

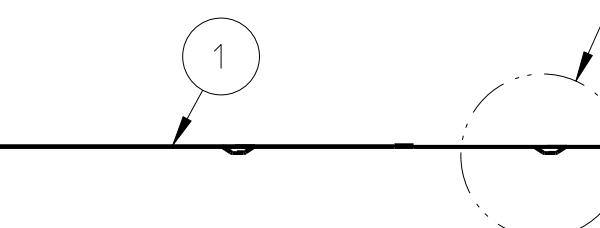
11 10 9 8 7 ◇ 5 4 3 2 1

BILL OF MATERIAL

Item No.	Part No.	Description	Quantity
1	M111821-013	SIDE SHEET, DOOR POST	1
2	M111822-018	SIDE SHEET, INTERMEDIATE	1
3	M111822-019	SIDE SHEET, INTERMEDIATE	1
4	M111822-020	SIDE SHEET, INTERMEDIATE	1
5	M111822-021	SIDE SHEET, INTERMEDIATE	1

DETAIL A
SCALE 0.100

SEE DETAIL A



269.938 REF

0.063 GAP

58.750 REF

GRIND WELD FLUSH
FOR TOP CHORD FITUP
(TYP 4 PLCS)

58.750 REF

46.719 REF

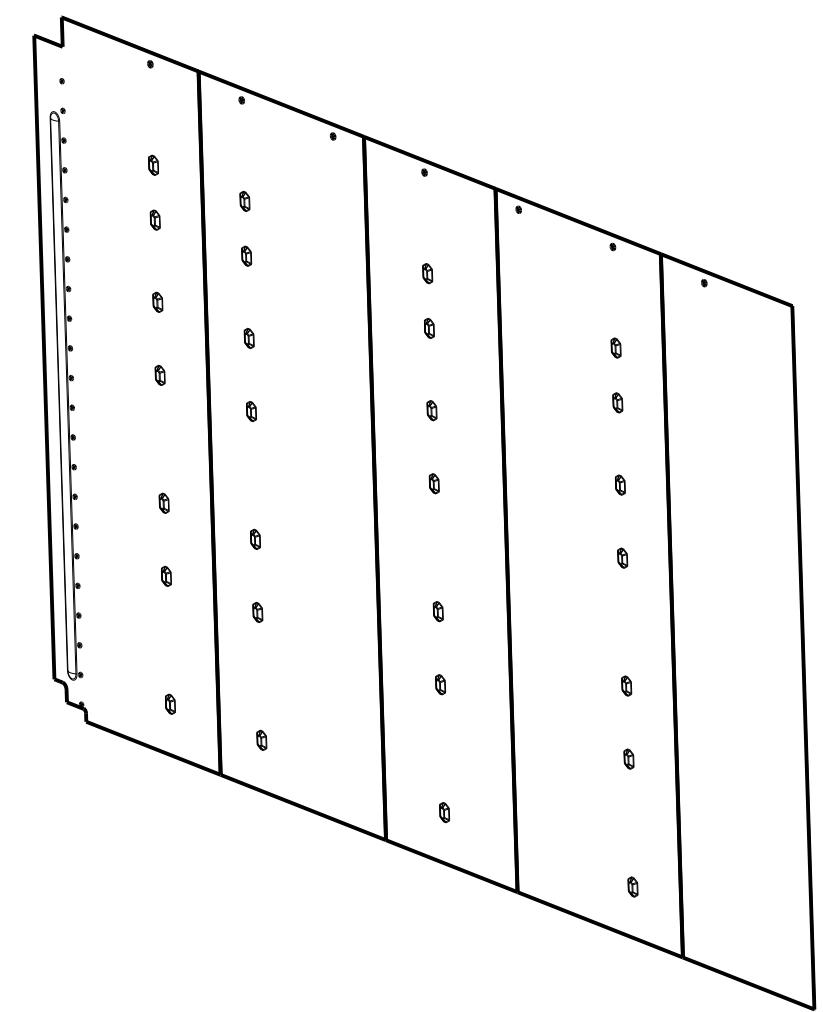
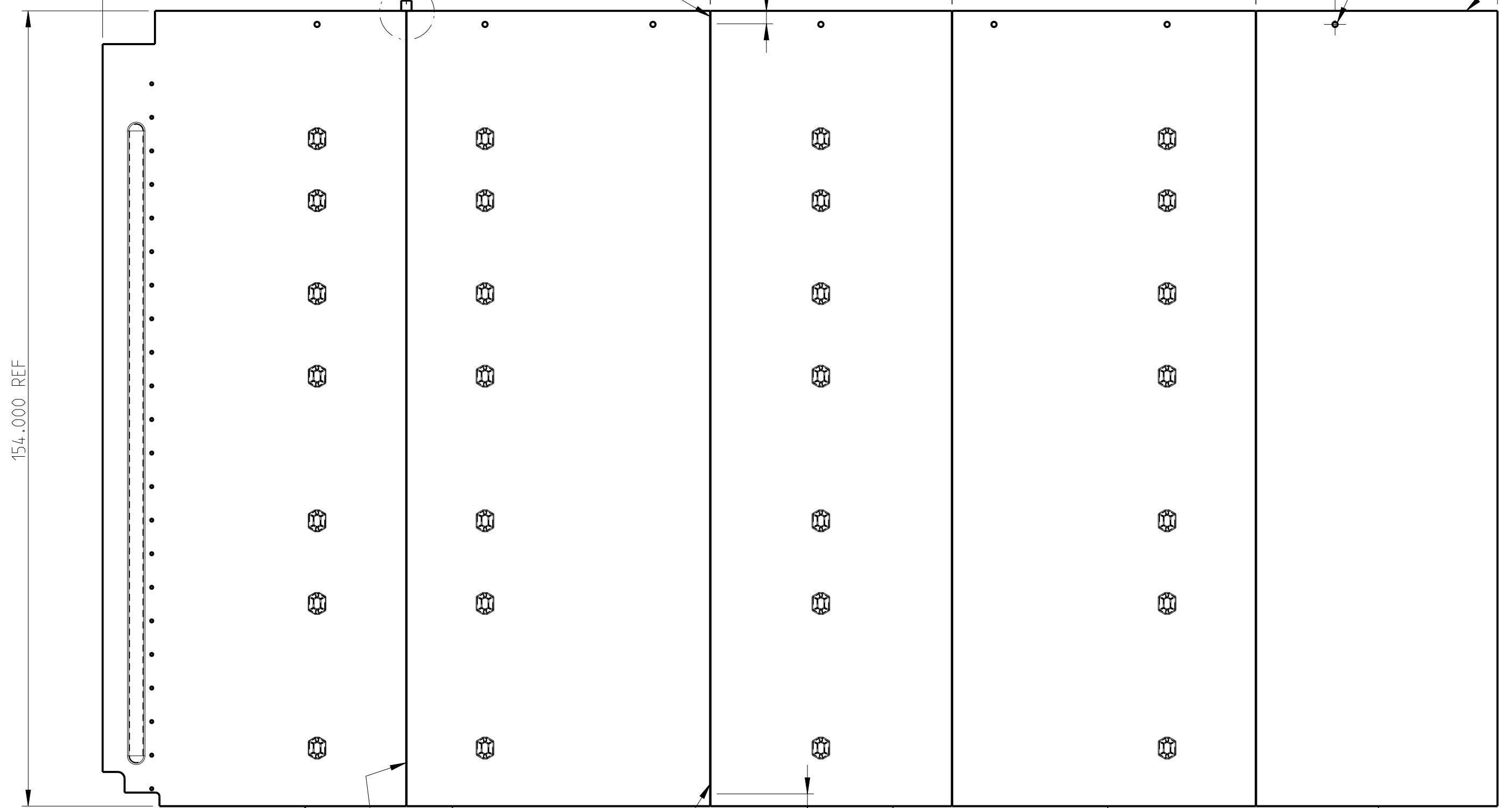
0.063 GAP

