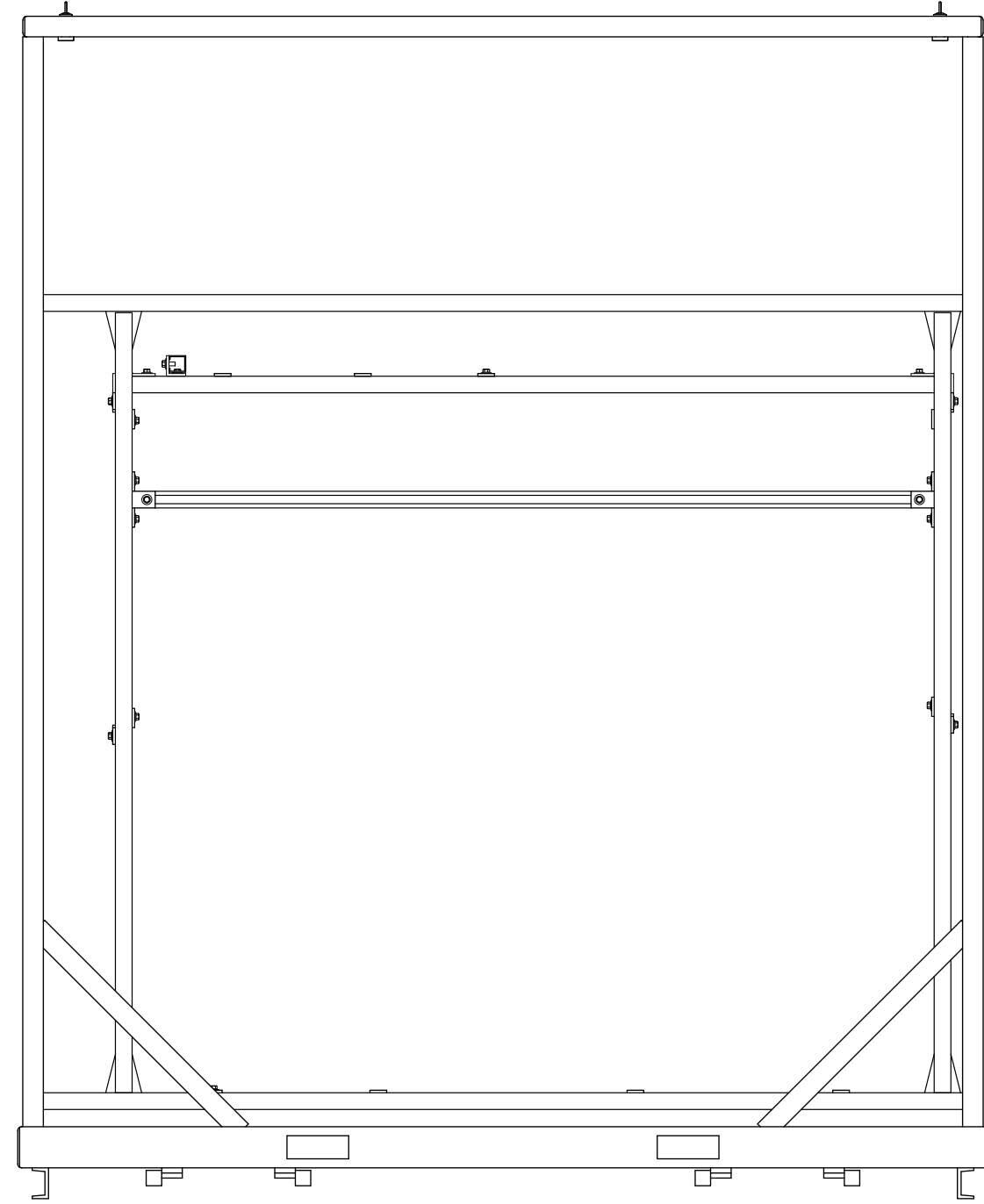
SEE SHEET 1 FOR NOTES

SYSTEMS DIVISION			
REV	DATE	DESCRIPTION	APPROVED
E	XXXXX	XXXXXXXXXX	E
SCALE	1/8	RELEASE DATE	SHEET 2 OF 6

ZONE		LTR		DESCRIPTION	DATE	APPROVED
SEE SHEET 1 FOR REVISIONS						



SECTION A-A



-502 ASSY \triangle
 (UNISTRUT FRAME DETAILS AND ASSY)
 (805 MHz TRANSMITTER)

SEE SHEET 1 FOR NOTES

SYSTEMS DIVISION			
REV	DATE	DESCRIPTION	APPROVED
E	XXXXX	XXXXXXXXXX	E
SCALE 1/8	RELEASE DATE	DRAWING NUMBER	SHEET 3 OF 6

