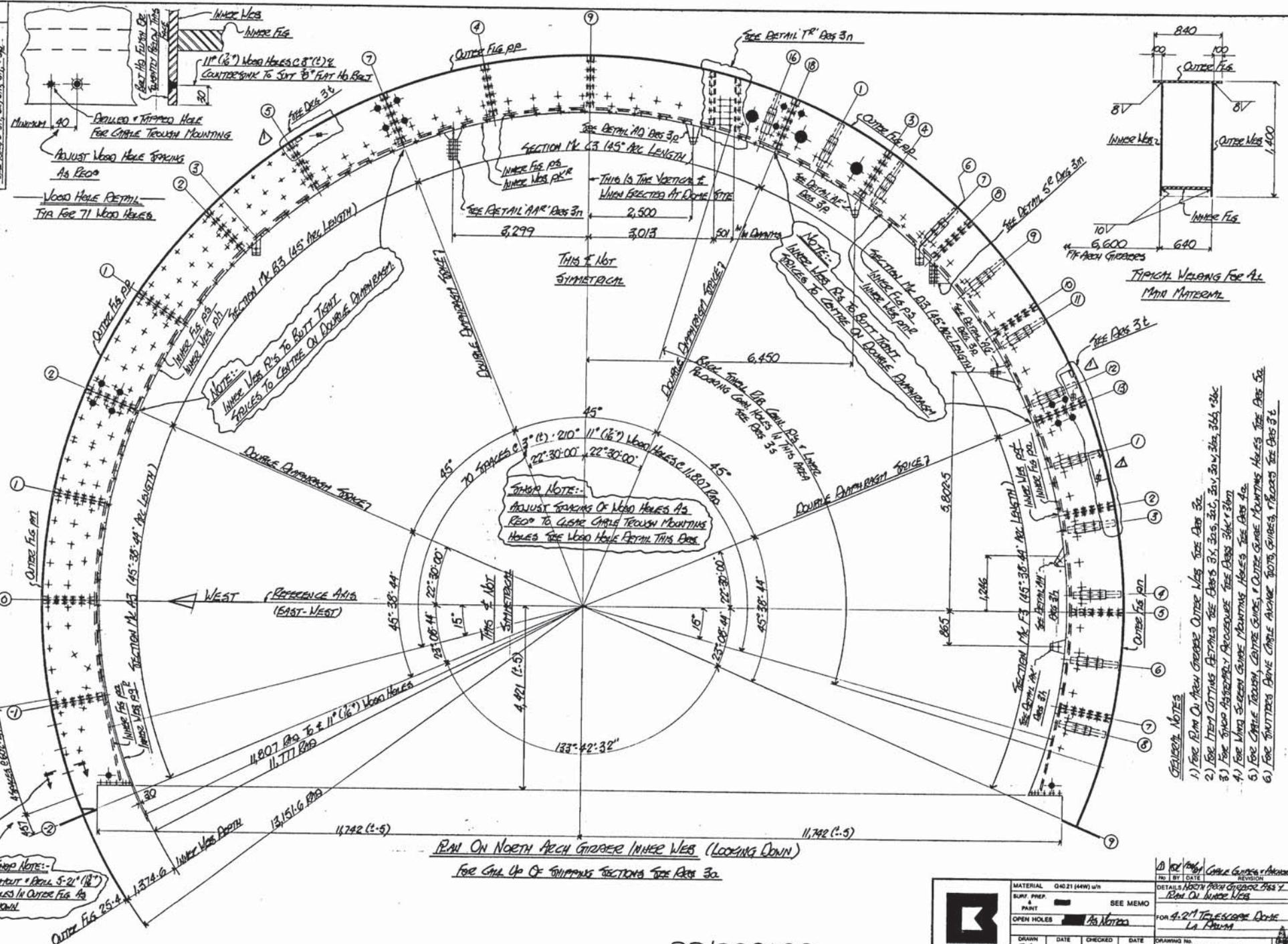


DETAIL LOCATION TABLE

SECTION No.	LOCATION NUMBER	ANGLE	LOCATION
			(COORDINATE BEARING)
			FROM REFERENCE AXIS
			SECTION AT THIS LOCATION
			SEE PAGES 31, 32, 33, 34, 35, 36, 37, 38, 39, 40
A3	1	336° 51' 16"	18R
	2	348° 45' 00"	F
	3	0° 00' 00"	G
	4	17° 15' 00"	H
	5	22° 30' 00"	A
	6	33° 45' 00"	H
	7	45° 00' 00"	H
E3	8	47° 15' 30"	N
	9	56° 15' 00"	H
	10	67° 30' 00"	B
	11	78° 45' 00"	K
	12	90° 00' 00"	K
	13	110° 30' 00"	P
	14	112° 30' 00"	C
	15	118° 00' 00"	P
	16	123° 45' 00"	M
	17	125° 30' 00"	P
	18	132° 44' 30"	N
	19	133° 00' 00"	P
	20	135° 00' 00"	M
	21	140° 30' 00"	P
	22	146° 15' 00"	M
	23	148° 00' 00"	P
	24	155° 30' 00"	P
	25	157° 30' 00"	D
	26	163° 00' 00"	P
	27	178° 00' 00"	M
	28	180° 00' 00"	P
	29	185° 30' 00"	M
	30	191° 15' 00"	M
	31	193° 00' 00"	P
	32	203° 08' 44"	18L



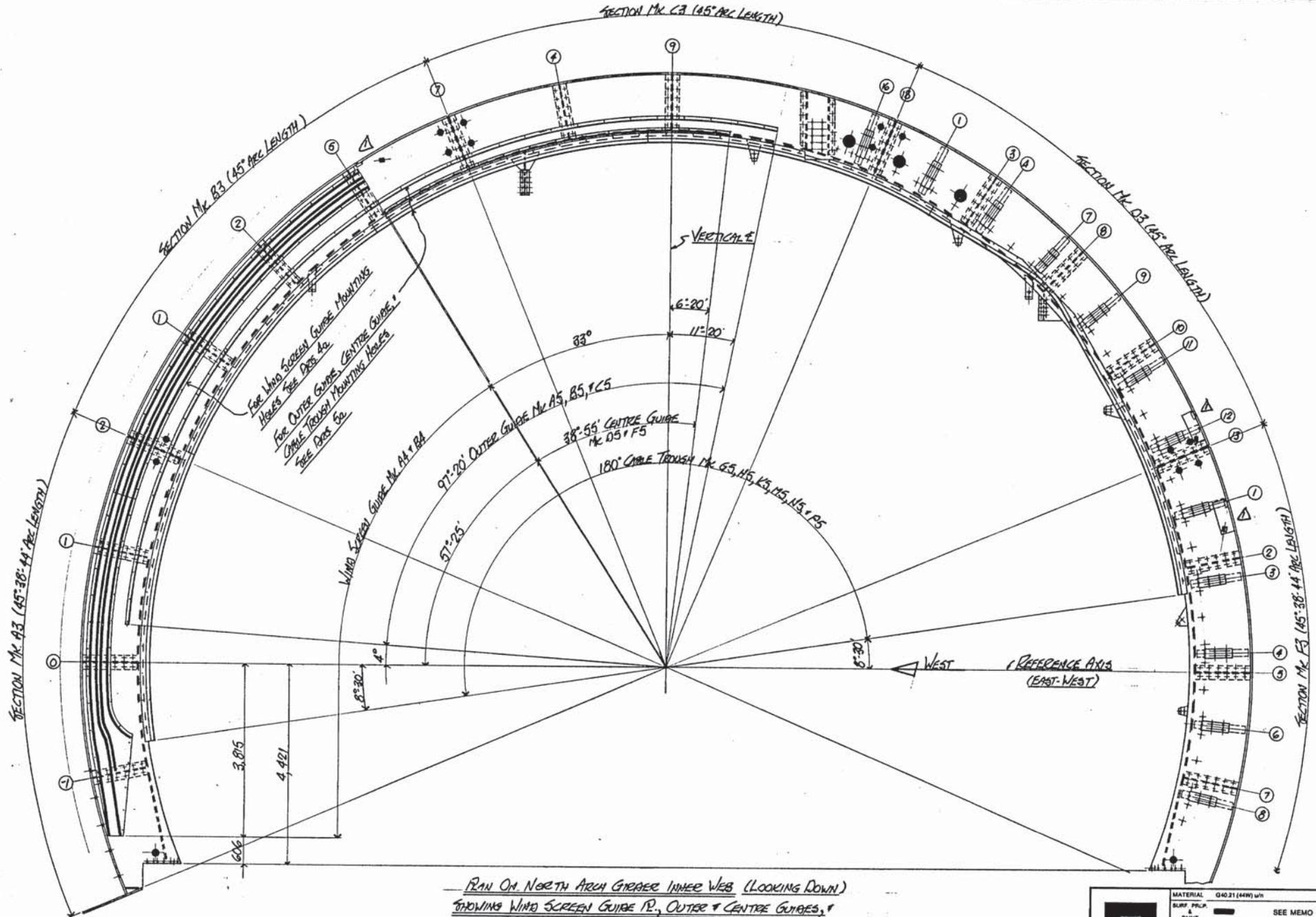
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m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

3R/3001120

BRITAIN	MATERIAL	Q421 (44W) WH	NO. BY DATE
	SURF. PREP. & PAINT	SEE MEMO	
	OPEN HOLES	AS NOTED	FOR 4-2" TELESCOPE DRIVE LA THRU
DRAWN	DATE	CHECKED	DATE
BY			
BRITAIN STEEL LTD.		401 BALZER AVENUE, NEW WESTMINSTER, B.C.	
SHOP DEPARTMENT		INSTRUMENTS	



- GENERAL NOTES**
- 1) FOR DETAILS OF WIND SCREEN GUIDE SEE DRAWINGS # 4
 - 2) FOR DETAILS OF CABLE TROUGH & GUIDES SEE DRAWINGS # 5
 - 3) FOR DIMENSIONS & PROPORTIONS SEE DRAWINGS # 4 & 5

RAN ON NORTH ARCH GIRDER INNER WEB (LOOKING DOWN)
SHOWING WIND SCREEN GUIDE (P), OUTER & CENTRE GUIDES, &
CABLE TROUGH IN FINAL POSITION.

3R/3001121

	MATERIAL	G40.21 (44K) w/h	DATE	1/1/78	BY	BR	REVISED	1
	SURF. PRCP.	PAIN	SEE MEMO					
	OPEN HOLES							
	PRINT ON FINAL ASSEMBLY							
FOR	4.2" TELESCOPE DOOR		DATE		CHECKED		DATE	
BRITAIN	BR							
BRITAIN STEEL LTD.		401 BALTER AVENUE, NEW WESTMINSTER, B.C.						
SHOP DEPARTMENT		INS. / S. / D. / M. / T. / P. / H. / DP. / AS. / PA. / EB.		DRAWING NO.		1420-3c		REV.
								NO. PRINTS

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m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

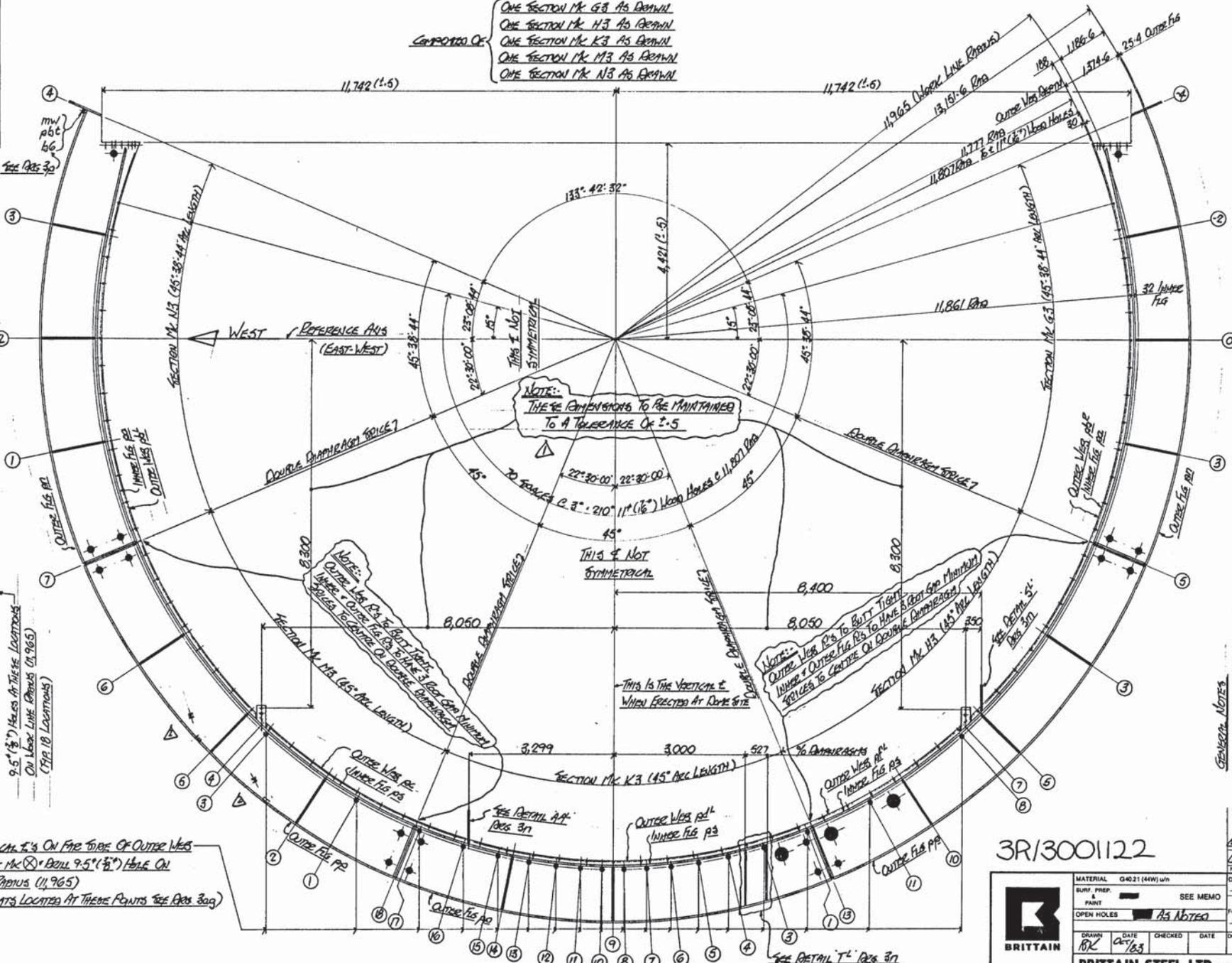
INS. / S. / D. / M. / T. / P. / H. / DP. / AS. / PA. / EB. NO. PRINTS

DETAIL LOCATION TABLE		
SECTION / LOCATION NUMBER	ANGULAR (CLOCKWISE DIRECTIONS)	DETAIL AT THIS LOCATION FROM REFERENCE AXIS
G3	336° 51' 16"	ABK
1	348° 45' 00"	M
2	0° 00' 00"	M
3	11° 16' 00"	M
4	22° 30' 00"	D
5	33° 45' 00"	M
6	45° 00' 00"	M
7	47° 16' 30"	N
H3	48° 06' 25"	
8	56° 15' 00"	M
9	60° 28' 25"	
10	67° 30' 00"	C
11	67° 56' 44"	
12	78° 12' 54"	
13	77° 17' 22"	
14	80° 39' 16"	
15	88° 34' 55"	
16	86° 14' 40"	
17	88° 45' 48"	
18	90° 00' 00"	W
19	91° 14' 12"	
20	93° 45' 20"	
21	96° 25' 05"	
22	99° 20' 44"	
23	101° 15' 00"	W
24	102° 42' 38"	
25	106° 47' 06"	
26	112° 03' 16"	
27	112° 30' 00"	V
28	119° 31' 35"	
29	123° 45' 00"	H
30	131° 53' 35"	
31	132° 44' 30"	N
32	135° 00' 00"	H
33	146° 15' 00"	H
34	157° 30' 00"	A
35	168° 45' 00"	H
36	180° 00' 00"	G
37	191° 15' 00"	F
38	203° 08' 44"	AGL

RAIN ON SOUTH ARCH GROUND OUTER WEB (LOOKING DOWN)

ONE COMPLETE SOUTH ARCH GROUND REQUIRED

- COMPOSED OF:
- ONE SECTION MK G3 AS DETAIL
 - ONE SECTION MK H3 AS DETAIL
 - ONE SECTION MK K3 AS DETAIL
 - ONE SECTION MK M3 AS DETAIL
 - ONE SECTION MK N3 AS DETAIL



NOTE: THESE DIMENSIONS TO BE MAINTAINED TO A TOLERANCE OF ±.5

NOTE: OUTER WEB P'S TO BE BUILT TIGHT INNER & OUTER FLG P'S TO HAVE A CLEARANCE DIMENSIONED TO CENTRE OF DOUBLE RAMP RAILS

NOTE: OUTER WEB P'S TO BE BUILT TIGHT INNER & OUTER FLG P'S TO HAVE A CLEARANCE DIMENSIONED TO CENTRE OF DOUBLE RAMP RAILS

THIS IS THE VERTICAL & WHEN ERECTED AT RISE SITE

SECTORS VERTICAL T'S ON FIRE SIDE OF OUTER WEB AT EACH POINT MK (X) BORE 9.5" (3/8") HOLE ON WORK LINE RADIUS (11,965) (MAIN SHELL P'S BEATS LOCATED AT THESE POINTS SEE DRAW 309)

GENERAL NOTES

- 1) FIRE WEB TUBES SEE AREA 31
- 2) SEE RAIN ON ARCH GROUND INNER WEB SEE AREA 31
- 3) SEE FIRE CUTTING DETAILS SEE AREA 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42
- 4) FIRE ORIENTATION & LOCATION OF MAIN SHELL P'S BEATS SEE AREA 309
- 5) FIRE STOP ASSEMBLY PROVISIONS SEE AREA 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42

3R/3001122



MATERIAL	G4021 (40W) W/	SEE MEMO
SURF. PREP.		
PAINT		
OPEN HOLES	AS NOTED	
DRAWN	BY	DATE
PK	ACT/63	
CHECKED		DATE
DRAWING NO.	1420-3d	
REV.		

BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.

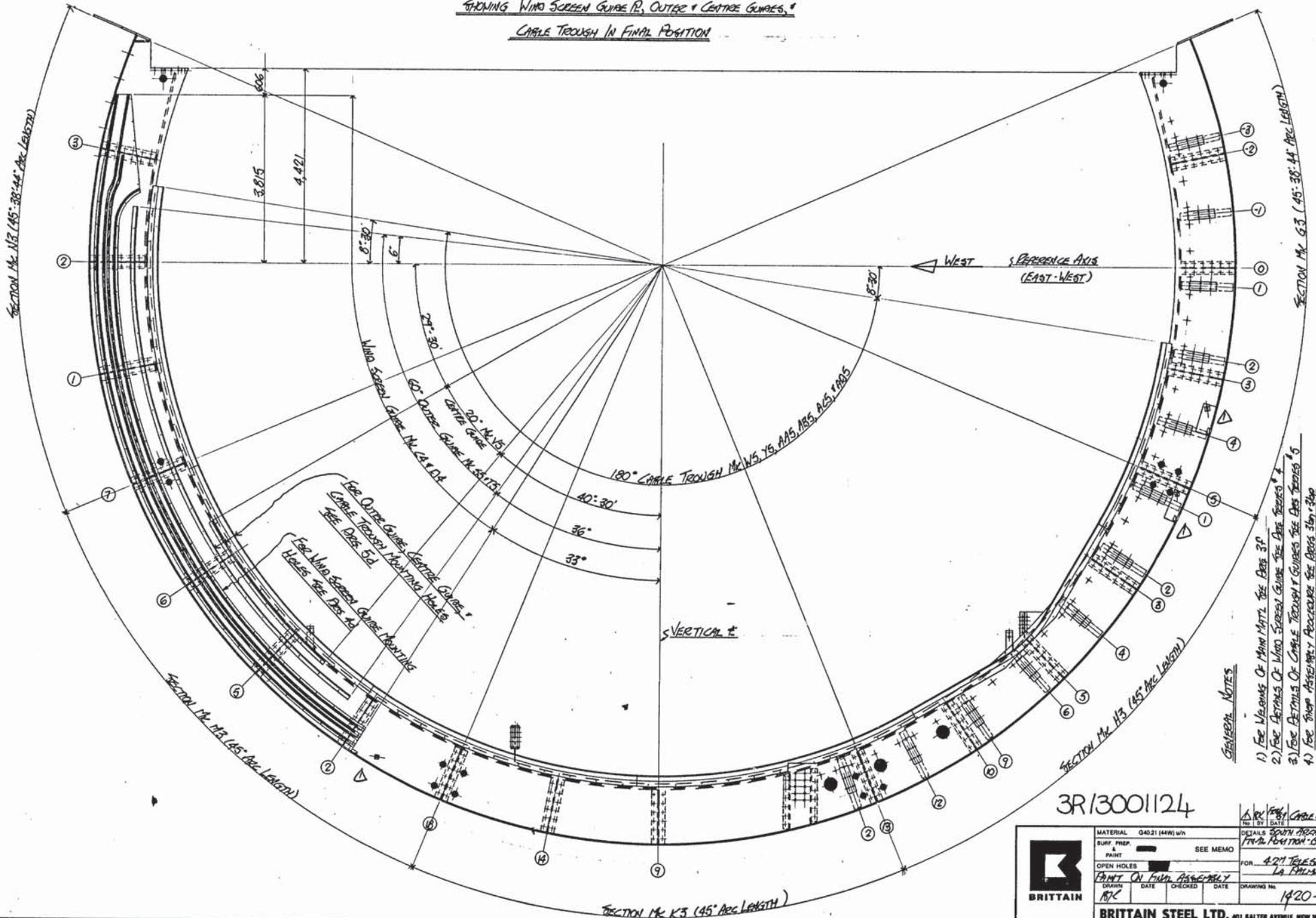
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m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

SHOP DEPARTMENT

PLAN ON SOUTH ARCH GRADERS INNER WEB (LOOKING DOWN)
SHOWING WIND SCREEN GUIDE R, OUTER & CENTRE GUIDES, &
CABLE TROUGH IN FINAL POSITION



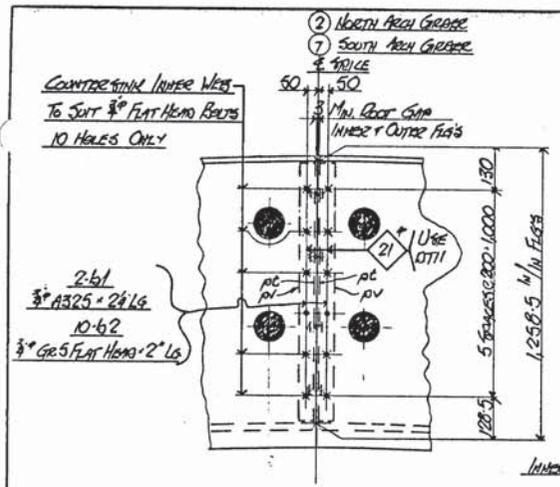
3R/3001124

	MATERIAL	Q4021 (44W) WH	DETAILS	SOUTH ARCH GRADERS
	SURF PREP	P	FOR	42" TELESCOPE DRIVE
	PAINT	SEE MEMO	FOR	FINAL POSITION GUIDES & TROUGH
	OPEN HOLES		FOR	42" TELESCOPE DRIVE
PRINT ON FULL ASSEMBLY		DATE	CHECKED	DATE
DRAWING NO.		1420-3g		REV
BRITAIN STEEL LTD., 401 BALLET AVENUE, NEW WESTMINSTER, B.C.				
SHOP DEPARTMENT				

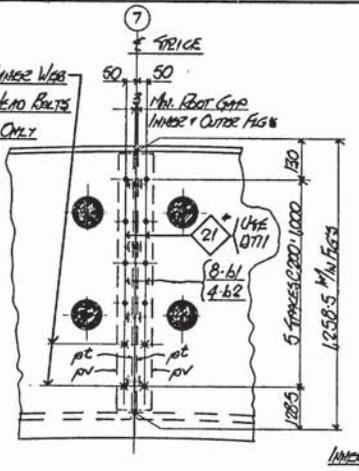
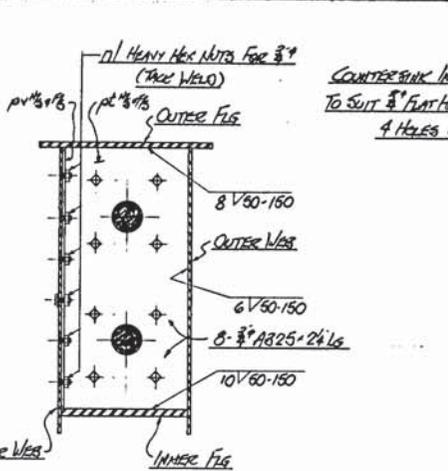
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m-abcdefghijklmnpstvw

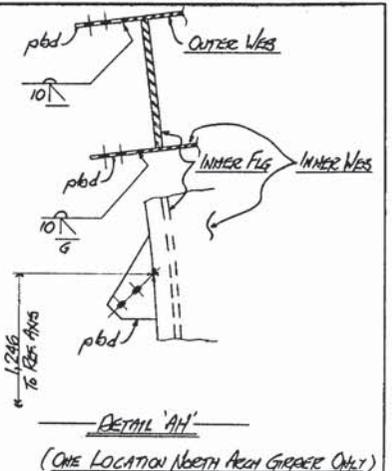
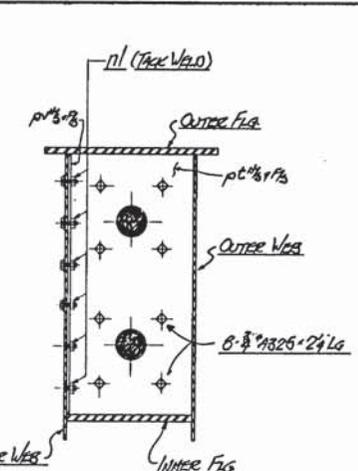
s-abcdefghijklmnpstvw



DETAIL 'A' (DOUBLE AMPHIRASH GIRDER)
 (ONE LOCATION NORTH ARCH GIRDER)
 (ONE LOCATION SOUTH ARCH GIRDER)

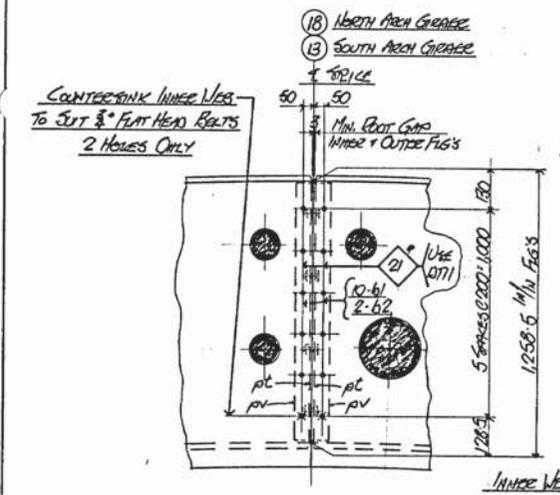


DETAIL 'B' (DOUBLE AMPHIRASH GIRDER)
 WELD AS FOR DETAIL 'A'
 (ONE LOCATION NORTH ARCH GIRDER ONLY)

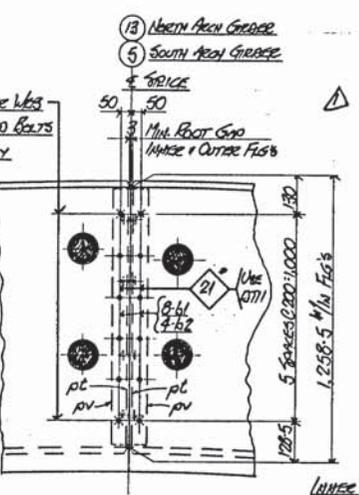
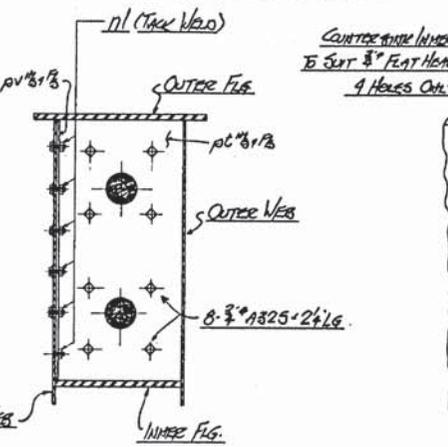


DETAIL 'AH'
 (ONE LOCATION NORTH ARCH GIRDER ONLY)

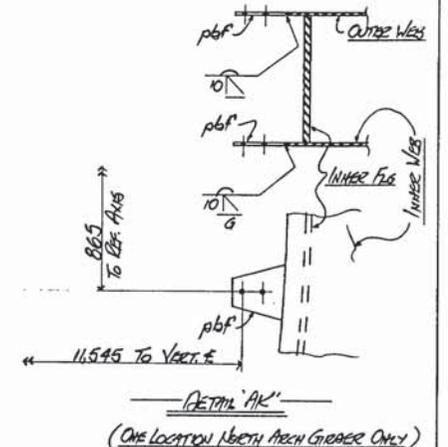
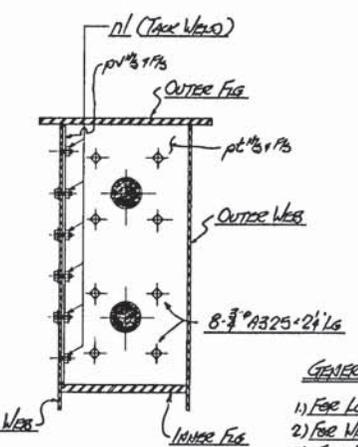
SHOP NOTE:-
 DETAILS 'A', 'B', 'C', & 'D' BOLT AMPHIRASHING IN TOGETHER BEFORE WELDING TO FLG'S & OUTER WEBS. INSTALL & TIGHTEN ALL BOLTS '61' & '62' BEFORE WELDING INNER WEBS.



