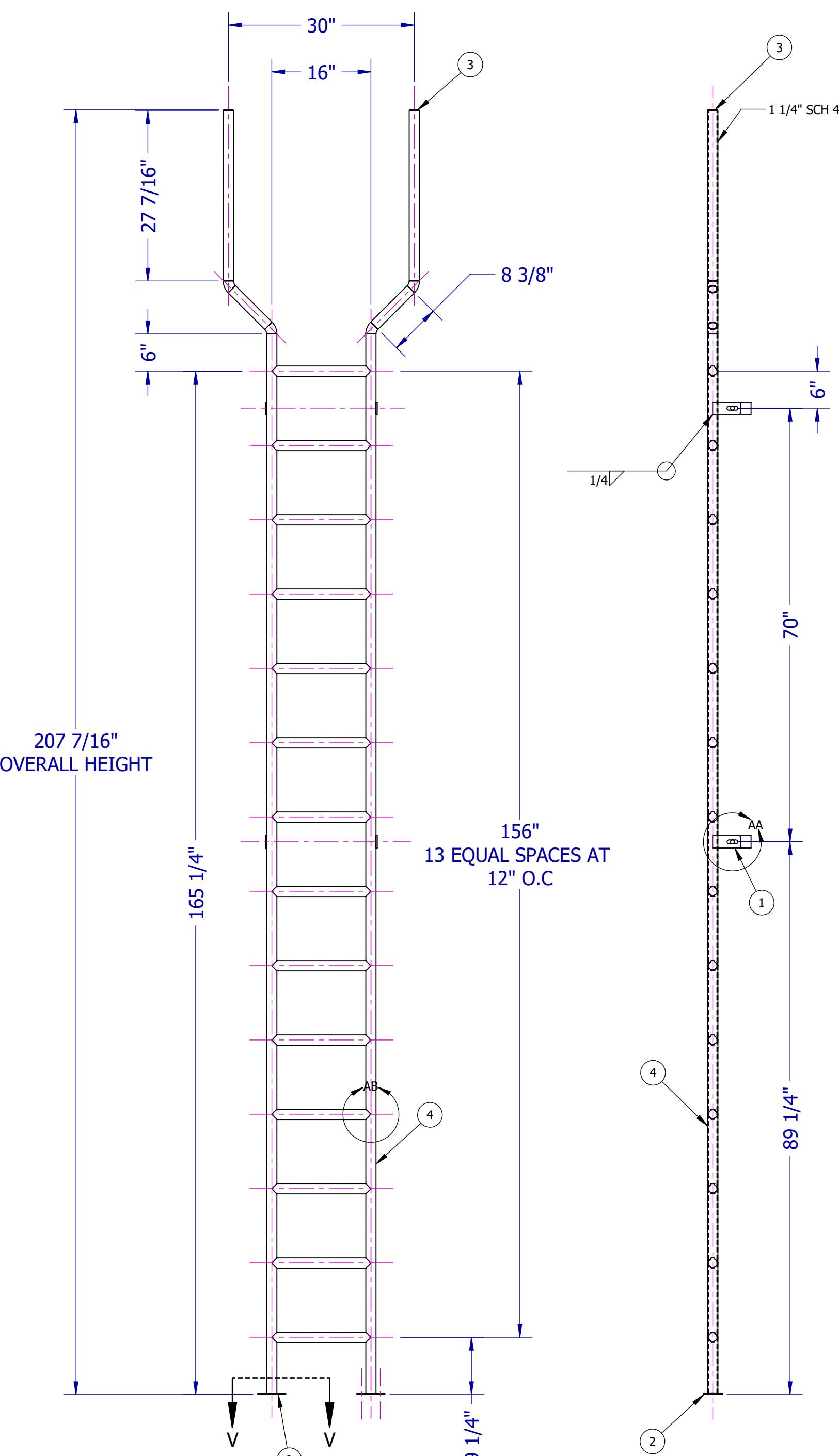


TOLERANCE TABLE	
LINERAR	$\pm 1/16"$
ANGULAR	$\pm 1^\circ$
HOLE SIZE	$\pm 1/16"$
HOLE LOCATION	$\pm 1/16"$

