10472-96 important Notice: Any and all designs, plans, drawings, specifications, advice relative to geological and safety conditions, and all other technical and engineering services which we may have furnished or may hereafter furnish with reference to this matter or the project to which it relates are furnished solely for your review and approval and the review and approval of your engineers. We make no representation or warranty with respect to the accuracy or sufficiency of any of such documents, advice or services, nor shall we have any liability of any kind or nature with respect hereto, whether or not so reviewed and approved by you and your engineers. GENERAL NOTES AND TOLERANCES: Unless otherwise noted, the following notes and tolerances apply to the fabrication 3 — FABRICATION TOLERANCES. of the products called for on this drawing. (a) Chord out to out of butt and/or foot plates measured on centerline of rib to 1 - NOTE: Reference made to mill rolling tolerances below are those tolerances for be within plus or minus 1/4" of theoretical length. structural shapes and plates as specified in ASTM Spec. A6. (b) Face of butt or foot plates after welding to be within plus or minus $\frac{1}{6}$ of 2 - BENDING TOLERANCES. theoretical plane. Any burrs or ragged edges on connection plates caused by cutting or punching shall be turned toward the rib segment in assembly. RISE (a) Rib segment assembly shall conform to true template at ends within tolerances stated below. Rib between end plates may depart from true (c) Gap between ends of beams and butt or foot plates prior to welding shall not exceed 1/6" for at least 75% of the cross-sectional area of the beam. Where template plus or minus 1/4" provided no point shall depart more than 1/4" in any 3 ft. gage length. The rib shall be of uniform contour. gaps are in excess of 1/4", they shall be filled by additional welding. (b) Flanges shall be true to shape within established mill rolling tolerances (d) Tie rod holes in web of rib segments may be distorted and out of round due except that after bending, the outer flange will be permitted to droop 1/6" to piercing before bending, however, tie rods shall pass freely through the holes. Pairs of tie rod holes shall lie within plus or minus %" of dimensions maximum toward the inner flange for all radii of bend which are 14 times the beam depth or greater. " maximum droop will be permitted for radii of bend which are less than 14 times the beam depth. Permissible flange droop (e) Mill rolling tolerances to apply to width of mill edge plates. Width or length will be in addition to any flange deviation, allowed within mill rolling of sheared plates to be within plus or minus 1/6" of theoretical dimensions. (c) The web shall be true within established mill rolling tolerances being free of (f) Center to center of hole dimensions on butt or foot plates to be held within cracks and wrinkles. Where radii of bend are 14 or more times the beam plus or minus 3/4" depth, buckling of the web for a distance of 1/2 the beam depth from each (g) Groups of holes in butt plates after assembly shall lie within 1/6" of correct end will be permitted where deviation from flat does not exceed plus or location irrespective of the variations which may exist in the beam as a result minus 1/2". Where radii of bend are less than 14 times the beam depth, of allowable tolerances. buckling of the web for a distance equal to the beam depth from each end will be permitted where deviation from flat does not exceed plus or minus (h) Camber and sweep permitted in straight structural members not to exceed mill rolling tolerances. (d) Depth of beam at web after bending can be a maximum of 1/2" less than the 4 - WELDING. nominal depth. (a) All welds 1/4" minimum fillet welds unless otherwise noted. (e) Sweep in beams between end plates will be permitted within established (b) Welding shall conform to the applicable provisions of the American Welding mill rolling tolerances. Society's Structural Welding Code AWS D1.1 NK2A 40 MELD BEYOND BACK OF RIB 7'-0" RAD. TO -In OUTSIDE OF RIB N BUTT PLATE DETAIL 1200 0 U SYM ABT 497 530 1300 T.L. NUTS 437 500 1320 3-4AAB-002 550 061 3206 2B 7 3/8" × 4 /2" × 6" BUTT PLATES 142.5 EXTEN45 MAX 10 = x 14'-3 MN.A. 444.9 [48.3] 025 1221 2A 3 KING DEGMENT HSSYS. EA. CONSISTS OF! DRAWING NO. MARK NO. NO. REQ'D. PART NO. WT. WT. DESCRIPTION MATL SPEC. TOTAL WT. FOR _____COURSE MATL. REOD. PER RING Shoft Funnel lines YOUNGSTOWN, OHIO 44501 U.S.A., PHONE 216 746-8011 3-PC. RING & M4 X 10# M4 × 10 # 14'-0"0 URLING #3 MINE URLING COAL HAULAGE ENTRY REPCOAL CO. SHELOCTA, PA. NATIONAL MINE SERVICE CO. DATE 3-24-75 DR. BY RUA CH. BY 3-24 SCALE AS NOTED UTT R WA KN RJA SCALE: COP REV. DATE CHG. BY REVISION CH. BY D.R. NO. WG/15-059-4AAB-002 APPROVE PRINT IN FILE DATED 4/2/15 PER REV "1 DATED 4/9/75 MC-90-74 IMAPS # 09064