

DRAWING IS APPROVED

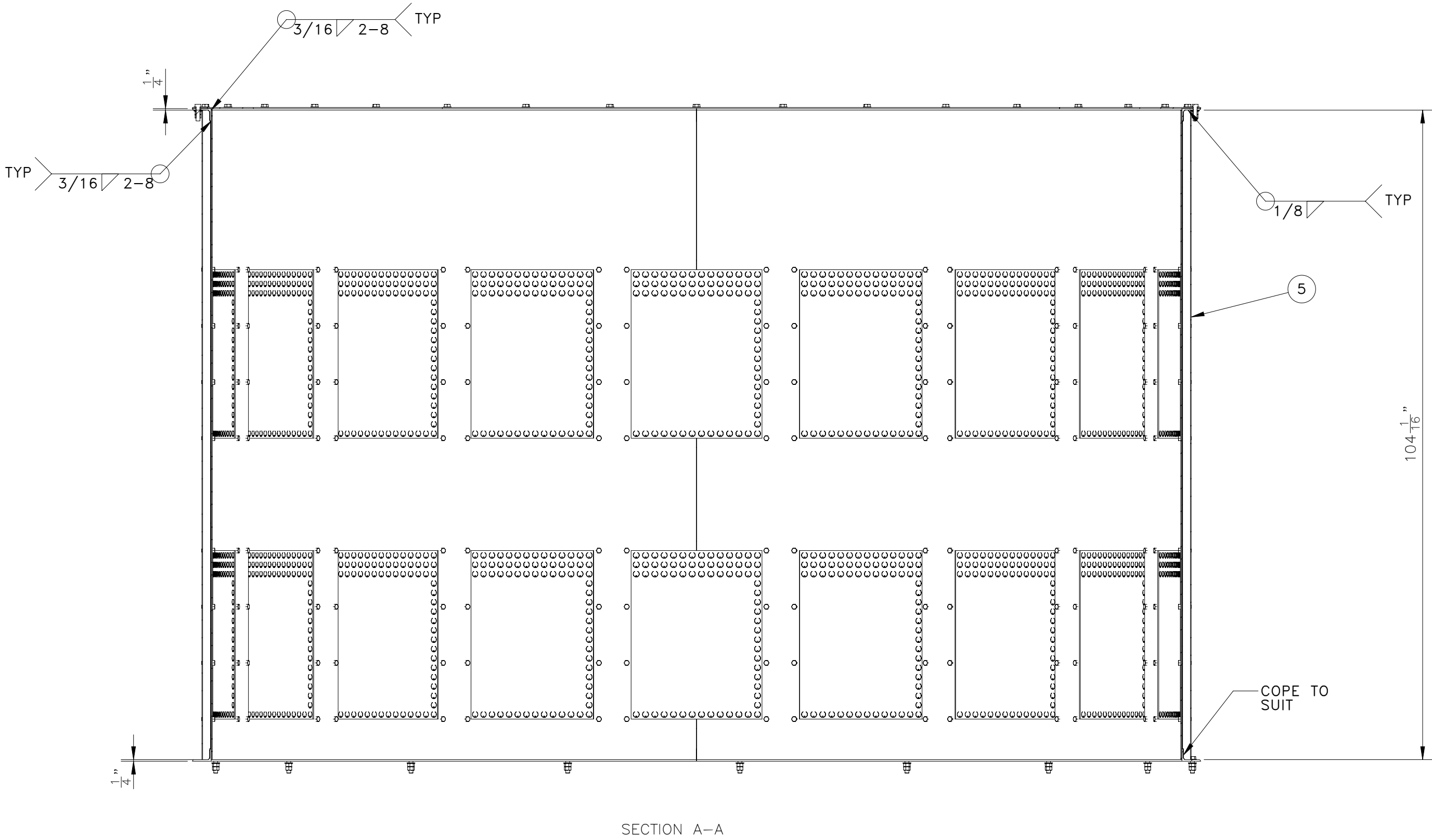
