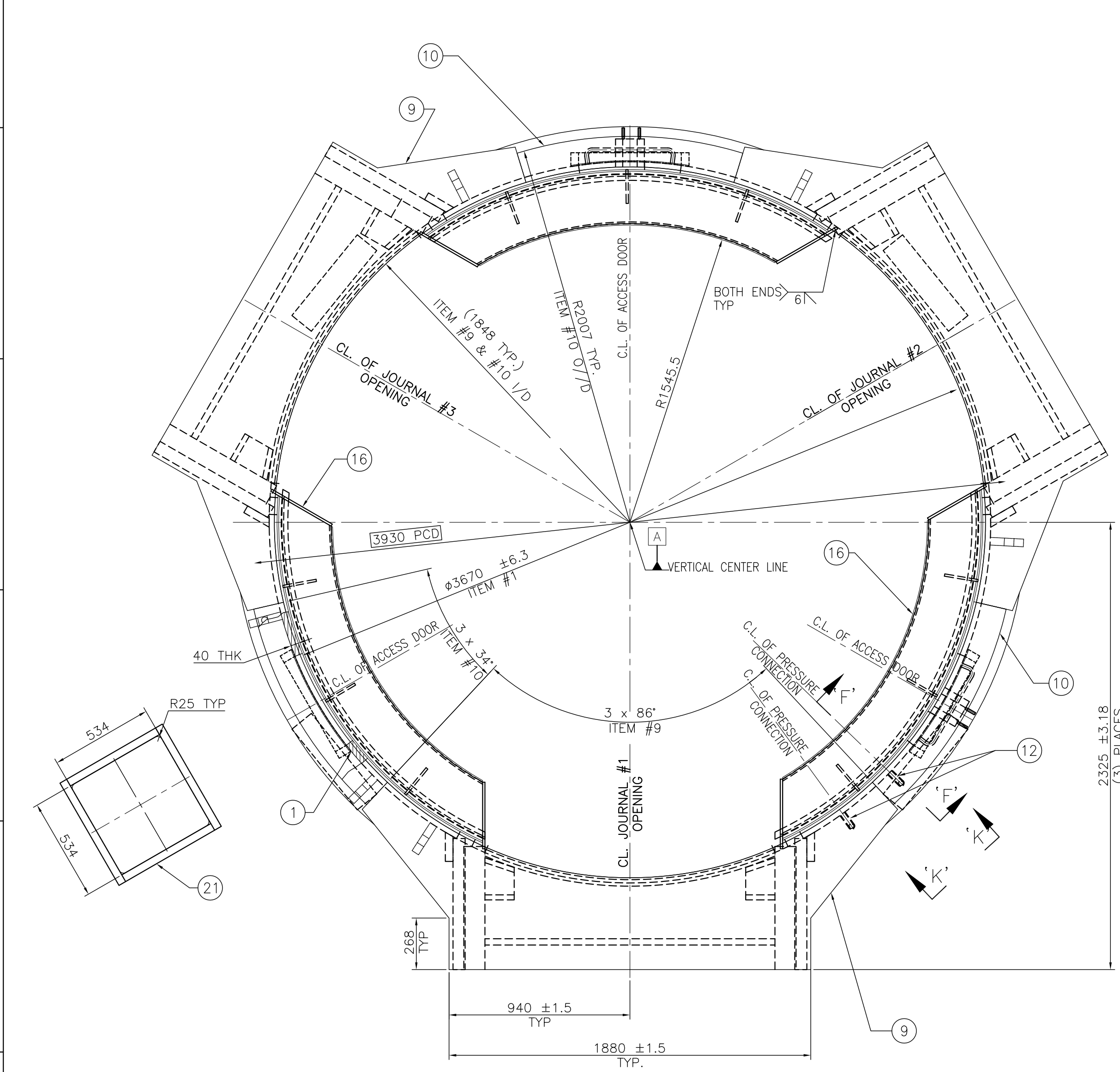
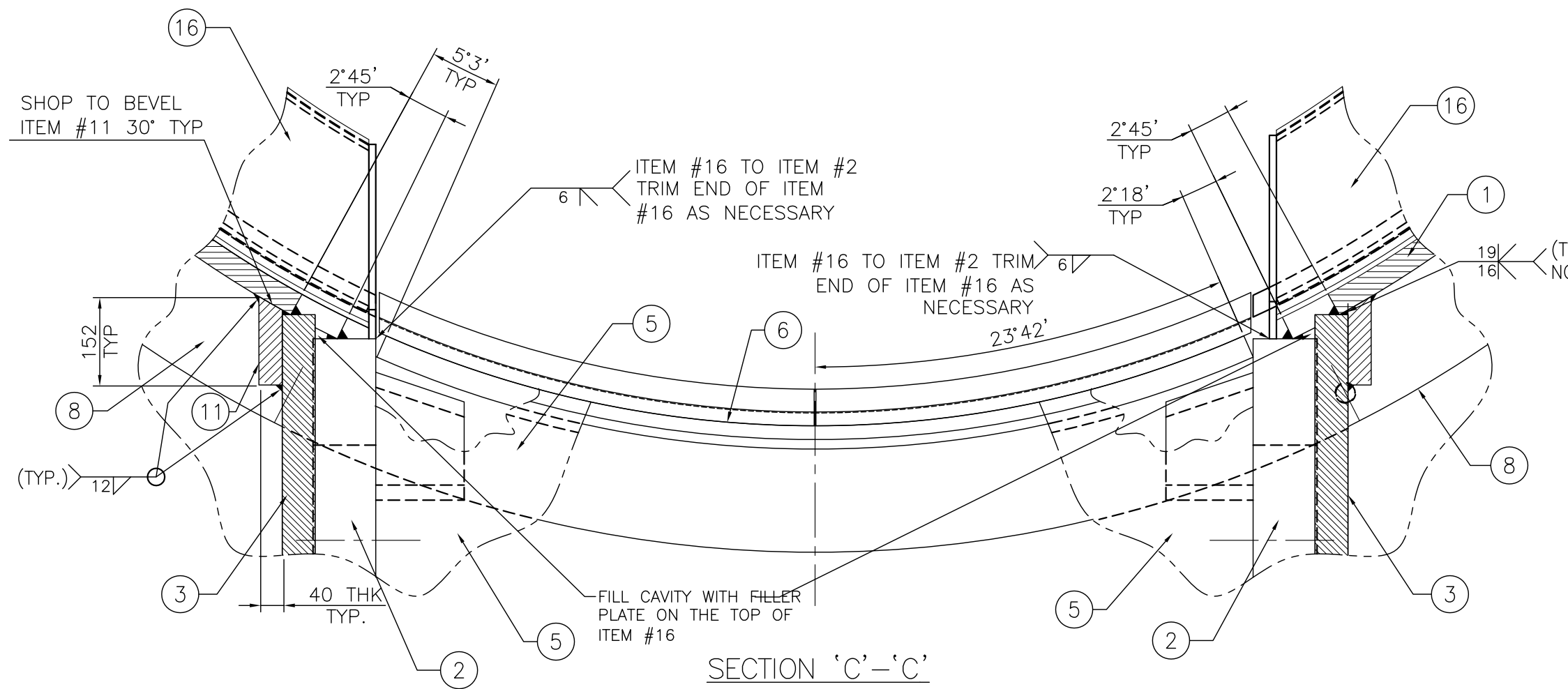