DETAIL 'C' (DOUBLE AMPHIRASH GIRDER)
 WELD AS FOR DETAIL 'A'
 (ONE LOCATION NORTH ARCH GIRDER)
 (ONE LOCATION SOUTH ARCH GIRDER)



DETAIL 'D' (DOUBLE AMPHIRASH GIRDER)
 WELD AS FOR DETAIL 'A'
 (ONE LOCATION NORTH ARCH GIRDER)
 (ONE LOCATION SOUTH ARCH GIRDER)



DETAIL 'AK'
 (ONE LOCATION NORTH ARCH GIRDER ONLY)

GENERAL NOTES

- 1) FOR LOCATIONS OF DETAILS ON THIS JOB SEE DESIGS 36 & 37
- 2) FOR WELDING OF MAIN MATERIAL SEE DESIGS 36 & 37
- 3) FOR ITEM CUTTING DETAILS SEE DESIGS 36A & 36B
- 4) FOR SHOP ASSEMBLY PROCEDURE SEE DESIGS 36A, 36B, 36C, & 36D
- 5) USE 1/2\"/>

3R/3001125

	MATERIAL	Q421 (44W) W/H	DETAILS	TELESCOPE ASSEMBLY
	SURF. PREP.		FOR	4.2\"/>
	OPEN HOLES		DATE	1420-3h
	PRINT ON FINAL ASSEMBLY		CHECKED	
BRITAIN STEEL LTD.		401 BALTER AVENUE, NEW WESTMINSTER, B.C.		

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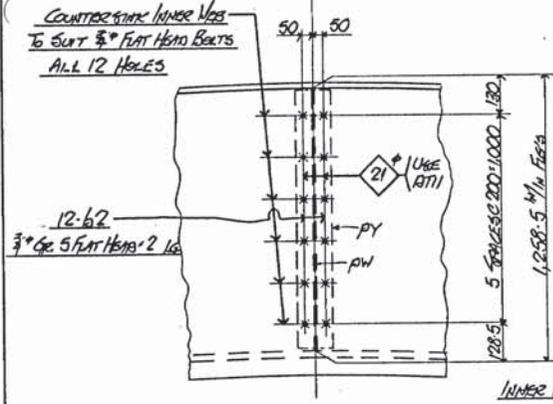
m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

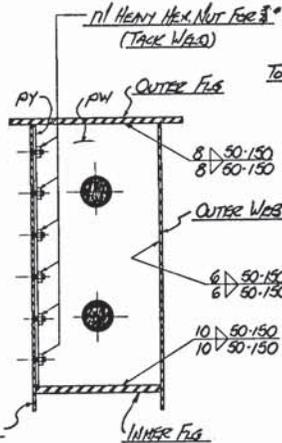
SHOP DEPARTMENT
 1/16/63
 1/16/63

① NORTH ARCH GIRDER
③ SOUTH ARCH GIRDER

COUNTERSINK INNER WEBS
TO SUIT 3/8" FLAT HEAD BOLTS
ALL 12 HOLES



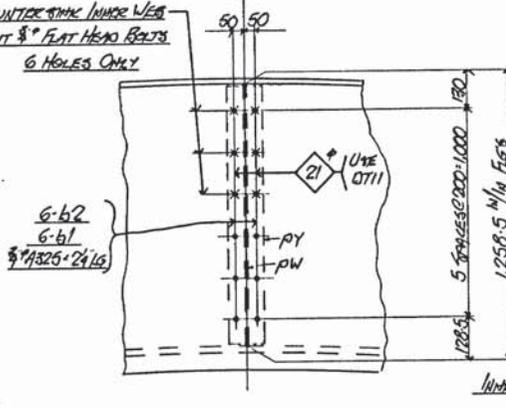
INNER WBS



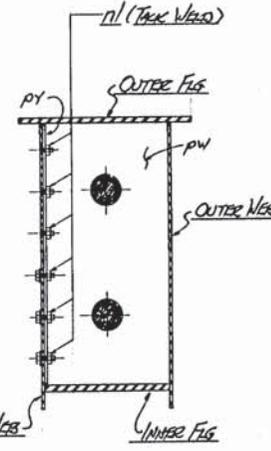
INNER FLS

① NORTH ARCH GIRDER
② SOUTH ARCH GIRDER

COUNTERSINK INNER WEBS
TO SUIT 3/8" FLAT HEAD BOLTS
6 HOLES ONLY



INNER WBS



INNER FLS

DETAIL 'F'
(ONE LOCATION NORTH ARCH GIRDER
ONE LOCATION SOUTH ARCH GIRDER)

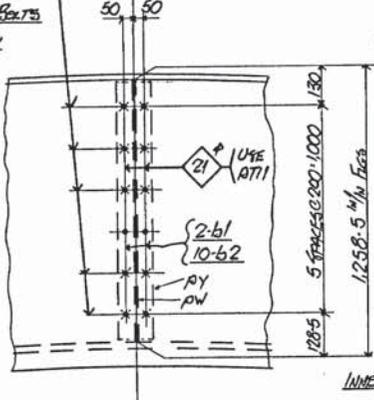
SHOP NOTE:-

DETAILS F, G, H, & K, INSTALL
& TIGHTEN ALL BOLTS 161 & 62
BEFORE WELDING INNER WEBS

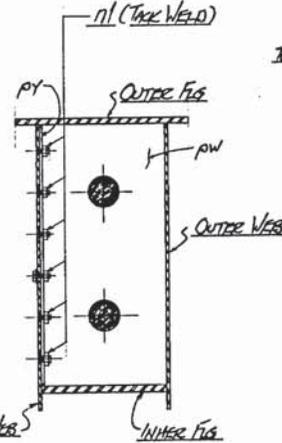
DETAIL 'G'
WELD AS FOR DETAIL 'F'
(ONE LOCATION NORTH ARCH GIRDER
ONE LOCATION SOUTH ARCH GIRDER)

SOUTH ARCH GIRDER NORTH ARCH GIRDER

COUNTERSINK INNER WEBS
TO SUIT 3/8" FLAT HEAD BOLTS
10 HOLES ONLY

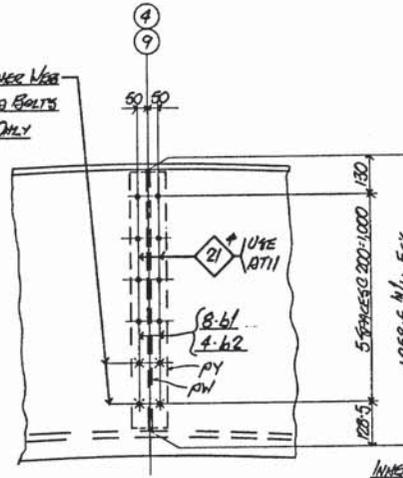


INNER WBS

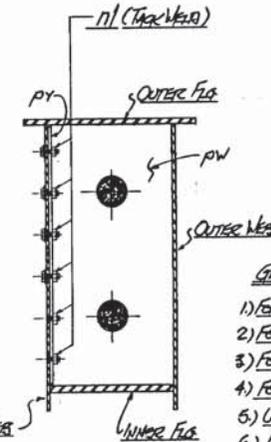


INNER FLS

COUNTERSINK INNER WEBS
TO SUIT 3/8" FLAT HEAD BOLTS
4 HOLES ONLY



INNER WBS



INNER FLS

GENERAL NOTES

- 1) FOR LOCATIONS OF DETAILS ON THIS DRAW SEE CROSS 30, 36, 30 & 31
- 2) FOR WELDING OF MAIN MATERIAL SEE CROSS 36 & 31
- 3) FOR HEAT CUTTING DETAILS SEE CROSS 30
- 4) FOR BRIGGS ASSEMBLY PROCEDURE SEE CROSS 36, 36, 30 & 31
- 5) USE 1/8" DRILL FOR 21" HOLES IF PREFERRED
- 6) FOR DRILLING TEMPERATURE DT11 SEE CROSS 30C

DETAIL 'H'
WELD AS FOR DETAIL 'F'
(4 LOCATIONS NORTH ARCH GIRDER
4 LOCATIONS SOUTH ARCH GIRDER)

DETAIL 'K'
WELD AS FOR DETAIL 'F'
(2 LOCATIONS NORTH ARCH GIRDER ONLY)

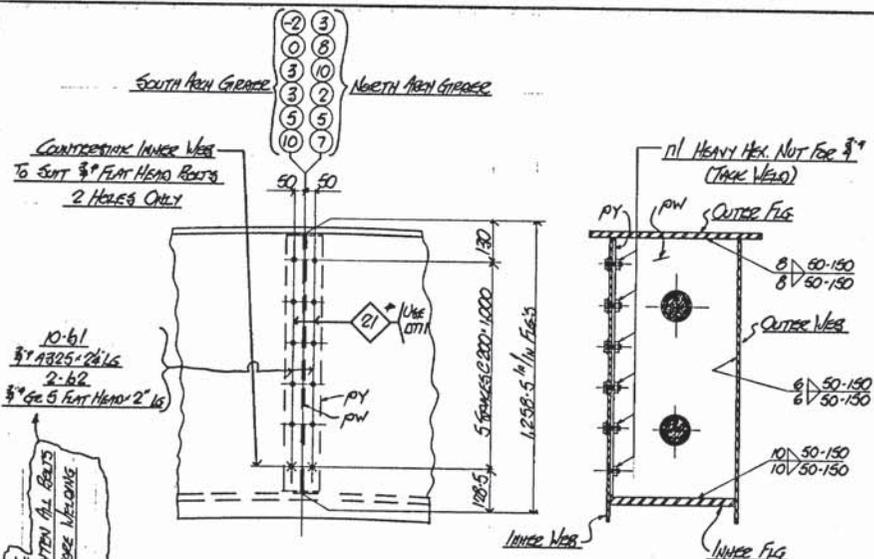
3R/3001126

BRITAIN	MATERIAL	G40.21 (44W) WP	NO.	BY	DATE	REVISION
	SURF. PREP. & PAINT	SEE MEMO	DETAILS BRIGGS ASSEMBLY CROSS SECTIONS			
	OPEN HOLES	AS NOTED	FOR 4.2M TELESCOPE DOCK LA PALMA			
	PAINT ON FINAL ASSEMBLY		DRAWING NO. 1420-3X			
DRW	DATE	CHECKED	DATE	BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.		
SHOP DEPARTMENT			ING/P/S/O/M/T/P/SH/DP/AS/PA/ER			NO. PRINTS

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m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

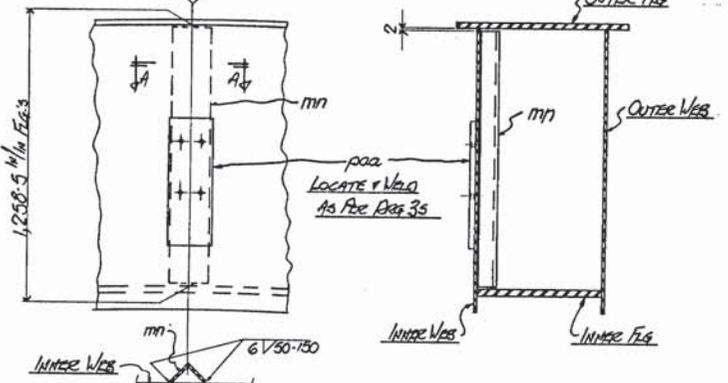
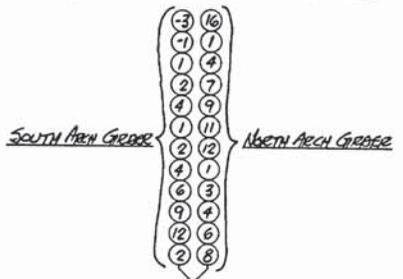


DETAIL 'M'
(6 LOCATIONS NORTH ARCH GIRDER)
(6 LOCATIONS SOUTH ARCH GIRDER)

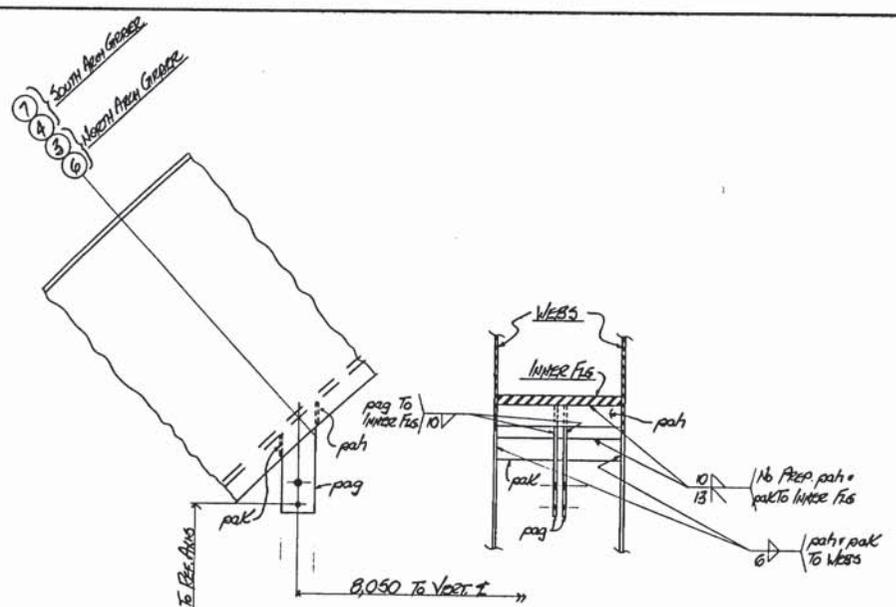
COUNTERSINK INNER WEBS
TO SUIT 3/4" FLAT HEAD BOLTS
2 HOLES ONLY

10-61
3/4" A325-70 1/2
2-62
3/4" G. S. FLAT HEAD 2" Lg

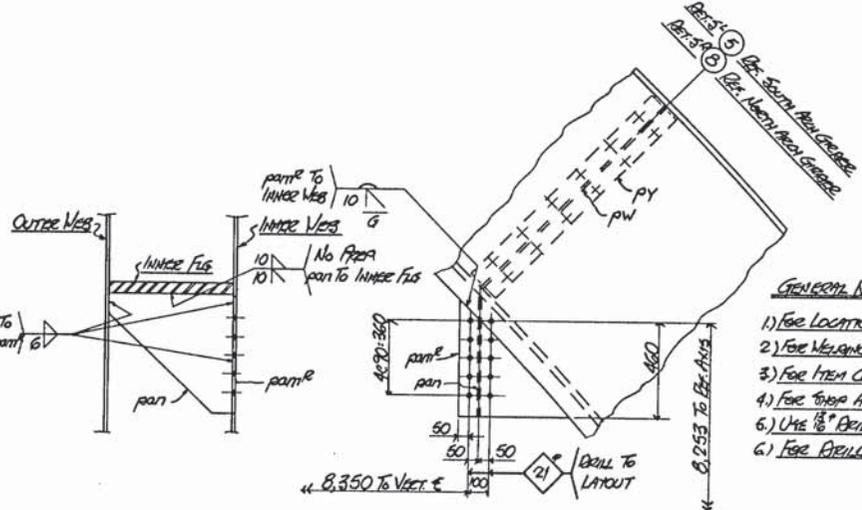
TRAP NOTE:
INSTALL & TIGHTEN ALL BOLTS
1/4" Lg. REMOVE WELDS
INNER WEBS



DETAIL 'P'
(12 LOCATIONS NORTH ARCH GIRDER)
(12 LOCATIONS SOUTH ARCH GIRDER)



DETAIL 'N'
(2 LOCATIONS NORTH ARCH GIRDER)
(2 LOCATIONS SOUTH ARCH GIRDER)



DETAIL '5R' (AS SHOWN)
(ONE LOCATION NORTH ARCH GIRDER)
DETAIL '5L' (OPP. HAND)
(ONE LOCATION SOUTH ARCH GIRDER)

GENERAL NOTES

- 1) FOR LOCATIONS OF DETAILS ON THIS DRAWING SEE DESIGNS 30, 36, 34, 35
- 2) FOR WELDS OF MAIN MATERIAL SEE DESIGNS 36 & 35
- 3) FOR ITEM CUTTING DETAILS SEE DESIGNS 30, 34, 35 & 36
- 4) FOR WELD ASSEMBLY PROCEDURES SEE DESIGNS 30, 34, 35 & 36
- 5) USE 1/8" DRILL FOR 21" HOLES IF PREFERRED
- 6) FOR BREWING TEMPERATURES SEE DESIGN 36

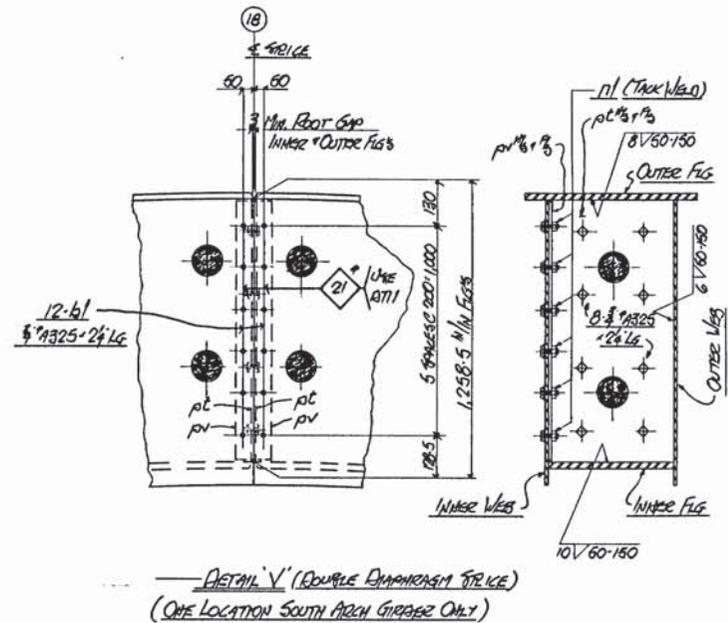
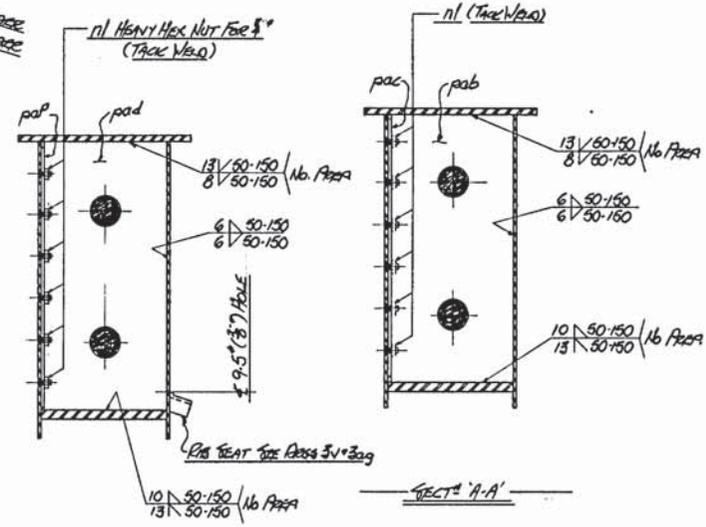
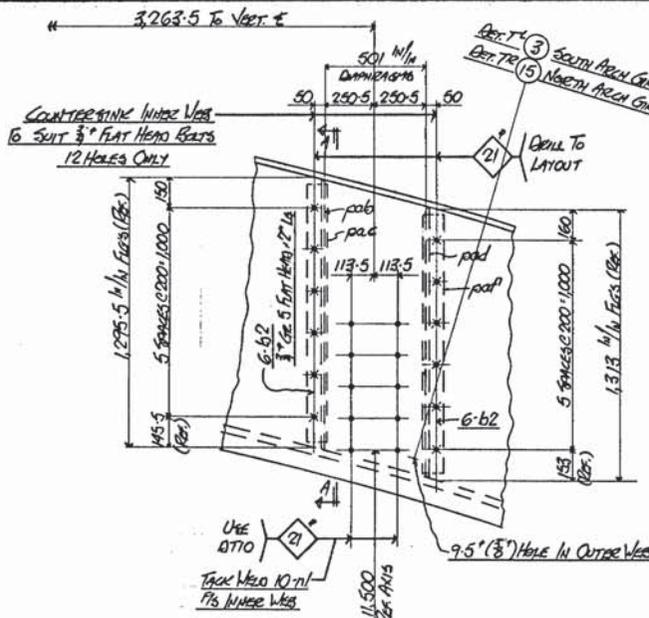
3R/300/1127

	MATERIAL	GA021 (4MM) W/	NO.	BY	DATE	REVISION
	BLANK PREP.		DETAILS 30, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100			
	PRINT		SEE MEMO	FOR 4-2M TELESCOPE DRAWING LA 100-99		
	OPEN HOLES	AS NOTED	PRINT ON FINAL ASSEMBLY	DATE	CHECKED	DATE
						1420-3m
BRITAIN STEEL LTD. 401 BALTER AVENUE, NEW WESTMINSTER, B.C.						
SHOP DEPARTMENT INR / E / S / O / M / T / P / SH / DP / AS / PA / ER NO. PRINTS						

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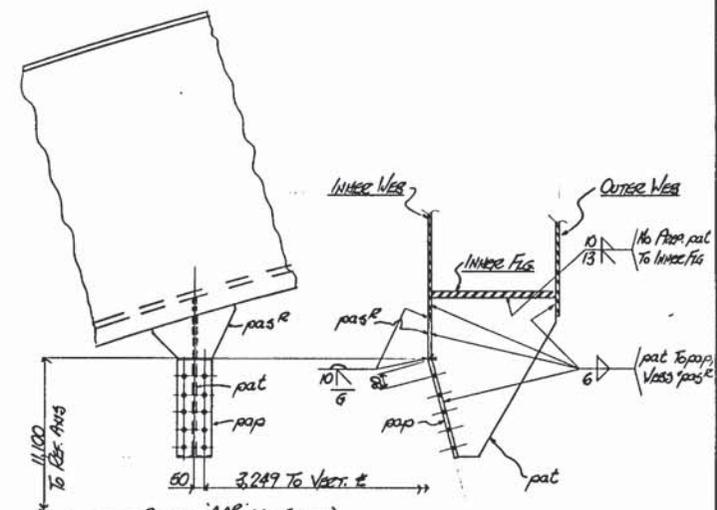
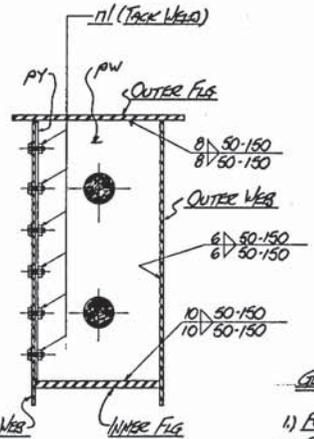
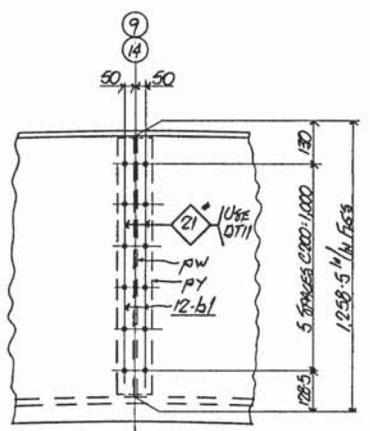
m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw



DETAIL 'T' (AS SHOWN)
(ONE LOCATION NORTH ARCH GIRDER)
DETAIL 'T' (OPP. HAND)
(ONE LOCATION SOUTH ARCH GIRDER)

SHOP NOTE:-
DETAIL 'V' BOLT DIMENSIONS IN TOGETHER BEFORE WELDING TO FLGS & OUTER WELLS.
DETAILS 'T', 'V', 'W' INSTALL & TIGHTEN ALL BOLTS 'b1' & 'b2' BEFORE WELDING INNER WELLS.



