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NOTE TO FABRICATOR:
ALL HOLES TO BE FREE OF BURRS

TRINITY PRODUCTS, INC. STANDARD TOLERANCES

DRILLED AND/OR BURNED ITEMS:

- DRILLED/BURNED HOLE SIZE: TOLERANCE (+1/16"; -0")
- DRILLED/BURNED HOLE PLACEMENT: TOLERANCE (+1/16"; -1/16")
- BURNED PARTS (NON-HOLE DIMS.): TOLERANCE (+1/16"; -1/16")

DIMENSIONS APPLIED TO ITEMS CREATED ON A BURN TABLE, NOT INCLUDING HOLES - SEE PREVIOUS LISTINGS.

FOR CUT MATERIAL: MATERIAL MADE TO LENGTH TO INCLUDE, BUT NOT LIMITED TO, I-BEAM, CHANNEL, ANGLE, TUBING, PIPE, OR BARSTOCK ON EQUIPMENT SUCH AS A SAW, BEAM COPER, OR IRON WORKER.

- WELDED CONNECTIONS: TOLERANCE (+1/8"; -1/8")
A PART WHOSE ENDS WILL BE WELDED TO ANOTHER PIECE OF STRUCTURAL MATERIAL WITH NO INTENTION OF BOLTING.
- BOLTED END CONNECTIONS: TOLERANCE (+0"; -1/16")
A PART WHOSE ENDS WILL BE WELDED TO A MATCH PLATE OR FLANGE.
- ANGLE OF CUT: TOLERANCE (+1 DEGREE; -1 DEGREE)

- FABRICATION PIPE CUTTING: TOLERANCE (+1/16"; -3/8")
DIMENSIONS APPLIED TO PIPES WHOSE END USE IS FABRICATION.

FOR GENERAL FITTING: THE ASSEMBLY OF ITEMS PER PRINTS PRIOR TO WELDING

- WELDED MEMBERS: TOLERANCE (+1/8"; -1/8")
DIMENSIONS APPLIED TO ASSEMBLIES WHICH ARE STAND ALONE ASSEMBLIES AND HAVE NO CONNECTIONS TO BE MADE IN THE FIELD OR REQUIRE A WELDED CONNECTION IN THE FIELD.
- BOLTED CONNECTIONS FOR SHOP FIT: TOLERANCE (+1/8"; -1/8")
DIMENSIONS APPLIED TO ASSEMBLIES WHICH TRINITY WILL BE PERFORMING A SHOP FIT TO ENSURE CONFORMANCE TO CUSTOMER DESIGN.
- UNCONTROLLED BOLTED CONNECTIONS: TOLERANCE (+1/16"; -1/16")
DIMENSIONS APPLIED TO ASSEMBLIES WHICH WILL BE BOLTED TO AN OBJECT IN THE FIELD, TRINITY DOES NOT HAVE ACCESS TO CONFIRM ACCURACY OF CONNECTION.

TRINITY PRODUCTS, INC. SIGN POLE TOLERANCES

- EXPOSED DIMENSIONS: TOLERANCE (+1/16"; -1/16" AT FIT, WITH +1/8"; -1/8" POST WELD.)
THE DIMENSION APPLIED TO THE DISTANCE FROM THE TOP OF A SIGNPOLE PIPE OR MATCH PLATE TO THE BASE OF THE CAP PLATE.
- LENGTH OF PAINT OMISSION BELOW GRADE: TOLERANCE (+6"; -0")
- SPACER RINGS: TOLERANCE (+3/16"; -3/16" IF TRINITY IS PROVIDING THE LOWER POLE, AND +1/8"; -1/8" IF TRINITY IS NOT PROVIDING THE BASE POLE.)

• FABRICATOR SHALL HOLD ALL LISTED TOLERANCES UNLESS OTHERWISE NOTED ON THE DRAWING.