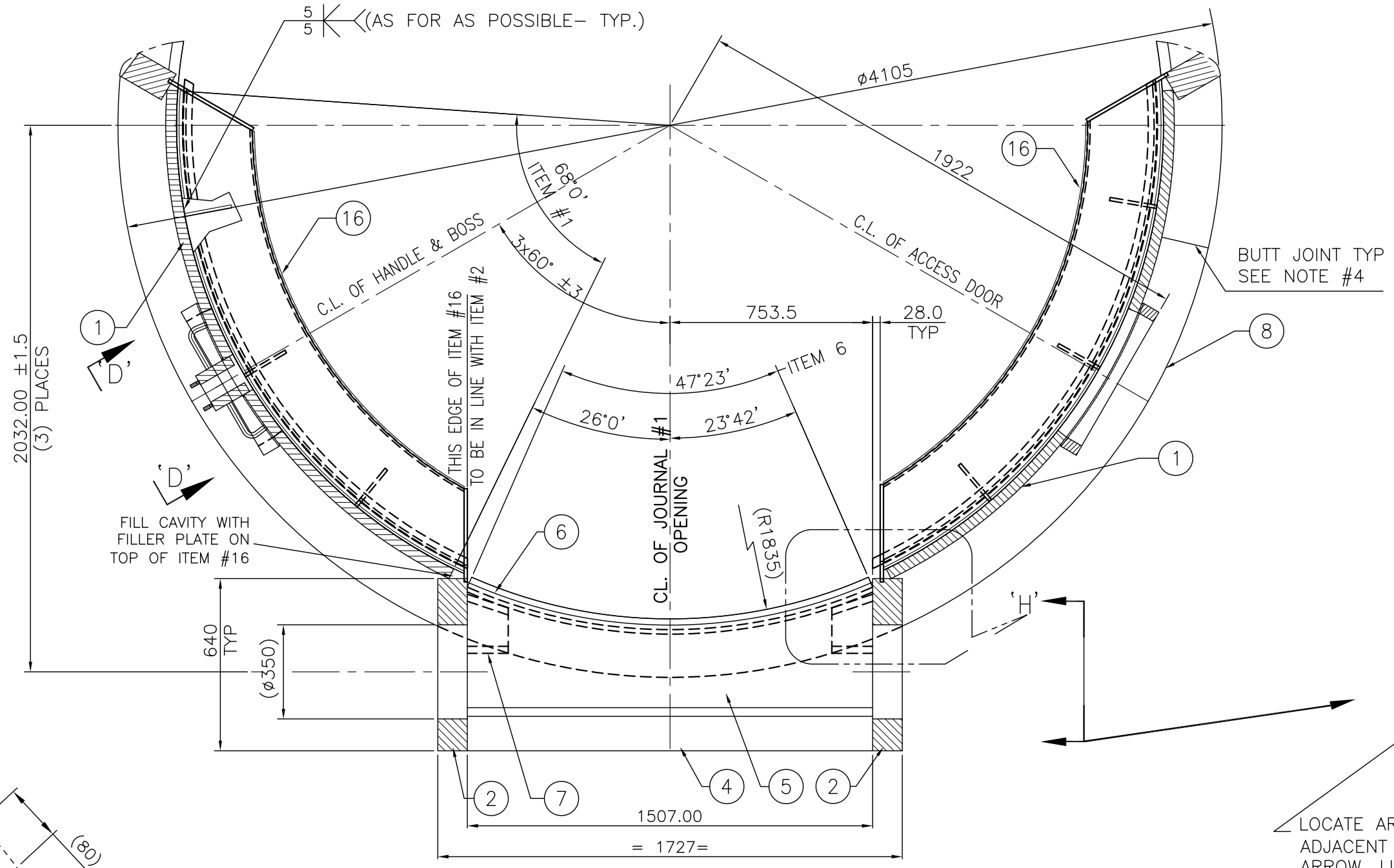
DRG. NO. 0-61-310-01552



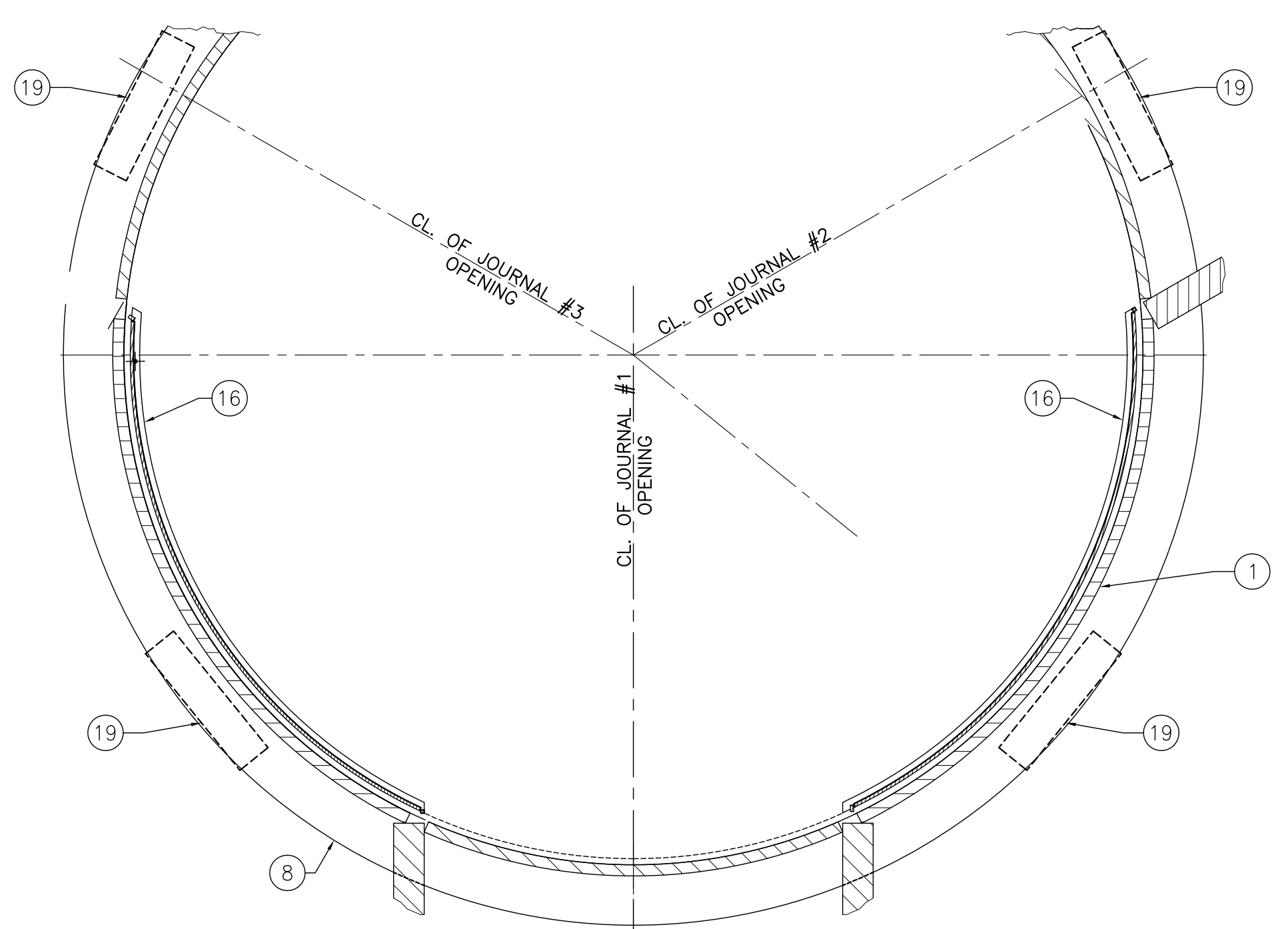