DETAIL 'W'
(2 LOCATIONS SOUTH ARCH GIRDER ONLY)

GENERAL NOTES

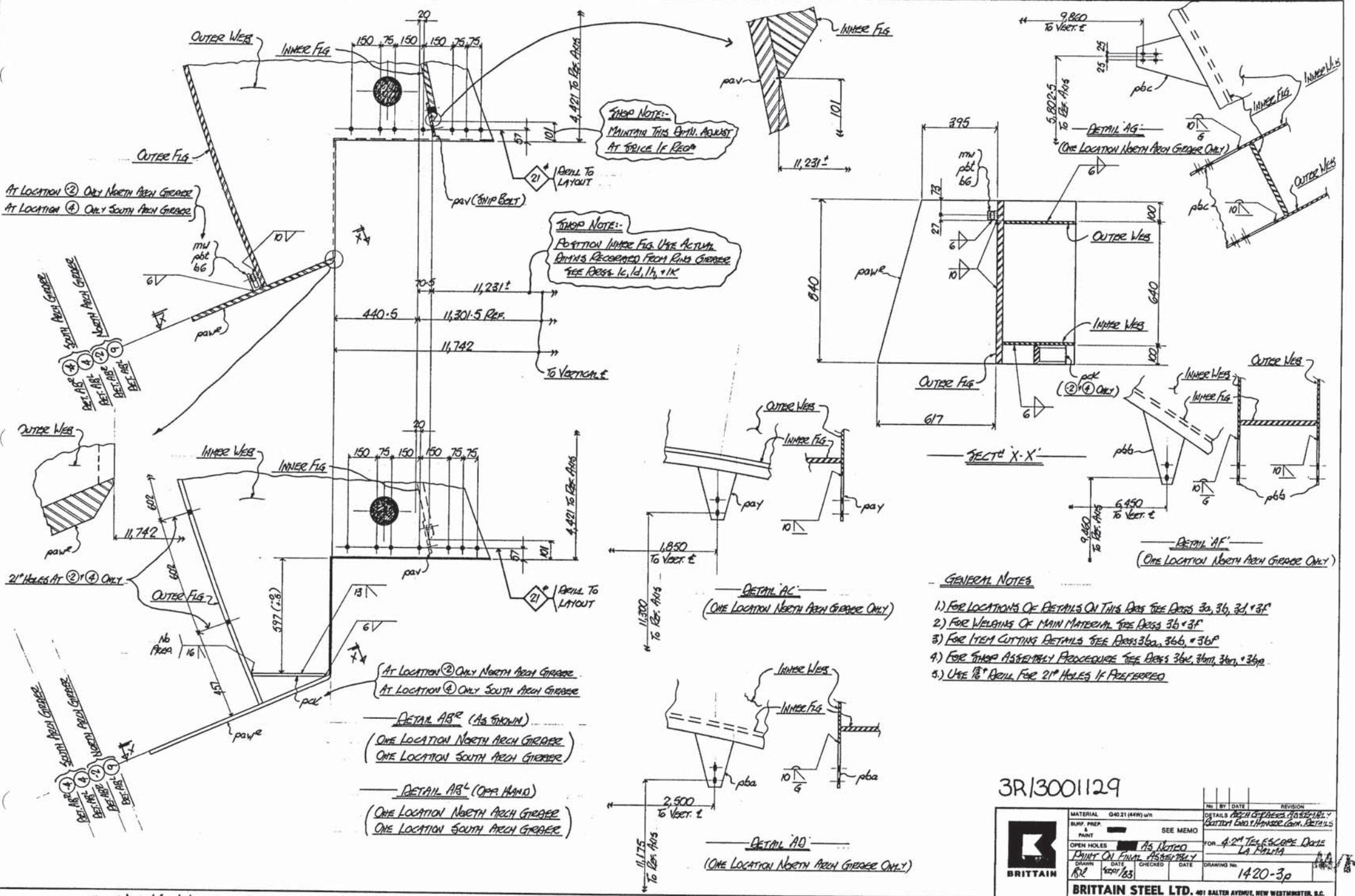
- 1) FOR LOCATIONS OF DETAILS ON THIS DRAWING SEE DEGS 3a, 3b, 3d/3f
- 2) FOR WELDING OF MAIN MATERIAL SEE DEGS 3b & 3f
- 3) FOR ITEM CUTTING DETAILS SEE DEGS 3a, 3b, 3d, 3f
- 4) FOR GIRDER ASSEMBLY PROCEDURE SEE DEGS 3a, 3b, 3d, 3f & 3g
- 5) USE 18" DRILL FOR 21" HOLES IF PREFERRED
- 6) FOR DRILLING TEMPERATURES DT10 & DT11 SEE DEGS 3b,c

DETAIL 'AA' (AS SHOWN)
(ONE LOCATION NORTH ARCH GIRDER)
DETAIL 'AA' (OPP. HAND)
(ONE LOCATION SOUTH ARCH GIRDER)

3R/3001128



MATERIAL	G40.21 (44W) W/	NO. BY	DATE	REVISION
BLANK PREP				
PART	SEE MEMO			
OPEN HOLES	AS NOTED			
DRAWN	DATE	CHECKED	DATE	DRAWING NO.
BK	5/27/83			1420-3n



GENERAL NOTES

- 1) FOR LOCATIONS OF DETAILS ON THIS DOME SEE DRESS 30, 36, 3d, *3f
- 2) FOR WELDING OF MAIN MATERIAL SEE DRESS 36 *3f
- 3) FOR ITEM CUTTING DETAILS SEE DRESS 36a, 36b, *36f
- 4) FOR SHOP ASSEMBLY PROCEDURE SEE DRESS 36c, 36d, 36e, *36g
- 5) USE 7/8" DRILL FOR 21" HOLES IF PREFERRED

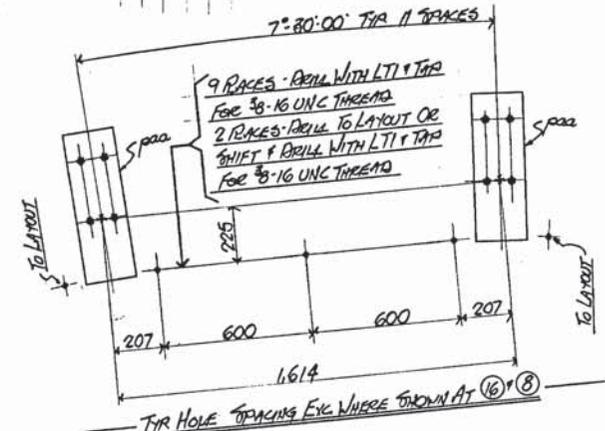
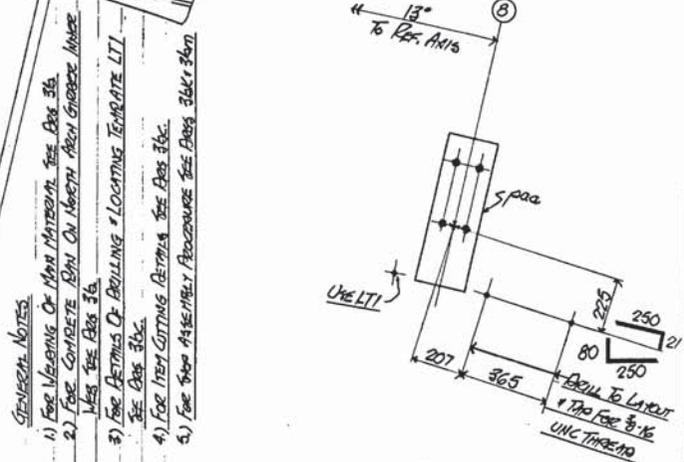
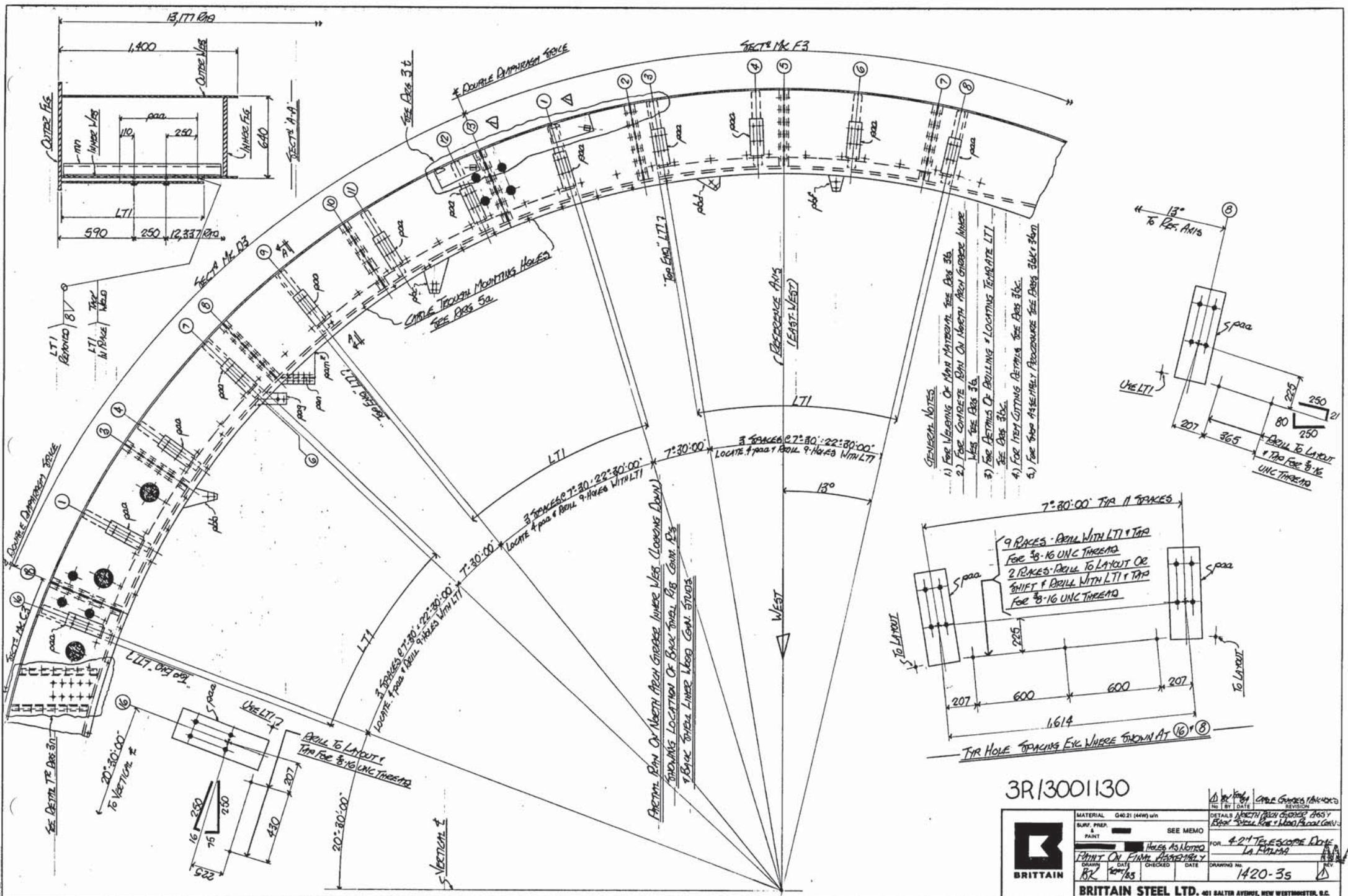
3R/3001129

	MATERIAL	Q40.21 (44W) w/h	NO. BY DATE	REVISION
	SURF. PREP.		DETAILS ARCH GIRDERS ASSEMBLY	
	PAINT	SEE MEMO	DETAILS ARCH GIRDERS GAIN. DETAILS	
	OPEN HOLES	AS NOTED	FOR 4.2" TELESCOPE DOME	
DRAWN ON FINAL ASSEMBLY			DATE	LA PUNTA
DATE	CHECKED	DATE	DRAWING NO.	1420-3p
1/2	1/24/83			
BRITAIN STEEL LTD. 401 BALTER AVENUE, NEW WESTMINSTER, S.C.				

p-abcdefghijklmnpstvw

m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw



GENERAL NOTES

- 1) FOR WEAVING OF MAIN MOUNTING SEE FIG 3a.
- 2) FOR CONCRETE TIE-IN ON NORTH ARCH CHECKER HOUSE SEE FIG 3b.
- 3) FOR DETAILS OF DRILLING & TAPPING TELESCOPE LTI SEE FIG 3c.
- 4) FOR TIE CUTTING DETAILS SEE FIG 3d.
- 5) FOR SHOP ASSEMBLY PROCEDURE SEE FIGS 3e & 3f.

3R/3001130

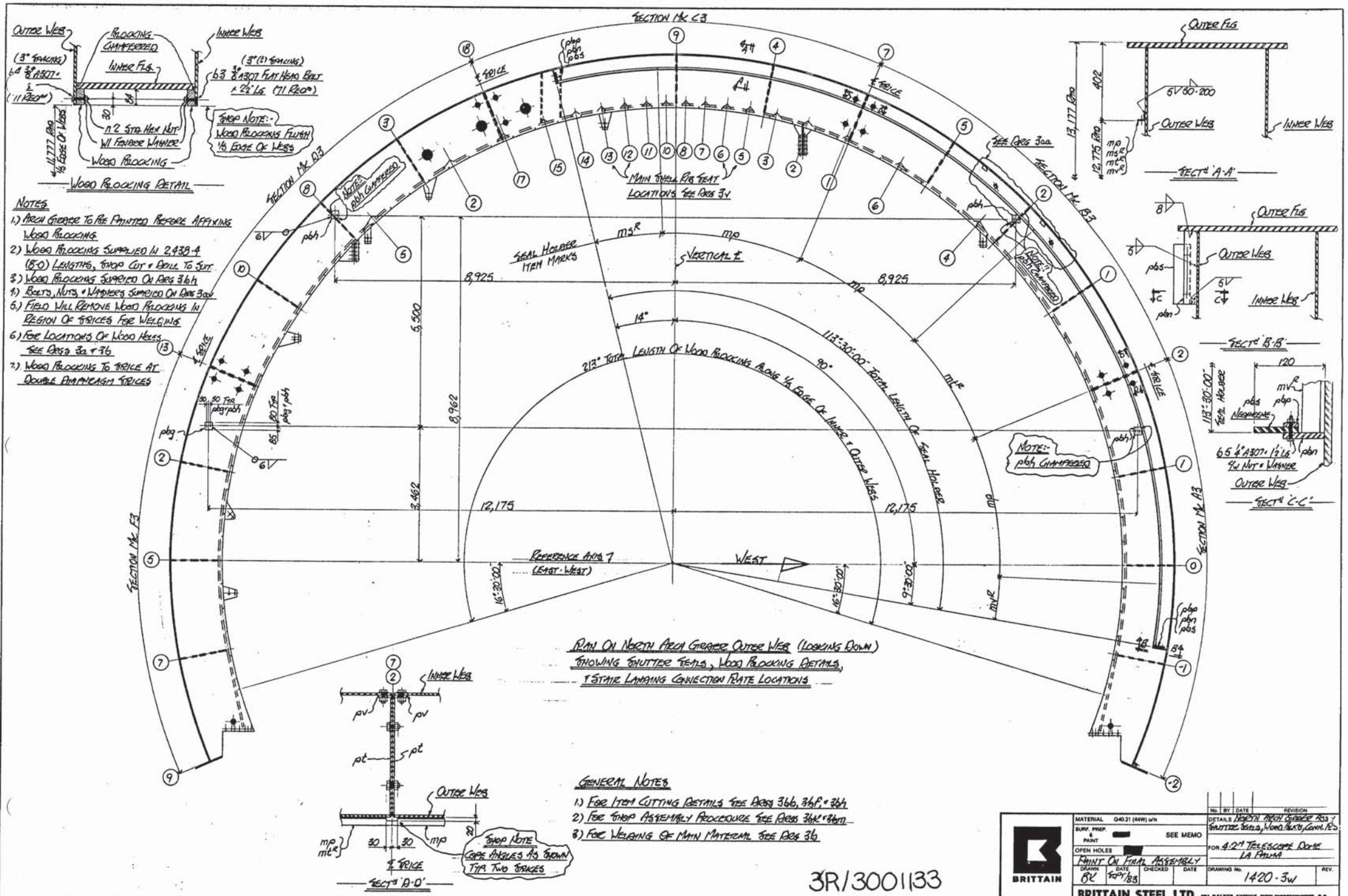
	MATERIAL	G4021 44WV Wn	REVISED	DATE	BY
	SURF. PREP. & PAINT		SEE MEMO		
	PRINT ON FINISH	HEREAS NOTED			
	DATE	CHECKED	DATE	DRAWING NO.	REV.
	10/1/55		1420-35		
BRITAIN STEEL LTD. , 401 SALTER AVENUE, NEW WESTMINSTER, B.C.					

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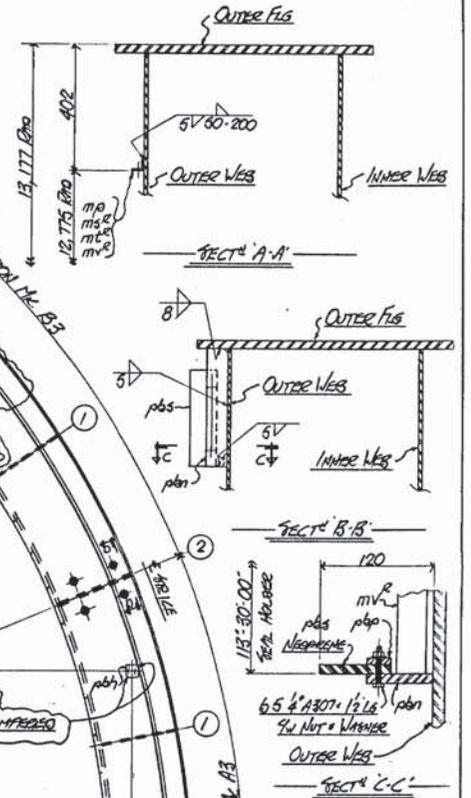
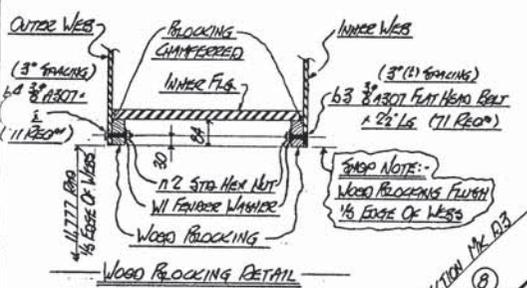
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SHOP DEPARTMENT

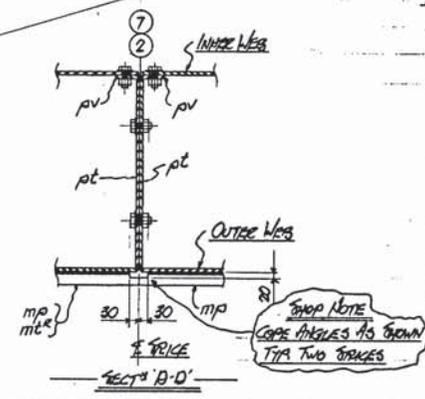


- NOTES**
- 1) ARCH GREASER TO BE APPLIED BEFORE AFFIXING WOOD BLOCKING
 - 2) WOOD BLOCKING SUPPLIED IN 2,438-4 (8'-0") LENGTHS, SHARP CUT & DRILL TO SUIT
 - 3) WOOD BLOCKING SUPPLIED ON DRS 36h
 - 4) BOLTS, NUTS & WASHERS SUPPLIED ON DRS 36a
 - 5) FIELD WILL REMOVE WOOD BLOCKING IN REGION OF TRICES FOR WELDING
 - 6) FOR LOCATIONS OF WOOD HEELS SEE DRS 3a & 3b
 - 7) WOOD BLOCKING TO BRICE AT DOUBLE AMPHICAM TRICES



PLAN ON NORTH AREA GREASER OUTER WEB (LOOKING DOWN) SHOWING SHUTTER SEALS, WOOD BLOCKING DETAILS, & STAIR LANDING CONNECTION RATE LOCATIONS

- GENERAL NOTES**
- 1) FOR ITEM CUTTING DETAILS SEE DRS 36b, 36f, & 36h
 - 2) FOR SHOP ASSEMBLY PROCEDURE SEE DRS 36k & 36m
 - 3) FOR WELDING OF MAIN MATERIAL SEE DRS 36



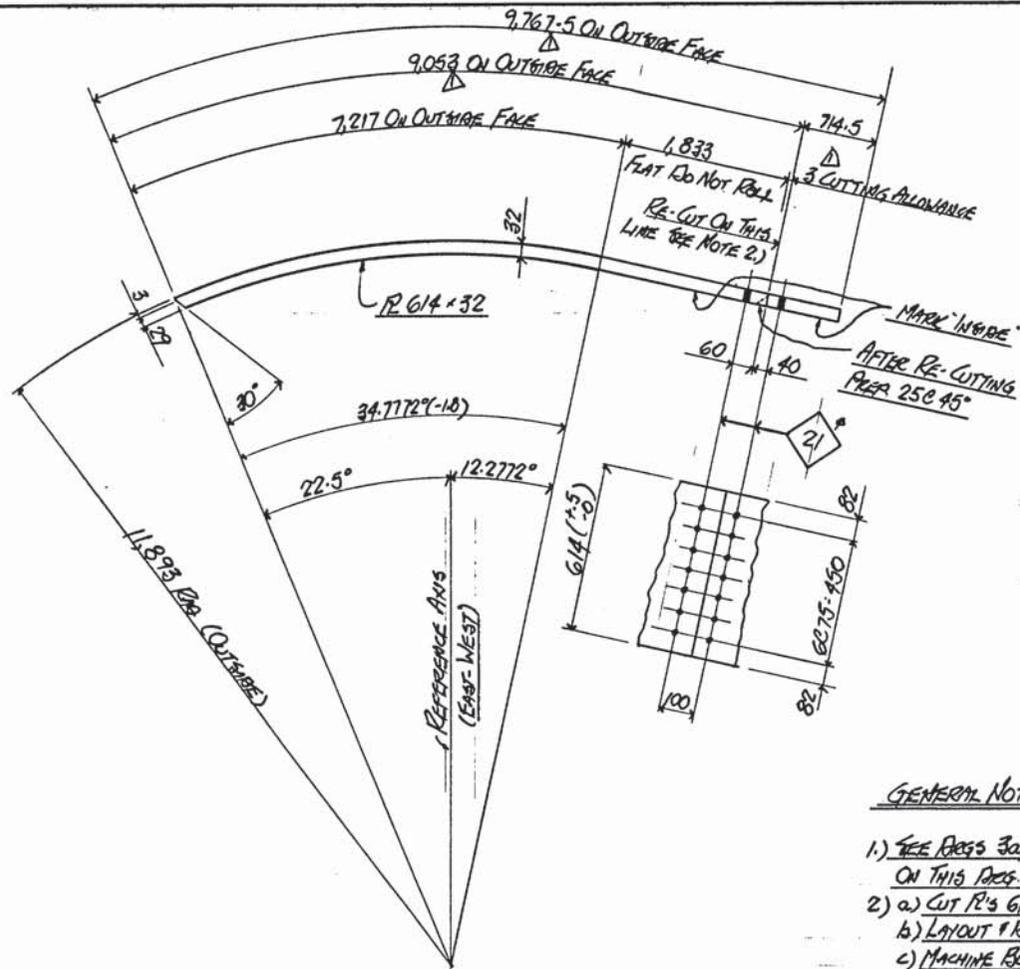
3R/3001133

	MATERIAL	G40.21 (44W) UN	NO	BY	DATE	REVISION
	SURF. PREP & PAINT					DETAILS: ARCHIT. ARCH. GREASER 253 & SHUTTER SEALS, WOOD BLOCKING, CONN. P.S.
	OPEN HOLES					FOR 4.2" TELESCOPE DOME LA FERRA
	PRINT ON FILM ASSEMBLY					LA FERRA
DRAWN	DATE	CHECKED	DATE	DRAWING NO.	REV.	
BL	12/1/83			1420-3w		
BRITAIN STEEL LTD. 401 BALLET AVENUE, NEW WESTMINSTER, B.C.						
SHOP DEPARTMENT V W / F / S / O / M / T / P / H / Q / R / A / S / P / A / R / E						

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m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw



4 REGR - MK RA
 ARCH GEARER INNER FLG
 Δ FOR SECTIONS MK A3, F3, G3, N3

GENERAL NOTES

- 1) SEE DRESS 3a, 3b, 3d, 3f FOR SHIP ASSEMBLY & SHIP WEARING OF ITEMS ON THIS DRESS.
- 2) a) CUT R's 614 ± 9.767-5 LG
 b) LAYOUT & DRILL 14-21" HOLES
 c) MACHINE BURR ON RE-CUT LINE, MATCH MARK R's & MARK 'INSIDE'
 d) USE 714-5 LG R's TO MAKE RING GEARER RING GRABBER R's FOR R (SEE DRESS 1c) & SHIP WELD TO RING GEARER SECTIONS MK D1 & K1 (SEE DRESS K, L, H, & IK)
 e) SET 9.050 LG R's ASIDE
 f) AT TIME OF ARCH GEARER FABRICATION, SEND THESE R's FOR ROLLING, & THEN PREP BOTH ENDS
 g) USE 1/8" DRILL FOR 21" HOLES IF PREFERRED

3R/300134

CUT ALLOWANCE ADDED
 LENGTH (REVISED)
 (SEE NOTE 1.)
 SECTION MARKS ADDED

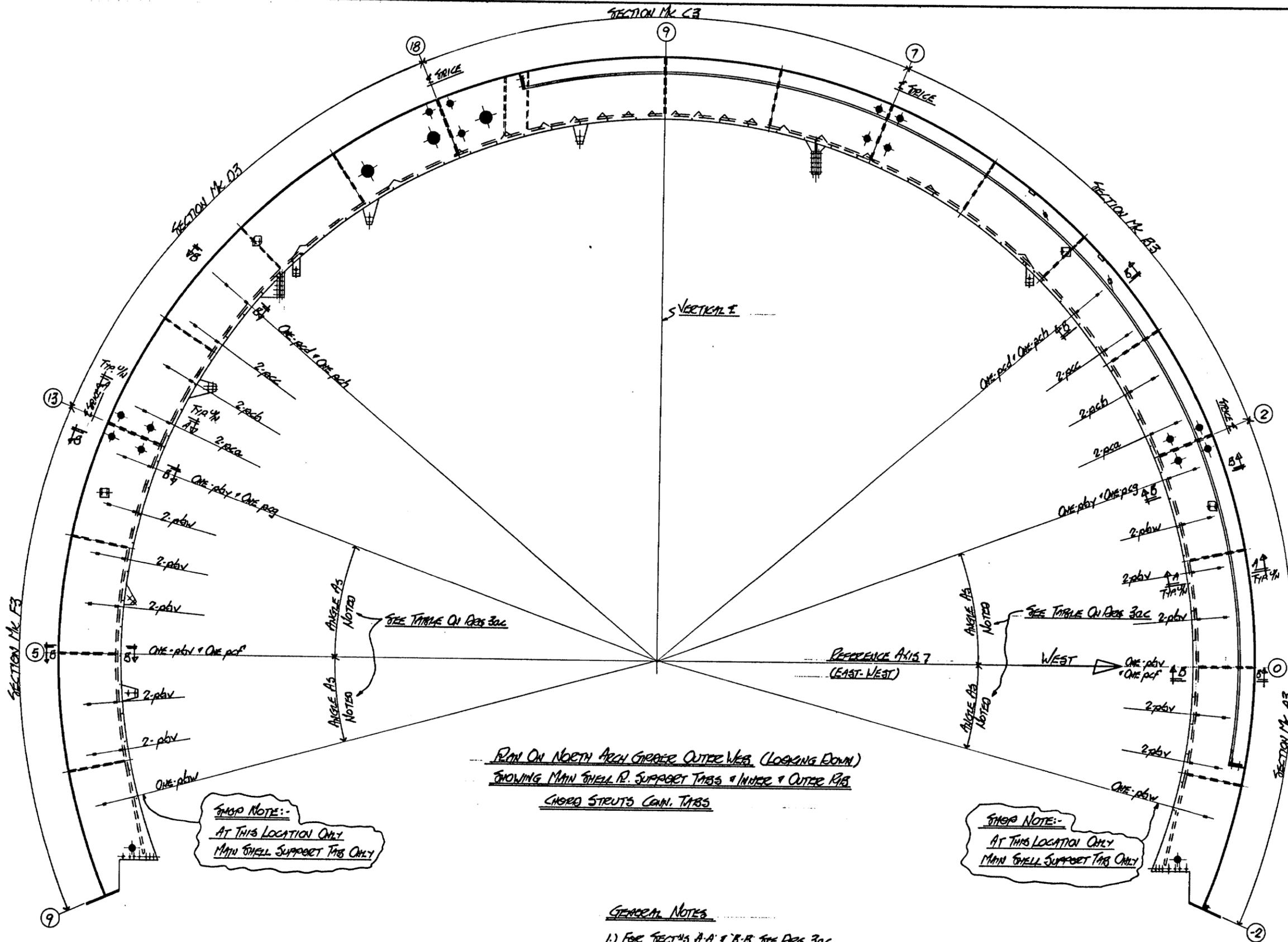
LINE	SHIP No. RECD.	FAB	MARK	DESCRIPTION	MAT'L	FT.	INS.	R.B.	LINE	REMARKS	CUTTING INSTRUCTIONS	WEIGHT	DIVISIONS
											SPLICING	ALLOWED	
1	4	RR	R 614 ± 32		44W	9.7675	1 1/4		14	(1/4" R)			