58.750 REF

0.063 GAP

46.719 REF

15.281 REF

NOTE
LOCATION
OF HOLEALIGN TOP
SURFACES**NOTE:**

1. UNLESS OTHERWISE NOTED, WELD LENGTHS SHOWN ARE MINIMUM LENGTHS, WELD TERMINATIONS MUST HAVE A MINIMUM EDGE DISTANCE OF 0.25.
2. ALL WELDING TO BE IN ACCORDANCE WITH RAILROAD WELDING SPECIFICATION AWS D15.1, LATEST REVISION, AND TO BE CLASS 2 UNLESS OTHERWISE SPECIFIED.
3. WELD 1:W TO BE GROUND FLUSH ON INTERIOR SIDE WITHOUT REMOVING PARENT MATERIAL. OUTER SIDE TO BE GROUND FLUSH ONLY IN LOCATIONS NEEDED FOR APPLICATION OF HORIZONTAL STIFFENERS AND DOOR STOP BRACKETS.

SEE NOTE 3

(TYP 4 PLCS) 1:W
0.063
154.0GRIND WELD FLUSH
FOR SIDE SILL FITUP
(TYP 4 PLCS)

2.000 REF

BUTT RUN OFF TAB 00594-649
AGAINST SIDE SHEET ON EACH
END OF EACH WELD SEAM, AFTER
WELDING SEAM IS COMPLETE. REMOVE
RUN-OFF TAB, AND GRIND SMOOTH
ASSEMBLY

2.375

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