PLAN VIEW



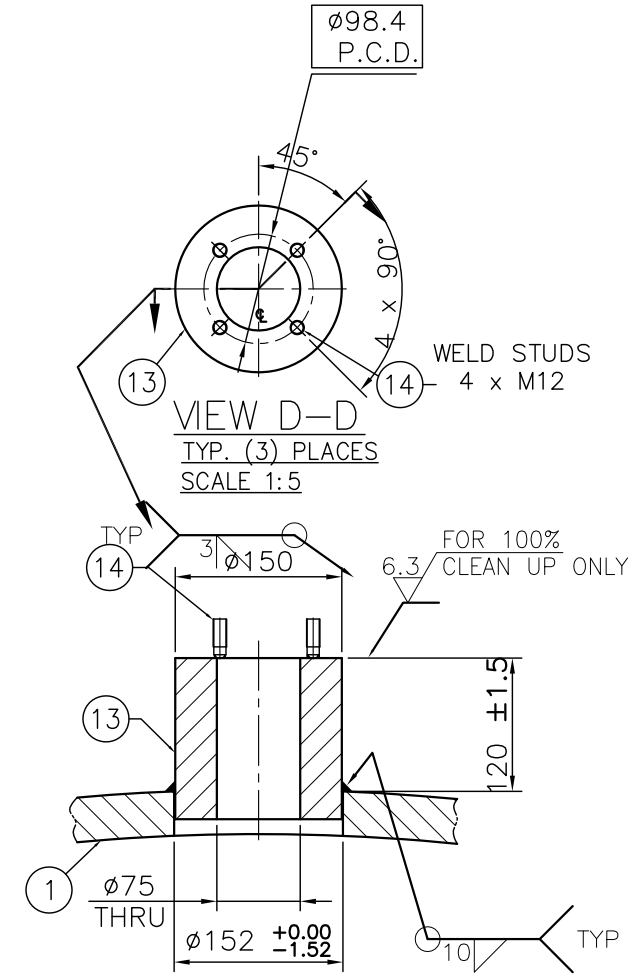
SECTION 'C'-C'