	MATERIAL	G40.21 (44W) 1/2in	DETAILS OF	Arch Gearers
	SURF. PREP & PAINT	SEE MEMO	SUB-ASSEMBLY ITEM CUTTING	
	OPEN HOLES	AS NOTED	FOR	4.2M TELESCOPE BORE LA FINISH
	DRAWN BY		DATE	CHECKED
DRAWING No.		1420-3x		REV. Δ
BRITAIN STEEL LTD. 400 EWEN AVENUE, NEW WESTMINSTER, B.C.				
SHOP DEPARTMENT			INS / F / S / O / M / T / P / SH / DP / AS / PA / ER	

p - a b c d f g h k m n p s t v w y

m - a b c d f g h k m n p s t v w y

MFR



PLAN ON NORTH ARCH GIRDER OUTER WEB (LOOKING DOWN)
 SHOWING MAIN SHELL R. SUPPORT TABS + INNER + OUTER RIBS
 CHORD STRUTS CAN. TABS

SHOP NOTE:-
 AT THIS LOCATION ONLY
 MAIN SHELL SUPPORT TABS ONLY

SHOP NOTE:-
 AT THIS LOCATION ONLY
 MAIN SHELL SUPPORT TABS ONLY

GENERAL NOTES

- 1) FOR SECT'S A-A + B-B SEE DES 306
- 2) FOR ITEM CUTTING DETAILS SEE DES 306
- 3) FOR WELDING OF MAIN MATERIAL SEE DES 36
- 4) FOR SHOP ASSEMBLY PROCEDURE SEE DES 36C + 36M

3R/3001136

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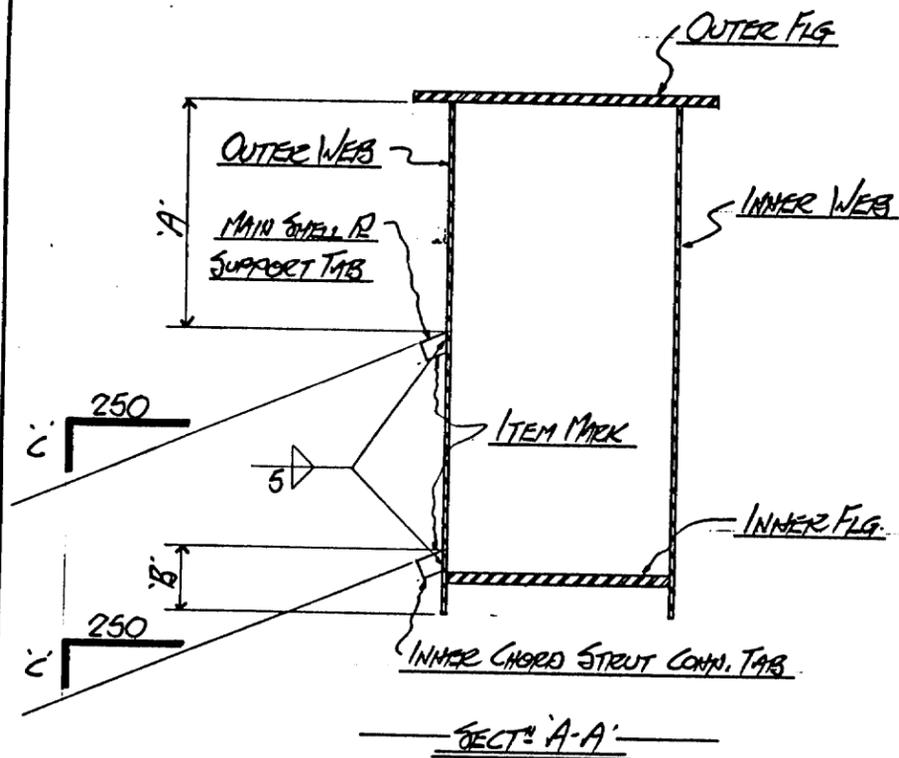
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s-abcdefghijklmnpstvw



MATERIAL	G40.21 (44W) w/n	NO.	BY	DATE	REVISION
SURF. PREP. & PAINT	STD.	SEE MEMO			
FOR 4.0M TELESCOPE DOME LA FOUEN					
DRAWN	DATE	CHECKED	DATE	DRAWING NO.	
RJR	5/20/83			1420-306 MJE	
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.					

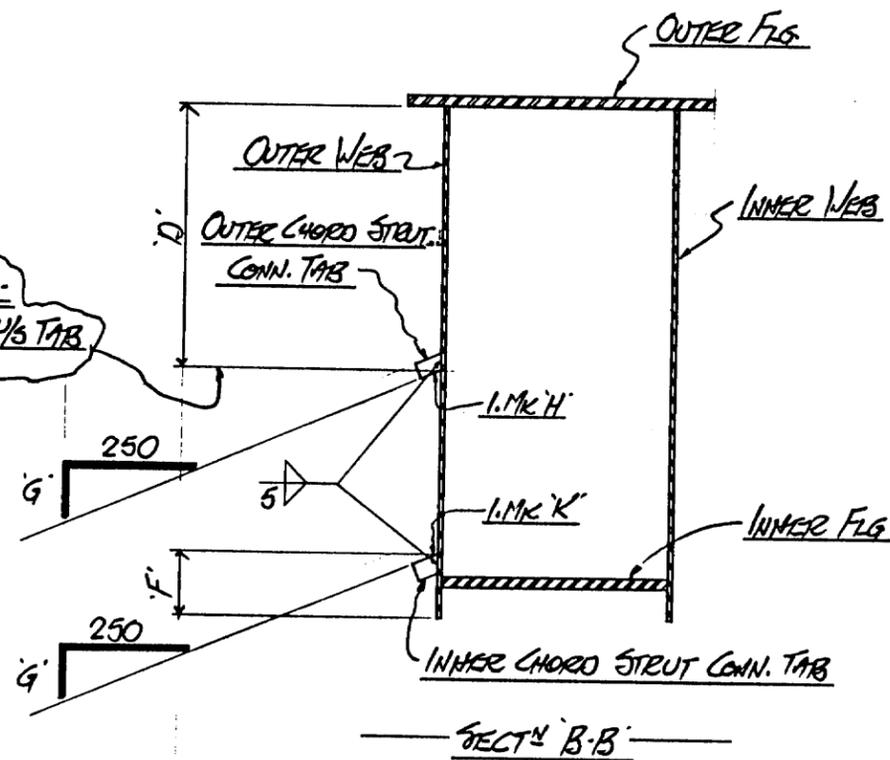
SHOP DEPARTMENT INS / F / S / O / M / T / P / SH / DP / AS / PA / ER NO PRINTS



NUMBER OF LOCATIONS
EACH COMPLETE ARCH GIRDER

ANGLE		A'	B'	C'	ITEM MK.
5°-15'-00"	4	610.5	172	102.5	pbv
10°-30'-00"	4	615	168.5	102.5	pbv
15°-50'-00"	4	622.5	163	100	pbw
26°-30'-00"	2	640	150.5	95	pca
31°-50'-00"	2	647.5	146.5	90	pcb
37°-15'-00"	2	651.5	146.5	85	pcc

SHOP NOTE:-
MIN R TO 1/8 TAB



NUMBER OF LOCATIONS
EACH COMPLETE ARCH GIRDER

ANGLE		D'	F'	G'	I.M.K.H	I.M.K.K
0°-00'-00"	2	658.5	173.5	102.5	pcf	pbv
21°-10'-00"	2	680.5	156.5	97.5	pcg	pbv
42°-40'-00"	2	698	152	80	pch	pcd

GENERAL NOTES

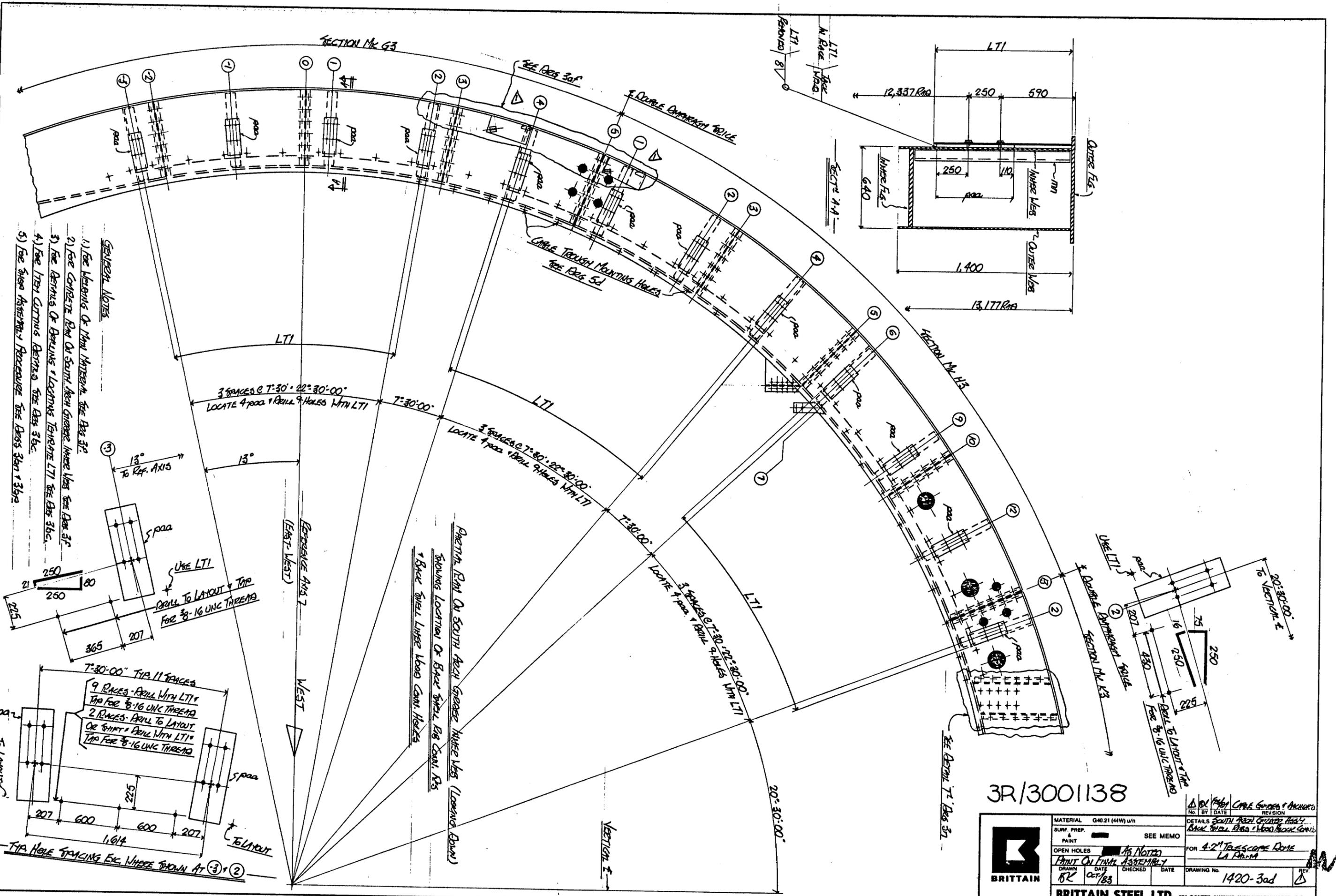
- 1) FOR LOCATIONS OF DETAILS ON THIS AREA SEE DESG'S 3a/b & 3am
- 2) FOR WELDING OF MAIN MATERIAL SEE DESG'S 3b & 3f
- 3) FOR SHOP ASSEMBLY PROCEDURE SEE DESG'S 3b/k, 3am, 3an, & 3ap
- 4) FOR ITEM CUTTING DETAILS SEE DESG 3bg

3R/3001137

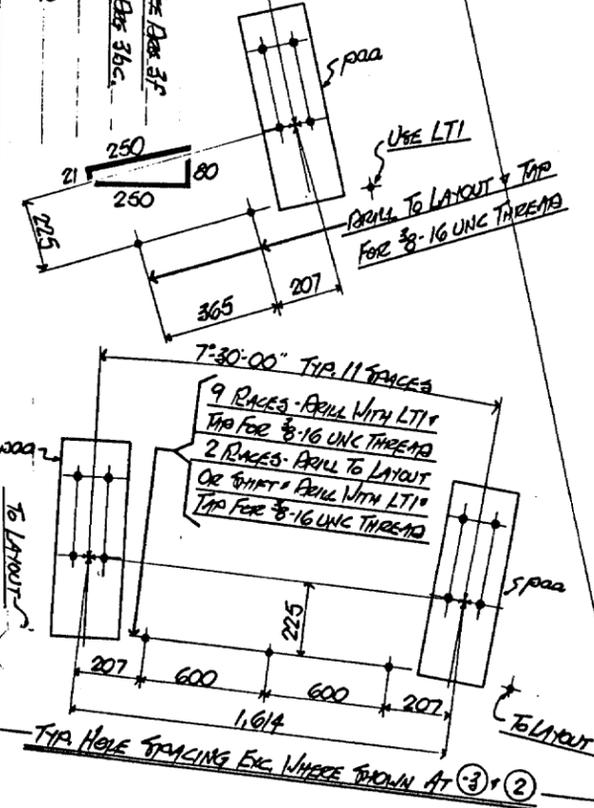
	MATERIAL G40.21 (44W) 1/2m		No. BY DATE REVISION		
	SURF. PREP. & PAINT SEE MEMO		DETAILS OF ARCH GIRDERS ASBY MAIN SHELL & RB CHORD STRUT TABS		
	PAINT ON FINAL ASSEMBLY		FOR 4.2M TELESCOPE DOME LA PALMA		
	DRAWN BR	DATE 02/01/83	CHECKED	DATE	DRAWING No. 1420-3ac
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.					
SHOP DEPARTMENT			INS / S / O / M / T / P / SH / DP / AS / PA / ER		
				No. PRINTS	

p - a b c d f g h k m n p s t v w y

m - a b c d f g h k m n p s t v w y



- GENERATOR NOTES**
- 1) See Locations of Main Wires on the Base 31'
 - 2) See COMPLETE PLAN ON SOUTH PEAK SPOKE INNER LEGS SEE Base 31'
 - 3) See DETAILS OF BEARINGS & LOCATIONS THEREON SEE Base 31'
 - 4) See VERY CRITICAL BEARINGS SEE Base 31'
 - 5) See SHOP ASSEMBLY PROCEDURES SEE Base 31' & 31a



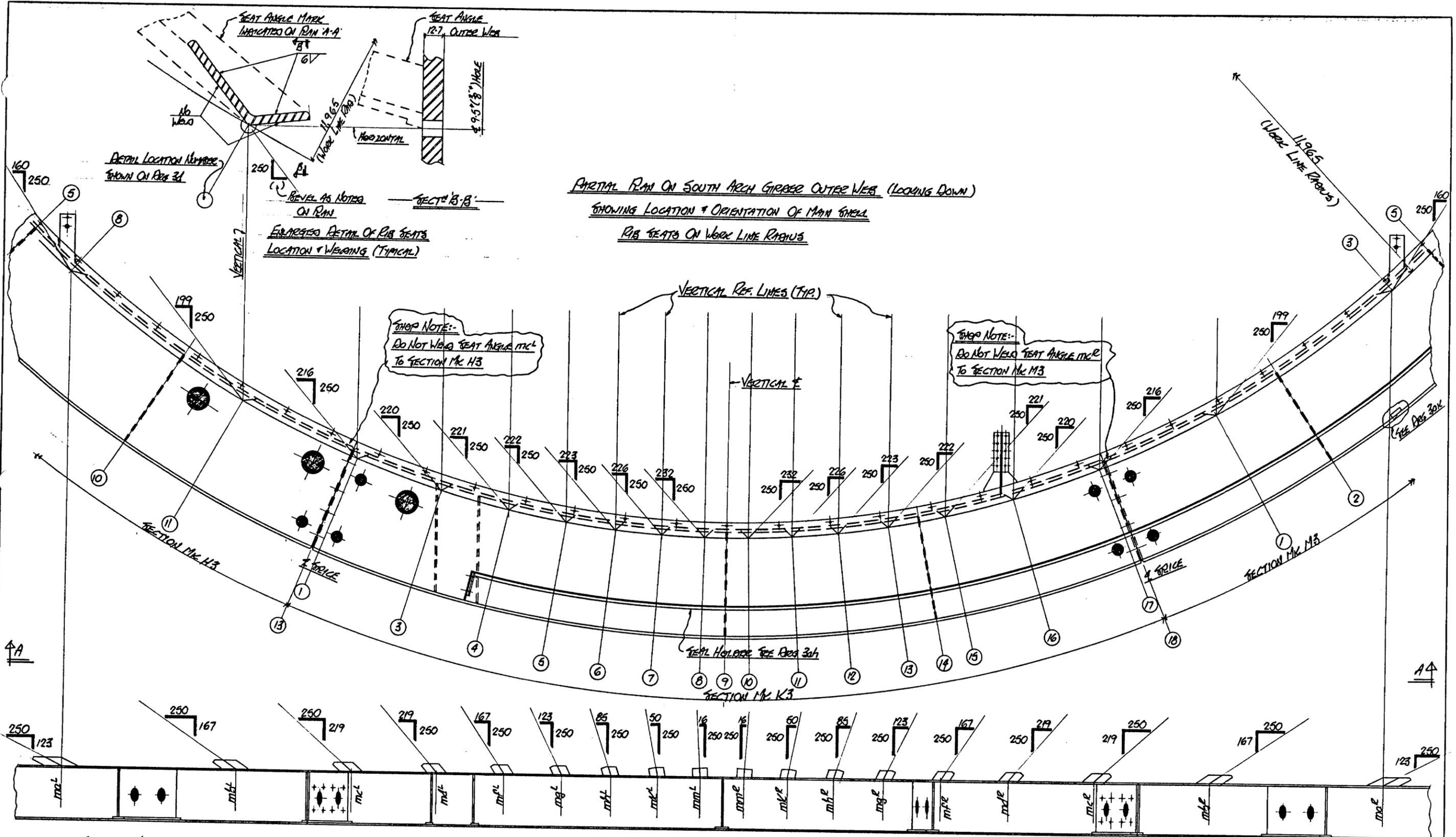
3R/3001138

	MATERIAL	G4021 (44W) w/n	SEE MEMO	
	SURF. PREP. & PAINT			
	OPEN HOLES	AS NOTED		
	PRINT ON FINAL ASSEMBLY			
DRAWN	BR	DATE	OCT/83	
CHECKED		DATE		
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, S.C.			DRAWING NO.	1420-3ad
SHOP DEPARTMENT			INS / F / S / G / M / T / P / SH / DP / AS / PA / ER	NO PRINTS

p-abcdefghijklmnopstvw

m-abcdefghijklmnopstvw

s-abcdefghijklmnopstvw



PARTIAL RIM ON SOUTH ARCH GIRDER OUTER WEB (LOOKING DOWN)
SHOWING LOCATION & ORIENTATION OF MAIN SHELL
RIB SEATS ON WORK LINE RADIUS

SHOP NOTE:-
 DO NOT WELD SEAT ANGLE TO SECTION MK H3

SHOP NOTE:-
 DO NOT WELD SEAT ANGLE TO SECTION MK M3

- GENERAL NOTES
- 1) FOR DETAILS OF RIB SEAT ANGLES SEE PAGE 36d.
 - 2) FOR ADDITIONAL INFORMATION RE ITEMS ON THIS PAGE SEE PAGE 3d
 - 3) FOR WELDING OF MAIN MATERIAL SEE PAGE 3F.
 - 4) FOR SHOP ASSEMBLY PROCEDURE SEE PAGES 36n & 36p.
 - 5) FOR COMPLETE RIM ON SOUTH ARCH GIRDER OUTER WEB SEE PAGE 3ah.

RAN A-A
 (OUTER FLG & SEAT HOLDER)
 OMITTED FOR CLARITY

3R/3001140

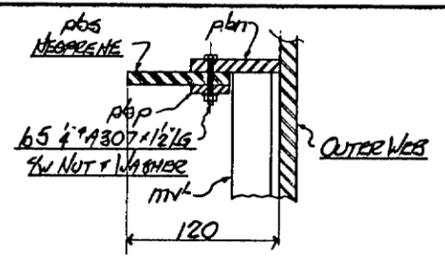
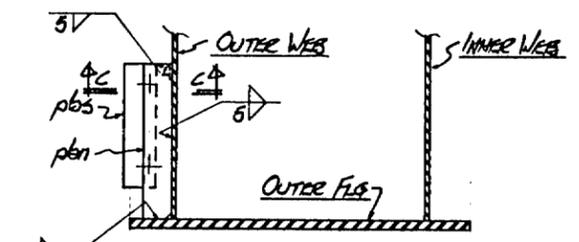
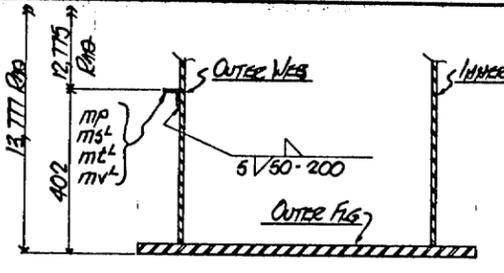
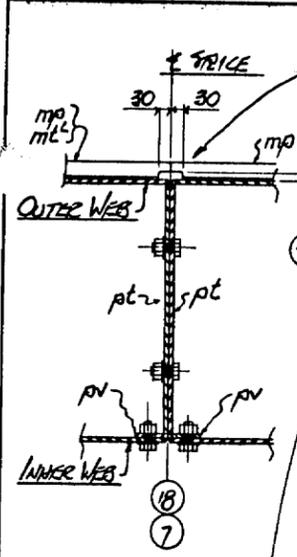
	MATERIAL	G40.21 (44W) w/n	No	BY	DATE	REVISION
	SURF. PREP. & PAINT	SEE MEMO	DETAILS SOUTH ARCH GIRDER ASSY			
	OPEN HOLES		FOR 4.2" TELESCOPE CORE			
	PAINT ON FINAL ASSEMBLY		LA PAINT			
DRAWN	DATE	CHECKED	DATE	DRAWING No.	REV.	
BR	OCT/83			1420-309		
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, S.C.						
SHOP DEPARTMENT						

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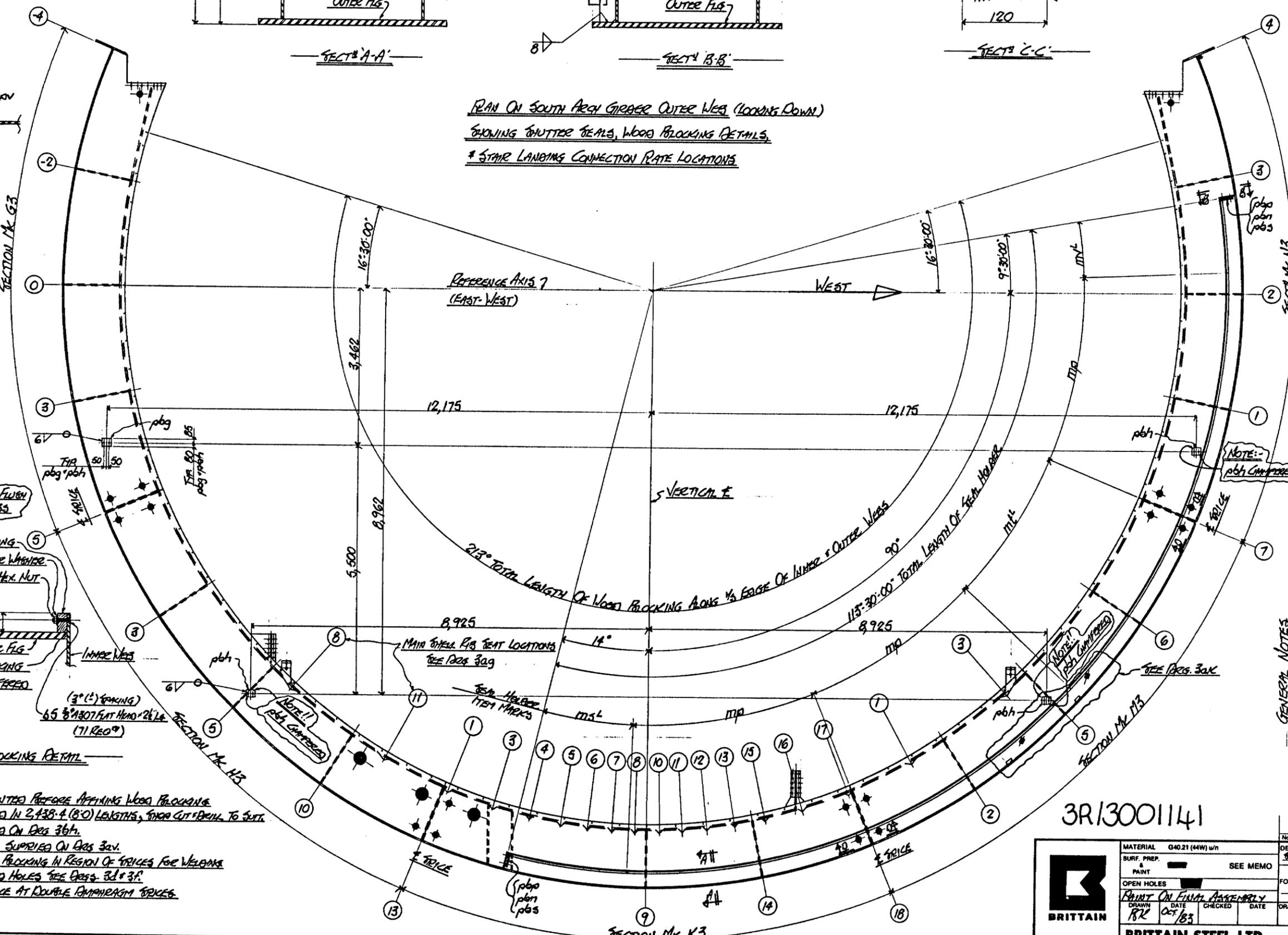
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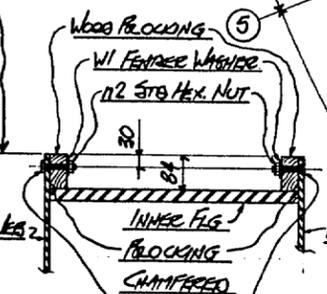
SHOP NOTES:
 COPE ANGLES TO SHOW
 TOP 2 TRICES



PLAN ON SOUTH ARCH GREYER OUTER WEB (LOOKING DOWN)
 SHOWING SHUTTER BEAMS, WOOD BLOCKING DETAILS,
 & STAIR LANDING CONNECTION PLATE LOCATIONS



SHOP NOTE:
 WOOD BLOCKING FINISH
 1/8" EDGE OF WEBS



- NOTES**
- 1) ARCH GREYER TO BE PAINTED BEFORE AFFIXING WOOD BLOCKING
 - 2) WOOD BLOCKING SUPPLIED IN 2,138-4 (8'0") LENGTHS, SHOP CUT & DRILL TO SUIT. WOOD BLOCKING SUPPLIED ON DES 364.
 - 3) BOLTS, NUTS, & WASHERS SUPPLIED ON DES 36V.
 - 4) FIELD WILL REMOVE WOOD BLOCKING IN REGION OF TRICES FOR WELDING
 - 5) FOR LOCATIONS OF WOOD HOLES SEE DES 3d & 3f.
 - 6) WOOD BLOCKING TO TRICE AT DOUBLE CONCENTRIC TRICES

NOTE:
 rsh COMPRESSED

- GENERAL NOTES**
- 1) FOR FEM CUTTING DETAILS SEE DES 366, 36f, & 36h.
 - 2) FOR SHOP ASSEMBLY PROCEDURE SEE DES 36m & 36p.
 - 3) FOR WELDING OF MAIN MATERIAL SEE DES 3f.