XXXXXXXXXX

8

7

6

5

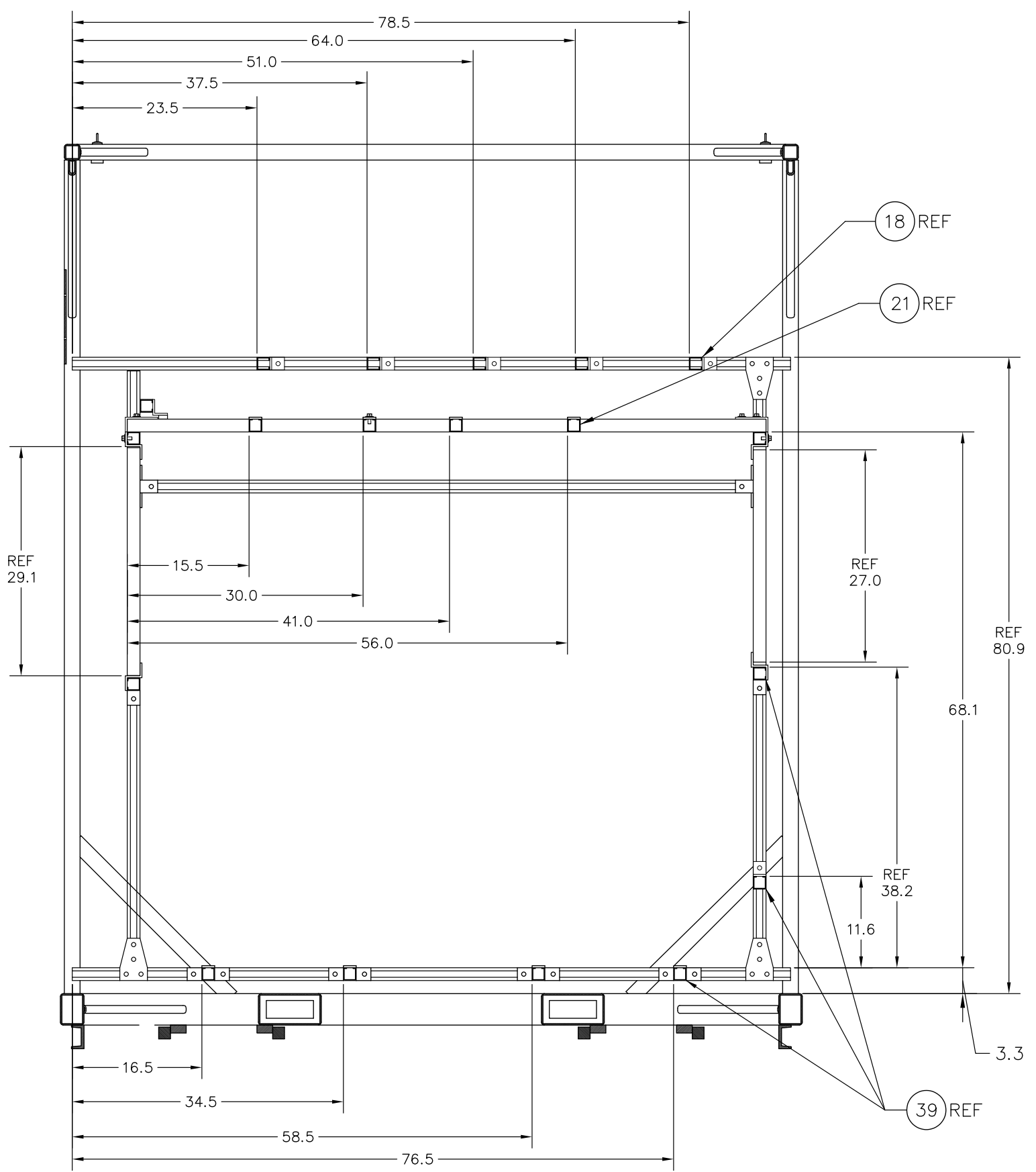
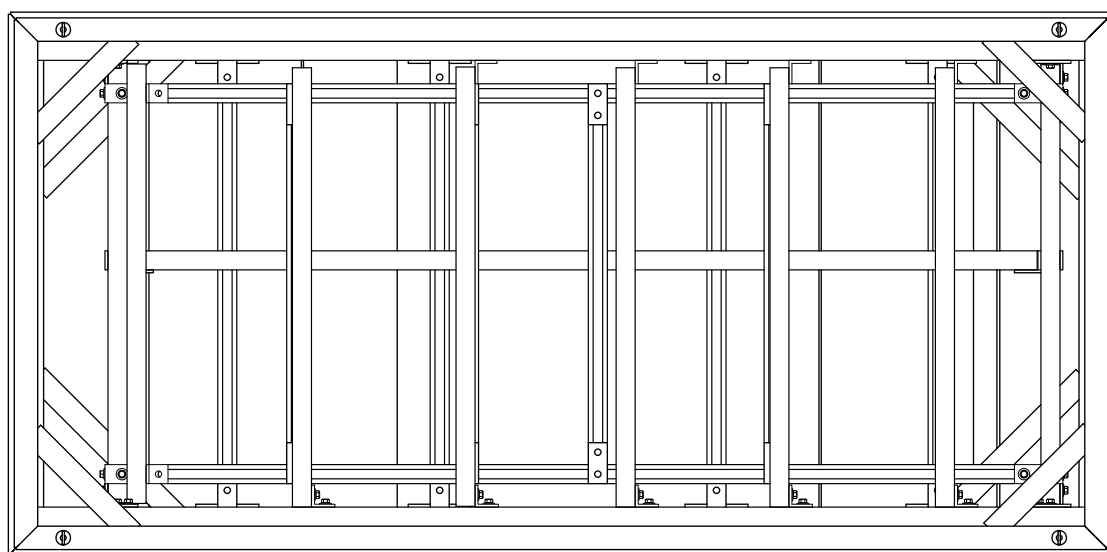
4

