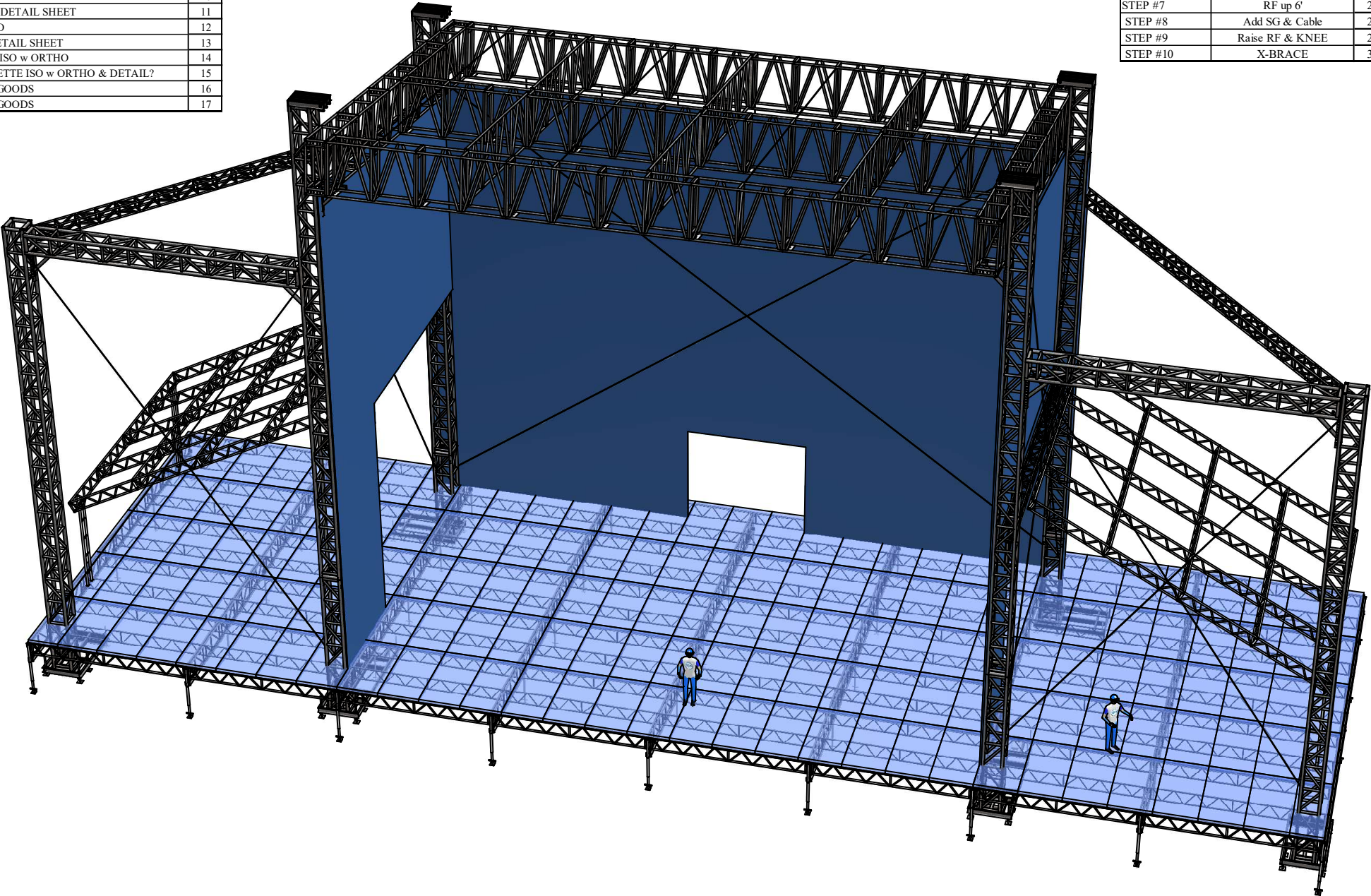
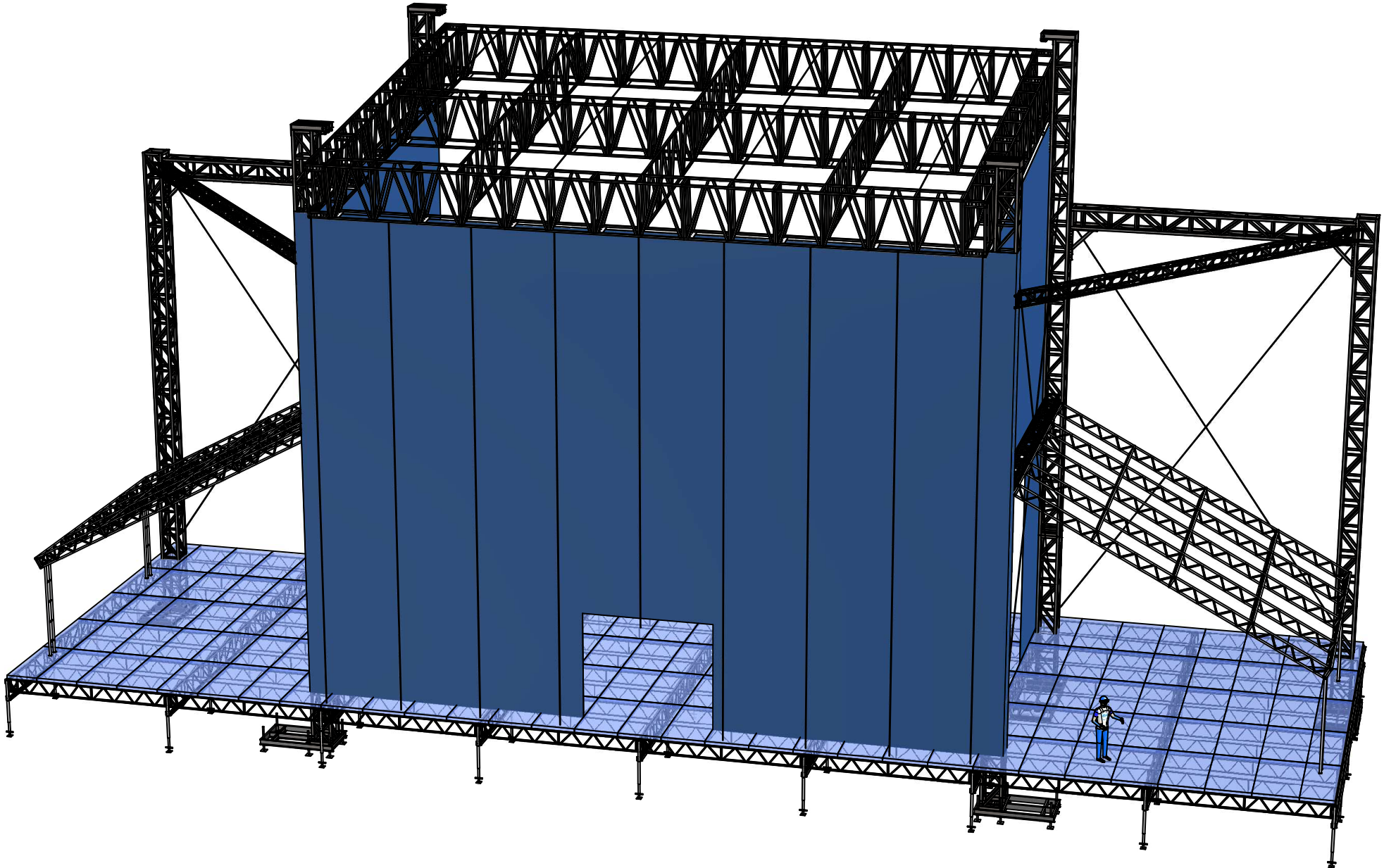


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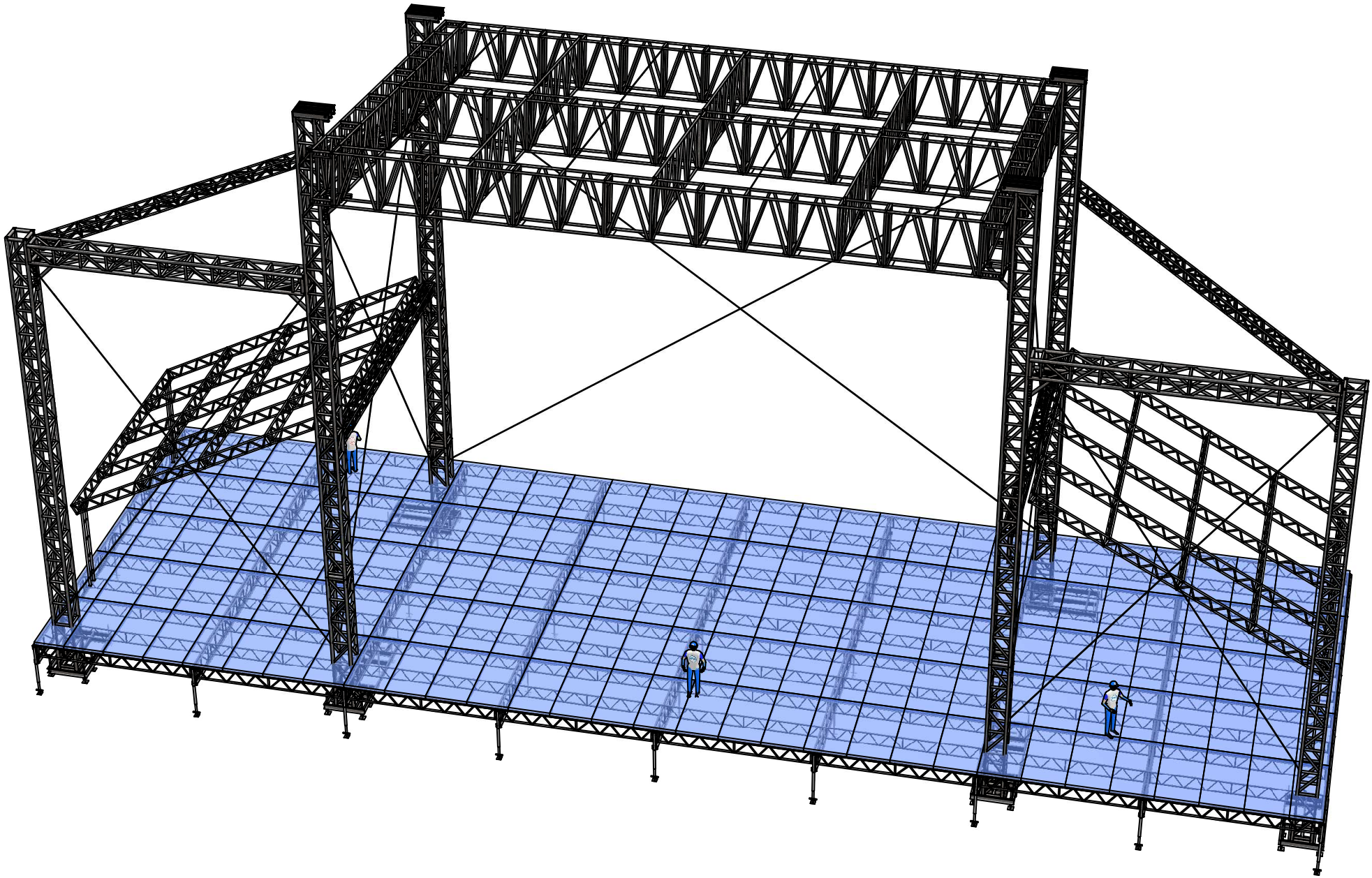


STAGE	ASSEMBLY	PAGE
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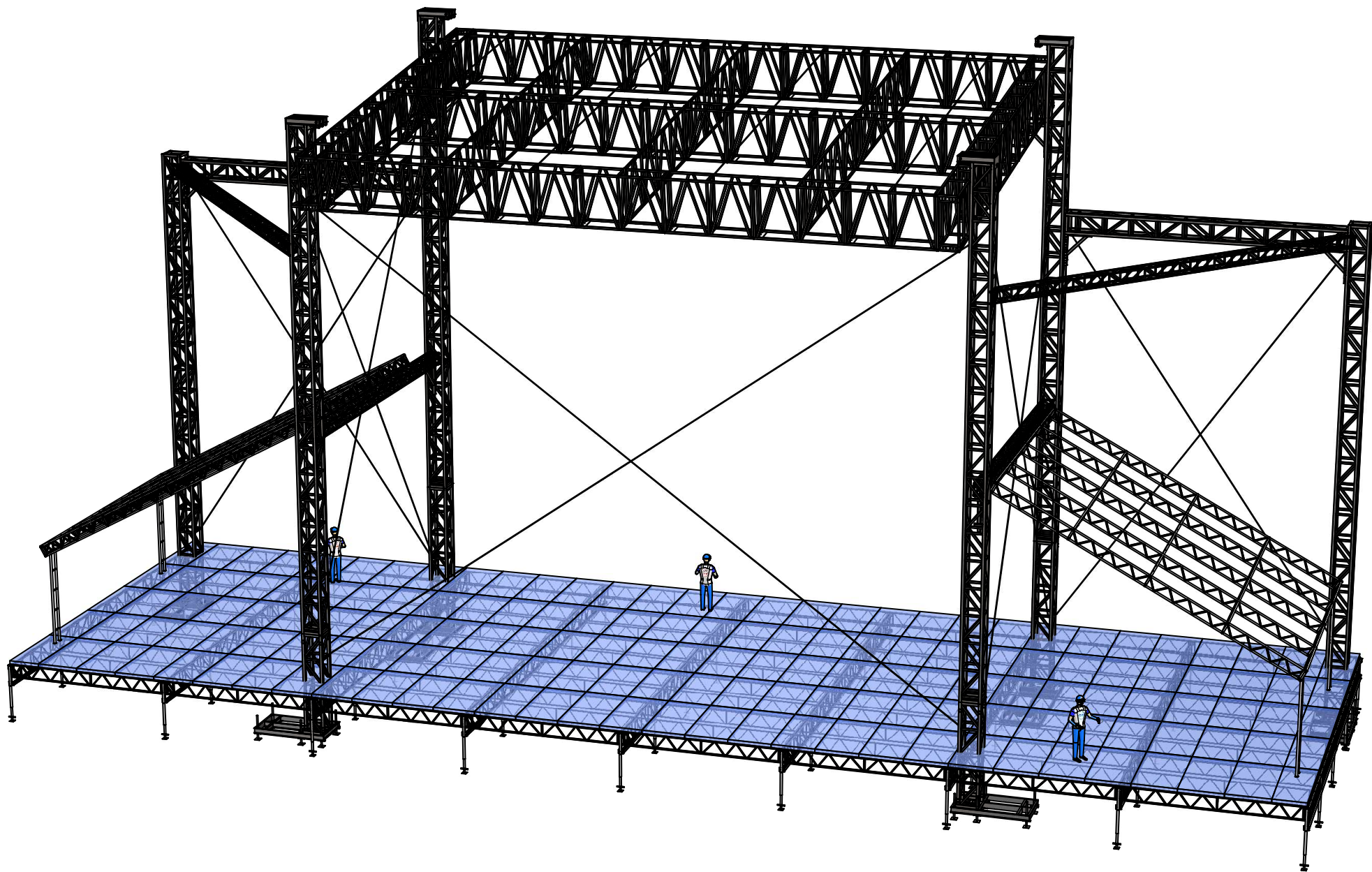
MANUFACT. TOLERANCES - U.N.O.		MACHINING TOLERANCES - U.N.O.		CHECKED	2023-04-25	60 x 40	REV
SAW - ± 1/16	DRILL DIA. - ±1/64/8	CONCENTRICITY: 0.005 TIR	1X - ±0.015	S. CHAMRYK			