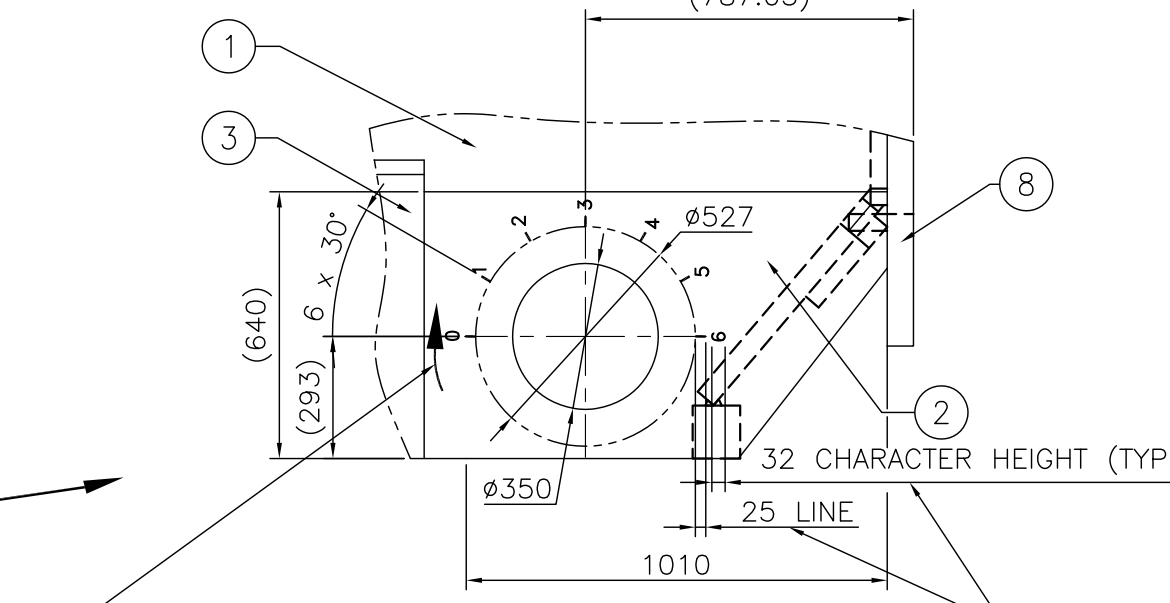
SECTION 'A'-A'



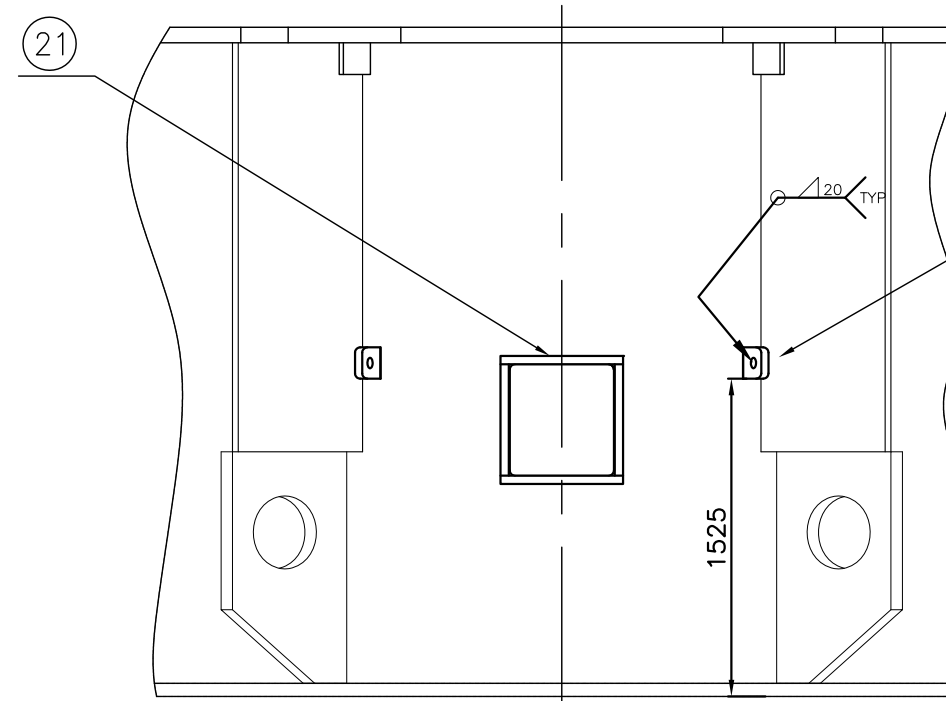
SECTION 'G'-G'