3

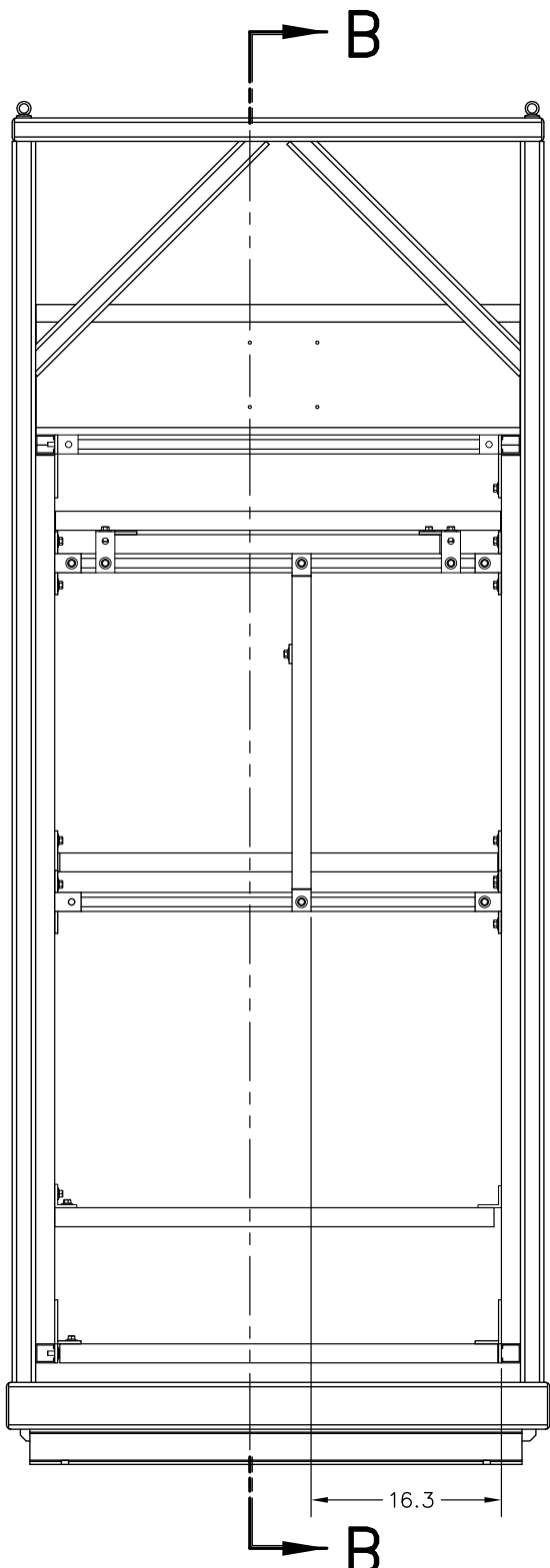
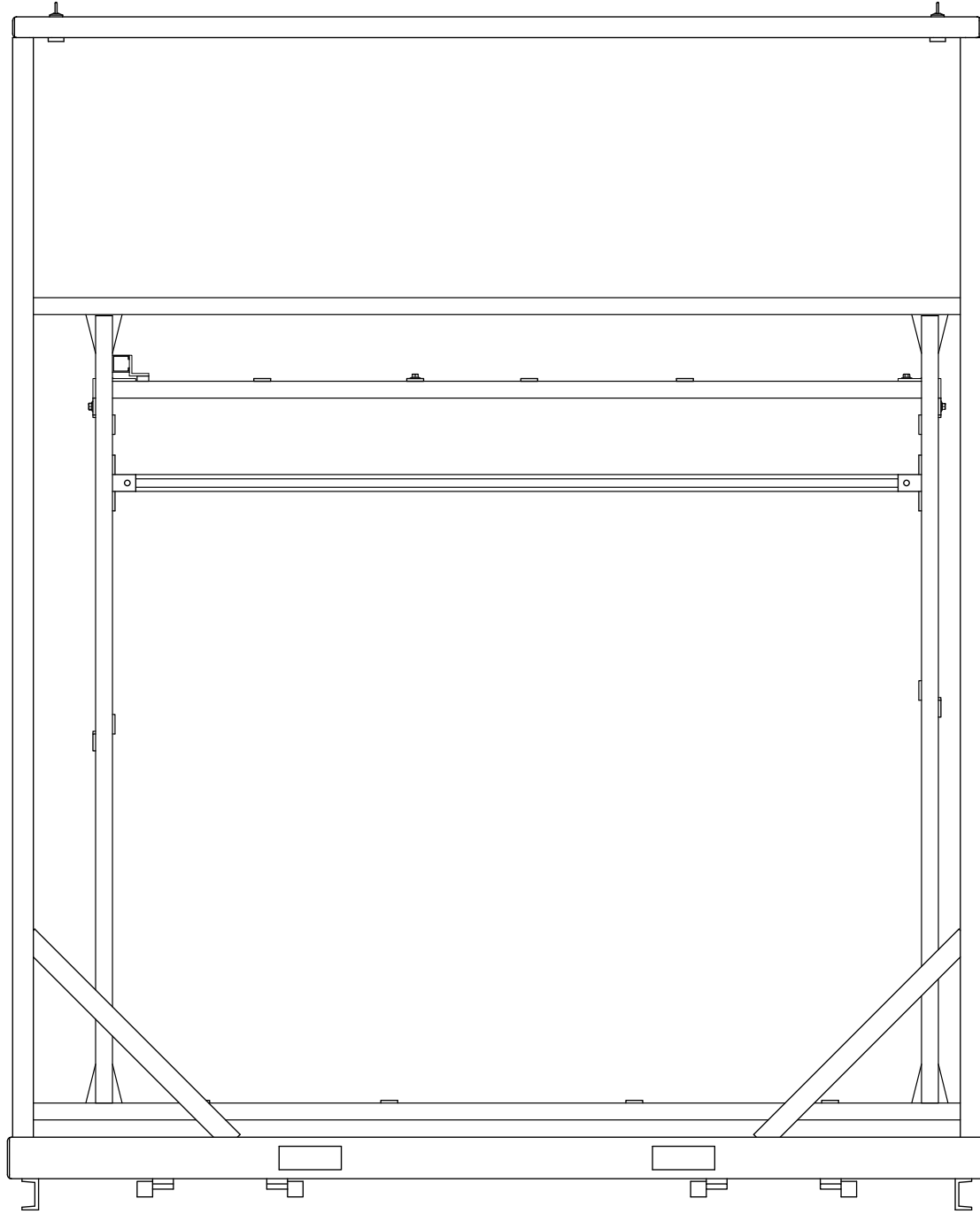
2

1

ZONE		LTR		DESCRIPTION		REVISIONS		DATE	APPROVED
SEE SHEET 1 FOR REVISIONS									



SECTION B-B



-503 ASSY ₁₂
 (UNISTRUT FRAME DETAILS AND ASSY)
 (402.5 MHz TRANSMITTER)