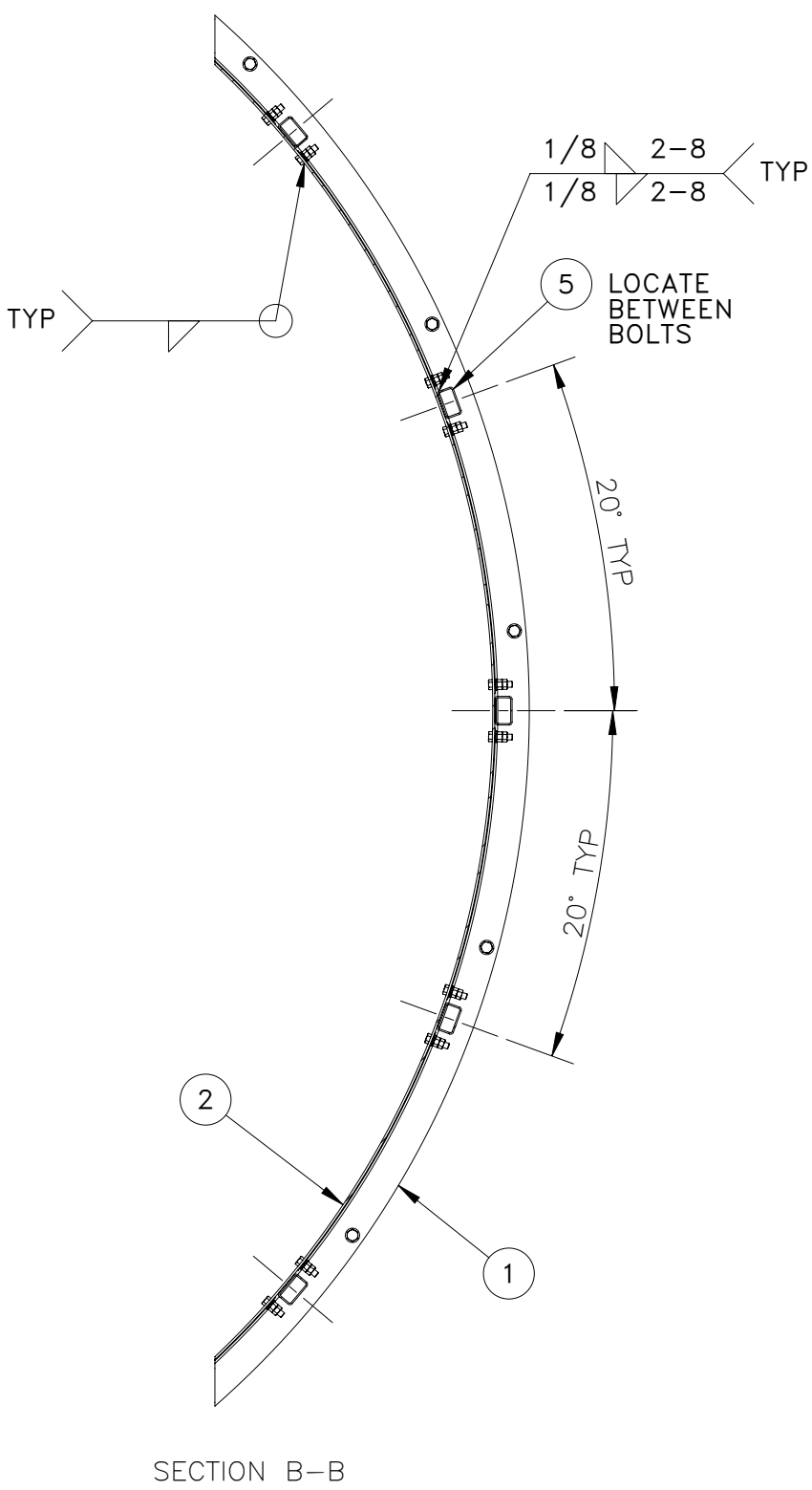
