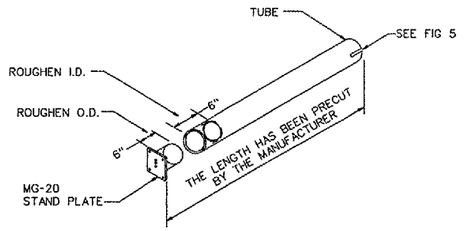


FIGURE 1. MG-20 MAST

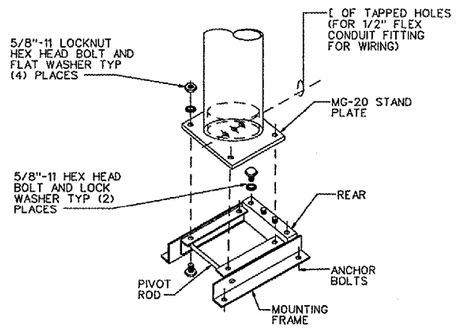


FIGURE 2. MOUNTING STAND ASSEMBLY MG-20

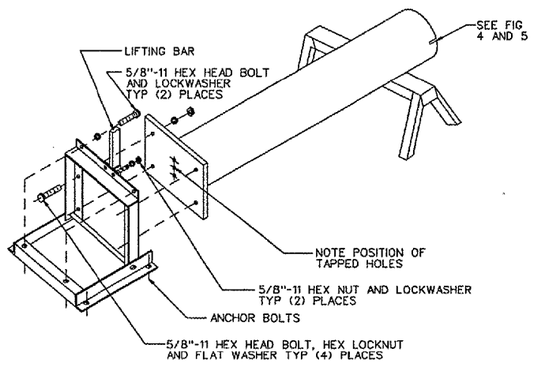


FIGURE 3. MG-20
ERECTION DETAILS

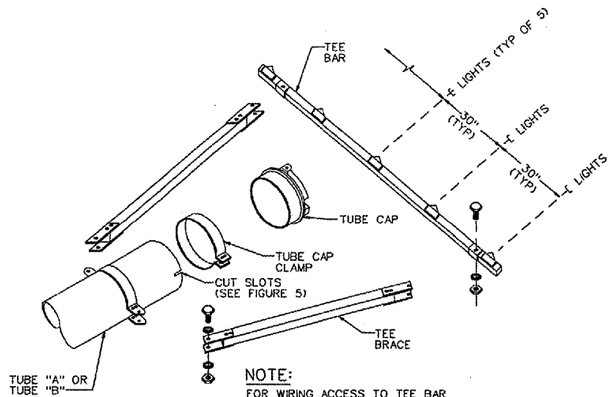


FIGURE 4. TEE-ASSEMBLY

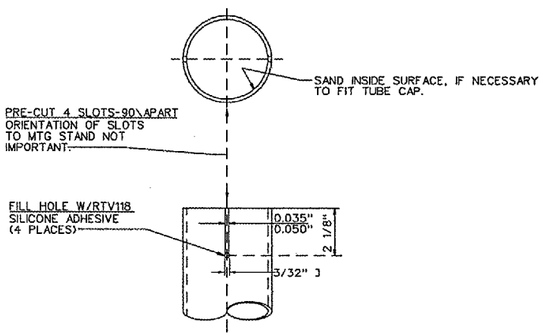
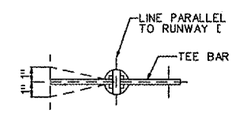


FIGURE 5. FACTORY CUT SLOTS & HOLES
(FOR INSTALLING TUBE CAP)



INSTALLATION TOLERANCE
PLAN

CAUTION: 1. BONDING INVOLVES USE OF CHEMICALS. FOLLOW MANUFACTURER'S PRECAUTIONS.

CAUTION: 2. BOND STRENGTH IS SENSITIVE TO SURFACE PREPARATION, TEMPERATURE AND CURE TIME. INCREASED TEMPERATURE CAN REDUCE CURE TIME. FOLLOW MANUFACTURER'S RECOMMENDATIONS.

INFO: POLE BASE ADHESIVE TO BE FURNISHED BY THE CONTRACTOR SHALL BE CHEMLOCK 304, PARTS 1 AND 2 – MANUFACTURED BY: LORD CORPORATION, CHEMICAL PRODUCTS GROUP, ERIE, PA., TEL (814) 868-3611.

CAUTION: 3. 6 INCH I.D. (LIR) POLES: HANDLE WITH CARE. DO NOT LIFT BONDED STAND PLATE/LIR POLE ASSEMBLY BY THE LIR POLE ONLY.