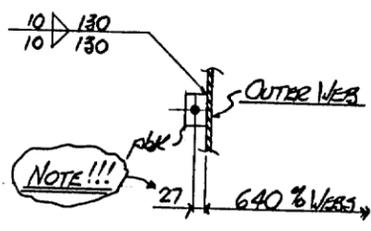
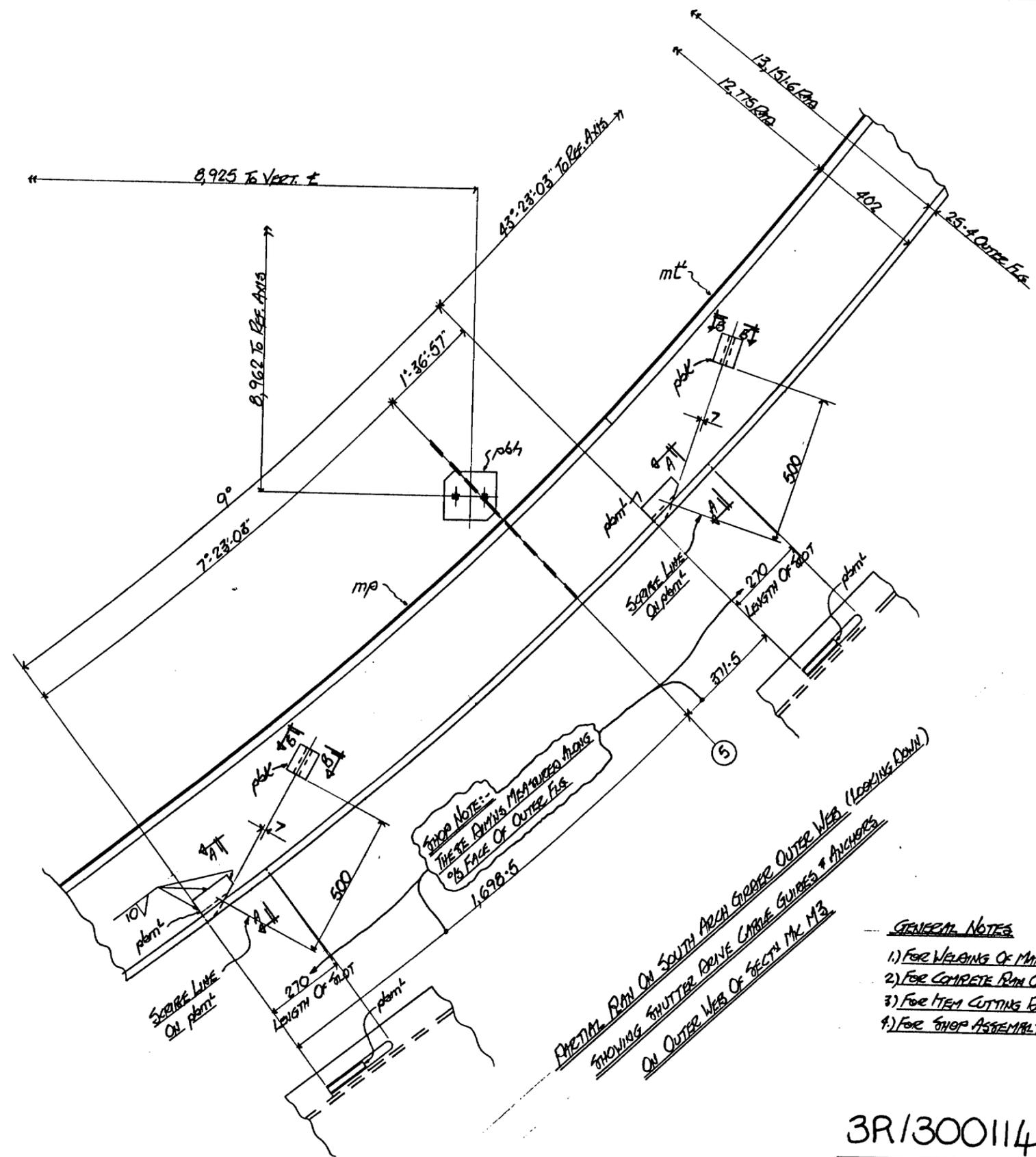
3R/3001141

	MATERIAL	G4021 (44W) w/h	NO. BY DATE	REVISION
	SURF. PREP. & PAINT	SEE MEMO	DETAILS SOUTH ARCH GREYER 1553-4	
	OPEN HOLES		FOR 4.2M TELESCOPE DOME LA PALMA	
	PAINT ON FINAL ASSEMBLY		DRAWING NO. 1420-3ah	
DRAWN	DATE	CHECKED	DATE	REV.
BR	OCT/83			
BRITAIN STEEL LTD., 401 SALTER AVENUE, NEW WESTMINSTER, B.C.				
SHOP DEPARTMENT				

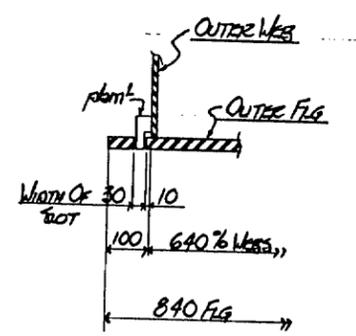
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SECTN B-B
TYP. 2 PLACES



SECTN A-A
TYP. 2 PLACES

SHOP NOTES:
THESE DIMS MEASURED ALONG
THE FACE OF OUTER FLG.

SPRINKLE RUN ON SOUTH ARCH SHOULD COVER OUTER WEB (LOOKING DOWN)
SHOWING SHUTTER BENE CHAIR GUIDES + ANCHORS
ON OUTER WEB OF SECTN MC M3

GENERAL NOTES

- 1) FOR WELDING OF MAIN MATERIAL SEE PAGE 31.
- 2) FOR CONCRETE RUN ON SOUTH ARCH COVER OUTER WEB SEE PAGE 30.
- 3) FOR ITEM CUTTING DETAILS SEE PAGE 366.
- 4) FOR SHOP ASSEMBLY PROCEDURE SEE PAGES 367 + 368.

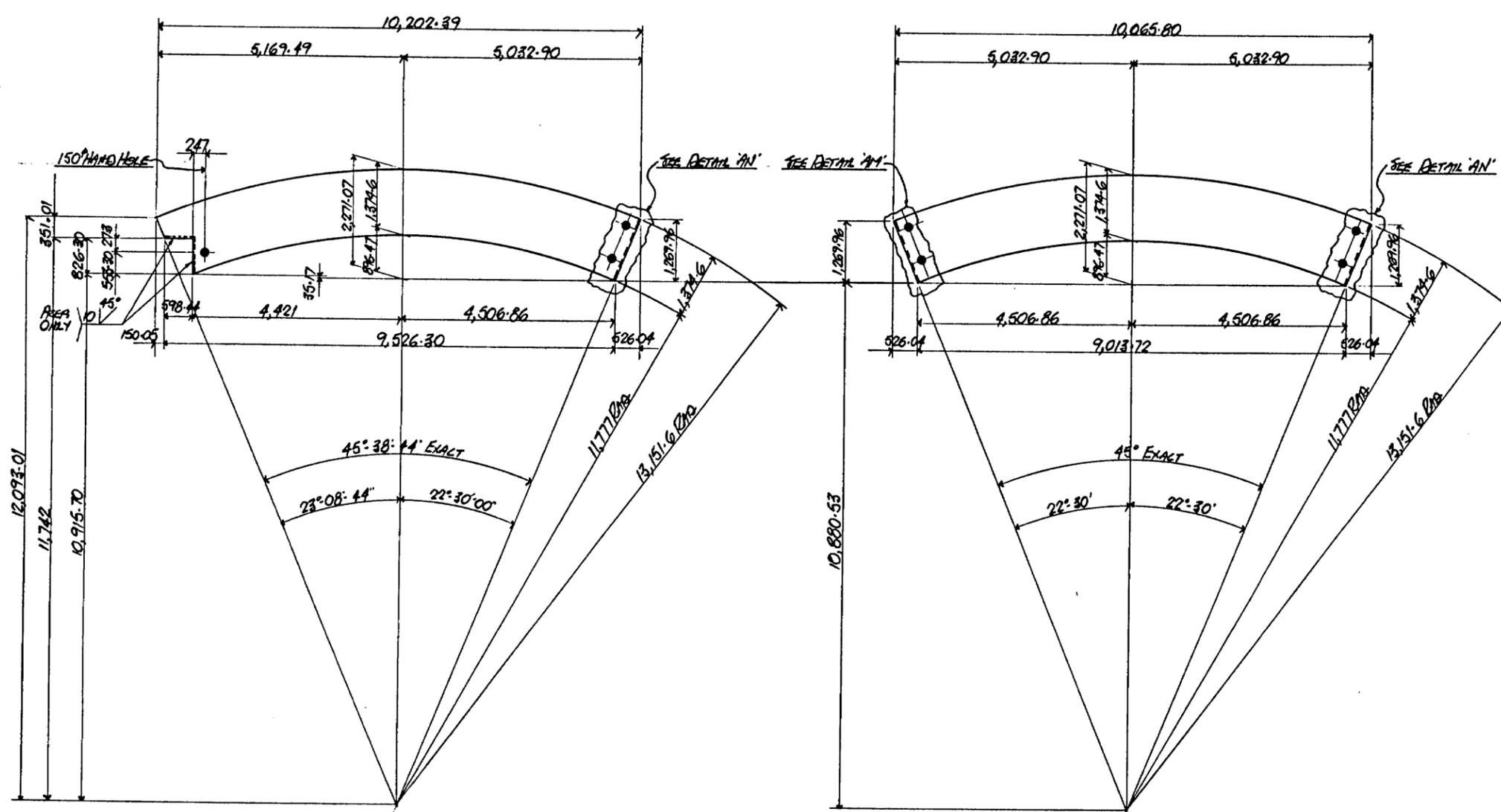
3R/3001142

	MATERIAL	G40.21 (44W) w/n	SEE MEMO
	SURF. PREP.		
	PAIN		
	PAINT ON FINAL ASSEMBLY		
DRAWN	DATE	CHECKED	DATE
BR	Oct/63		
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.			DRAWING No
			1420-30K
SHOP DEPARTMENT			

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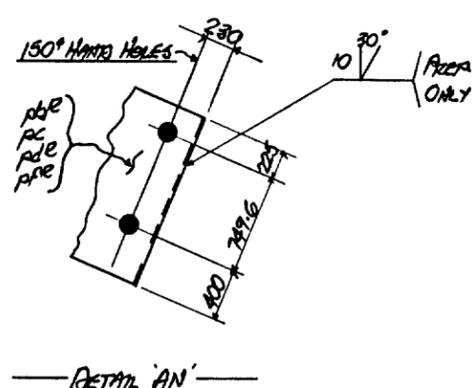
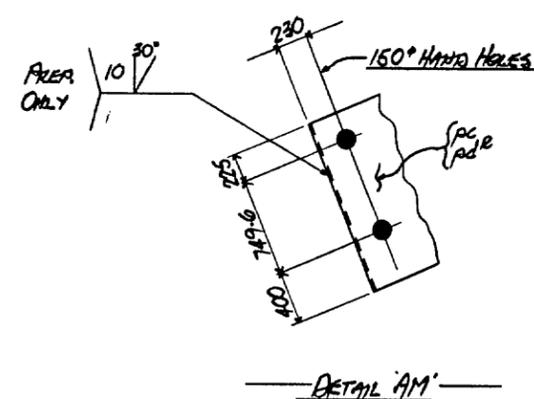
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CUT HAND HOLES BEFORE ALL OTHER CUTS
 2 REQ. MC $p6^E$ (AS SHOWN) FOR SECTIONS MC A3 + G3
 2 REQ. MC $p6^L$ (OFF HAND) FOR SECTIONS MC F3 + N3
ARCH GIRDER OUTER WEBS

CUT HAND HOLES BEFORE ALL OTHER CUTS
 2 REQ. MC $p6$
 FOR SECTIONS MC B3 + M3
ARCH GIRDER OUTER WEBS



GENERAL NOTES

1) FOR SHOP ASSEMBLY + SHOP WELDING OF ITEMS ON THIS DRAW SEE DROGS 32, 36, 31, 131

3R/3001144

	MATERIAL	G4021 (44W) w/n	No. BY DATE	REVISION
	SURF. PREP. & PAINT	SEE MEMO	DETAILS ARCH GIRDERS SUB 4531 HEAVY CUTTING	
	OPEN HOLES	AS NOTED	FOR 4.2" TELESCOPE ROOME LA ROMA	
	DRAWN DATE CHECKED DATE		DRAWING No. REV	
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.		1420-307		

SHOP DEPARTMENT INS P S O M T P SH DP AS PA ER No PRINTS

MATERIAL BILL						BRITAIN STEEL LTD.		CONTRACT 1420	
LINE	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	ROLL LINE	WEIGHT
1	$p6^E$	2	R	12.7 THICK CUT TO CONTOUR (1/2 R)			44W	111	
2	$p6^L$	2	R					111	
3									
4	$p6$	2	R	12.7 THICK CUT TO CONTOUR (1/2 R)			44W	110	
5									
6									
7									
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11									
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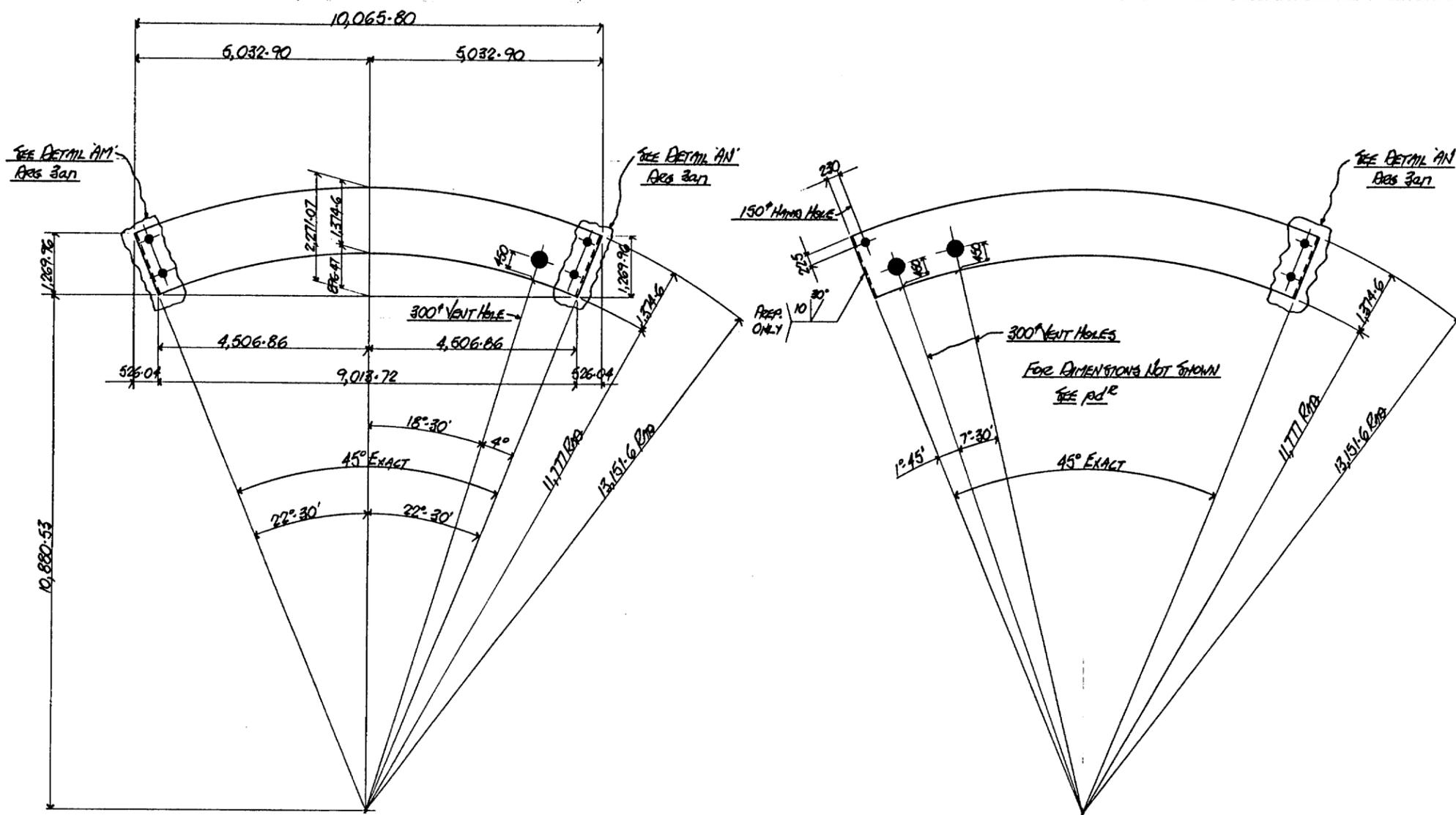
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s-abcdefghijklmnpstvw y

MATERIAL BILL
BRITAIN STEEL LTD.

CONTRACT 1420

LINE NO.	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	W	L	WEIGHT
1	RD ^R	ONE	R	12.7 THICK CUT TO CONTOUR (1/2 R)			44W	1	10	
2	RD ^L	ONE	R				L	1	10	
3										
4	RD ^R	ONE	R	12.7 THICK CUT TO CONTOUR (1/2 R)			44W	1	10	
5	RD ^L	ONE	R				L	1	10	
6										
7										
8										
9										
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CUT HAND & VENT HOLES BEFORE ALL OTHER CUTS
ONE REQ. MK RD^R (AS SHOWN) FOR SECTION MK C3
ONE REQ. MK RD^L (OPP. HAND) FOR SECTION MK K3
ARCH GIRDER OUTER WEB

CUT HAND & VENT HOLES BEFORE ALL OTHER CUTS
ONE REQ. MK RD^R (AS SHOWN) FOR SECTION MK D3
ONE REQ. MK RD^L (OPP. HAND) FOR SECTION MK H3
ARCH GIRDER OUTER WEB

GENERAL NOTES

1) FOR SHOP ASSEMBLY & SHOP WELDING OF ITEMS ON THIS DRAWING SEE DRS 3a, 3b, 3c, 13f

3R/3001145

	MATERIAL	G40 21 (44W) w/n	SEE MEMO	REVISION
	SURF. PREP.	PAINT		DETAILS ARCH GIRDER SUB PART
	OPEN HOLES	AS NOTED		ITEM CUTTING
	PRINT ON FILM	ASSEMBLY		FOR 4.2m TELESCOPE DOME LA PALMA
DRAWN	DATE	CHECKED	DATE	DRAWING No.
RD	10/01/83			1920-3ap
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.				

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m-abcdefghijklmnpstvw y

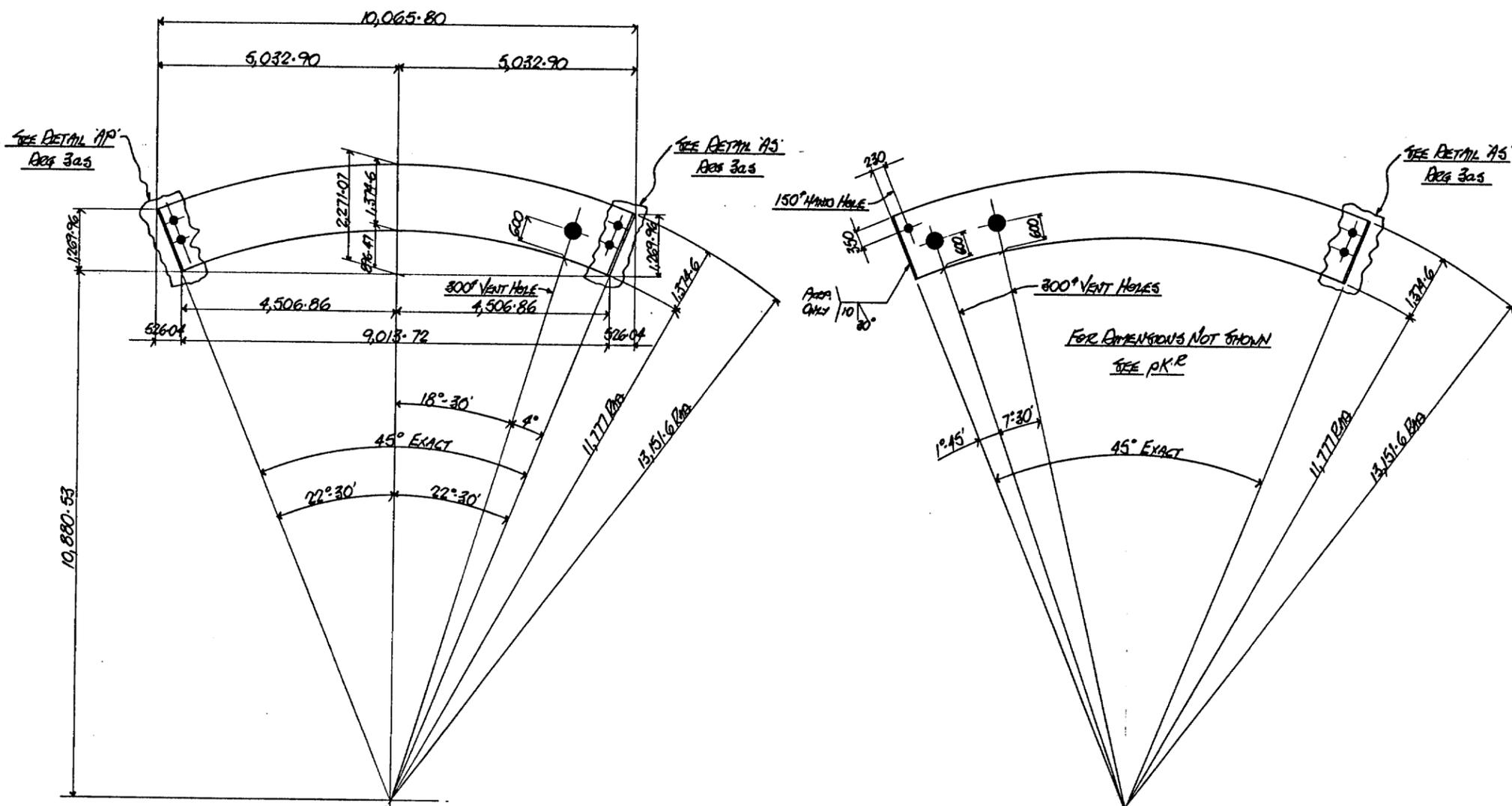
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SHOP DEPARTMENT / INS / F / S / O / M / T / P / SH / DP / AS / PA / ER / No PRINTS

MATERIAL BILL
BRITAIN STEEL LTD.

CONTRACT 1420

MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	W	L	W	WEIGHT
1 PKR	ONE	R	1/2" THICK CUT TO CONTOUR (3" R)			44W	1	10		
2 PKR	ONE	R	1/2" THICK CUT TO CONTOUR (3" R)			44W	1	10		
3										
4 PKR	ONE	R	1/2" THICK CUT TO CONTOUR (3" R)			44W	1	10		
5 PKR	ONE	R	1/2" THICK CUT TO CONTOUR (3" R)			44W	1	10		
6										
7										
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CUT HAND & VENT HOLES BEFORE ALL OTHER CUTS
 ONE REQⁿ-MK PKR (AS SHOWN) FOR SECTION MK C3
 ONE REQⁿ-MK PKR (OPP. HAND) FOR SECTION MK K3
ARCH GROOVE INNER WEB

CUT HAND & VENT HOLES BEFORE ALL OTHER CUTS
 ONE REQⁿ-MK PKR (AS SHOWN) FOR SECTION MK D3
 ONE REQⁿ-MK PKR (OPP. HAND) FOR SECTION MK H3
ARCH GROOVE INNER WEB

GENERAL NOTES

1.) FOR SHOP ASSEMBLY & SHOP WEARING OF ITEMS ON THIS DRAW SEE DRESS 3613P

3R/3001147

	MATERIAL	G40 21 (44W) w/h	NO.	BY	DATE	REVISION
	SURF. PREP. & PAINT	SEE MEMO	DETAILS ARCH GROOVES SUB ASSEMBLY ITEM CUTTING			
	OPEN HOLES	AS NOTED	FOR 4.2M TELESCOPE DOME LA PRIMA			
	DRAWN DATE		CHECKED DATE		DRAWING NO.	
PKR 1601/83				1420-3at		
BRITAIN STEEL LTD. 401 BALTER AVENUE, NEW WESTMINSTER, B.C.						
SHOP DEPARTMENT						
INS / F / S / O / M / T / P / SH / DP / AS / PA / ER						
NO PRINTS						

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m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

MATERIAL BILL
BRITAIN STEEL LTD.