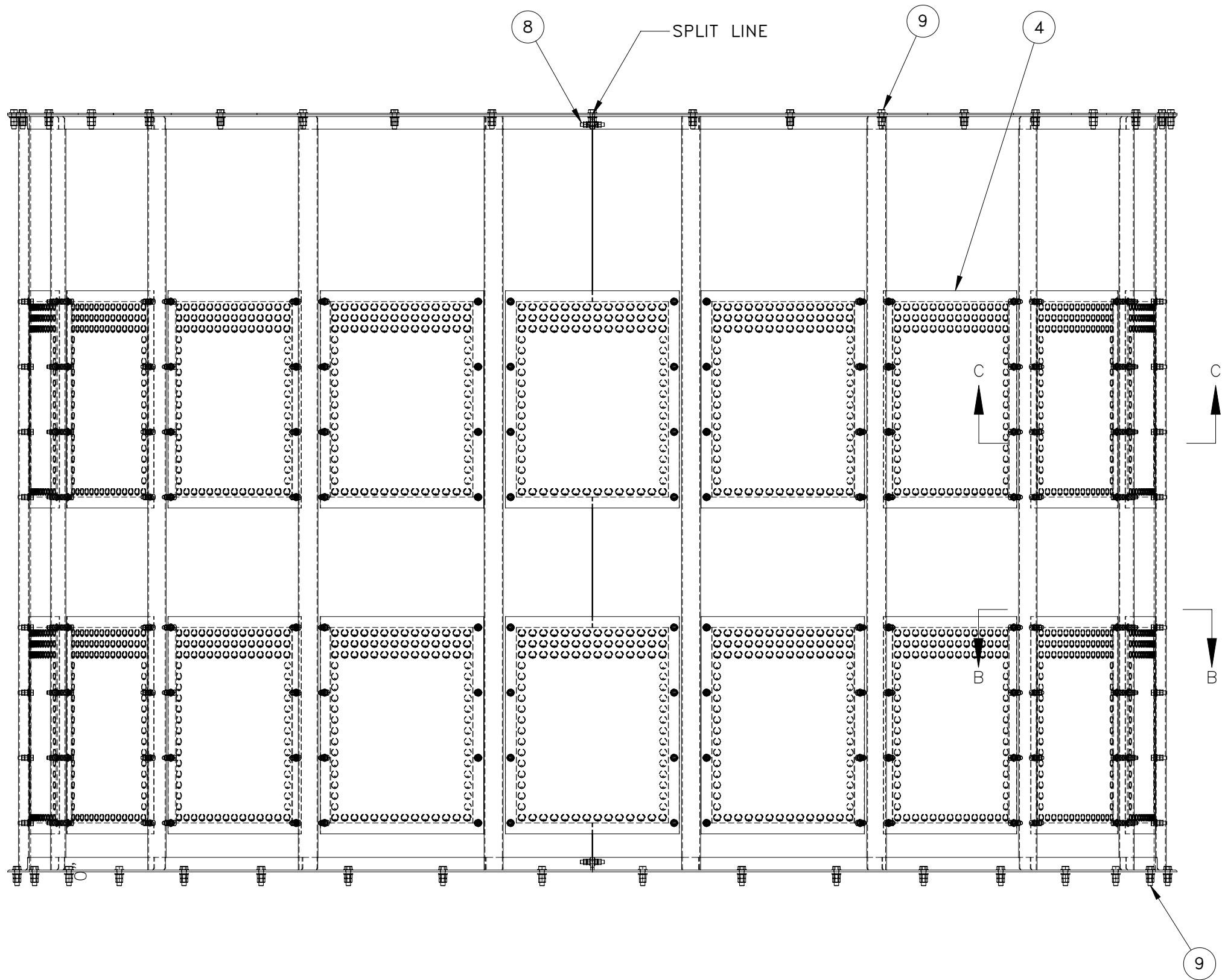