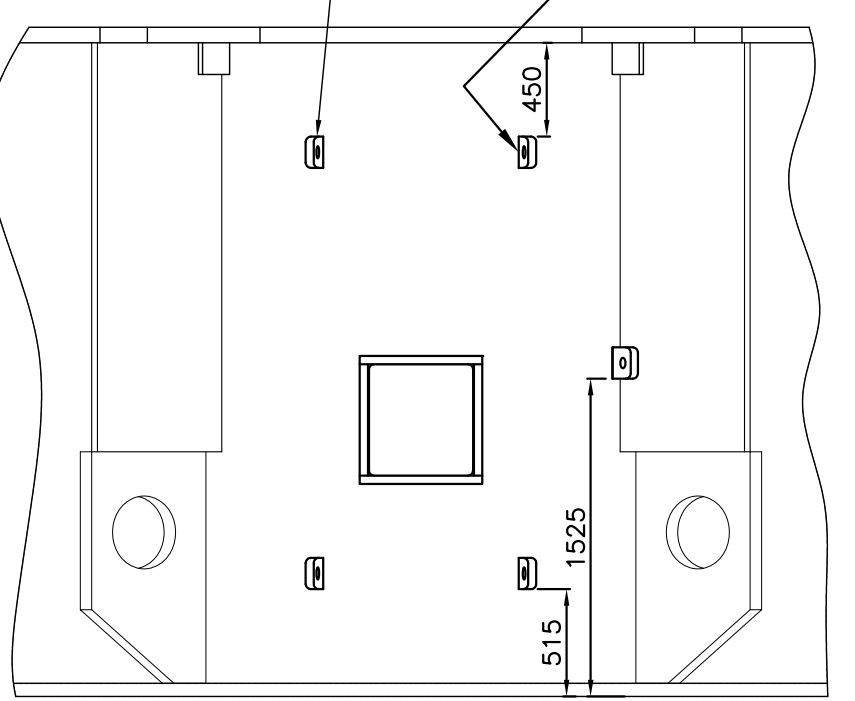
VIEW D-D



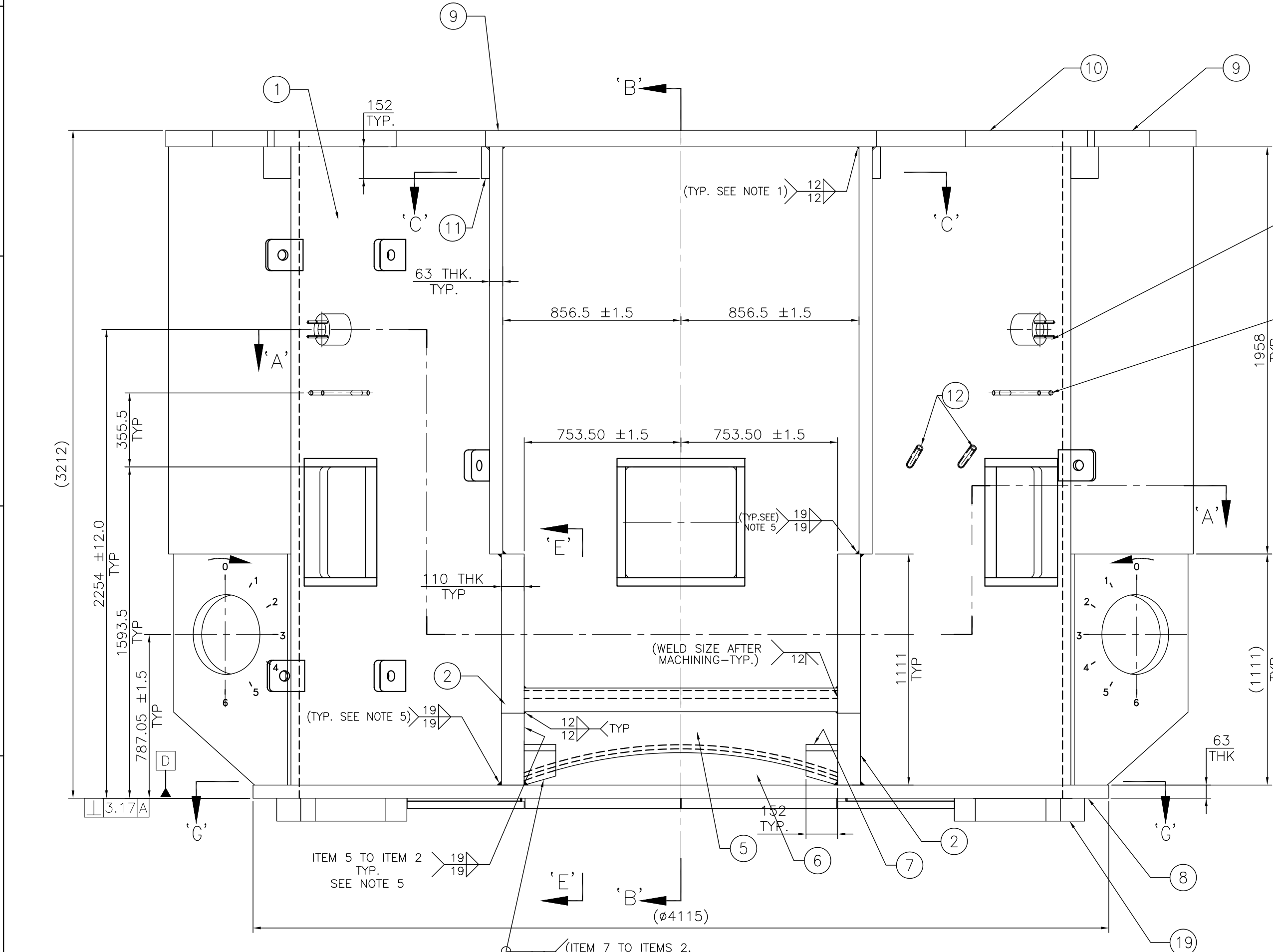
DETAIL 'H'