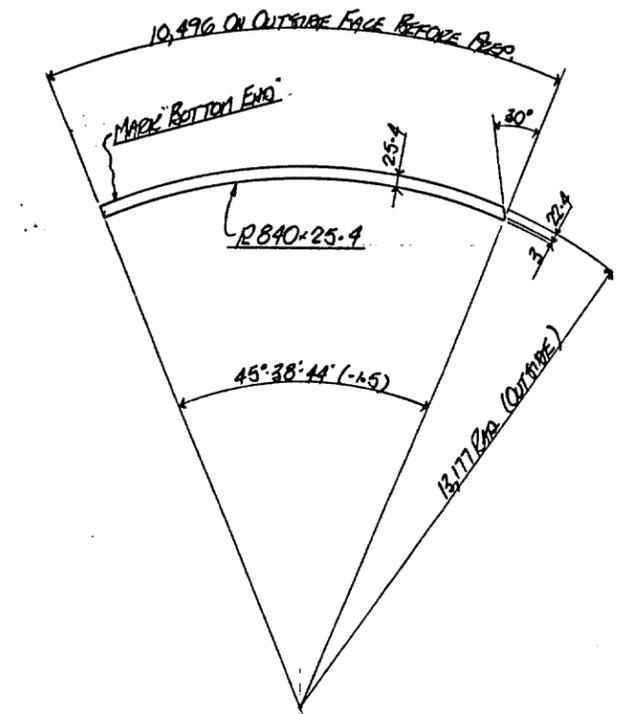
CONTRACT 1420

LINE #	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	WGT. LINE	WEIGHT
1	PT	4	R	840*25.4	10,496	(1/R) ROLLED PREFR. ONE END	7-1	112	
2									
3									
4	PP	6	R	840*25.4	10,346	(1/R) ROLLED PREFR. 2 ENDS	7-1	113	
5									
6									
7	PS	6	R	614*32	9,337	(1/R) ROLLED PREFR. 2 ENDS	44V	115	
8									
9									
10	PT	16	R	604.5*12.7	1,258.5	(3/8R)			44V
11	PV	16	R	80*9.5	1,256	(3/8R)			
12									
13									
14	AW	28	R	604.5*12.7	1,258.5	(3/8R)			44V
15	PV	28	R	160*9.5	1,256	(3/8R)			
16									
17									
18	b1	248	Bolt	3/8" H.H.S.	24	9/16 NUTS, NO NUT	A325		
19									
20	b2	208	Bolt	3/8" Flat Head	2"		A307		
21									
22	b3	142	Bolt	5/8" Flat Head	2 1/2"		A307		
23									
24	b4	142	Bolt	5/8" Mach	2 1/2"		A307		
25									
26	b5	8	Bolt	3/4" Mach	1 1/2"	9/16 NUTS/WASHER	A307		
27									
28	n1	476	Nut	Hex Hex Nut For 3/8"			A325		
29									
30	n2	284	Nut	Std Hex Nut For 5/8"			A307		
31									
32	w1	284	Washer	Flange Washer For 5/8"			A307		
33									
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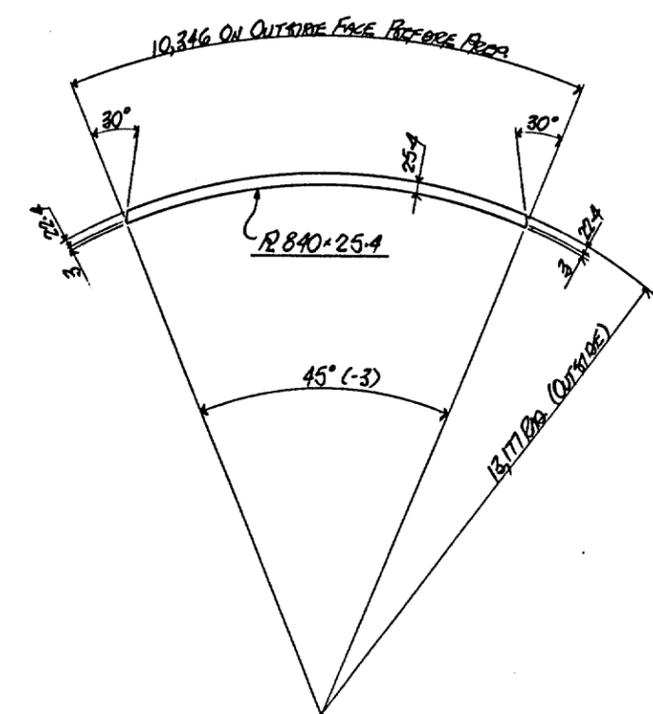
GENERAL NOTES
 1.) FOR SHOP ASSEMBLY & SHOP WELDING OF ITEMS ON THIS DRS SEE
 DRSs 3a, 3b, 3d, 3f, 3h, 3c, 3m, & 3n
 2.) USE 1/2" BOLT FOR 21" HOLES IF PREFERRED

3R/3001148

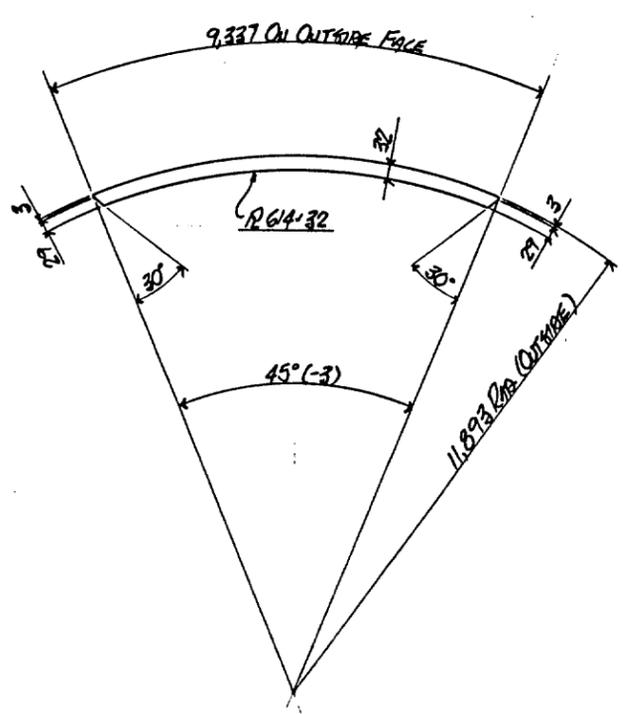
	MATERIAL	G40.21 (44V) W/P	NO. BY DATE	REVISION
	SURF. PREP.	PAINT	SEE MEMO	
	OPEN HOLES	As Noted		
	PRINT ON FINAL ASSEMBLY			
DRAWN	DATE	CHECKED	DATE	DRAWING NO.
RL	20/1/83			1420-3a
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.				



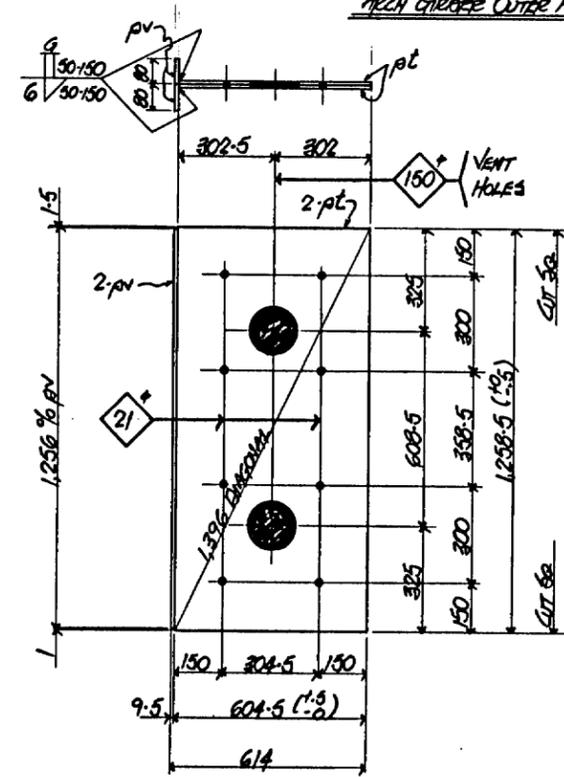
4 REQ^d - MK PT
 FOR SECTIONS MK A3, F3, G3, I13
 ARCH GIRDER OUTSIDE FLG.



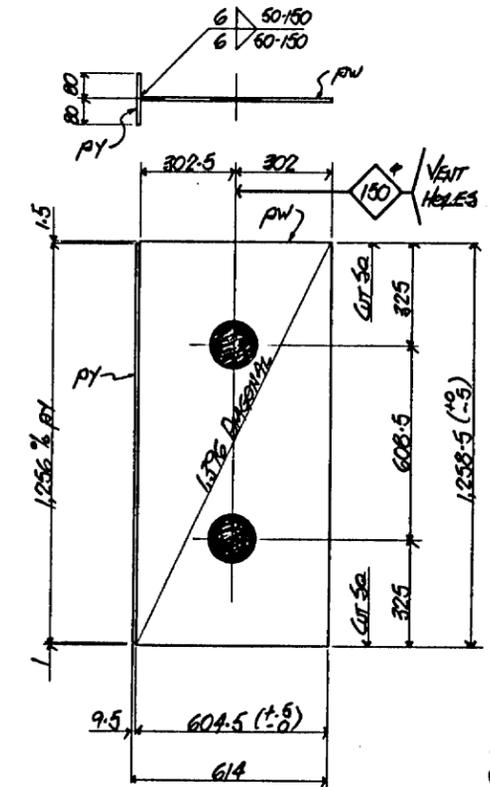
6 REQ^d - MK PP
 FOR SECTIONS MK B3, C3, D3, H3, K3, I13
 ARCH GIRDER OUTSIDE FLG.



6 REQ^d - MK PS
 FOR SECTIONS MK B3, C3, D3, H3, K3, I13
 ARCH GIRDER INSIDE FLG.



8 REQ^d THUS
 ARCH GIRDER DIAPHRAGM ASSEMBLY C BRICES
 STACK DRILL IN PILES AS SHOWN &
 BOLT TOGETHER AS NOTED ON DRSs 3h & 3n



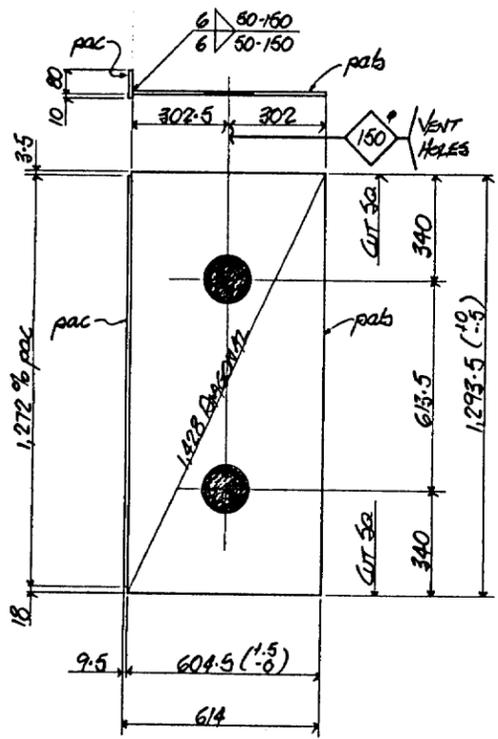
28 REQ^d THUS
 ARCH GIRDER DIAPHRAGM ASSEMBLY

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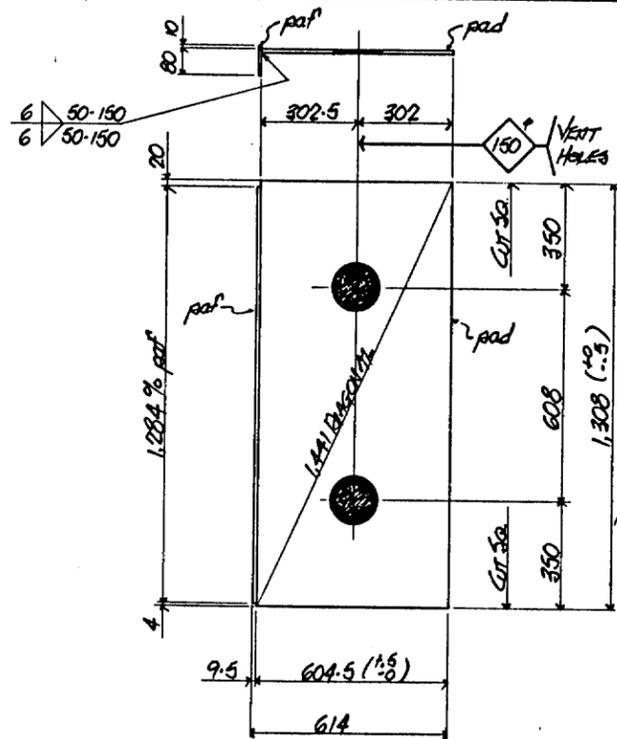
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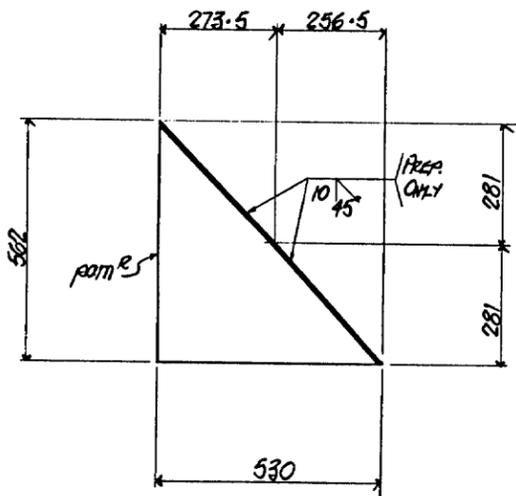
SHOP DEPARTMENT / INS / F / S / O / M / T / P / SH / DP / AS / PA / ER / NO PRINTS



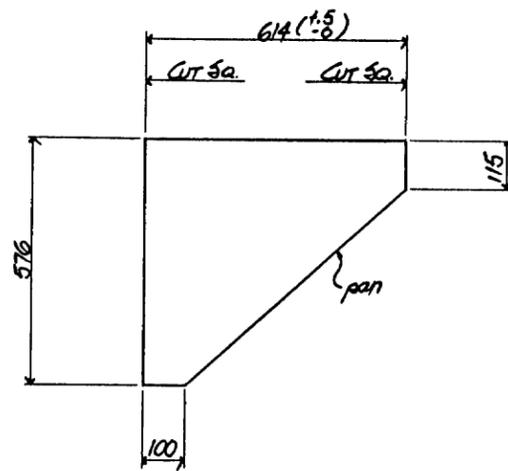
ONE REQ^d AS SHOWN (FOR NORTH ARCH GIRDER)
 ONE REQ^d OPP. HAND (FOR SOUTH ARCH GIRDER)
 ARCH GIRDER DIAPHRAGM ASSEMBLIES



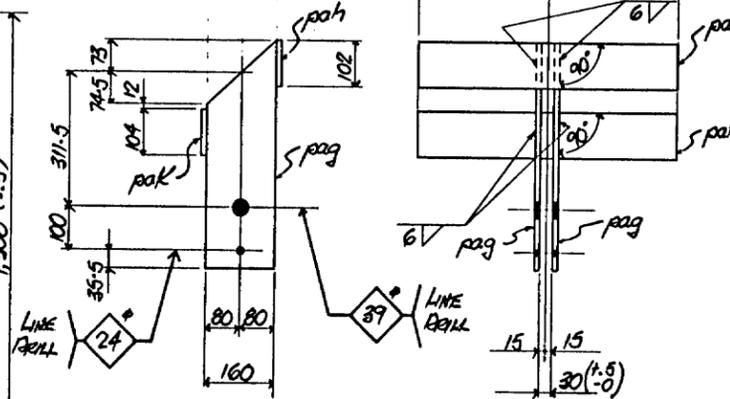
ONE REQ^d AS SHOWN (FOR NORTH ARCH GIRDER)
 ONE REQ^d OPP. HAND (FOR SOUTH ARCH GIRDER)
 ARCH GIRDER DIAPHRAGM ASSEMBLIES



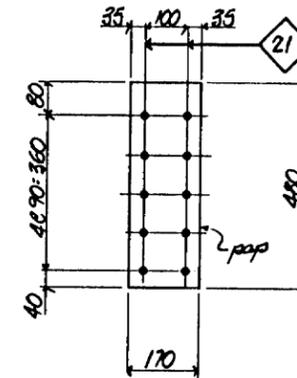
ONE REQ^d AS SHOWN (FOR NORTH ARCH GIRDER)
 ONE REQ^d OPP. HAND (FOR SOUTH ARCH GIRDER)
 END SUPPORT BEAM CONNECTION R



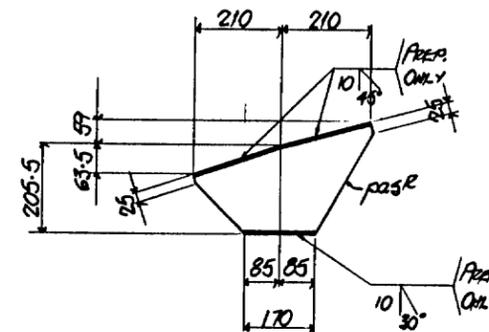
2 REQ^d THUS
 END SUPPORT BEAM CONNECTION R DIFFERENT



4 REQ^d THUS
 ERECTION BEAM CONNECTION ASSEMBLIES



2 REQ^d THUS
 TEMPORARY BRACE FRAME CONNECTION R



ONE REQ^d AS SHOWN (FOR NORTH ARCH GIRDER)
 ONE REQ^d OPP. HAND (FOR SOUTH ARCH GIRDER)
 TEMPORARY BRACE FRAME CONNECTION R REINFORCING

MATERIAL BILL						BRITAIN STEEL LTD.		CONTRACT 1420	
NO.	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	W. LINE	WEIGHT
1	pab	2	R	604.5-12.7	1272.5 (1/2 R)		44W		
2	pac	2	R	90-9.5	1272 (3/4 R)				
3									
4	pad	2	R	604.5-12.7	1308 (1/2 R)		44W		
5	pad	2	R	90-9.5	1284 (3/4 R)				
6									
7	pag	8	R	160-12.7	520		44W		
8	pagh	4	R	102-12.7	614 (1/2 R)				
9	pagk	4	R	104-12.7	614				
10									
11	pan	ONE	R	170-12.7	562 (1/2 R) FROM ONE EDGE		44W		
12	panh	ONE	R						
13									
14	pan	2	R	576-9.5	614 (1/2 R)		44W		
15									
16	pan	2	R	170-12.7	480 (1/2 R)		44W		
17									
18	pan	ONE	R	1264.5-12.7	427 (1/2 R) FROM 2 EDGES		44W		
19	pan	ONE	R						
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GENERAL NOTES
 1) FOR TEMP ASSEMBLY & TEMP WELDING OF ITEMS ON THIS DRAWING SEE PARTS 301 & 302
 2) USE 1/8" DRILL FOR 21" HOLES, 1/4" DRILL FOR 24" HOLES, 3/8" DRILL FOR 37" HOLES
 IF PREFERRED

3R/3001149

BRITAIN

MATERIAL G40-21 (44W) w/p
 SURF. PREP. & PAINT SEE MEMO
 OPEN HOLES AS NOTED
 FINISH ON FINAL ASSEMBLY

FOR 4.2M TELESCOPE DOME
 LA FERRAS

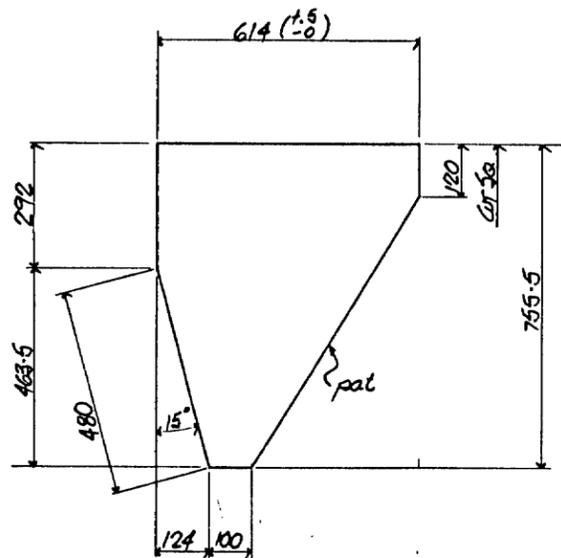
DATE 2001/03
 CHECKED DATE
 DRAWING NO. 1420-3aw
 REV.

BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.
 SHOP DEPARTMENT
 INB/F/S/D/M/T/P/SH/DP/AS/PA/ER
 NO PRINTS

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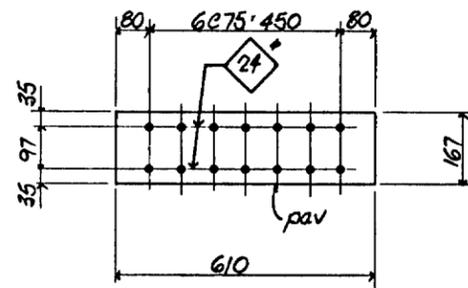
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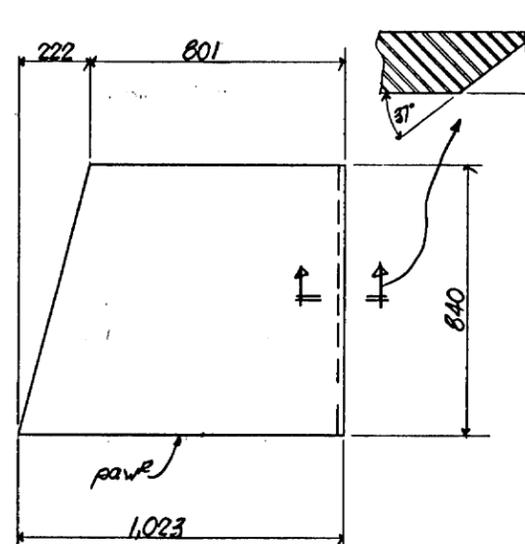


2 REQS THUS

TEMPORARY BRACE FRAME CONNECTION R STIFFENER

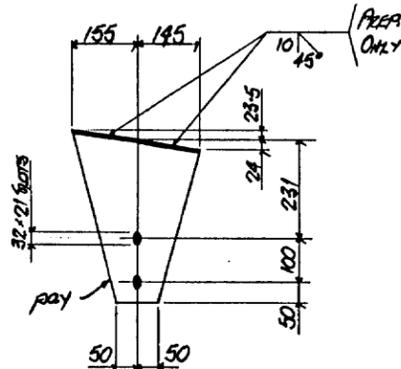


4 REQS THUS
ARCH GIRDER INNER FLANGE BRACE R



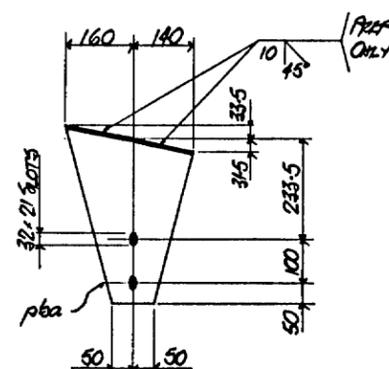
2 REQS AS SHOWN
2 REQS OFF HAND
SHUTTER BUMPER SUPPORT R

MATERIAL BILL		BRITAIN STEEL LTD.		CONTRACT 1420				
NO	MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MATL TYPE	WEIGHT
1	pat	2	R	614x12.7	755.5	(1/2 R)	44W	
2								
3	pav	4	R	167x12.7	610	(1/2 R)	44W	
4								
5	pav	2	R	1840x19	1023	(1/2 R) FROM ONE EDGE	44W	
6	pav	2	R					
7								
8	pav	ONE	R	300x12.7	404.5	(1/2 R) FROM ONE EDGE	44W	
9								
10	pba	ONE	R	300x12.7	417	(1/2 R) FROM ONE EDGE	44W	
11								
12	pbb	2	R	325x12.7	565.5	(1/2 R) FROM ONE EDGE	44W	
13								
14	pbc	2	R	395x12.7	565.5	(1/2 R) FROM ONE EDGE	44W	
15								
16	pbd	2	R	248.5x12.7	411.5	(1/2 R) FROM ONE EDGE	44W	
17								
18	pbf	2	R	289x12.7	260	(1/2 R) FROM ONE EDGE	44W	
19								
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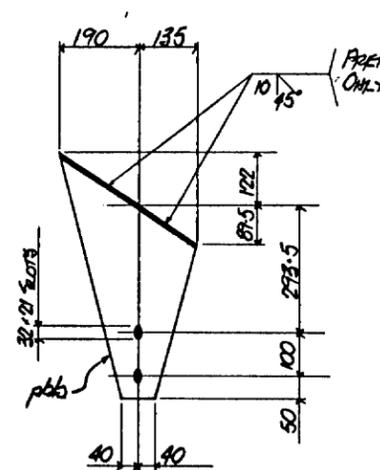
ONE REQ THUS

WALK WAY HANGER CONNECTION R



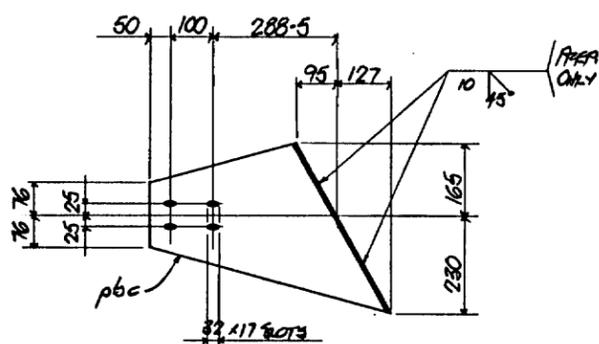
ONE REQ THUS

WALK WAY HANGER CONNECTION R



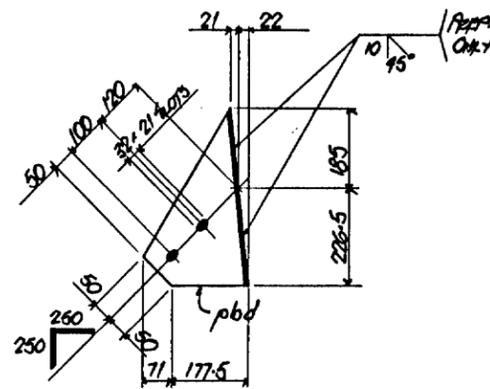
2 REQS THUS

WALK WAY HANGER CONNECTION R's



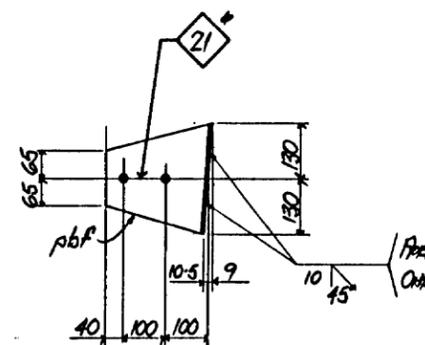
2 REQS THUS

WALK WAY STRINGER CONNECTION R's



2 REQS THUS

LARGER STRUT BRACE CONNECTION R's



2 REQS THUS

LARGER STRUT CONNECTION R's

GENERAL NOTES

- 1) FOR SHOP ASSEMBLY & SHOP WELDING OF MEMS ON THIS DRAW SEE DEGS 34, 37, & 30
- 2) USE 1/8" DRILL FOR 21" HOLES & 1/8" DRILL FOR 28" HOLES IF PROFFERED
- 3) USE 1 1/2" PUNCH FOR 32x21 BOTS & 1 1/2" PUNCH FOR 32x17 BOTS IF PROFFERED

3R/3001150

	MATERIAL	G40.21 (44W) w/n	NO	BY	DATE	REVISION
	SURF. PREP. & PAINT	SEE MEMO	DETAILS OPEN GIBBES FOR 4554 ITEM CUTTING			
	OPEN HOLES	AS NOTES	FOR 4.2" TELESCOPE DOME LA PALMA			
	PRINT ON FINISH ASSEMBLY					
DRAWN	DATE	CHECKED	DATE	DRAWING NO.	REV.	
RJR	8/20/83			1420-36a		
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.						
SHOP DEPARTMENT						
INS / P / S / O / M / T / P / SH / DP / AS / PA / ER						

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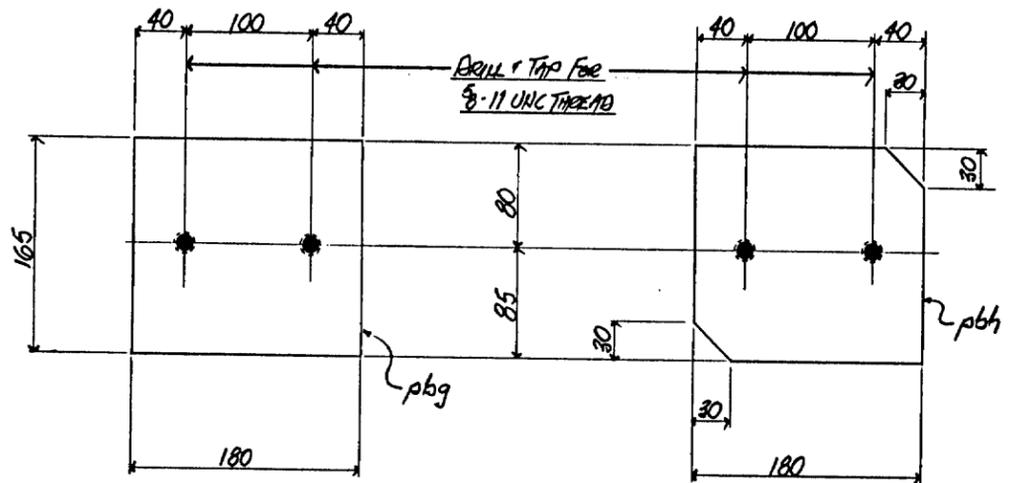
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NO PRINTS

MATERIAL BILL
BRITAIN STEEL LTD.

