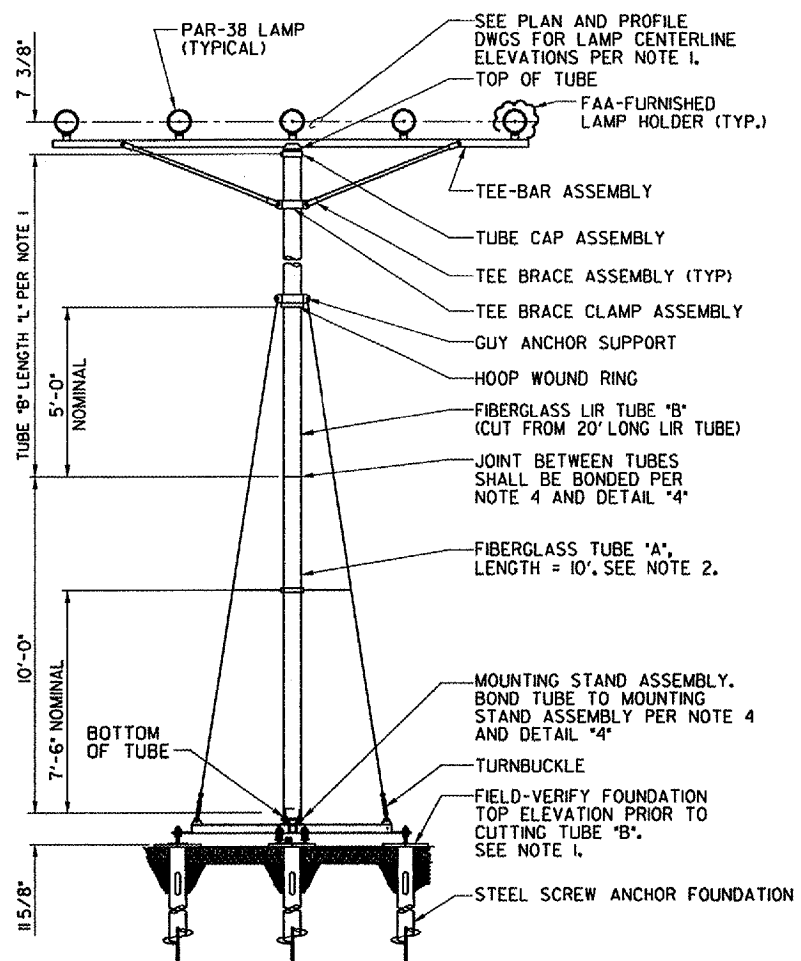


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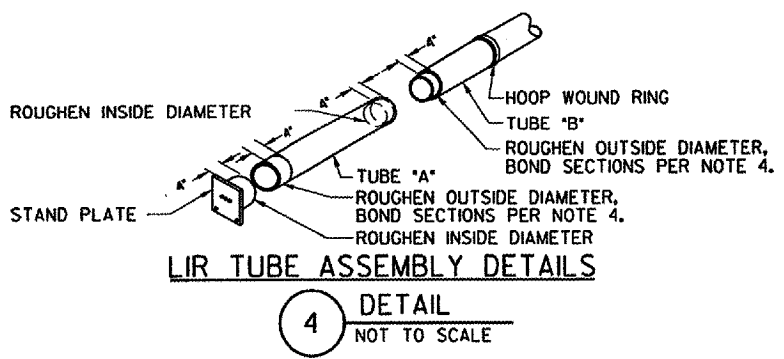


**ELEVATION
MALSR STEADY-BURNING LIGHT
BAR ON MG-30 LIR STRUCTURE**

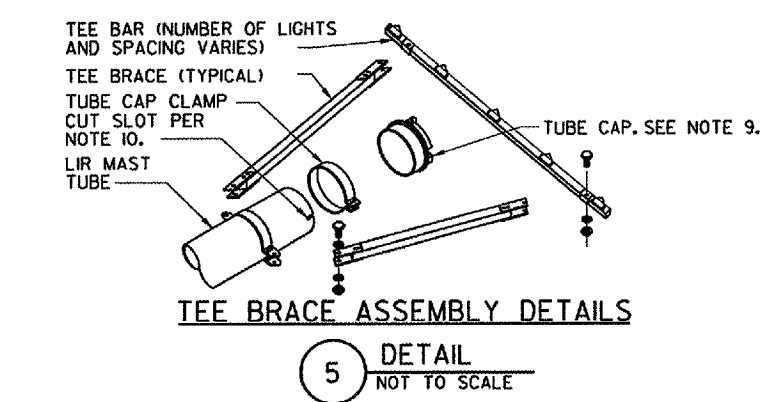
1 DETAIL
NOT TO SCALE

NOTES:

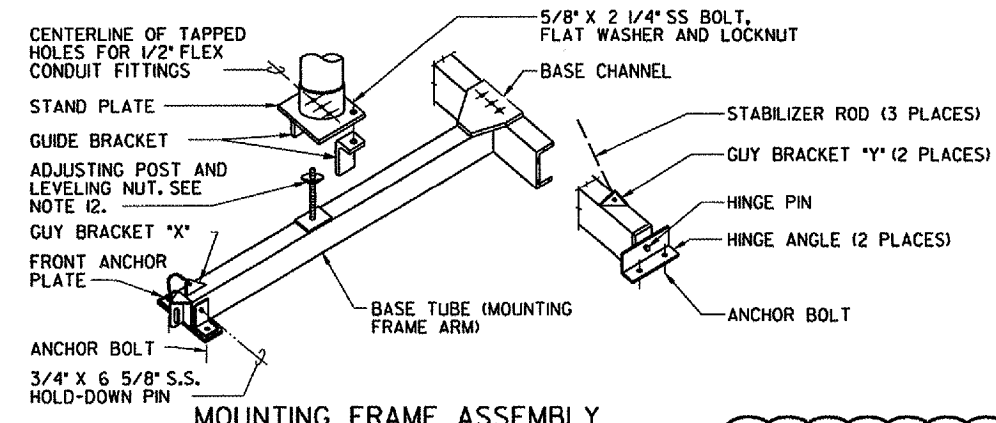
- THE CONTRACTOR SHALL ESTABLISH TOP OF FOUNDATION ELEVATION PER PLAN AND PROFILE DWGS. FOR EACH LIR TOWER PER LIGHT STATION, THE CONTRACTOR SHALL FIELD-VERIFY THE ACTUAL FOUNDATION TOP ELEVATION PRIOR TO CUTTING LIR TUBE 'B'. THE CONTRACTOR SHALL DETERMINE THE REQUIRED TUBE 'B' LENGTH 'L' AS FOLLOWS:
FOR MALSR STEADY-BURNING:
L = LAMP Q ELEVATION - FOUNDATION TOP ELEVATION (FIELD-VERIFIED) - TUBE 'A' LENGTH - 1.6 FT.
FOR RAIL FLASHER:
L = LAMP Q ELEVATION - FOUNDATION TOP ELEVATION (FIELD-VERIFIED) - TUBE 'A' LENGTH - 1.9 FT.
- CUT TUBE LENGTH FROM THE 20 FOOT TUBE 'A' STOCK AS REQUIRED, USING A TABLE SAW WITH A DIAMOND OR CARBIDE ABRASIVE BLADE. ALL SAW CUTS SHALL PERPENDICULAR TO THE TUBE AXIS. DEBURR CUT EDGES.
- USE EMERY CLOTH TO ROUGHEN THE SURFACES TO BE BONDED TO THE STAND PLATE PER DETAIL '4'. CLEAN THE ROUGHENED SURFACES WITH A SOLVENT (TRICHLOROETHYLENE, ACETONE, OR METHYL ETHYL KETONE).
- CONTRACTOR SHALL BOND EACH JOINT BY SPREADING A LIGHT COAT OF MIXED ADHESIVE ON BOTH SURFACES TO BE BONDED. SLOWLY SLIDE THE TUBE ONTO THE STAND PLATE, WHILE ROTATING IT TO EXCLUDE AIR. THE BONDING ADHESIVE MATERIALS, 2-PART EPOXY, FUSOR 304-1 RESIN AND 304-2 HARDENER, FUSOR 304-1 AND 304-2 ARE AVAILABLE FROM LORD CORP CHEMICAL PRODUCTS GROUP, ERIE PA. FOR BEST RESULTS, THE ADHESIVE SHOULD BE MIXED AND CURED IN AIR TEMPERATURES ABOVE 67°F. CURING IS COMPLETE AFTER 48 HOURS. FOLLOW MANUFACTURER'S INSTRUCTIONS.
- ASSEMBLE LIR STRUCTURES IN HORIZONTAL POSITION PER DETAIL '7'. INSERT HINGE PINS WHICH ARE ATTACHED TO BASE CHANNEL, INTO LEFT AND RIGHT ANCHOR PLATES. PLACE THE FRONT, THE LEFT, AND THE RIGHT ANCHOR PLATES OVER THE 3/4" ANCHOR BOLTS. CONNECT BASE TUBE TO BASE CHANNEL, MAKING SURE MOUNTING FRAME ASSEMBLY SWINGS FREELY ON HINGE PINS. SECURE ANCHOR PLATES TO FOUNDATION AND RAISE MOUNTING FRAME ARM TO VERTICAL (VERIFY). ATTACH THE GUY ANCHOR SUPPORT ABOVE THE HOOP WOUND RING. ATTACH STABILIZER RODS TO THREE GUY ANCHOR ENDS. BOLT TWO GUIDE BRACKETS TO BOTTOM OF MAST STAND PLATE WITH THE 5/8" X 2 1/4" STAINLESS STEEL BOLTS AND NUTS. DO NOT TIGHTEN. POSITION STAND PLATE WITH TAPPED HOLES ALIGNED PER DETAIL '6'. SET STAND PLATE OVER ADJUSTING POST. POST IS INSERTED INTO HOLE IN CENTER OF STAND PLATE. ADJUST NUT FOR PROPER HEIGHT. SUPPORT UPPER END OF MAST SO IT IS APPROXIMATELY PARALLEL WITH GROUND. CLAMP GUIDE BRACKETS TO BASE TUBE, AND SECURE. FASTEN TURNBUCKLES (ATTACHED TO STABILIZER RODS) TO GUY BRACKETS 'X' AND 'Y'. TIGHTEN TURNBUCKLE AT GUY BRACKET 'X' UNTIL MAST IS EXACTLY PERPENDICULAR TO MOUNTING FRAME. TIGHTEN THE OTHER TWO TURNBUCKLES AT GUY BRACKETS 'Y'. ATTACH HORIZONTAL STABILIZER ASSEMBLY, USE THE APPROPRIATE NUMBER AND SIZE OF STABILIZER RODS DEPENDING ON THE TOWER TYPE (MG-30 OR MG-40). SEE DETAIL '7'.
- SEE INSTRUCTION BOOK T16850.77 FOR ADDITIONAL ASSEMBLY INSTRUCTIONS.
- CONTRACTOR SHALL SUPPLY TWO SPARE 'A' TUBES TO DAN GEIST-FAA, PHONE NUMBER (815)509-3200. PROVIDE FAA WITH ANY TUBE REMNANT GREATER THAN 10' LONG.
- TEE BAR SHALL BE ALIGNED PERPENDICULAR TO RUNWAY CENTERLINE +/- 1'.
- A SMALL HOLE MUST BE CUT IN THE RUBBER LINER OF TUBE CAP TO ALLOW ACCESS FOR TEE BAR WIRING INSTALLATION. DO NOT REMOVE RUBBER LINER.
- SAWCUT FOUR 2" LONG SLOTS, EQUALLY SPACED AROUND PERIMETER, IN TOP OF LIR TUBE TO ALLOW EASY INSERTION OF TUBE CAP.
- NOT USED.
- AFTER LEVELING AND PLUMBING THE MAST, LIFT THE MAST BY ONE COMPLETE TURN OF THE LEVELING NUT. THIS IS INTENDED TO CREATE UNIFORM TENSION IN (200-500 LBS) IN ALL STABILIZER RODS.
- WHEN LIFTING OR LOWERING THE TOWER, THE TILT DEVICE HOOK SHALL BE CONNECTED TO THE SLOTTED PLATE ON THE END OF THE LIFTING FRAME AND SHALL NOT BE CONNECTED TO THE LIFTING HANDLE.