SEE SHEET 1 FOR NOTES

SYSTEMS DIVISION		DRAWING NUMBER		REV
E	XXXXX	XXXXXXXXXX		E
SCALE	1/8	RELEASE DATE		SHEET 4 OF 6

8

7

6

5

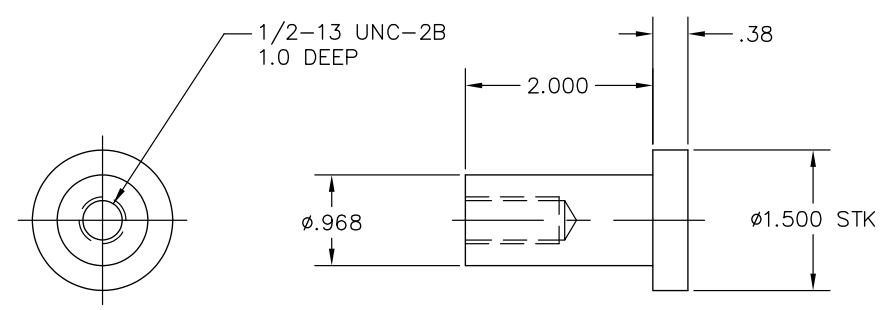
4


3

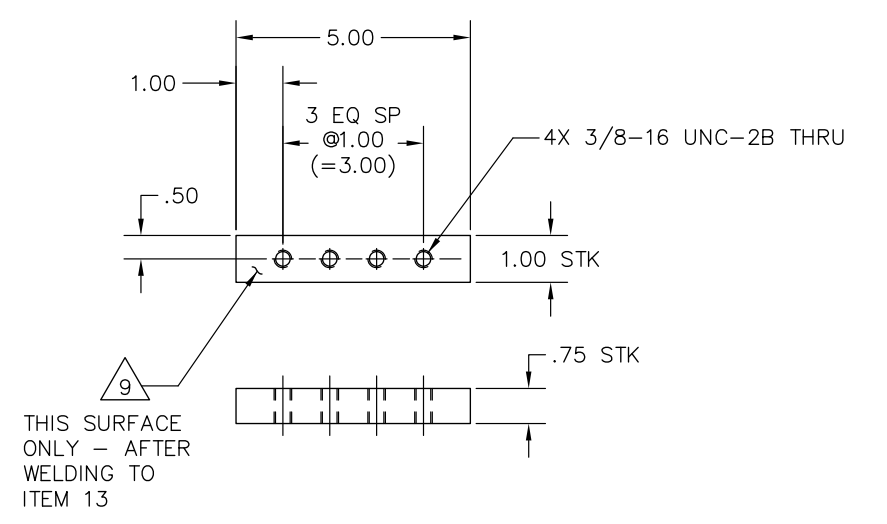
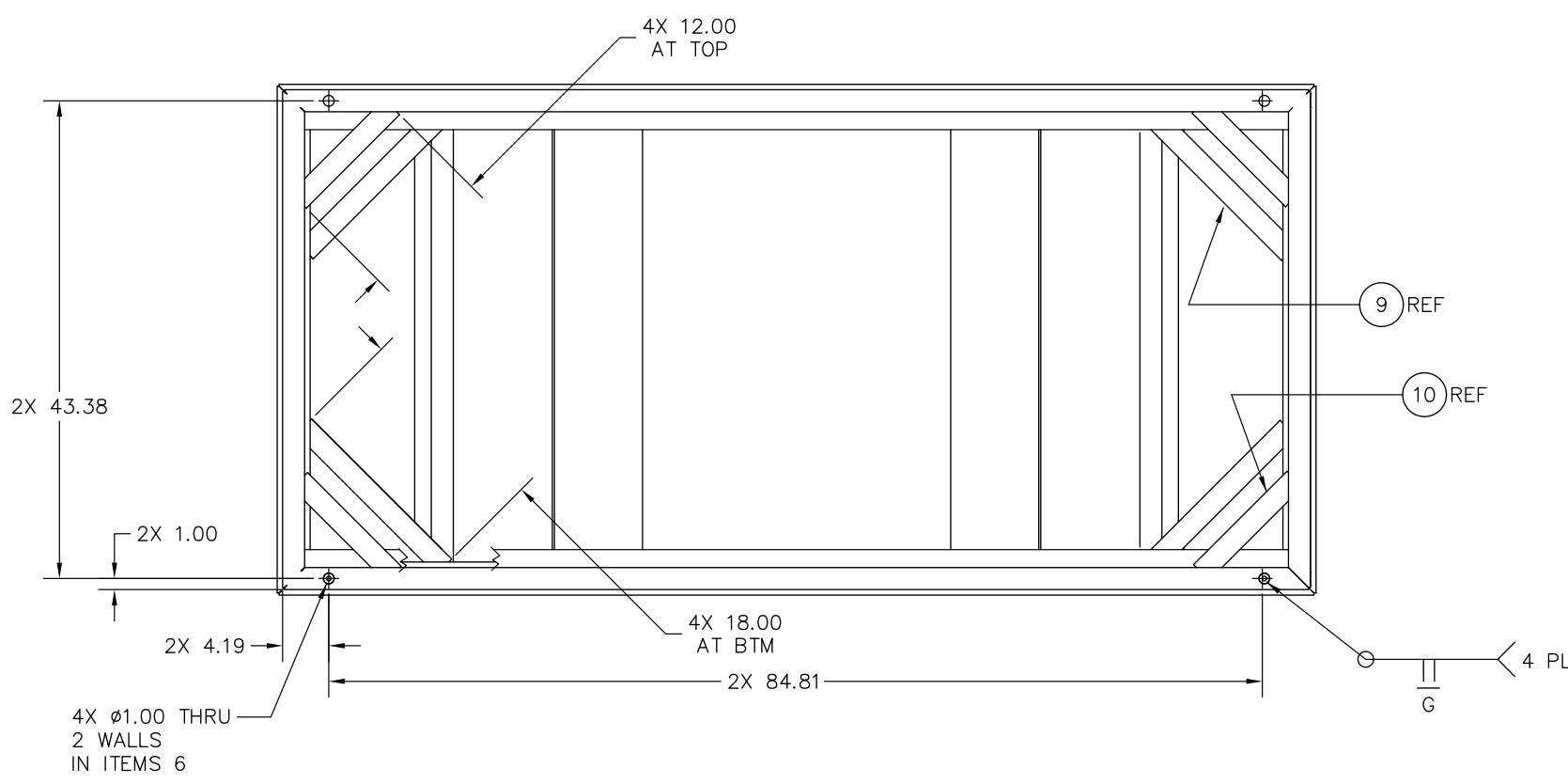
2