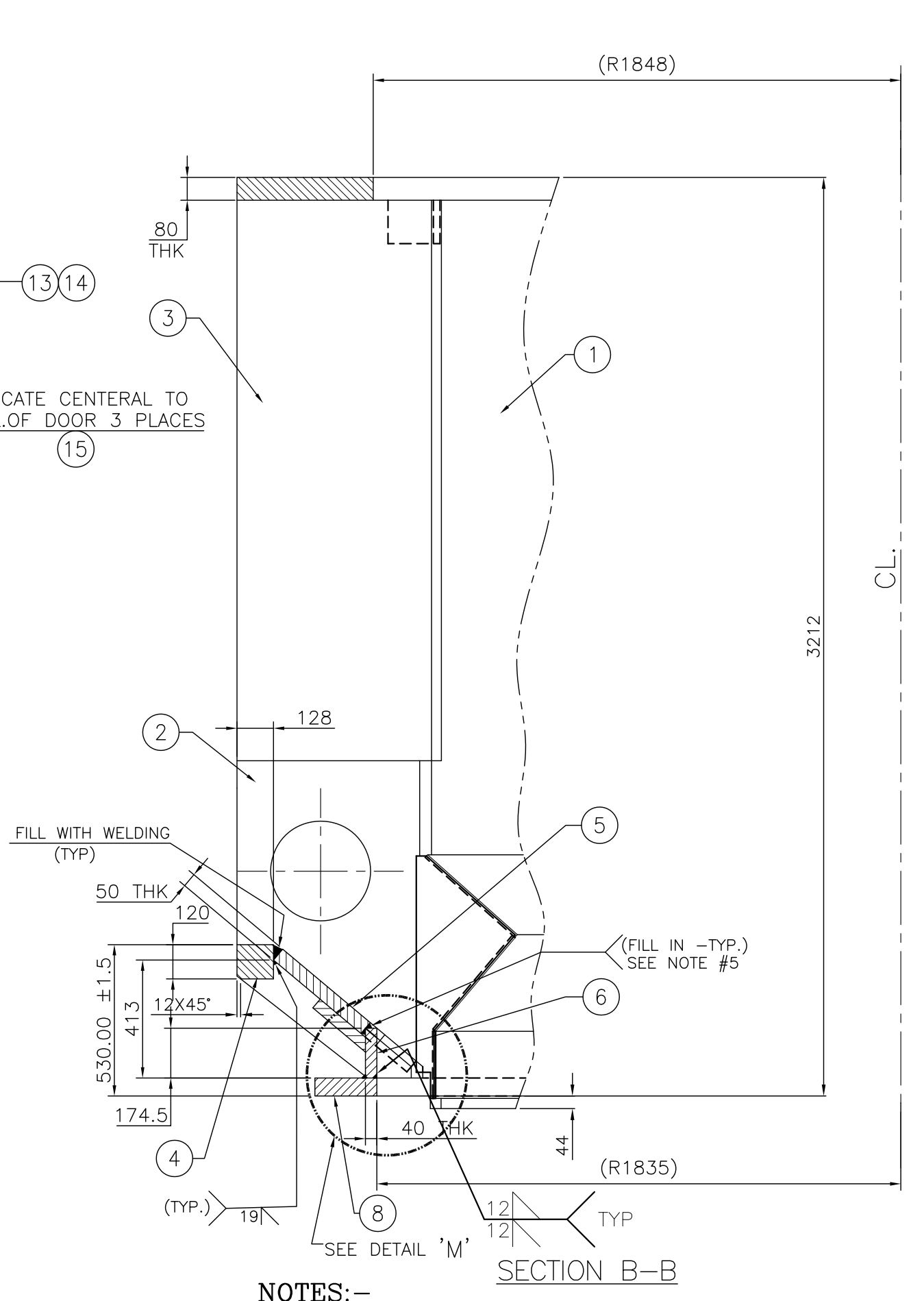
VIEW-N (LUG POSITIONING)



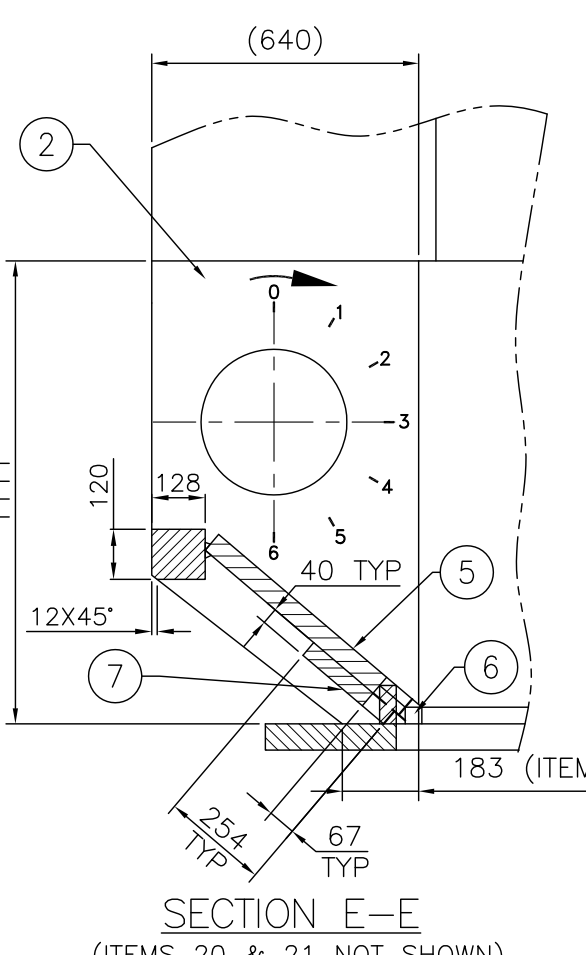
VIEW-L (LUG POSITIONING)