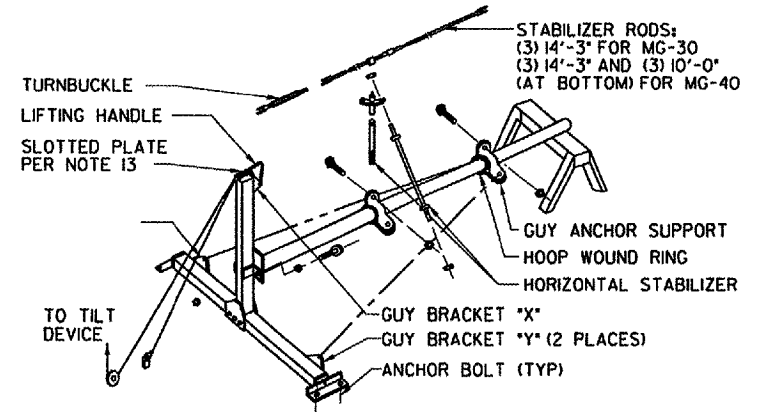
LIR TUBE ASSEMBLY DETAILS
4 DETAIL
NOT TO SCALE



TEE BRACE ASSEMBLY DETAILS
5 DETAIL
NOT TO SCALE



MOUNTING FRAME ASSEMBLY
6 DETAIL
NOT TO SCALE



LOWERED CONDITION
7 DETAIL
NOT TO SCALE

CONTRACTOR SHALL SUBMIT REQUESTS FOR SUBSTITUTION OF SPECIFIC MANUFACTURER'S ITEMS SHOWN PER PARAGRAPH 1 OF THE SPECIAL SPECIFICATIONS.

DEPARTMENT OF TRANSPORTATION FEDERAL AVIATION ADMINISTRATION GREAT LAKES REGION				CHICAGO, ILLINOIS	
MALSR STRUCTURE ASSEMBLY DETAILS FOR LIR TOWER, TYPES MG-30 RUNWAY 33					
AURORA		AURORA MUNICIPAL AIRPORT		IL	
REVIEWED BY	SUBMITTED BY	APPROVED BY			
	PROJ ENGR, TIMOTHY DYER	PLATFORM MGR, CLELAND MICHEAL			
DESIGNED	TAD	ISSUED BY	DATE 02/18/2006	JCN	
DRAWN	TAD	CHICAGO NAS IMPLEMENTATION CENTER	DRAWING NO		
CHECKED	EGS		ARR-D-MALSR33-S02	REV	

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