1

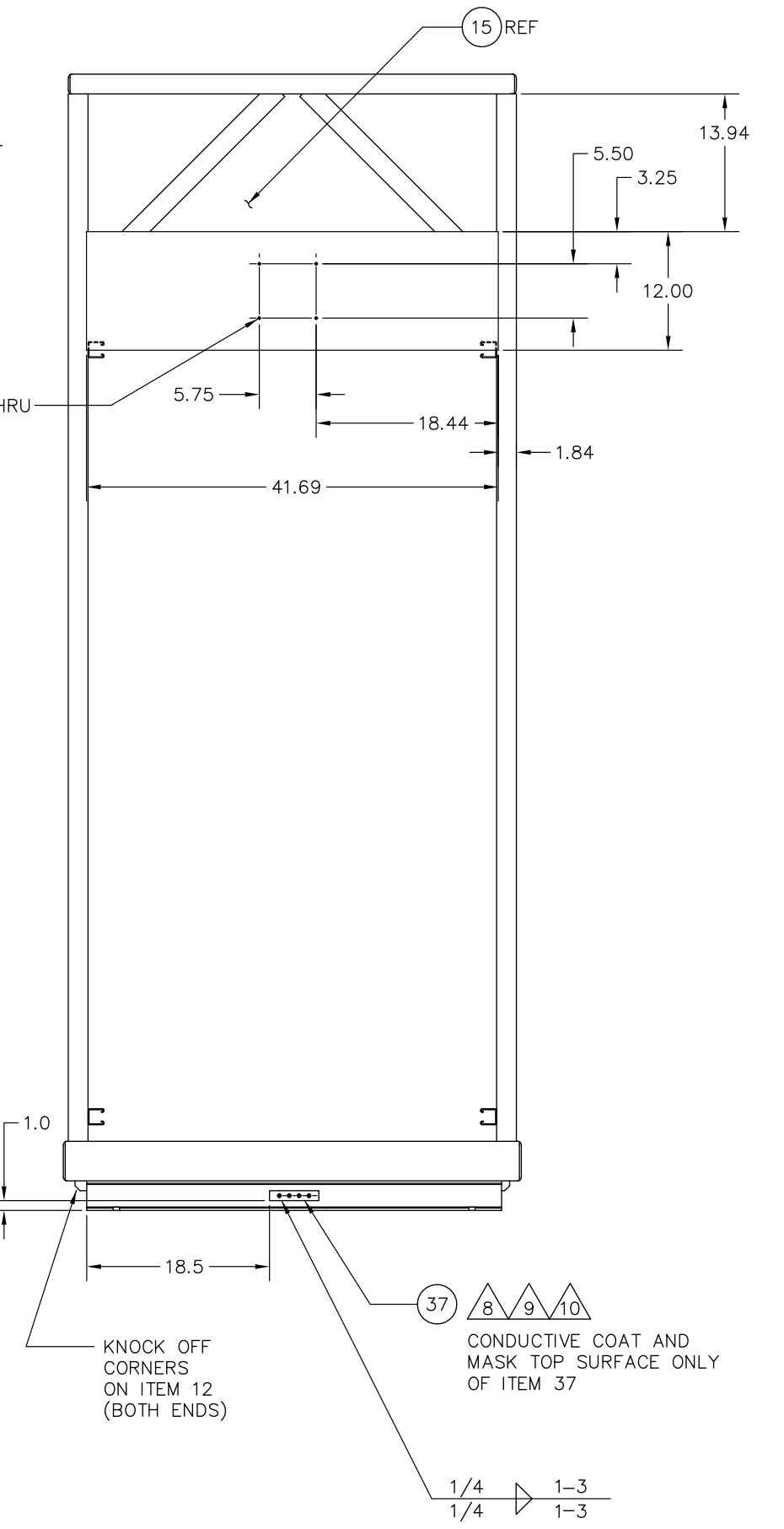
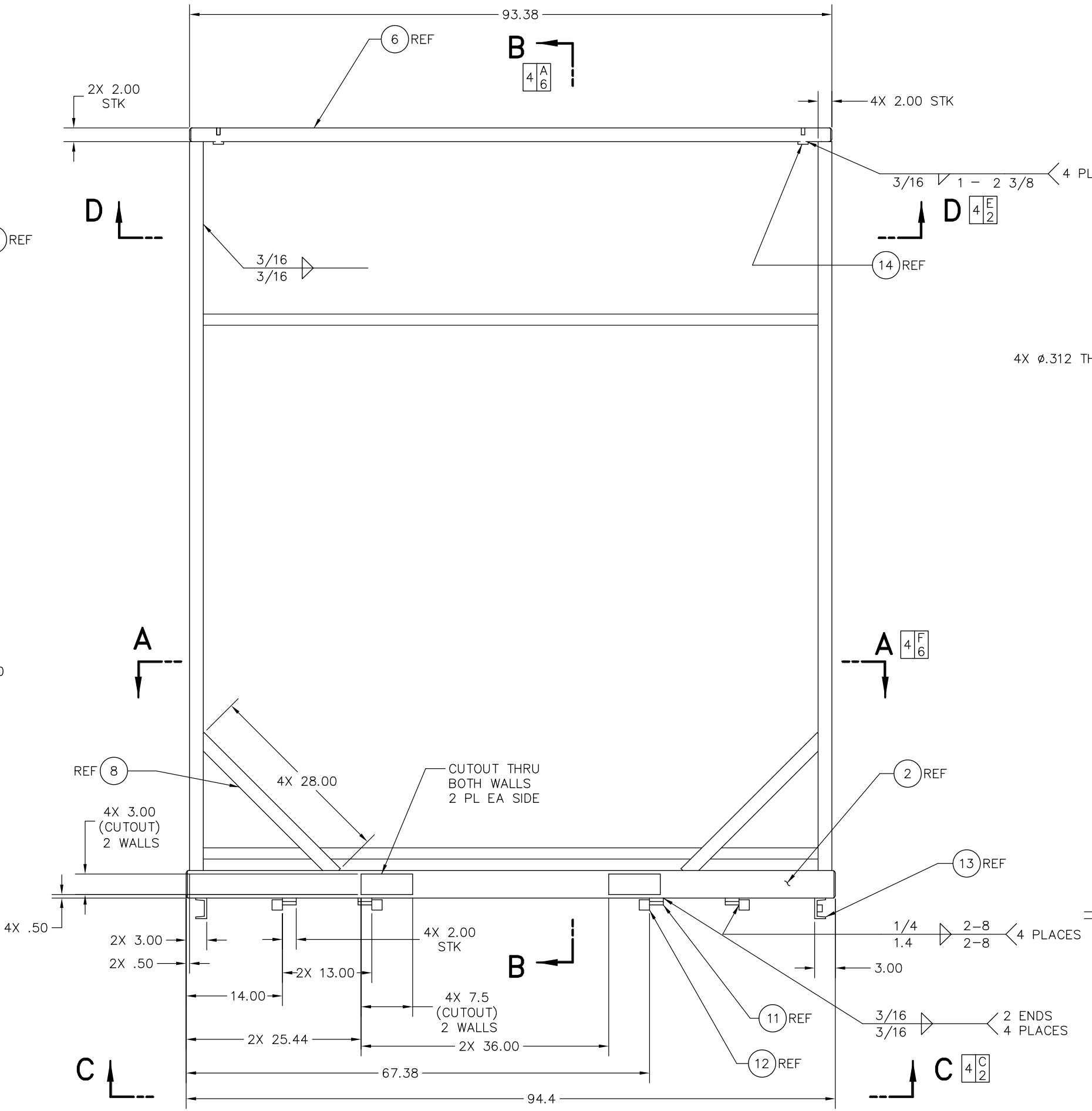