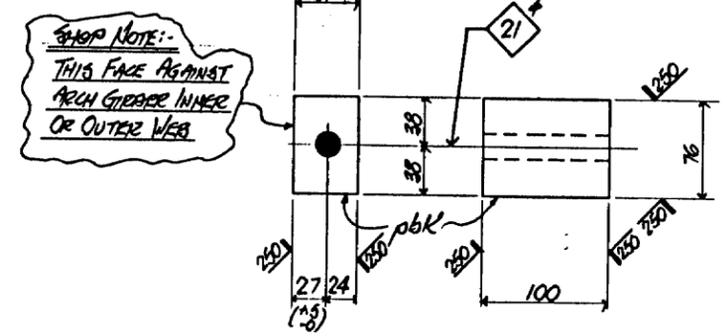
CONTRACT 1420

LINE	MARK	QTY.	SHAPE	SIZE	LENGTH	REMARKS	MATL. TYPE	UNIT	WEIGHT
1	pbg	2	R	165x19	180	(3/2)	A36		
2	pbh	6	R	165x19	180	(3/2)	A36		
3									
4	pbk	10	R	76x51	100	(MACHINE FROM 21/2)	A36		
5	pbm	5	R	90x32.1	182	(1 1/2 R)	A36		
6	pbm	5	R						
7	pbn	4	R	70x9.5	376.5	(3/2 R)	A36		
8	pbp	4	R	30x6.35	300	(1/2 R)	A36		
9									
10									
11									
12									
13									
14	pbs	4	PRO	80x6.35	300	(1/2" REOPENING 55 TO 60 DIAMETER)			
15									
16	pcK	2	R	100x16	374	(3/2 R) REAR 2 ENDS	A36		
17									
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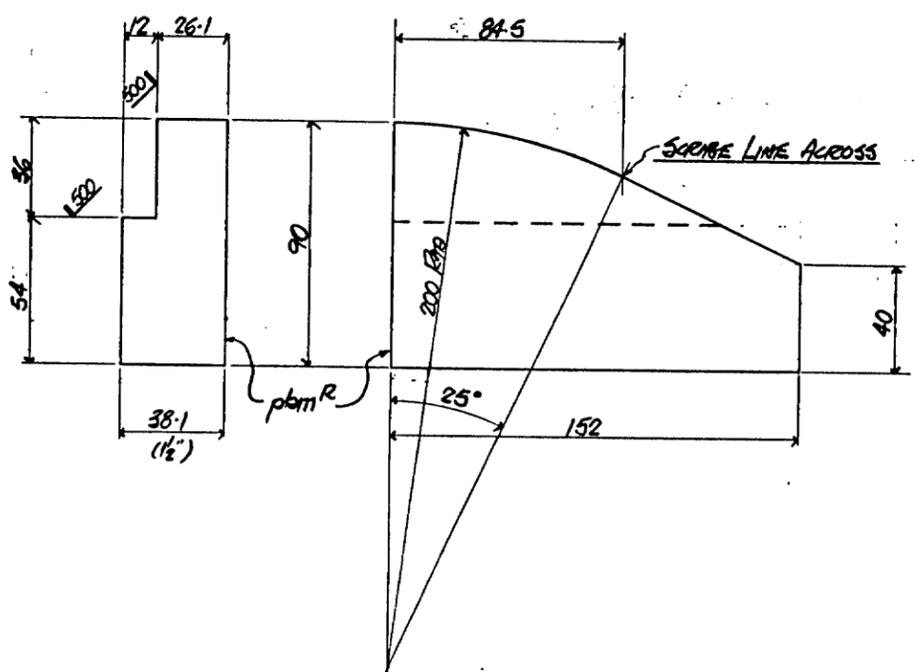


2 REQ^d THUS
STEEL LANDING SUPPORT CONNECTION R

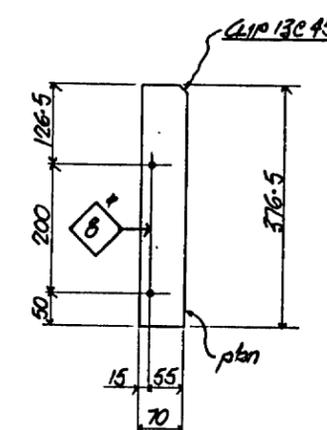
6 REQ^d THUS
STEEL LANDING SUPPORT CONNECTION R



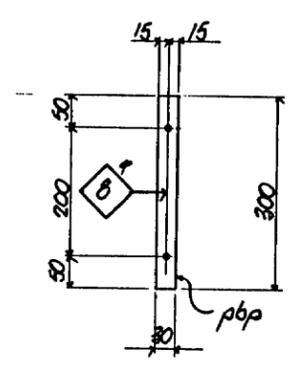
10 REQ^d THUS
SHUTTER RENE CABLE ANCHOR BLOCKS



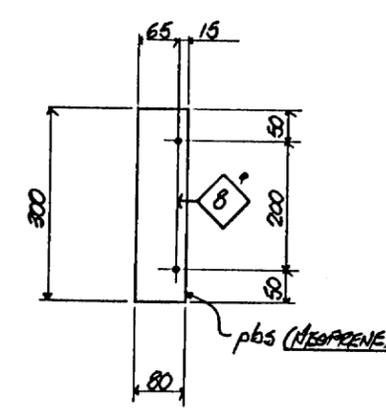
6 REQ^d AS SHOWN (FOR NORTH ARCH GIRDER)
5 REQ^d OPP. HANDS (FOR SOUTH ARCH GIRDER)
SHUTTER RENE CABLE GUIDE BLOCKS



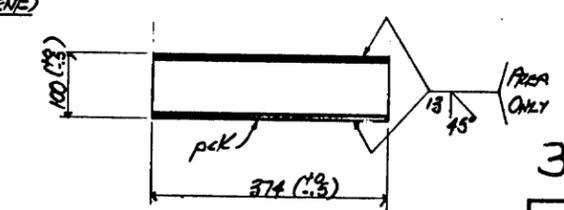
4 REQ^d THUS
SHUTTER END BEAM SUPPORT R'S



4 REQ^d THUS
SHUTTER END BEAM CLAMP BAR



4 REQ^d THUS
SHUTTER END SEALS



2 REQ^d THUS
FINNED SHIELD SEAL R'S

GENERAL NOTES

- 1.) FOR SHOP ASSEMBLY & SHOP WELDING OF ITEMS ON THIS DRAWING SEE PAGES 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55.
- 2.) USE 1/8" DRILL FOR 21" HOLES & 5/8" DRILL FOR 8" HOLES IF PREFERRED.

3R/3001151

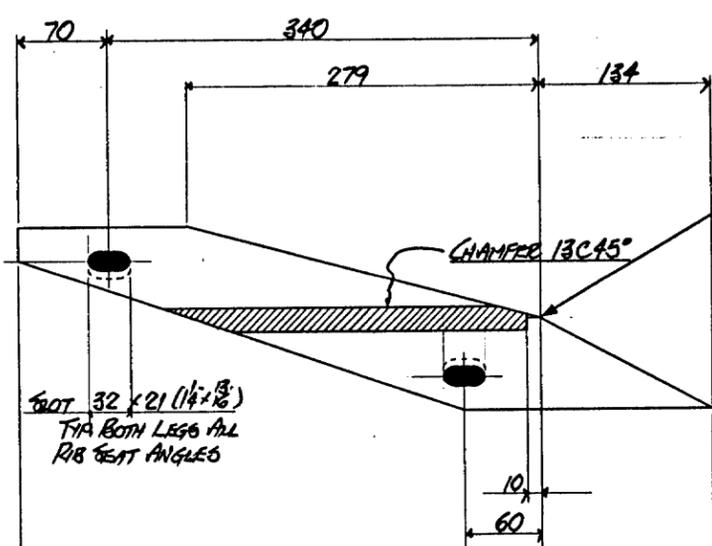
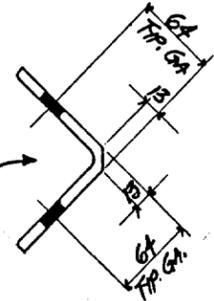
	MATERIAL	G40.21 (44W) w/n	NO.	BY	DATE	REVISION
	SURF. PREP.	SEE MEMO	DETAILS ARCH GIRDER SUB ASSEMBLY HIGH CUTTING			
	PAINT	SEE MEMO	FOR 4.2" TELESCOPE DOME LA PALMA			
	OPEN HOLES	AS NOTED				
DRAWN		DATE	CHECKED	DATE	DRAWING NO.	
RK		10/01/83			1420-366	
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.						
SHOP DEPARTMENT						

p-abcdefghijklmnpstvw

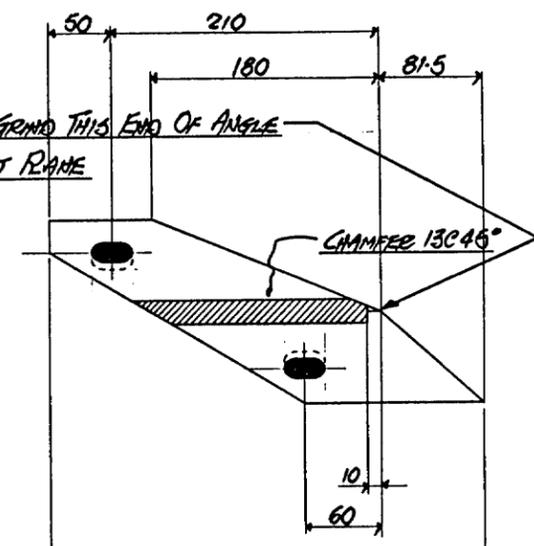
m-abcdefghijklmnpstvw

s-abcdefghijklmnpstvw

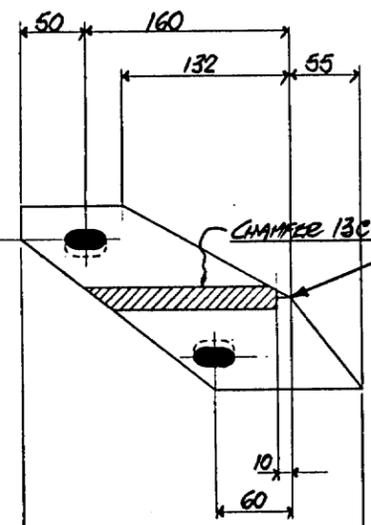
TYP END VIEW FOR ALL RIB TEST ANGLES
SHOWING GROUPE & CHAMFER DIMENS



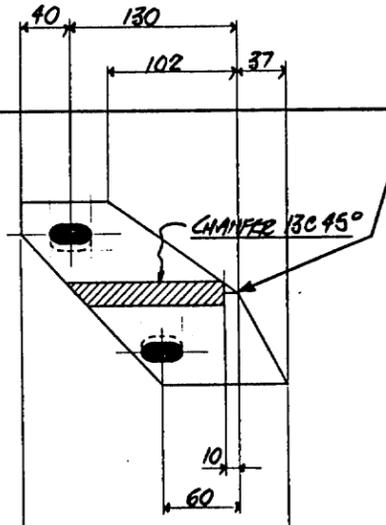
2 REQ^m mcl^e (AS SHOWN) L101.6 x 101.6 x 8 = 644
2 REQ^m mcl^t (OPP HAND)



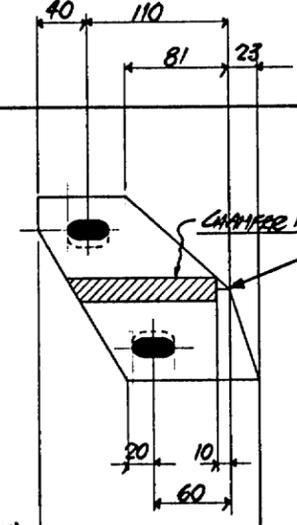
2 REQ^m mbl^e (AS SHOWN) L101.6 x 101.6 x 8 = 341.5
2 REQ^m mbl^t (OPP HAND)



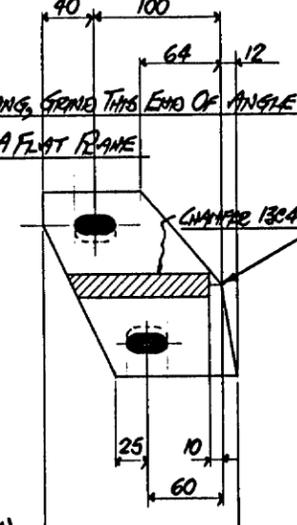
2 REQ^m mcl^e (AS SHOWN) L101.6 x 101.6 x 8 = 265
2 REQ^m mcl^t (OPP HAND)



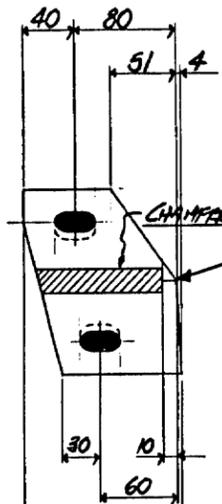
2 REQ^m md^e (AS SHOWN) L101.6 x 101.6 x 8 = 207
2 REQ^m md^t (OPP HAND)



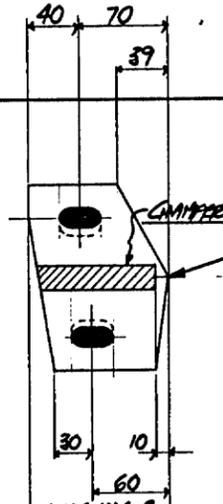
(AS SHOWN)
2 REQ^m mfl^e
2 REQ^m mfl^t (OPP HAND)
L101.6 x 101.6 x 8 = 173



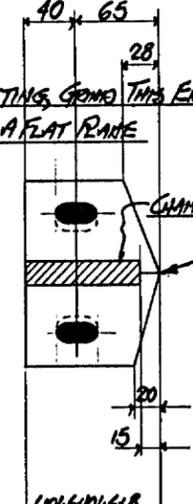
(AS SHOWN)
2 REQ^m mg^e
2 REQ^m mg^t (OPP HAND)
L101.6 x 101.6 x 8 = 152



(AS SHOWN)
2 REQ^m mh^e
2 REQ^m mh^t (OPP HAND)
L101.6 x 101.6 x 8 = 124



(AS SHOWN)
2 REQ^m ml^e
2 REQ^m ml^t (OPP HAND)
L101.6 x 101.6 x 8 = 110



(AS SHOWN)
2 REQ^m mm^e
2 REQ^m mm^t (OPP HAND)
L101.6 x 101.6 x 8 = 105

MATERIAL BILL										BRITAIN STEEL LTD.		CONTRACT 1462	
NO	MARK	QTY	SHAPE	SIZE	LENGTH	REMARKS	MATL TYPE	W	WEIGHT				
1	mcl ^e	2	L	101.6x101.6x8	644	(14.4%)	44W						
2	mcl ^t	2			644								
3													
4	mb ^e	2			341.5								
5	mb ^t	2			341.5								
6													
7	mc ^e	2			265								
8	mc ^t	2			265								
9													
10	md ^e	2			207								
11	md ^t	2			207								
12													
13	mfl ^e	2			173								
14	mfl ^t	2			173								
15													
16	mg ^e	2			152								
17	mg ^t	2			152								
18													
19	mh ^e	2			124								
20	mh ^t	2			124								
21													
22	ml ^e	2			110								
23	ml ^t	2			110								
24													
25	mm ^e	2			105								
26	mm ^t	2			105								
27													
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55													

GENERAL NOTES
1.) FOR ORIENTATION, LOCATION, & OTHER WORKING OF ITEMS ON THIS DRAWING SEE PAGES 3v & 3og

3R/3001153

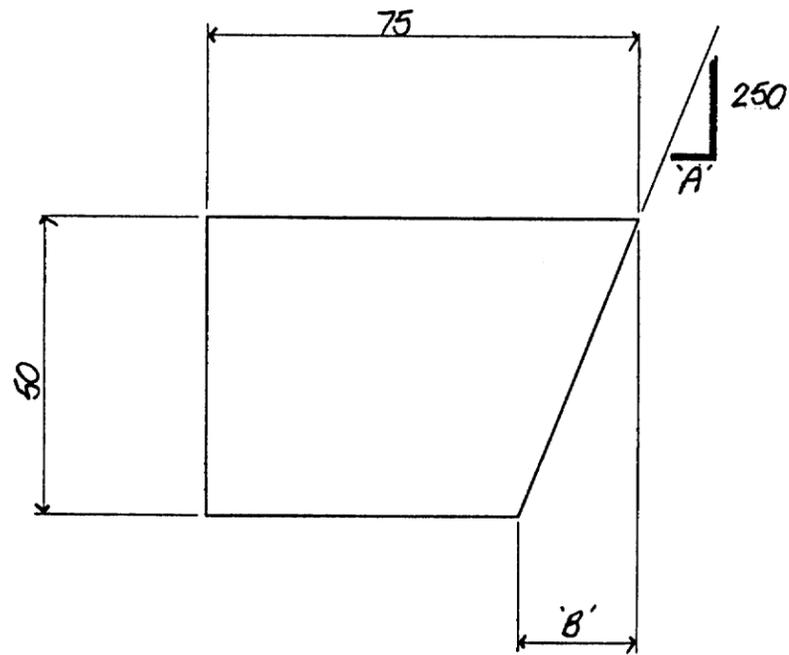
	MATERIAL	Q4021 (44W) w/n	NO	BY	DATE	REVISION
	SURF. PREP. & PAINT	SEE MEMO	DETAILS FROM CHANGES SUB 9534			
	OPEN HOLES	AS NOTED	FOR 4.2" TELESCOPE DOME			
	PRINT ON FILM	AS NOTED	LA FAYON			
DRAWN	DATE	CHECKED	DATE	DRAWING No. 1420-3bd		
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.						
SHOP DEPARTMENT						

p-abcdefghijklmnpstvw

m-abcdefghijklmnpstvw

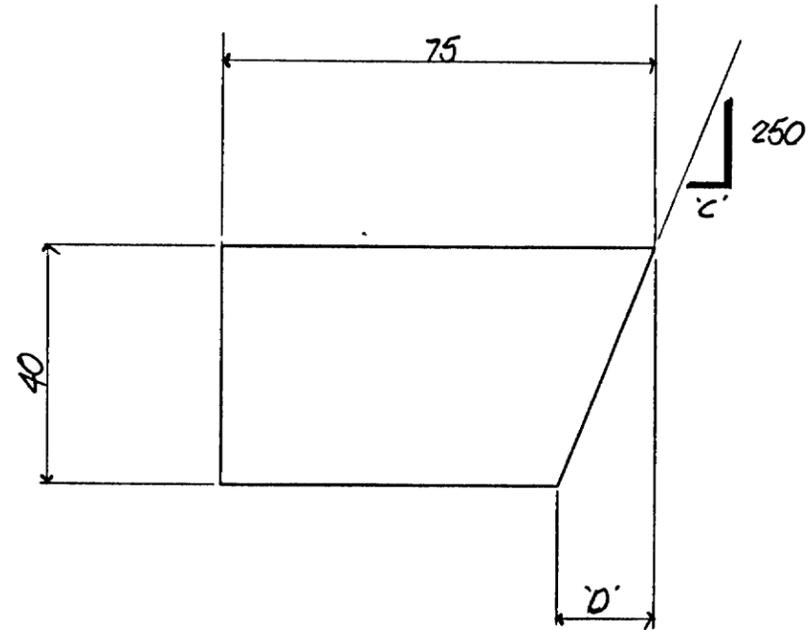
s-abcdefghijklmnpstvw

MF



INNER CHORD STRUT CONNECTION TABS
† MAIN SHELL SUPPORT TABS

ITEM MK	QUANTITY	'A'	'B'
pbv	36	102.5	20.5
pbw	12	100	20
pbx	4	97.5	19.5
pca	8	95	19
pcb	8	90	18
pcc	8	85	17
pcd	4	80	16



OUTER CHORD STRUT CONNECTION TABS

ITEM MK	QUANTITY	'C'	'D'
pcf	4	102.5	16.5
pcg	4	97.5	15.5
pch	4	80	13

GENERAL NOTES

1.) FOR SHOP ASSEMBLY † SHOP WELDING OF ITEMS ON THIS DRAWING SEE DRESS 3ab, 3ac, † 3am

LINE	SHIP	FAB	MARK	DESCRIPTION	MAT'L	FT.	INS.	R.B.	LINE	REMARKS	CUTTING INSTRUCTIONS	WEIGHT	DIVISIONS
	No. REQD.					LENGTH					SPLICING	ALLOWED	
11	4	rch											
10	4	pcg		R 40x6.35	A36	-	75			(4'R)			
9	4	pcf											
8													
7	4	pcd											
6	8	pcc											
5	8	pcb											
4	8	pca		R 50x6.35	A36	-	75			(4'R)			
3	4	pbx											
2	12	pbw											
1	36	pbv											

3R/3001155



MATERIAL G40.21 (44W) 1/2"n
 SURF. PREP. & PAINT SEE MEMO
 PRINT ON FINAL ASSEMBLY
 DRAWN RR DATE 6/27/83 CHECKED DATE

No. BY DATE REVISION
 DETAILS OF ARCH GRACES SUB ASSEMBLY ITEM CUTTING
 FOR 4.2M TELESCOPE DOME LA PALMA
 DRAWING No. 1420-359 REV.

BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.

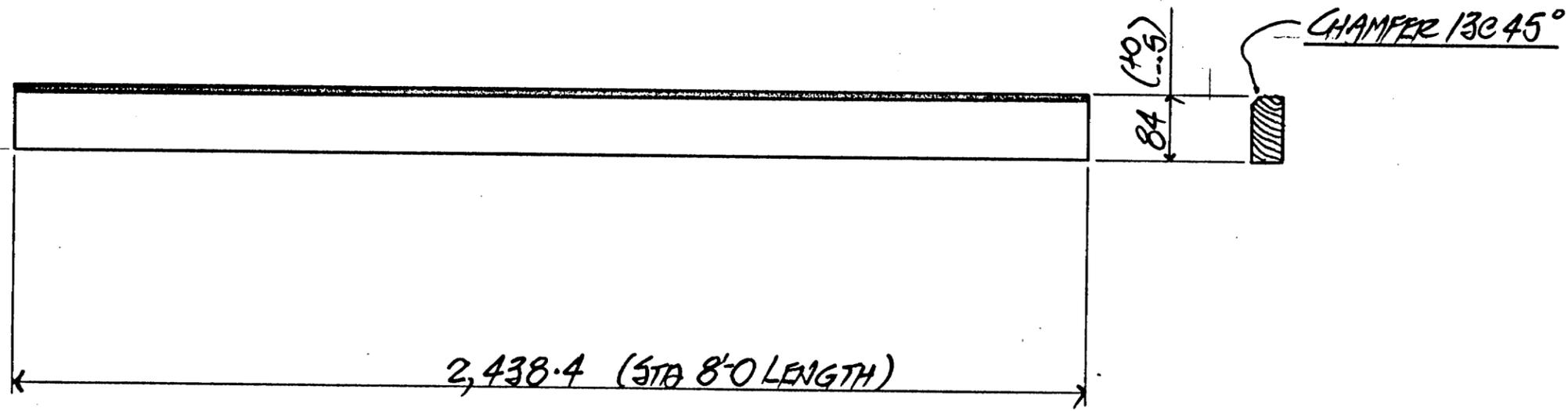
p - a b c d f g h k m n p s t v w y

m - a b c d f g h k m n p s t v w y

SHOP DEPARTMENT

INS / F / S / O / M / T / P / SH / DP / AS / PA / ER

No. PRINTS



73 REQ^d THIS

WOOD BLOCKING @ INNER EDGE OF ARCH GIRDER WEBS

CUT FROM FIR 2x4 STA GRADE OR BETTER

GENERAL NOTES

- 1.) FOR SHOP ASSEMBLY OF ITEMS ON THIS PRG SEE PRGS 3w 9 3ah.
- 2.) ALL ITEMS ON THIS PRG TO BE COATED WITH PRESERVATIVE.

3R/3001150		REVISION		CONTRACT	DWG. No.	REV.
				1420	36h	
No.	DATE	CH'KD	DATE			
10						
9						
8						
7						
6						
5						
4						
3						
2						
1						
BRITAIN STEEL LTD.		MADE IN		DATE		
NEW WESTMINSTER B.C.		BR		08/01/83		
BRITAIN		BRITAIN		CONTRACT		
NEW WESTMINSTER B.C.		NEW WESTMINSTER B.C.		1420		
				DWG. No.		
				36h		
				REV.		



NORTH ARCH GIRDER SHOP ASSEMBLY PROCEDURE

CONTINUED FROM DRG 31k.