TORCH - ±1/8	DRILL LOC. - ±1/32	BREAK EDGES: 0.015 x 45°	X - ±0.030	ENGINEER APPROVAL	2023-04-25	N/A	SHEET 1 OF 31
FAB - ±1/16	ANGLE - ±1°	Min. RADIUS: 0.010	XX - ±0.015	N. WALSMAN			
ALL WELDS TO BE FULL 1/4" FILLET U.N.O.		SURFACE FINISH - ψ	XXX - ±0.005				
		ANGLE: ±0.5°	XXXX - ±0.0005				



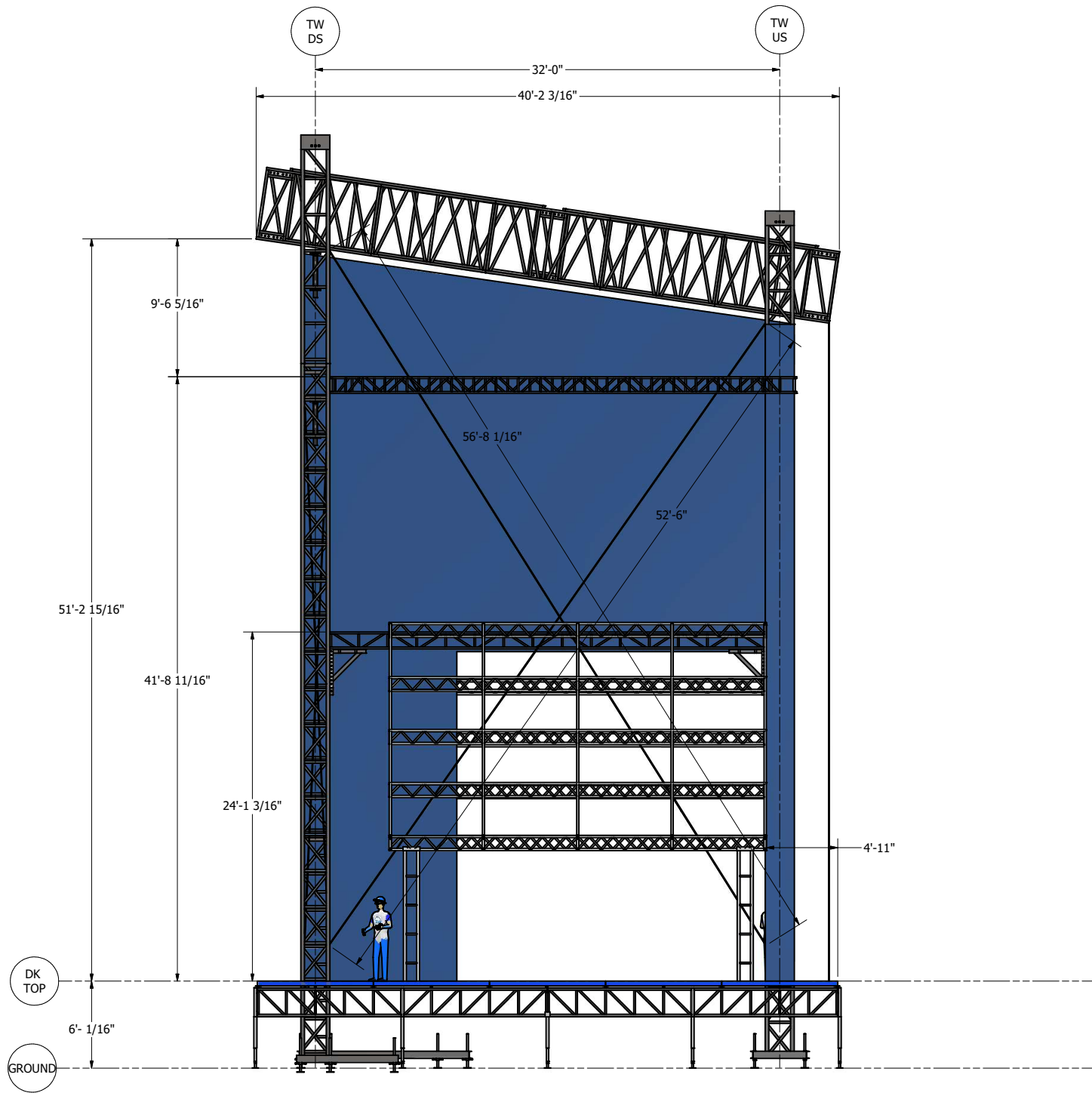
MANUFACT. TOLERANCES - U.N.O.		MACHINING TOLERANCES - U.N.O.		CHECKED	2023-04-25	60 x 40	REV