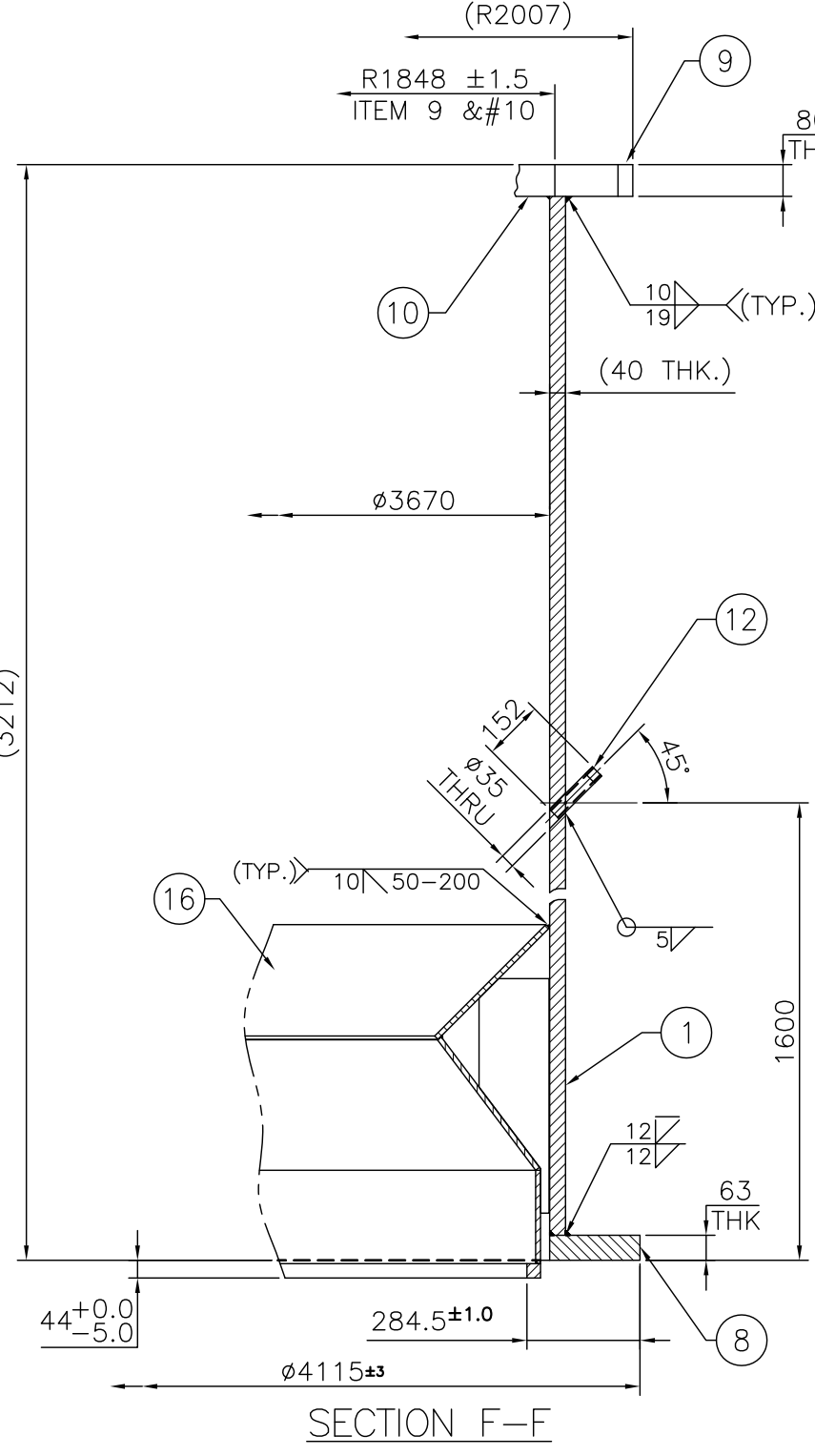
ELEVATION



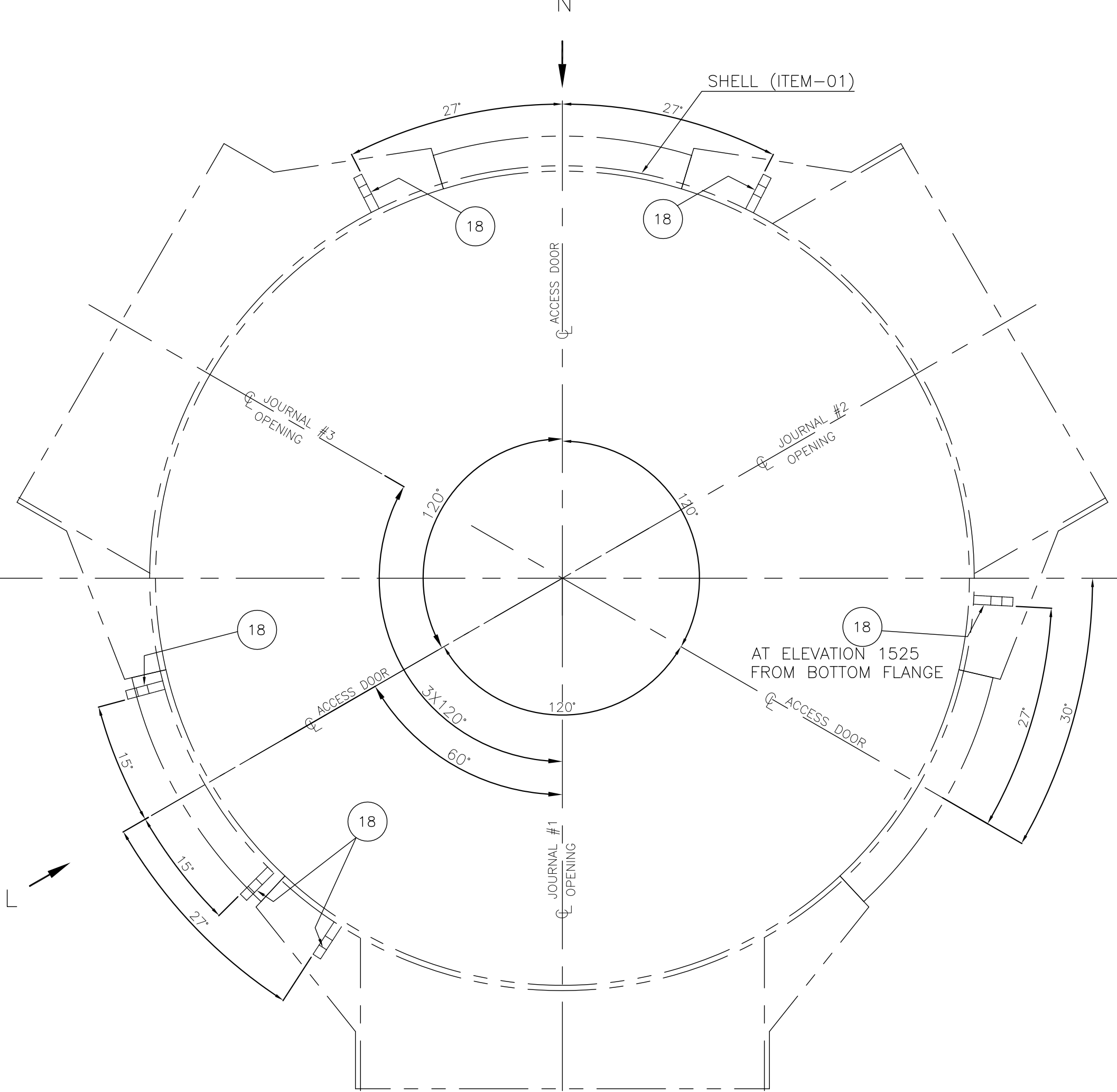
SECTION B-B



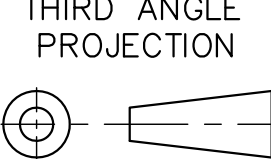
SECTION E-E (ITEMS 20 & 21 NOT SHOWN)



SECTION F-F



ITEM-18 (LUG) POSITIONING DETAILS



NOTES:-

1. THIS WELD MUST BE MAGNETIC PARTICLE INSPECTED BEFORE MACHINING (TYP 12 PLACES).
2. USE DOOR FRAME (ITEM 4) AS A TEMPLATE FOR THE CUTTING OF DOOR FRAME OPENING
3. THIS WELD TO BE MADE WITH GAS SHIELDED FLUX CORE WELDING
4. ALL FILLET WELD TO BE 12% UNLESS OTHERWISE NOTED
5. ALL "Y" WELDS TO BE FULL PENETRATION WELDS UNLESS OTHERWISE NOTED
6. ALL BUTT WELDS TO BE:
A) FULL PENETRATION 'X' WELDS.
B) LPI TESTED AFTER BACK CHIPPING AS PER AA0850131 ACCEPTANCE AS PER AA0850129
C) 100% MINIMUM RADIOGRAPHY TESTED (100% FOR ALL KNOT WELDS) AS PER HY0850170.
7. LPI OF ALL FINISHED WELDS AS PER AA0850131 AND ACCEPTANCE AS PER AA0850129.
8. REFER TO 0-61-310-00902 FOR MACHINING DRAWING.
9. NOTES 4 TO 7 ARE ALSO APPLICABLE FOR PART DRAWINGS REFERRED TO IN THIS DRAWING
10. ABOVE ARE MINIMUM NDT REQUIREMENTS. CUSTOMER APPROVED QUALITY PLAN MAY REQUIRE ADDITIONAL NDT REQUIREMENT / PERCENTAGE.
11. FOR LOCATION OF ITEM 16 SEE SECTIONS A-A, C-C AND F-F.
12. WELD ITEMS #1 THRU #15 AS SHOWN.
13. REFER 06131000935 DRAWING FOR CUTTING PLANS
14. LIFTING LUGS TO BE FIXED AS PER DRG NO. 26131003585.

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COMP. FILE NAME 0-61-310-00934-13

REF. DRG. NO.

INVENTORY NO