NOTE TO CUSTOMER:

DUE TO PIPE LENGTHS AVAILABLE AT TIME OF ORDER CUSTOMER MAY HAVE MIDWELD PRODUCED TO AWS D1.1 PRE-QUALIFIED CJP WELD JOINT AND AISC SPECIFICATIONS. SEE BELOW FOR PRE QUALIFIED JOINT DETAILS:

- ALL PIPE WITH MAT'L THICKNESS LESS THAN OR EQUAL TO .500" NOMINAL AND OUTSIDE DIAMETER LESS THAN OR EQUAL TO 30":
PREQUALIFICATION JOINT DESIGNATION: B-U4a-GF
NOMENCLATURE: BEVEL-GROOVE WELD WITH BACKING BAND
WELD PROCESS: FCAW
ROOT OPENING: 3/16" +1/4"; -1/16"
GROOVE ANGLE: 30 DEG +10 DEG; -5 DEG
POSITIONS: ALL
- ALL PIPE WITH MAT'L THICKNESS GREATER THAN .500" NOMINAL AND OUTSIDE DIAMETER LESS THAN OR EQUAL TO 30":
PREQUALIFICATION JOINT DESIGNATION: B-U4a-S
NOMENCLATURE: BEVEL-GROOVE WELD WITH BACKING BAND
WELD PROCESS: SAW
ROOT OPENING: 3/8" +1/4"; -1/16"
GROOVE ANGLE: 30 DEG +10 DEG; -5 DEG
POSITIONS: FLAT
- ALL PIPE WITH MAT'L THICKNESS LESS THAN OR EQUAL TO .500" NOMINAL AND OUTSIDE DIAMETER GREATER THAN OR EQUAL TO 36":
PREQUALIFICATION JOINT DESIGNATION: B-U4b-GF
NOMENCLATURE: BEVEL-GROOVE WELD WITH BACKING WELD
WELD PROCESS: FCAW
ROOT OPENING: 0" +1/16"; -1/8"
GROOVE ANGLE: 45 DEG +10 DEG; -5 DEG
POSITIONS: ALL
- ALL PIPE WITH MAT'L THICKNESS GREATER THAN .500" NOMINAL AND OUTSIDE DIAMETER GREATER THAN OR EQUAL TO 36":
PREQUALIFICATION JOINT DESIGNATION: B-L2c-S
NOMENCLATURE: V BEVEL-GROOVE WELD WITH BACKGOUGE
WELD PROCESS: SAW
ROOT OPENING: 0" +1/16"; -0"
GROOVE ANGLE: 60 DEG +10 DEG; -5 DEG
POSITIONS: FLAT

CUSTOMER APPROVAL:

SIGNED _____ DATE _____

THIS FABRICATION DRAWING REPRESENTS TRINITY PRODUCTS' UNDERSTANDING OF THE DRAWINGS AND/OR REQUIREMENTS PROVIDED BY THE CUSTOMER. TRINITY PRODUCTS DOES NOT PROVIDE DESIGN, ENGINEERING OR ANALYSIS SERVICES. IT IS THE CUSTOMERS RESPONSIBILITY TO HAVE ALL DESIGNS AND DRAWINGS REVIEWED AND APPROVED BY THE APROPRIATE PARTIES. UNLESS OTHERWISE SHOWN, ALL MATERIAL SIZES AND THICKNESS ARE NOMINAL, MATERIAL SUPPLIED WILL BE WITHIN ASTM TOLERANCES

REQUIRED WELD PRE-HEAT	
MATERIAL THICKNESS	PRE-HEAT TEMP.
3/4" OR LESS	32 DEGREES
> 3/4" TO 1 1/2"	50 DEGREES
> 1 1/2" TO 2 1/2"	150 DEGREES
> 2 1/2"	225 DEGREES

Trinity Products			
TITLE BORE TECH			
SIZE B	JOB NO. 17-0219-JW	REV	
SCALE	SHEET 1 OF 2		

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