SAW - ± 1/16	DRILL DIA. - ±1/64"	CONCENTRICITY: 0.005 TIR	1X - ±0.015	S. CHAMRYK			
TORCH - ±1/8	DRILL LOC. - ±1/32	BREAK EDGES: 0.015 x 45°	X - ±0.030	ENGINEER APPROVAL	2023-04-25	N/A	SHEET 2 OF 31
FAB - ±1/16	ANGLE - ±1°	Min. RADIUS: 0.010	XX - ±0.015	N. WALSMAN			
ALL WELDS TO BE FULL 1/4" FILLET U.N.O.		SURFACE FINISH - ψ	XXX - ±0.005				
		ANGLE: ±0.5°	XXXX - ±0.0005				



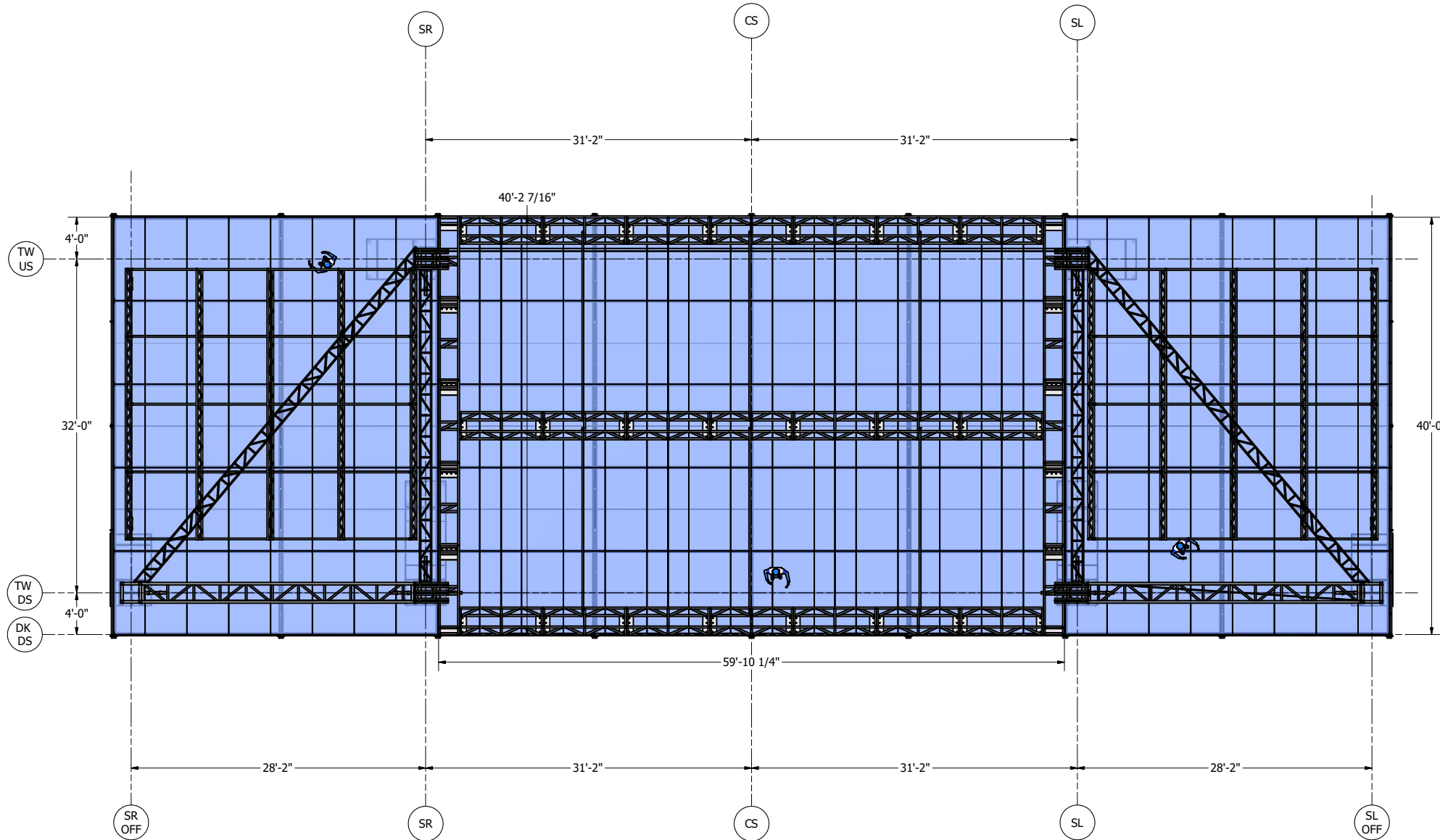
MANUFACT. TOLERANCES - U.N.O.		MACHINING TOLERANCES - U.N.O.		CHECKED	2023-04-25	60 x 40	REV