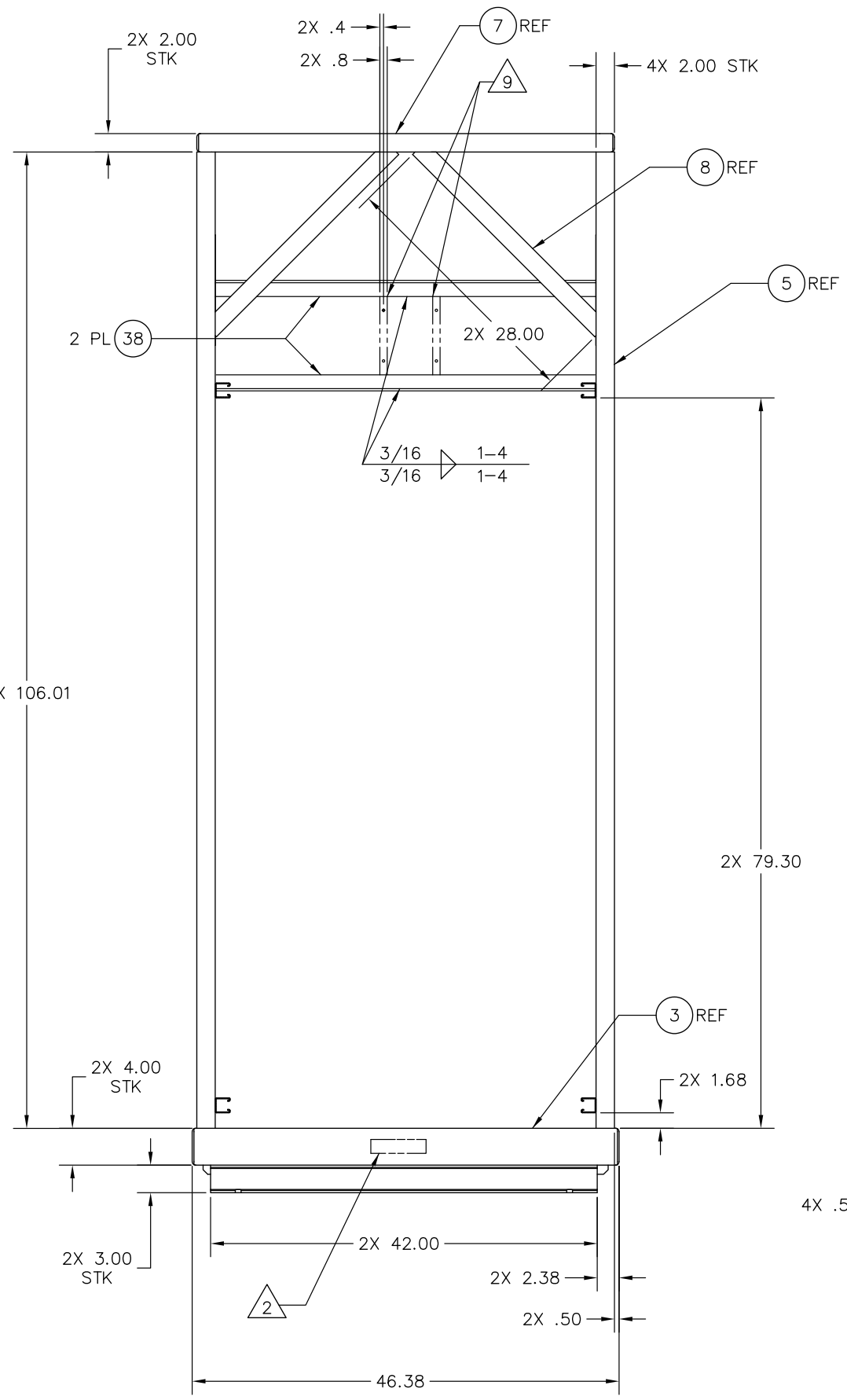
REVISES		DATE	APPROVED
ZONE	LTR	DESCRIPTION	
		SEE SHEET 1 FOR REVISIONS	



