



Fabricating Tube back Cover

(4) Weld attachments for handles halfway along ribs flush with bottom of rib as shown in auxiliary drawing at left.

In fabrication, maintain circular frame members parallel to within 1/8 inch (preferably 1/16), centered to within 1/8 inch, and separated by 7.84 ± 0.06 inches (bottom to bottom).

(5) Attach cover plates (parts 5-028) to back (concave) surface of frame.

(2) Weld the block spanners (parts 5-025, 26, & 27) into place as shown, using a combination of fillet and butt welds all around.

(3) Weld frame stiffeners into place with fillet welds.

(1) Weld the 8 spokes to inner and outer frames with a combination of fillet and butt welds all around. Keep the two circular frames centered to within 0.125 inches.

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