SAW - ± 1/16	DRILL DIA. - ±1/64"	CONCENTRICITY: 0.005 TIR	1X - ±0.015	S. CHAMRYK			
TORCH - ±1/8	DRILL LOC. - ±1/32	BREAK EDGES: 0.015 x 45°	X - ±0.030	ENGINEER APPROVAL	2023-04-25	N/A	SHEET 3 OF 31
FAB - ±1/16	ANGLE - ±1°	Min. RADIUS: 0.010	XX - ±0.015	N. WALSMAN			
ALL WELDS TO BE FULL 1/4" FILLET U.N.O.		SURFACE FINISH - ψ	XXX - ±0.005				
		ANGLE: ±0.5°	XXXX - ±0.0005				



MANUFACT. TOLERANCES - U.N.O.		MACHINING TOLERANCES - U.N.O.		CHECKED	2023-04-25	60 x 40	REV
SAW - ± 1/16	DRILL DIA. - ± 1/64"	CONCENTRICITY: 0.005 TIR	1X - ± 0.015	S. CHAMRYK			
TORCH - ± 1/8	DRILL LOC. - ± 1/32	BREAK EDGES: 0.015 x 45°	X - ± 0.030	ENGINEER APPROVAL	2023-04-25	N/A	SHEET 4 OF 31
FAB - ± 1/16	ANGLE - ± 1°	Min. RADIUS: 0.010	XX - ± 0.015	N. WALSMAN			
ALL WELDS TO BE FULL 1/4" FILLET U.N.O.		SURFACE FINISH -	XXX - ± 0.005		EST WT		
		ANGLE: ± 0.5°	XXXX - ± 0.0005				