DETAIL -014 
SCALE: 1/1



DETAIL -037 
SCALE: 1/2

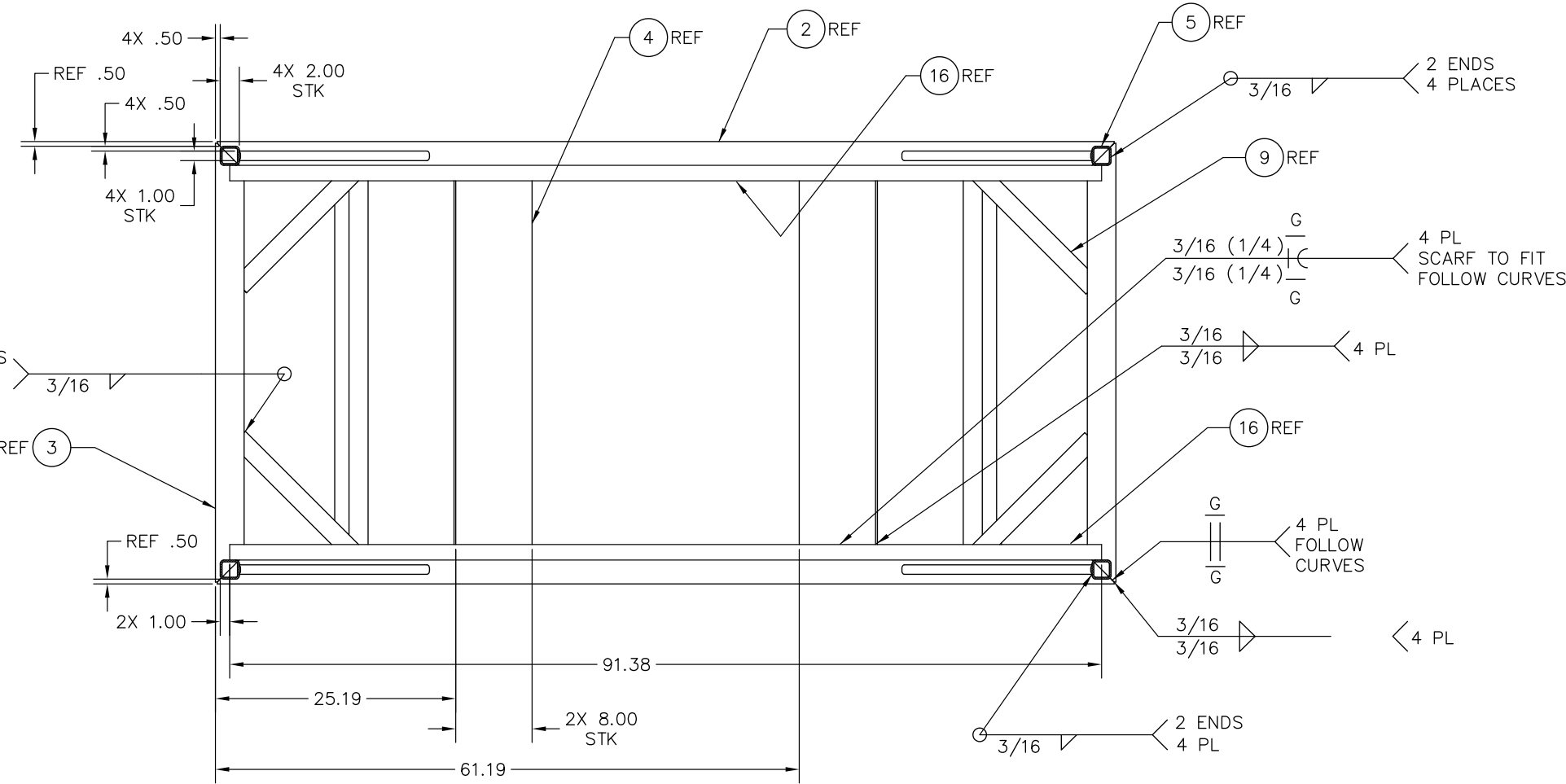


CONDUCTIVE COAT AND MASK TOP SURFACE ONLY OF ITEM 37

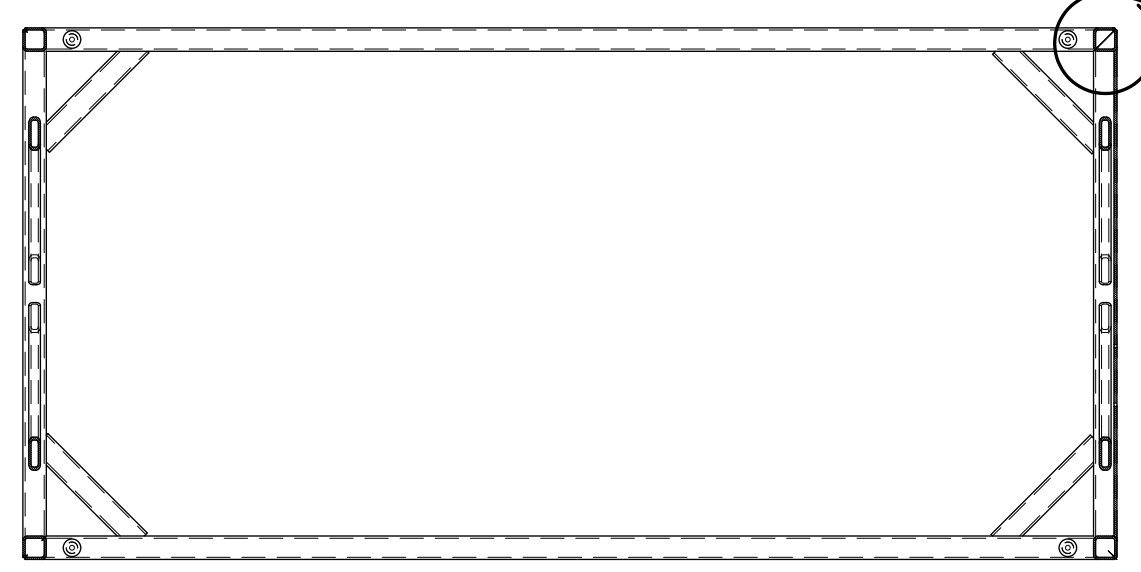
SEE SHEET 1 FOR NOTES

SYSTEMS DIVISION		REV	DATE
132	XXXXX	XXXXXX	XXXXXX
SCALE 1/8	RELEASE DATE	SHEET 5	OF 6

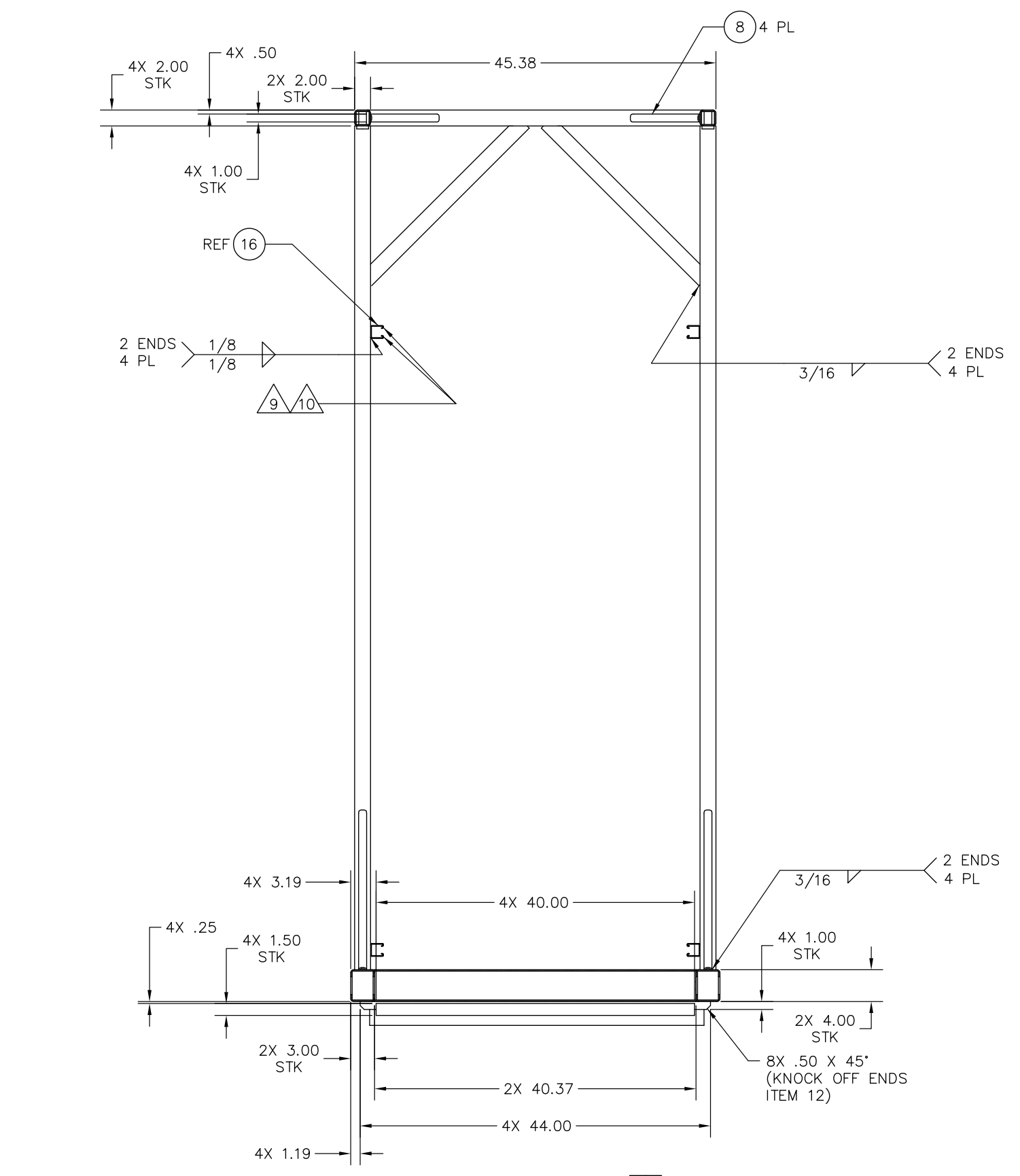
ZONE		LTR		DESCRIPTION	REVISIONS	DATE	APPROVED
SEE SHEET 1 FOR REVISIONS							