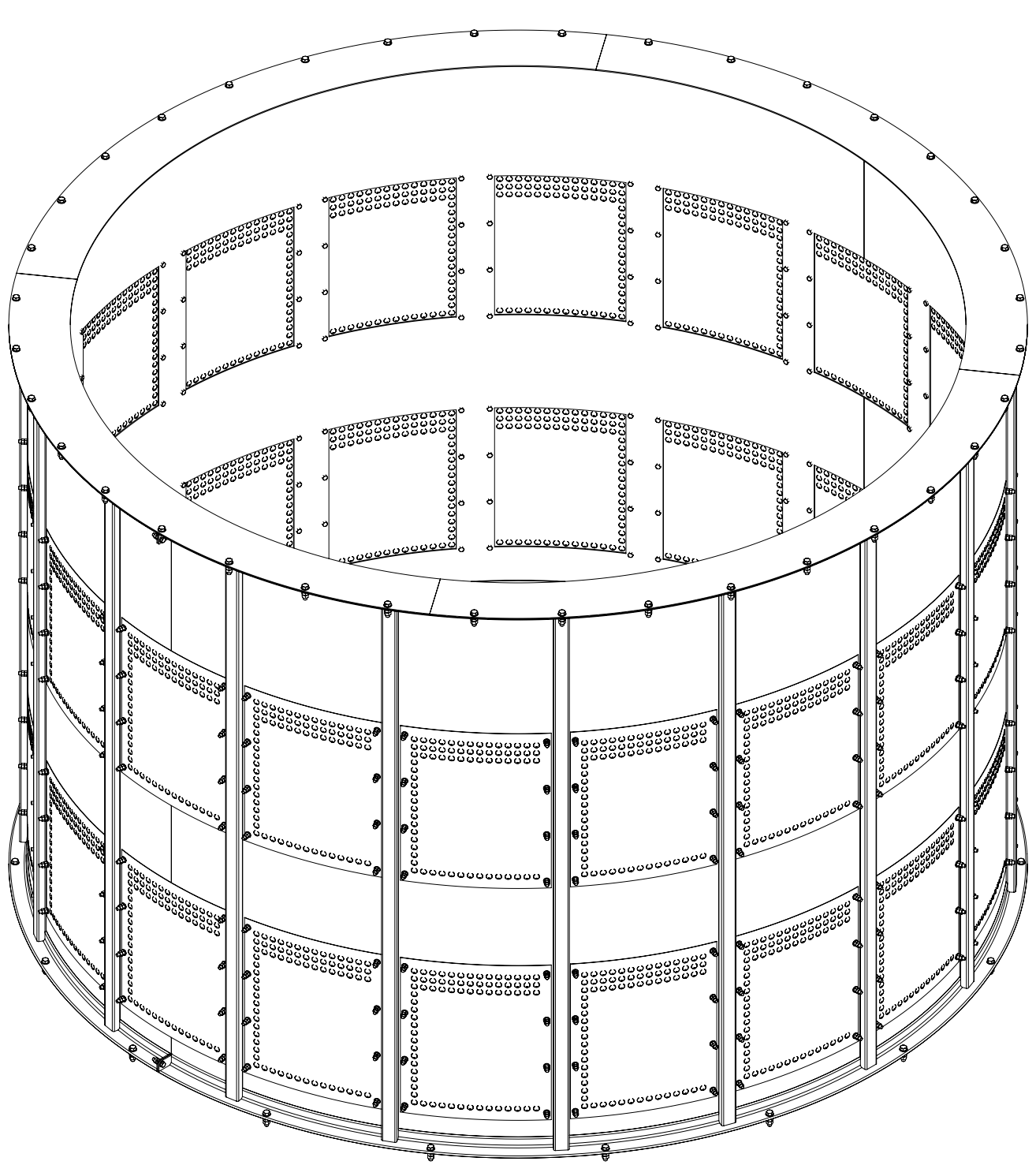
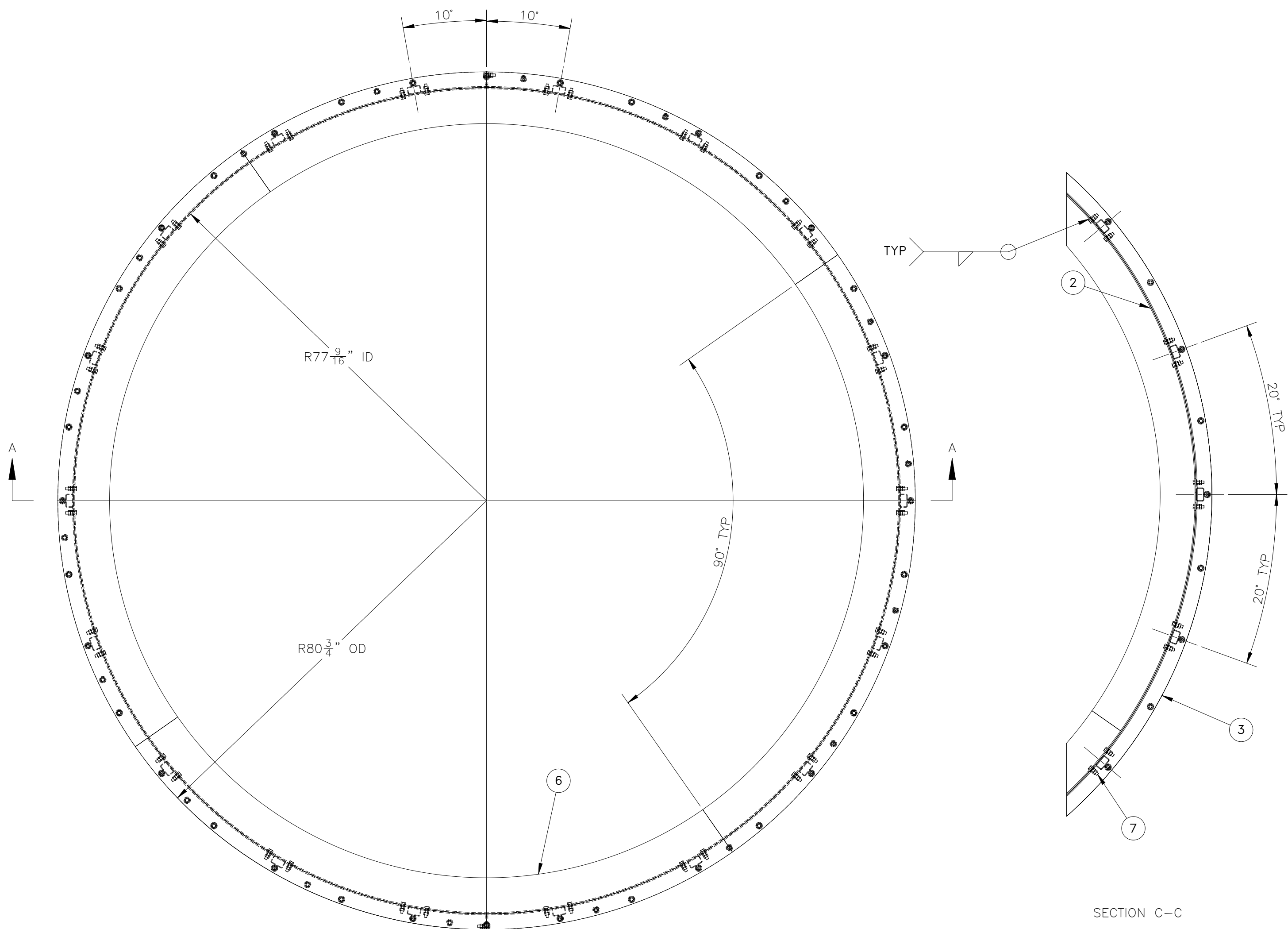
DRAWING NUMBER 112994-030-46-00