BILL OF MATERIALS

ITEM	LOCATION	QTY.	DESCRIPTION	MATERIAL
1	LADDER	8	4"LG X 2"WD X 1/4" THK FLAT BAR - ALTERED	T-304-SS
2	LADDER	2	4 1/2" LG X 3" WD X 1/4" THK PLATE - ALTERED	T-304-SS
3	LADDER	2	1 1/2" DIA X 1/4" THK END CAP	T-304-SS
4	LADDER	54FT	1 1/4" SCH 40 PIPE	T-304-SS
5	CAGE	26FT	3" WD X 3/16" THK FLAT BAR	T-304-SS
6	CAGE	91FT	1 1/2" WD X 3/16" THK FLAT BAR	T-304-SS

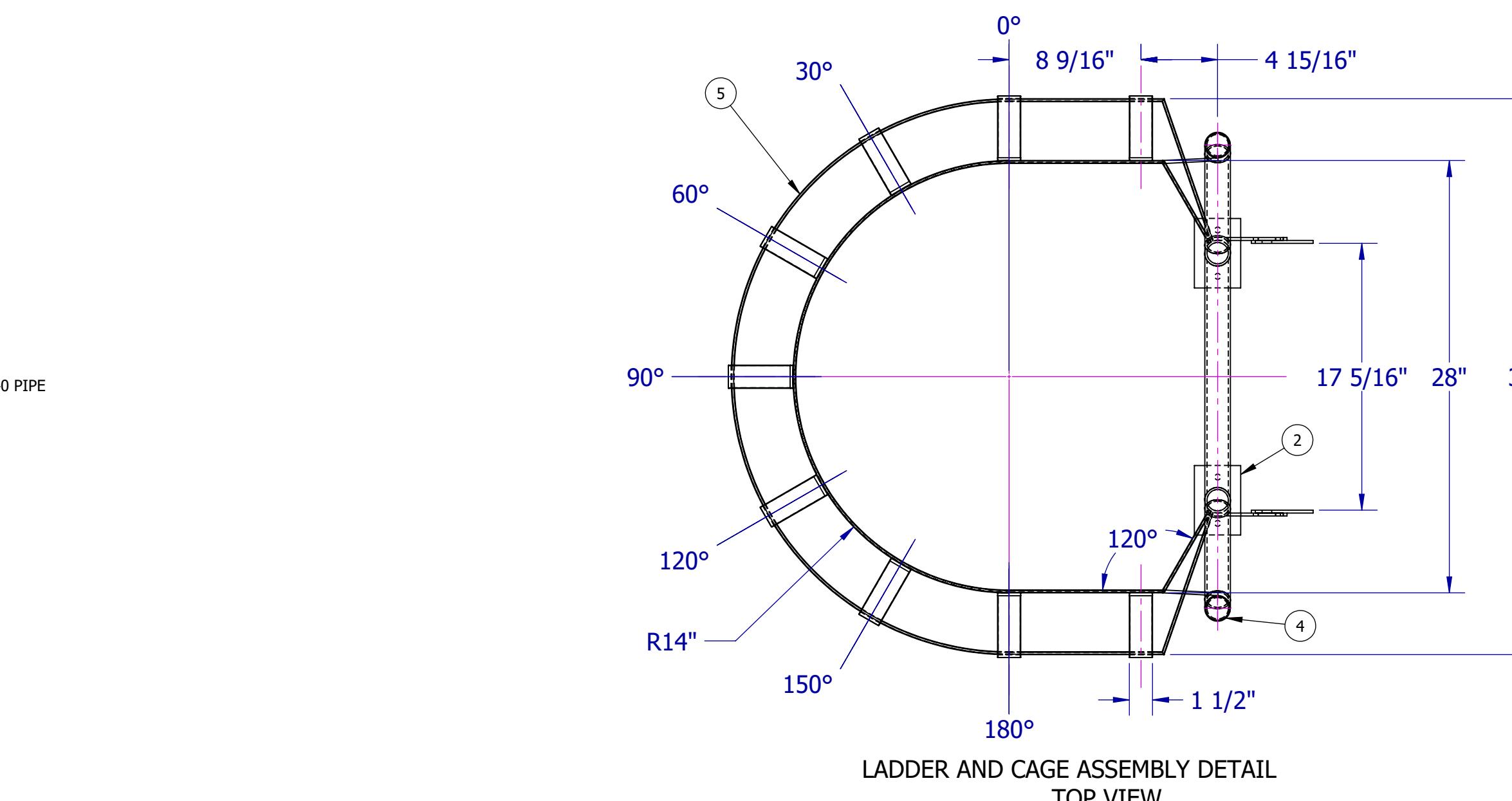


LADDER ASSEMBLY FRONT VIEW

LADDER ASSEMBLY SIDE VIEW

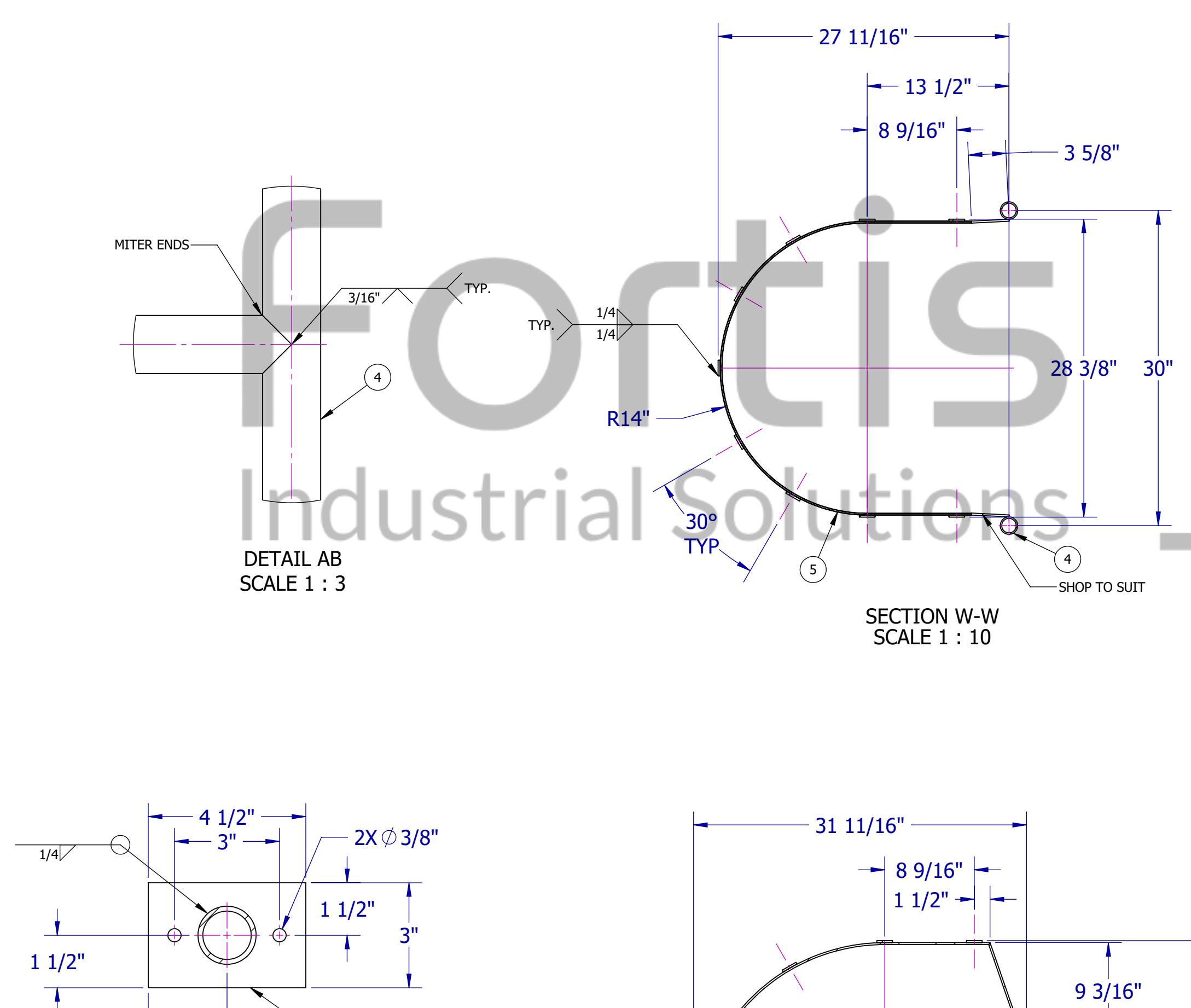
GENERAL NOTES

1. QUANTITY REQ'D: 4(FOUR)
2. ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
3. WELDING SYMBOLS PER AWS A2.4 AND ASME SECTION IX.
4. MATERIAL SUBSTITUTIONS ARE NOT PERMITTED WITHOUT WRITTEN APPROVAL.
5. ALL WELDING TO BE PERFORMED BY QUALIFIED WELDERS IN ACCORDANCE WITH APPROVED WPS/PO
6. ALL WELDS SHALL BE FULL PENETRATION (CJP) UNLESS OTHERWISE NOTED.
7. WELD SIZES SHOWN ARE MINIMUM REQUIRED.
8. WELD SPATTER SHALL BE REMOVED; WELDS SHALL BE FREE OF CRACKS, POROSITY, AND UNDERCUT
9. Crevices, sharp corners, and dead lags are not permitted in product-contact areas.
10. DISTORTION TO BE MINIMIZED DURING FABRICATION AND WELDING.