- 26.) DRILL & TAP INNER WEB FOR CABLE TROUGH & GUIDES AS PER DRGS 5a, 5b, & 5c.
- 27.) LAYOUT & DRILL 21° (13/16") HOLES ALONG INNER EDGE OF OUTER FLG R' PRI AS PER DRG 3b.
- 28.) FIT & WELD SHUTTER BUMPER SUPPORT R'S (paw^r) & FIXED SHIELD SEAL R (pck) TO DETAIL 'ABR' (SEE DRG 3p)
- 29.) FIT & WELD DRIVE CABLE ANCHOR BLOCK (pbt) TO DETAIL 'ABR' (SEE DRG 3p)
- 30.) FIT & WELD ERECTION BEAM CONNECTION ASSEMBLIES (pog, pah, & pak) TO DETAIL 'N' (SEE DRG 3m)
- 31.) FIT & WELD END SUPPORT BEAM CONNECTION R'S (pam^r & pan) TO DETAIL 'SR' & LAYOUT & DRILL 21° (13/16") HOLES (SEE DRG 3m)
- 32.) FIT & WELD TEMPORARY BRACE FRAME CONNECTION R'S (pap, pas^r, & pat) TO DETAIL 'AAR' (SEE DRG 3n)
- 33.) FIT & WELD WALKWAY HANGER R'S, (pay, pba, & pbb) WALKWAY STRINGER R'S, (pbc) & LARGER STRUT R'S (pbd & pbf) TO DETAILS 'AC', 'AD', 'AF', 'AG', 'AH', & 'AK' (SEE DRGS 3h & 3p)
- 34.) DRILL & COUNTERSINK 11° (16") WOOD HOLES @ 30" (±) SPACING ALONG INNER EDGE OF INNER WEB (11,807R10) AS PER DRG 3b.
- 35.) ATTACH WOOD BLOCKING TO INNER WEB AS PER DRG 3w, & MEASURE & RECORD ERECTION BEAM ASSY DIMS AS NOTED ON DRG 3a.
- 36.) UNBOLT ARCH GIRDER INTO SECTIONS, FLIP OVER GENTLY, RE-ALIGN ON JIG, & RE-BOLT @ SPICES.
- 37.) SCRIBE VERTICAL LINES AS CALLED FOR ON DRG 3a & FIT & WELD MAIN SHELL RIB SEATS AS SHOWN ON DRG 3v.
- 38.) FIT & WELD SEAL HOLDER ANGLES, (mp, ms^r, mt^r, & mvr) & END SEAL SUPPORT R'S (pan) AS SHOWN ON DRG 3w.
- 39.) ATTACH END SEALS (pas) & CLAMP BARS (pab) WITH BOLTS L5 AS SHOWN ON DRG 3w.
- 40.) LAYOUT & CUT SLOTS IN OUTER FLG & FIT & WELD CABLE GUIDES (pam^r) & ANCHOR BLOCKS (pbk) AS PER DRG 3a.
- 41.) FIT & WELD MAIN SHELL SUPPORT TABS, (pbv, pbw, pca, pcb, & pcc) INNER CHORD STRUT CONN. TABS, (pby, pbz, & pcd) & OUTER CHORD STRUT CONN. TABS (pcf, pcg, & pch) AS SHOWN ON DRGS 3ab & 3ac.
- 42.) ATTACH WOOD BLOCKING TO OUTER WEB AS PER DRG 3w.
- 43.) UNBOLT ARCH GIRDER INTO SECTIONS, PRIME COAT TO PMI, & SET ASIDE FOR SHIPMENT

NORTH ARCH GIRDER COMPLETED

3R/3001158

No. DIV.	1	2	3	4	5	6	7	8	9	10
	DATE									
MADE										
DATE										
CHK'D										
DATE										
BRITAIN STEEL LTD. B.C.										
NEW WESTMINSTER										
REVISION										
CONTRACT										
DWG. No.										
REV.										



MT

SOUTH ARCH GIRDER SHOP ASSEMBLY PROCEDURE (ALL ITEMS ASSUMED TO BE FABRICATED AS PER STEP 1.) ON DRG 3bK

- 1.) LOCATE OUTER WEB R'S $pg^R, pc, pd^L, \& pf^L$ ON LEVEL JIG (WITH BRICE JOINTS BUTTING TIGHT) & SECURE R'S TO JIG. OBSERVE ORIENTATION OF REFERENCE AXIS.
- 2.) DRILL 9.5° ($\frac{3}{8}^\circ$) LOCATION HOLES AS PER DRG 3d & MARK F'S OF OUTER EDGE FOR VERTICAL E'S.
- 3.) DRILL 11° ($\frac{7}{16}^\circ$) WOOD HOLES @ 3° SPACING ALONG INNER EDGE (11,807 R/A) AS PER DRG 3d.
- 4.) LAYOUT & DRILL HOLES TO DETAIL AB^R IN OUTER WEB. (SEE DRG 3p)
- 5.) FIT & TACK WELD ALL DIAPHRAGMS TO DETAILS 'A', 'C', 'D', 'F', 'G', 'H', 'M', 'T', 'V', & 'W'. (SEE DRGS 3h, 3k, 3m, & 3n)
- 6.) FIT INNER & OUTER FLG R'S. (MAINTAIN 3 MIN. ROOT GAP AT BRICE JOINTS)
- 7.) COMPLETELY WELD ALL DIAPHRAGMS.
- 8.) PRIME COAT INSIDE OF GIRDER WITH "RUSTBOND 8HB" AS CALLED FOR ON PAINT MEMO P.M.I.
- 9.) TACK WELD INNER WEB R'S $pg^R, ph, pk^L, \& pm^L$ IN POSITION. (WITH BRICE JOINTS BUTTING TIGHT)
- 10.) USING DRILLING TEMPLATE DT11 (SEE DRG 3bC) DRILL HOLES @ DIAPHRAGMS TO DETAILS 'A', 'C', 'D', 'F', 'G', 'H', 'M', 'V', & 'W'. (SEE DRGS 3h, 3k, 3m, & 3n)
- 11.) USING DRILLING TEMPLATE DT10 (SEE DRG 3bC) DRILL HOLES IN WEB TO DETAIL T^L. (SEE DRG 3n)
- 12.) LAYOUT & DRILL HOLES @ DIAPHRAGMS TO DETAIL T^L. (SEE DRG. 3n)
- 13.) REMOVE INNER WEB R'S & WELD STIFFENER ANGLES 'm' TO F'S FACE OF INNER WEB R'S $pg^R, pk^L, \& pm^L$ TO DETAIL 'P'. (SEE DRG 3m)
- 14.) TACK WELD NUTS 'n' TO DIAPHRAGMS TO DETAILS 'A', 'C', 'D', 'F', 'G', 'H', 'M', 'T', 'V', & 'W'. (SEE DRGS 3h, 3k, 3m, & 3n)
- 15.) TACK WELD NUTS TO F'S FACE OF INNER WEB R' pk^L @ HOLES DRILLED WITH DT10 TO DETAIL T^L. (SEE DRG 3n)
- 16.) PRIME COAT F'S FACE OF INNER WEB R'S $pg^R, ph, pk^L, \& pm^L$ WITH "RUSTBOND 8HB" AS CALLED FOR ON PAINT MEMO P.M.I.
- 17.) REPLACE INNER WEB R'S $pg^R, ph, pk^L, \& pm^L$ & COMPLETELY BOLT WITH BOLTS 'b1' & 'b2' @ ALL DIAPHRAGMS.
- 18.) LAYOUT & DRILL HOLES TO DETAIL AB^R IN INNER WEB. (SEE DRG 3p)
- 19.) SEAL WELD INNER FLG TO INNER & OUTER WEBS. (SIMULTANEOUSLY TO PREVENT WARPING)
- 20.) SEAL WELD OUTER FLG TO INNER & OUTER WEBS. (SIMULTANEOUSLY TO PREVENT WARPING)
- 21.) USING DRILLING & LOCATING TEMPLATE LT1, LOCATE & TACK WELD RIB CONN. R'S (paa), DRILL HOLES WITH LT1 & DRILL HOLES TO LAYOUT AS SHOWN
- 22.) COMPLETE WELDING OF RIB CONN. R'S (paa) & TAP HOLES FOR 3/8-16 UNC THREAD AS SHOWN ON DRG 3ad. ON DRG 3ad.
- 23.) LAYOUT & CUT SLOTS IN OUTER FLG & FIT & WELD CABLE GUIDES (pam^L) & ANCHOR BLOCKS (pak) AS PER DRG 3af.
- 24.) DRILL & TAP INNER WEB FOR WIND SCREEN GUIDES AS PER DRGS 4c & 4d.
- 25.) DRILL & TAP INNER WEB FOR CABLE TROUGH & GUIDES AS PER DRGS 5b, 5c, & 5d.

CONTINUED ON DRG 3bD

No.	DIV.	1	2	3	4	5	6	7	8	9	10	DATE	CH'KD	DATE	MADE	BY	BRITAIN STEEL LTD. NEW WESTMINSTER B.C.	BRITAIN
													REVISION	CONTRACT	DWG. No.	REV.		
													3R/3001159	1420	367A	1		

SOUTH ARCH GIRDER SHOP ASSEMBLY PROCEDURE

CONTINUED FROM PAGE 367

- 26.) LAYOUT & DRILL 21° (13/16") HOLES ALONG INNER EDGE OF OUTER FLG R' AS PER DRG 3F.
- 27.) FIT & WELD SHUTTER BUMPER SUPPORT R'S (pawr) & FIXED SHIELD SEAL R (pck) TO DETAIL 'ABR'. (SEE DRG 3P)
- 28.) FIT & WELD ORNE CABLE ANCHOR BLOCK (pbt) TO DETAIL 'AB': (SEE DRG 3P)
- 29.) FIT & WELD ERECTION BEAM CONNECTION ASSEMBLIES (pag, pah, & pak) TO DETAIL 'N'. (SEE DRG 3M)
- 30.) FIT & WELD END SUPPORT BEAM CONNECTION R'S (pam' & pan) TO DETAIL 5' & LAYOUT & DRILL 21° (13/16") HOLES. (SEE DRG 3M)
- 31.) FIT & WELD TEMPORARY BRACE FRAME CONNECTION R'S (pap, pas', & pat) TO DETAIL 'AA': (SEE DRG 3N)
- 32.) DRILL & COUNTERSINK 11° (1/16") WOOD HOLES @ 3" (±) SPACING ALONG INNER EDGE OF INNER WEB (11,807RAD.) AS PER DRG 3F.
- 33.) ATTACH WOOD BLOCKING TO INNER WEB AS PER DRG 3ah, & MEASURE & RECORD ERECTION BEAM ASSY DIMS AS NOTED ON DRG 3d.
- 34.) UNBOLT ARCH GIRDER INTO SECTIONS, FLIP OVER GENTLY, RE-ALIGN ON JIG, & RE-BOLT @ BRACES.
- 35.) SCRIBE VERTICAL LINES AS CALLED FOR ON DRG. 3d & FIT & WELD MAIN SHELL RIB SEATS AS SHOWN ON DRG 3ag.
- 36.) FIT & WELD SEAL HOLDER ANGLES (mp, ms', ml', & mv') & END SEAL SUPPORT R'S (pan) AS SHOWN ON DRG 3ah.
- 37.) ATTACH END SEALS (pbs) & CLAMP BARS (pbp) WITH BELTS 1/5 AS SHOWN ON DRG 3ah.
- 38.) LAYOUT & CUT SLOTS IN OUTER FLG & FIT & WELD CABLE GUIDES (pam') & ANCHOR BLOCKS (pak) AS PER DRG 3ak.
- 39.) FIT & WELD MAIN SHELL SUPPORT TABS, (pav, pav, pca, pcb, & pcc) INNER CHORD STRUT CONN. TABS, (pav, pav, & pcd) & OUTER CHORD STRUT CONN. TABS (pcf, pcg, & pch) AS SHOWN ON DRGS 3ac & 3am.
- 40.) ATTACH WOOD BLOCKING TO OUTER WEB AS PER DRG 3ah.
- 41.) UNBOLT ARCH GIRDER INTO SECTIONS, PRIME COAT TO PMI, & SET ASIDE FOR SHIPMENT.

SOUTH ARCH GIRDER COMPLETED

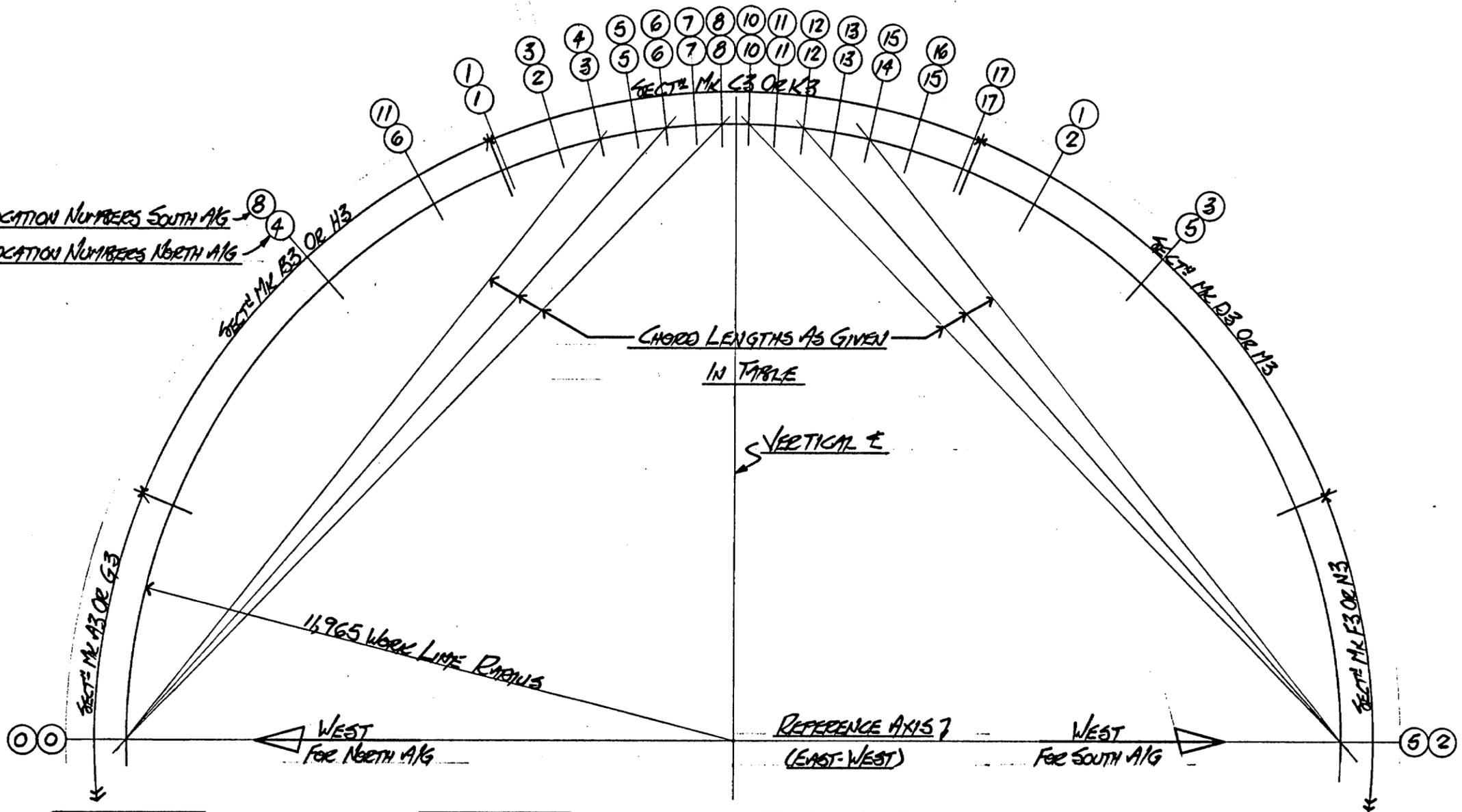
3R/3001160

REVISION	CONTRACT	DWG. No.	REV.
DATE	1420	36p	REV.
NO. BY			

10	DATE
9	CH/KD
8	DATE
7	Oct/83
6	MADE BY
5	RZ
4	BRITAIN STEEL LTD.
3	NEW WESTMINSTER B.C.
2	
1	
NO. DIV.	



LOCATION NUMBERS SOUTH A/G
 LOCATION NUMBERS NORTH A/G



SECT ⁿ MK		CHORD LENGTH
B3	H3	
(4)	(8)	9,753.5
(6)	(11)	12,050.5

LOCATION NUMBER	SECT ⁿ MK		CHORD LENGTH
	C3	K3	
(1)	(1)	13,372.0	
(2)	(3)	14,270.0	
(3)	(4)	14,944.0	
(5)	(5)	15,486.5	
(6)	(6)	15,947.5	
(7)	(7)	16,357.5	
(8)	(8)	16,737.5	
(10)	(10)	16,737.5	
(11)	(11)	16,357.5	
(12)	(12)	15,947.5	
(13)	(13)	15,486.5	
(14)	(15)	14,944.0	
(15)	(16)	14,270.0	
(17)	(17)	13,372.0	

SECT ⁿ MK		CHORD LENGTH
D3	M3	
(2)	(1)	12,050.5
(5)	(3)	9,753.5

GENERAL NOTES
 1) SEE PAGES 30 & 31 FOR DETAIL LOCATION TABLE

3R/3001161

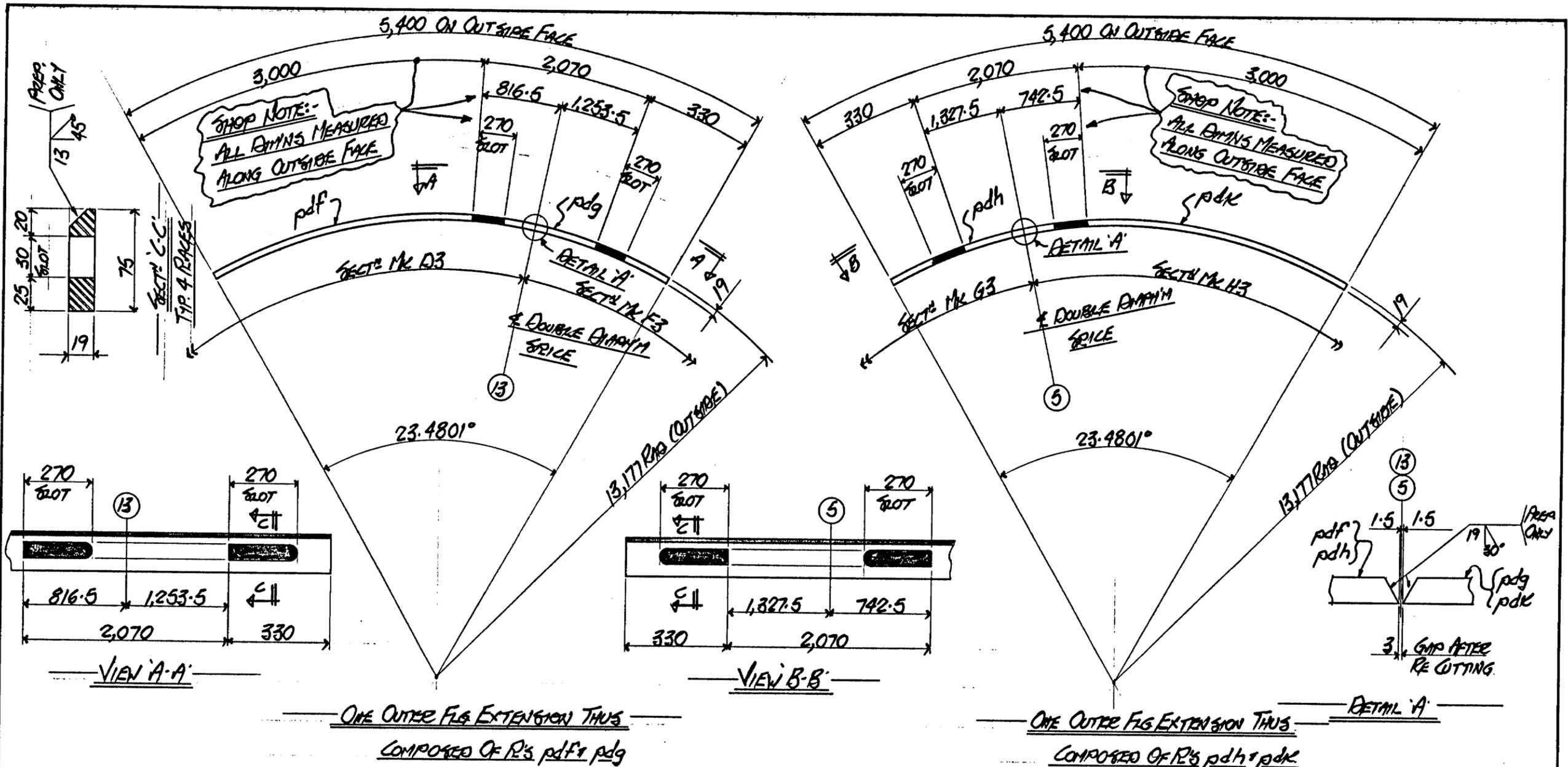
	No. BY DATE REVISION DETAILS OF <u>DETAIL LOCATION</u> <u>CHORD LENGTHS</u>		
	FOR <u>4.2" TELESCOPE DOME</u> <u>1st FLOOR</u>		
	DRAWN <u>RJR</u> DATE <u>FEB/81</u> CHECKED DATE DRAWING No. <u>1420-365</u> REV. <u>1/W</u>	No. PRINTS	
	BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.		

p - a b c d f g h k m n p s t v w y

m - a b c d f g h k m n p s t v w y

SHOP DEPARTMENT

INS / F / S / O / M / T / P / SH / DP / AS / PA / ER



PROCEDURE

- 1) CUT 2 R'S 75-19x5,400.
- 2) PREP EDGE AS SHOWN IN SECT'S C-C.
- 3) ROLL TO RADIUS
- 4) LAYOUT & BURN 270x30 SLOTS AS SHOWN.
- 5) RE-CUT & PREP AS PER DETAIL 'A'.
- 6) WELD TO INNER EDGE OF ARCH GIRDER OUTER FIG AS SHOWN ON DRESS 3t & 3af

3R/3001163

LINE	SHIP	FAB	MARK	DESCRIPTION	MAT'L	FT.	INS.	R.D.	LINE	REMARKS	CUTTING INSTRUCTIONS	WEIGHT	DIVISIONS
	No.					LENGTH					SPLICING	ALLOWED	
7													
6													
5													
4													
3				ONE R 75-19	44W	5,400				(3R) ROLL & CUTS pdh & pdk			
2										(PREP) EDGE			
1				ONE R 75-19	44W	5,400				(3R) CUTS pdh & pdk			

BRITAIN

MATERIAL G40.21 (44W) 1/2" No. BY DATE REVISION

SURF. PREP. & PAINT SEE MEMO

OPEN HOLES SLOTS AS SHOWN

POINT ON FINAL ASSEMBLY

DRAWN DATE CHECKED DATE

FOR 4.2" TELESCOPE DOME LA PALMA

DRAWING No. 1462-36v

BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.

INS / F / S / O / M / T / P / SH / DP / AS / PA / ER

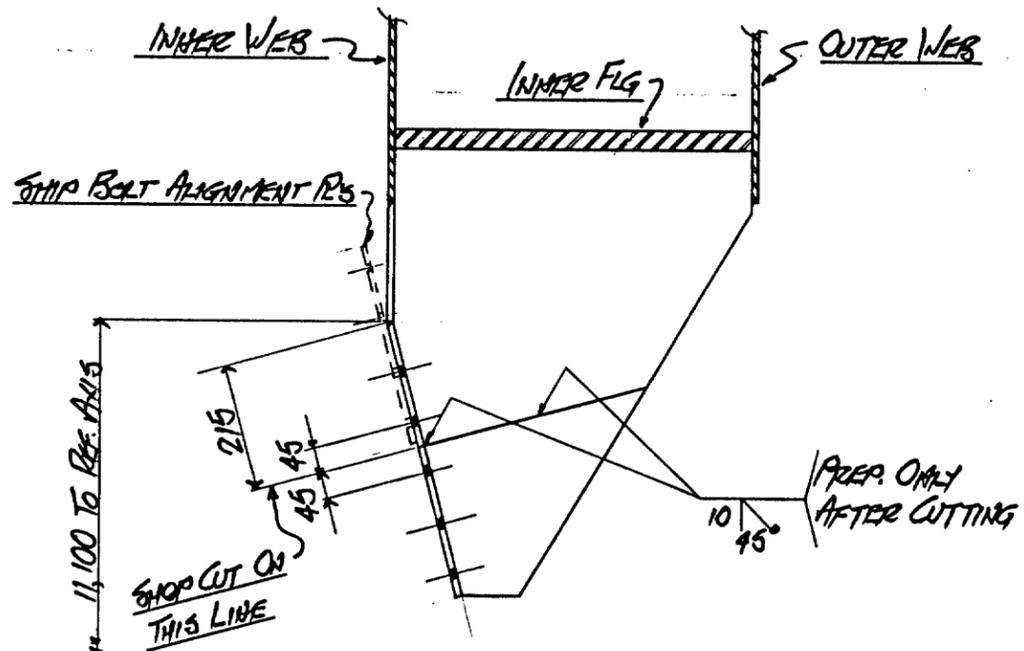
No. PRINTS

p - a b c d f g h k m n p s t v w y

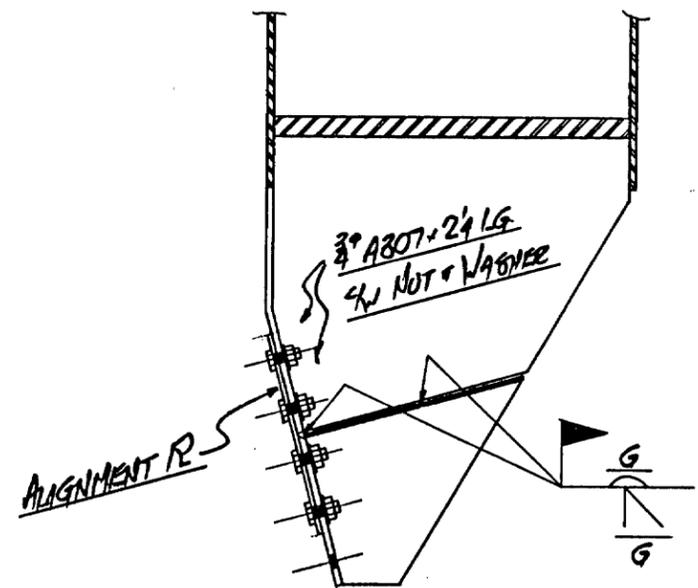
m - a b c d f g h k m n p s t v w y

SHOP DEPARTMENT

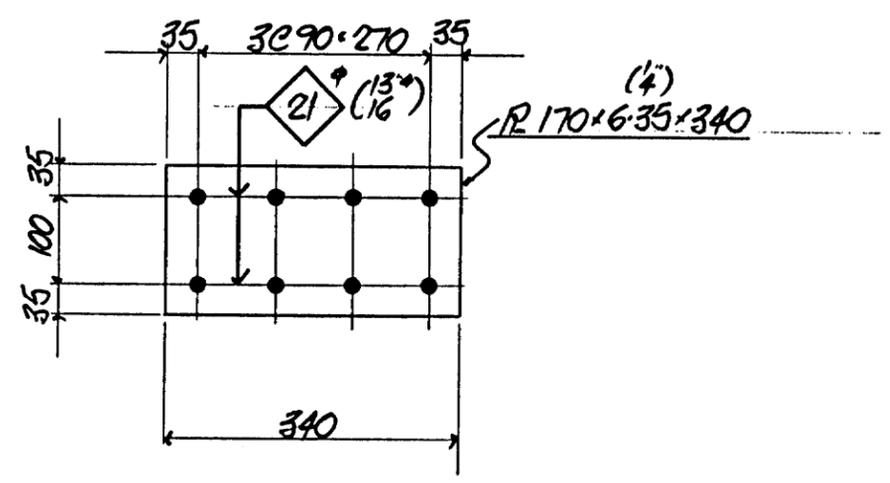
MF



DETAIL AAR ON Dwg 311
 ADDITIONAL SHOP WORK TO ARCH GIRDER
 SECTIONS MK C3+K3 DUE TO PROJECTING
 BEYOND MAX. SHIPPING WIDTH OF 2,350



FIELD WORK TO SAME AFTER
 REMOVAL FROM CONTAINERS



2 REQ^d ALIGNMENT R'S

3R/3001164

	MATERIAL	A36	No. BY DATE REVISION			
	SURF. PREP. & PAINT	NONE	DETAILS OF ARCH GIRDERS SHOP & FIELD WORK TO HANGERS			
	OPEN HOLES	AS NOTED	FOR 4.2M TELESCOPE ROPE LA PALMA			
	DRAWN	DATE	CHECKED	DATE	DRAWING No.	REV.
	BR	AP/84			1420-36w	MF
BRITAIN STEEL LTD. 401 SALTER AVENUE, NEW WESTMINSTER, B.C.						
SHOP DEPARTMENT						No. PRINTS

p - a b c d f g h k m n p s t v w y

m - a b c d f g h k m n p s t v w y