MANUFACT. TOLERANCES - U.N.O.		MACHINING TOLERANCES - U.N.O.		CHECKED	2023-04-25	60 x 40	REV
SAW - ± 1/16	DRILL DIA. - ±1/64"	CONCENTRICITY: 0.005 TIR	1X - ±0.015	S. CHAMRYK			
TORCH - ±1/8	DRILL LOC. - ±1/32	BREAK EDGES: 0.015 x 45°	X - ±0.030	ENGINEER APPROVAL	2023-04-25	N/A	SHEET 7 OF 31
FAB - ±1/16	ANGLE - ±1°	Min. RADIUS: 0.010	XX - ±0.015	N. WALSMAN			
ALL WELDS TO BE FULL 1/4" FILLET U.N.O.		SURFACE FINISH - ψ	XXX - ±0.005				
		ANGLE: ±0.5°	XXXX - ±0.0005				



MANUFACT. TOLERANCES - U.N.O.		MACHINING TOLERANCES - U.N.O.		CHECKED				
SAW - ± 1/16	DRILL DIA. - ± 1/64	CONCENTRICITY: 0.005 TIR	1X - ± 0.015	S. CHAMRYK	2023-04-25	60 x 40	REV	
TORCH - ± 1/8	DRILL LOC. - ± 1/32	BREAK EDGES: 0.015 x 45°	X - ± 0.030	ENGINEER APPROVAL				
FAB - ± 1/16	ANGLE - ± 1°	Min. RADIUS: 0.010	XX - ± 0.015	N. WALSMAN	2023-04-25	EST WT	N/A	SHEET 8 OF 31
ALL WELDS TO BE FULL 1/4" FILLET U.N.O.		SURFACE FINISH -	XXX - ± 0.005					
		ANGLE: ± 0.5°	XXXX - ± 0.0005					