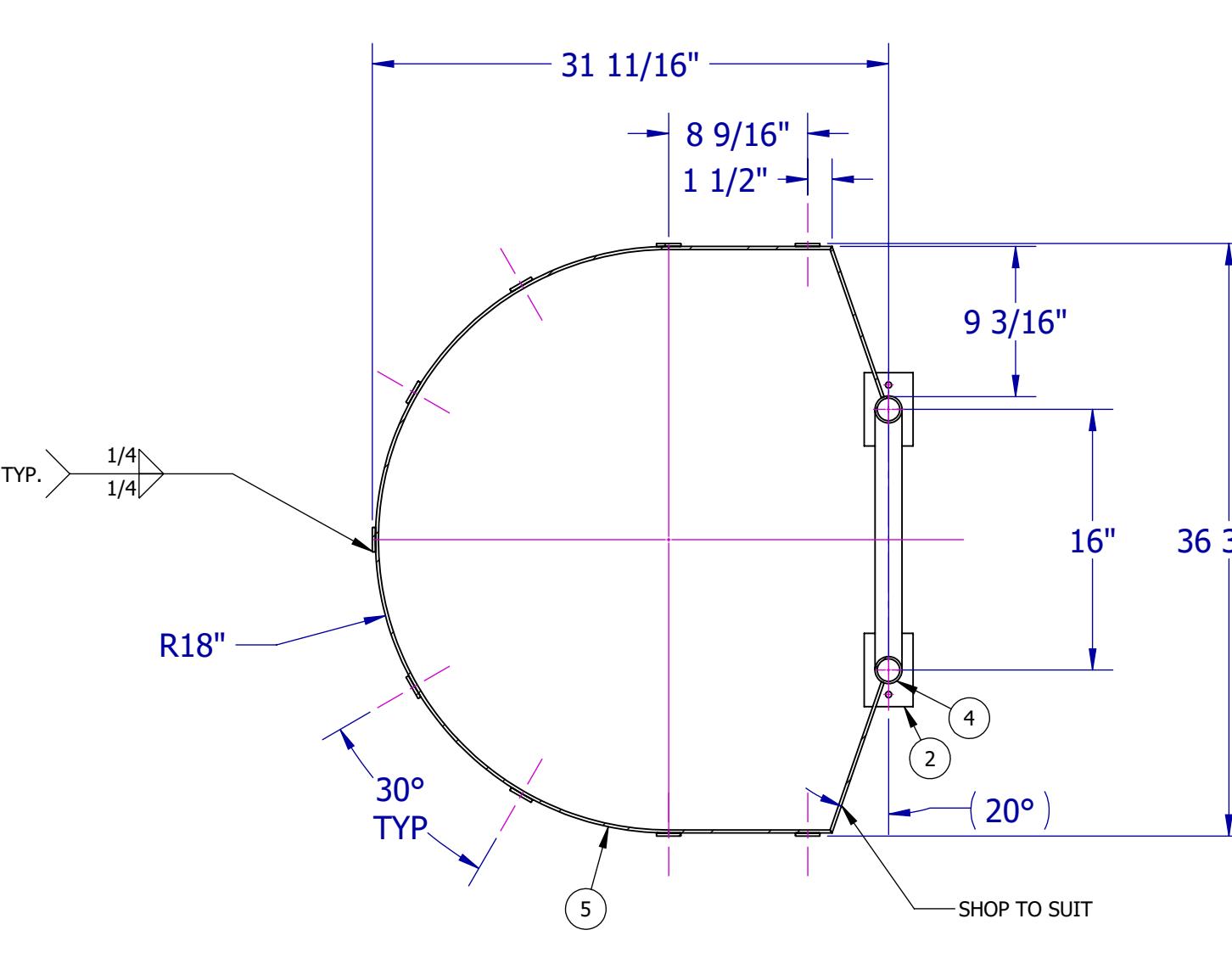
180

LADDER AND CAGE ASSEMBLY DETAIL
TOP VIEW



DETAIL A
SCALE 1 :

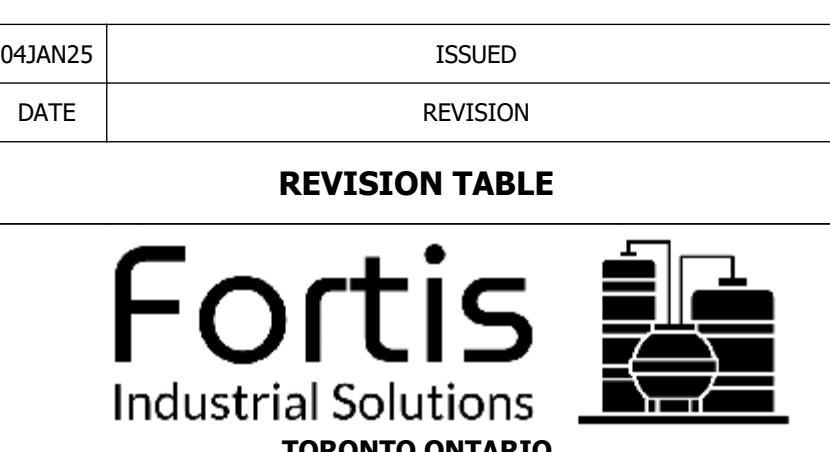
SECTION W
SCALE 1 :



This technical drawing illustrates a vertical pipe assembly, likely a support structure for a tank or similar equipment. The assembly consists of several vertical pipes and brackets. Key dimensions and features include:

- The total height of the assembly is 70'.
- The top section has a height of 48' and a width of 39" TYP.
- The middle section has a height of 89 1/4" and a width of 85 3/4".
- The bottom section has a height of 31 11/16" and a width of 4 1/2".
- A bracket labeled 1 is located at the top of the middle section.
- A bracket labeled 2 is located at the bottom of the middle section.
- A bracket labeled 3 is located on the top section.
- A bracket labeled 4 is located on the middle section.
- A bracket labeled 5 is located on the top section.
- A bracket labeled 6 is located on the middle section.
- A dimension 'W' is indicated between the top and middle sections.
- A label '1 1/4" SCH 40 PIPE' points to the bottom-most pipe.

LADDER AND CAGE ASSEMBLY DETAIL STDE VIEW



MATERIAL		
	GRADE	
PRODUCT CONTACT	T-304-SS	
NON-PRODUCT CONTACT	T-304-SS	
ELASTOMERS	-	
FINISH		
	INTERIOR	EXTERIOR
MATERIAL FINISH	N/A	GLASS BEAD
WELD FINISH	N/A	GLASS BEAD
STRUCTURAL ELEMENTS	N/A	GLASS BEAD
TUBING ELEMENTS	N/A	N/A