UPPER AIR DISTRIBUTION TUBE ASSEMBLY WEIGHT (lbs):3191

MATERIAL	ITEM	QTY	BOM DESCRIPTION	REF	DRW	WT
ASTM A36	1	2	ROLLED BASE ANGLE	112994-030-45-03	Y	166
C.S.	2	2	PL 3/16" x 104 1/16" x 243 7/8"	112994-030-46-01	Y	1612
ASTM A36	3	2	ROLLED BASE ANGLE	112994-030-46-03	Y	166
C.S.	4	36	SHEET 16 GAUGE x 24 1/8" x 30"	112994-030-46-04	Y	435
ASTM A36	5	18	HSS RECT. 2 1/2" x 1 1/2" x 1/8" X 104 1/16" LG	112994-030-46-02	N	468
C.S.	6	4	PL 3/16" x 30 9/16" X 114 3/16"	112994-030-46-07	Y	247
C.S.	7	288	HHMB 1/2"- 13 UNC x 1 3/4" c/w 2 NUTS & FW's	112994-030-46-05	N	0
C.S.	8	4	HHMB 1/2"- 13 UNC x 2" c/w 2 NUTS & FW's	112994-030-45-14	N	0
C.S.	9	54	HHMB 5/8"- 11 UNC x 2 1/4" c/w 2 NUTS & FW's	112994-030-46-06	N	0

WELDING NOTES:-

1. ALL WELDING IS TO BE PERFORMED ACCORDING TO CAN-ENG FURNACES INTERNATIONAL GENERAL WELDING STANDARD DOCUMENT.
2. ALL STRUCTURAL WELDS TO BE MINIMUM 3/16" (5mm) CONTINUOUS FILLET, BOTH SIDES, UNLESS NOTED OTHERWISE ON THE DRAWINGS.
3. ALL STITCH WELDS TO BE MINIMUM 3/16" (5mm) FILLET, 2" (50mm) LONG ON 8" (200mm) CENTRES, STAGGERED, BOTH SIDES, UNLESS NOTED OTHERWISE ON THE DRAWINGS.
4. ALL BEAMS TO BE FULLY COPED AS REQUIRED.
5. ALL SPLICES TO BE FULLY WELDED TOGETHER USING PREPARED BUTT WELDS TO DEVELOP THE FULL STRENGTH OF THE BEAMS OR PLATES.
6. ALL PLATE SEAMS TO BE BEHIND STRUCTURAL MEMBERS.
7. WHEN WELDING DISSIMILAR ALLOYS, THE FILLER MATERIAL USED SHALL BE THE RECOMMENDED ALLOY GRADE FOR THE MATERIAL COMBINATION SPECIFIED TO PREVENT DILUTION OF THE ALLOY CONTENT OF THE HIGHER GRADE MATERIAL IN THE WELD ZONE.
8. READ THIS DRAWING WITH D-27317 CAN-ENG WELDING STANDARDS



TOLERANCES UNLESS OTHERWISE NOTED

FABRICATION & ASSEMBLY TOLERANCES:

BILL OF MAT'L, CUT LENGTHS ± 0" (mm) $\frac{1}{16}$ " (1.3mm)
OVERALL DIMENSIONS TO TRUE SQUARE ± 0.125 (1/8) IN. ± 3.2 mm
DEVIATION FROM TRUE & SQUARE ± 0.125 (1/8) IN. ± 3.2 mm
OVERALL DIMENSION FROM TRUE & SQUARE ± 0.125 (1/8) IN. ± 3.2 mm

ANGULAR ELONGATION ± 0.001 IN.

HEADSTOCK ± 0.001 IN.

DIMENSION TOLERANCES:

FRACTIONAL $\pm \frac{1}{16}$ "

DECIMAL X

XX

XXX

XXXX

ANGULAR $\pm \frac{1}{2}$ "

± 12 " (304.8mm)

± 0.015 " (0.381mm)

± 0.007 " (0.178mm)

± 0.0005 " (0.0127mm)

$\frac{1}{16}$ $\frac{3}{2}$

IN SURF IN SURF

SURFACE SURF

1 CAN-ENG

CAN-ENG FURNACES
INTERNATIONAL LTD
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CANADA

<http://www.can-eng.com>

DRAWING TITLE		MODELED BY:	
UPPER AIR DISTRIBUTION TUBE ASSEMBLY		JD	
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		DRW SIZE:	D O
		REV.	O
SCALE : 1:16 DRAWN : JD 2015/11/11 CHECKED : JVO 2015/12/11 APPROVED : JC 2015/12/11		DRAWING NUMBER	
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