



BEFORE GALVANIZING

1. ASSEMBLE STRINGER, INSTALL AND TORQUE BOLTS CONFIRMING THAT SQUARENESS IS MAINTAINED.
2. USE WATER LEVEL OR LASER TO CONFIRM EACH CORNER OF JIG IS LEVEL.
3. CHECK EACH BEAM FOR TILT. DROP A PLUMB BOB FROM THE TOP FLANGE AND MEASURE BACK TO WEB IN TWO LOCATIONS.
4. CONFIRM ALL BEAMS ARE PARALLEL TO DIMENSIONS AS SHOWN ON ASSEMBLY DRAWINGS.
5. PULL STRING ACROSS ENDS OF FLANGES TO ENSURE BEAMS ARE FLUSH.
6. PULL STRING ALONG EACH BEAM TO CHECK FOR STRAIGHTNESS.
7. EMS-TECH INC. REPRESENTATIVE TO VERIFY.



1. MARK GEOMETRY FOR STRINGER SECTIONS ON LEVEL FLOOR. SEE "C" LOOP INSTALLATION/DATUM LINE GUIDANCE DRAWING.
2. TRIAL ASSEMBLE EACH "C" LOOP STRINGER SECTION AS PER ASSEMBLY DRAWING.
3. CHECK FOR GENERAL FLANGE FABRICATION AND FIT-UP. REPAIR ANY PROBLEMS.
4. MATCH MARK EACH COMPONENT PRIOR TO DISASSEMBLY.
5. ASSEMBLY TO BE CHECKED BY EMS-TECH FIELD REPRESENTATIVE PRIOR TO DISASSEMBLY



AFTER GALVANIZING




1. ASSEMBLE CURVED STRINGERS AFTER GALVANIZING USING SAME PROCEDURE AS IN STEP 1, CHECKING TO ENSURE BEAMS HAVE REMAINED PARALLEL, SQUARE AND STRAIGHT. REPAIR AS/IF REQUIRED.
2. TORQUE ALL BOLTS AFTER CORRECTNESS HAS BEEN CONFIRMED.
3. WELD 50mm LONG AT EACH BOLTED CONNECTION AND COLD GALVANIZE, AS REQUIRED. PAINTED SECTIONS DO NOT REQUIRE COLD GALVANIZING.

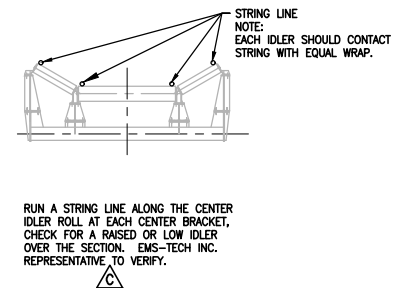
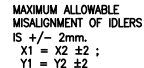


**CURVED STRINGER SECTION – BASE IDLER**

1. CAST CENTER LINE ON FLOOR.
2. PLACE FRAME OVER CENTER LINE.
3. INSTALL BASE IDLER.
4. DROP PLUMB BOB ON ONE SIDE OF ROLLER, MEASURE TO CENTER LINE. CHECK FOR SQUARENESS.
5. EMS-TECH INC. REPRESENTATIVE TO VERIFY.



1. LOOSELY FIT ALL CENTER ROLLS, ENSURING ALL ROLLS ARE CENTERED.
2. RUN CHAIN DIMENSIONS FROM BASE IDLER. 
3. PUSH BRACKETS INTO CENTER LINE AS FAR AS POSSIBLE. CONFIRM SQUARENESS TO BASE IDLER AND TIGHTEN BOLTS.
4. LOOSELY FIT ALL END ROLLS. 
5. RUN CHAIN DIMENSIONS. 
6. PUSH BRACKETS INTO CENTER LINE AS FAR AS POSSIBLE. CONFIRM SQUARENESS TO CENTER ROLL AND TIGHTEN BOLTS.
7. AFTER ASSEMBLY IS COMPLETED, EMS-TECH INC. REPRESENTATIVE TO VERIFY.
8. MARK EACH IDLER BRACKET WITH PANT OR MARKER.



RUN A STRING LINE ALONG THE CENTER IDLER ROLL AT EACH CENTER BRACKET, CHECK FOR A RAISED OR LOW IDLER OVER THE SECTION. EMS-TECH INC. REPRESENTATIVE TO VERIFY.

[illegible]