MATERIAL: LIR TUBE (FIG. 2): FILAMENT WOUND GLASS REINFORCED PLASTIC.

ASSEMBLY INSTRUCTIONS

1. FOR MG-20 LIR STRUCTURE, DETERMINE REQUIRED POLE LENGTH "L" AS SHOWN ON MALSR PLAN AND PROFILE SHEET AND FIELD VERIFIED.
2. BONDING INSTRUCTIONS: SEE FIG. 1.
   FOR BONDING, ROUGHEN SURFACES TO BE BONDED, AS SHOWN IN FIG. 1 USING EMERY CLOTH. CLEAN ROUGHENED SURFACES THOROUGHLY WITH A SOLVENT (TRICHLOROETHYLENE OR ACETONE). MIX EQUAL PARTS OF FUSOR 304-1 EPOXY RESIN AND 304-2 HARDENER, (BOTH CONTRACTOR FURNISHED), STIR THOROUGHLY BUT AVOID AIR INCLUSION. FOR EACH JOINT TO BE BONDED, SPREAD A LIGHT COAT OF MIXED ADHESIVE ON BOTH THE SURFACES TO BE BONDED. FOR MG-20: SLOWLY SLIDE POLE ONTO STAND PLATE WHILE ROTATING IT TO EXCLUDE AIR. CURE 48 HOURS AT ROOM TEMPERATURE ABOVE 67 DEGREES FARENHEIT AS REQUIRED.
3. ASSEMBLY INSTRUCTIONS:
   IMPORTANT – ALL LIR STRUCTURES ARE TO BE ASSEMBLED IN A HORIZONTAL POSITION (SEE FIG. 3). (ELECTRICAL WORK NOT SHOWN HERE).
   MG-20: USE MOUNTING STAND ASSEMBLY SHOWN IN FIG. 2. SET MOUNTING STAND ON ANCHOR BOLTS, SHIM TO LEVEL. FASTEN WITH (4) 3/4" NUTS. REMOVE 2 5/8" BOLTS AT REAR OF MOUNTING STAND ASSEMBLY AND PIVOT INNER SECTION UP TO VERTICAL POSITION. PLACE STAND PLATE (BOTTOM OF POLE) OVER (4) 5/8" STUDS IN MOUNTING STAND AND FASTEN WITH HEX NUTS. NOTE POSITION OF TAPPED HOLES IN STAND PLATE.

NOTES:

1. EACH LIR POLE SHALL BE CUT ACCURATELY, AND BONDED AND CURED PROPERLY IN A SUITABLE WORK ROOM.
2. BASE OF EACH LIR STRUCTURE SHALL BE GROUNDED ELECTRICALLY IN FIELD. FOR GROUNDING DETAILS SEE SHEETS 14 AND 15.
3. EACH LIR STRUCTURE SHALL BE MAINTAINED PER MANUFACTURER'S INSTRUCTION BOOK.
4. CONTRACTOR SHALL PROVIDE BONDING GLUE SPECIFIED BY POLE MANUFACTURER UNLESS OTHERWISE NOTED.
5. THE STAND PLATE AND MOUNTING STAND ASSEMBLIES COME PREASSEMBLED.
6. WHERE SPECIFIC MANUFACTURERS OF EQUIPMENT ARE GIVEN, THE CONTRACTOR MAY SUBMIT ALTERNATE EQUIPMENT EQUAL TO THAT PROPOSED FOR CONSIDERATION BY THE ENGINEER.

K:\FreeportAp\0229408\Draw\Sheets\
FILE: 12-facdetails.dwg
LAYOUT: Model
UPDATE BY: clouden
SURVEY BOOK #
DATE: Fri 7/8/05 5:32pm
XREF DWG: clntinfo.dwg
tb.dwg

REVISIONS

NUMBER	BY	DATE

0 1 2
THIS BAR IS EQUAL TO 2" AT FULL SCALE (34X22).

FREEPORT - ALBERTUS AIRPORT
FREEPORT, ILLINOIS

ILLINOIS PROJECT: FEP-3132 / A.I.P. PROJECT: 3-17-0045-B16

LIR STRUCTURE ASSEMBLY DETAILS
SHEET 2

CMT
CRAWFORD, MURPHY & TILLY, INC.
CONSULTING ENGINEERS

DESIGN BY:	
DRAWN BY:	
CHECKED BY:	
APPROVED BY:	
DATE:	06/17/05
JOB No:	02294-08

SHEET 24 OF 34 SHEETS