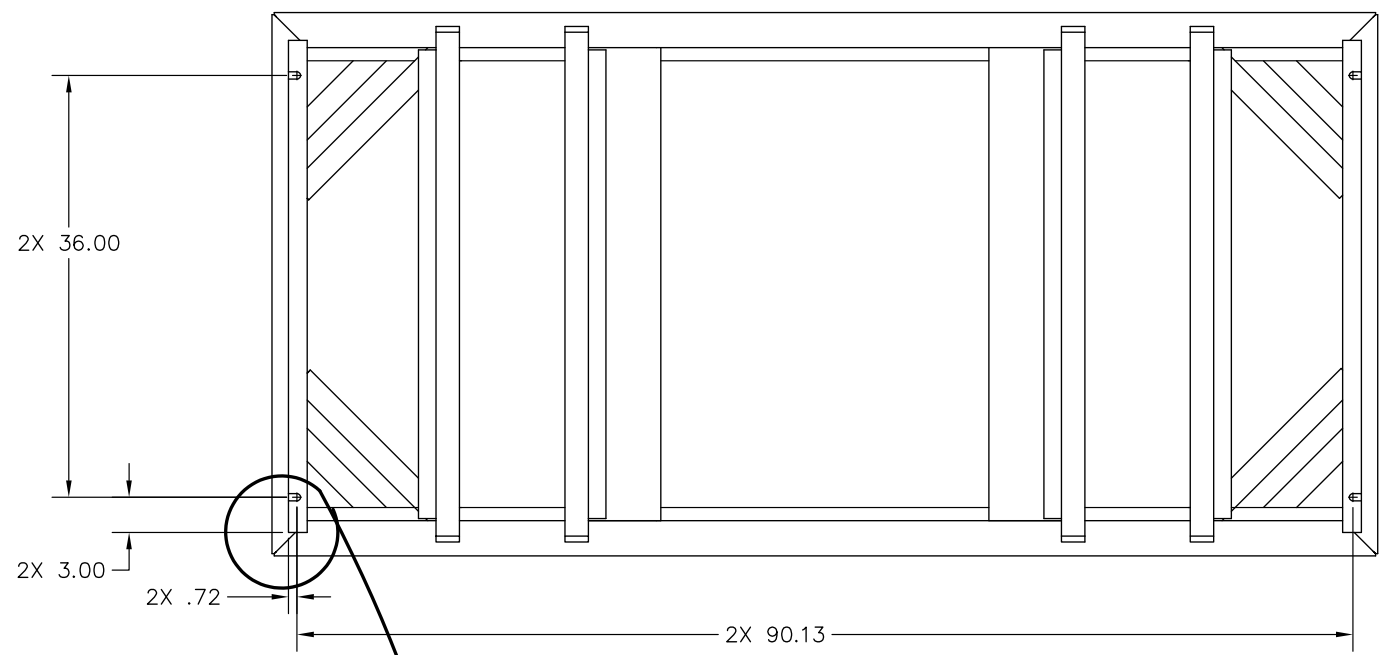
SECTION A-A 3 C 3



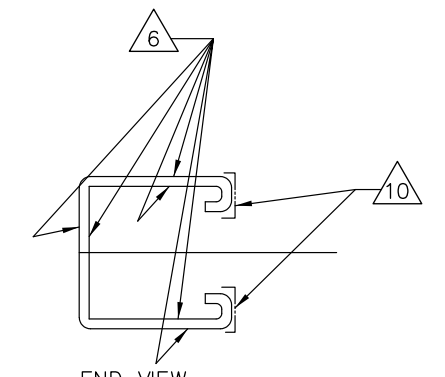
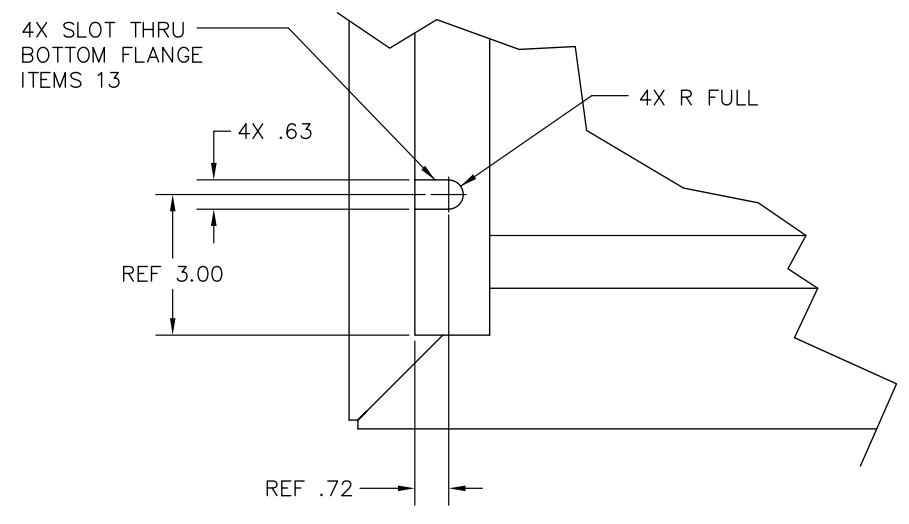
SECTION D-D 3 E 3



SECTION B-B 3 F 4



VIEW C-C 3 A 3



END VIEW UNISTRUT PIECES ITEMS 16 THRU 25 AND ITEM 39
TYPICAL MASKING AND FINISH FOR ITEMS 16 THRU 25 AND ITEM 39

SEE SHEET 1 FOR NOTES

SYSTEMS DIVISION			
REV	DATE	DESCRIPTION	APPROVED
E	XXXXX	XXXXXXXXXX	E
SCALE	1/8	DATE	SHEET 6 OF 6