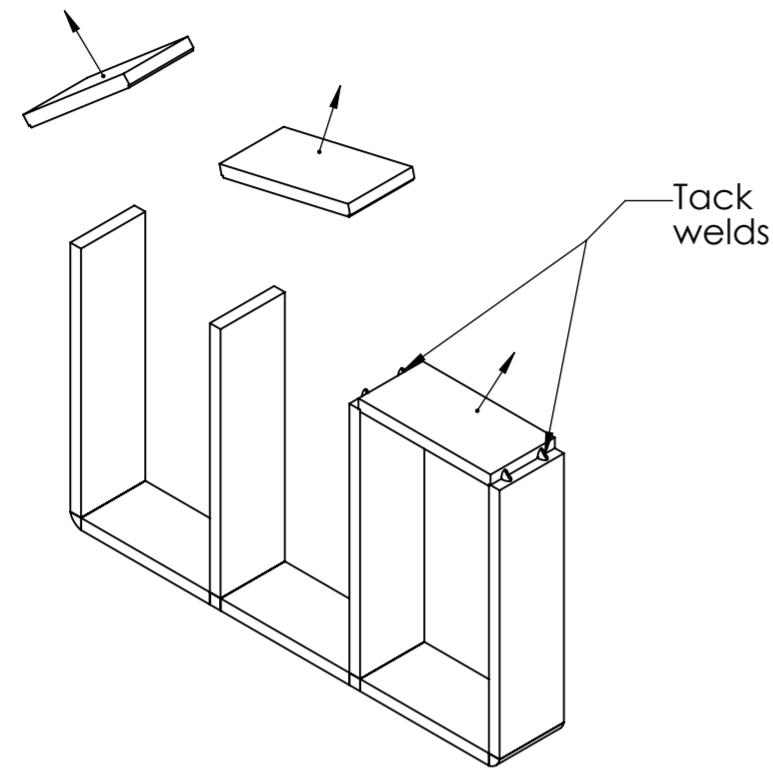
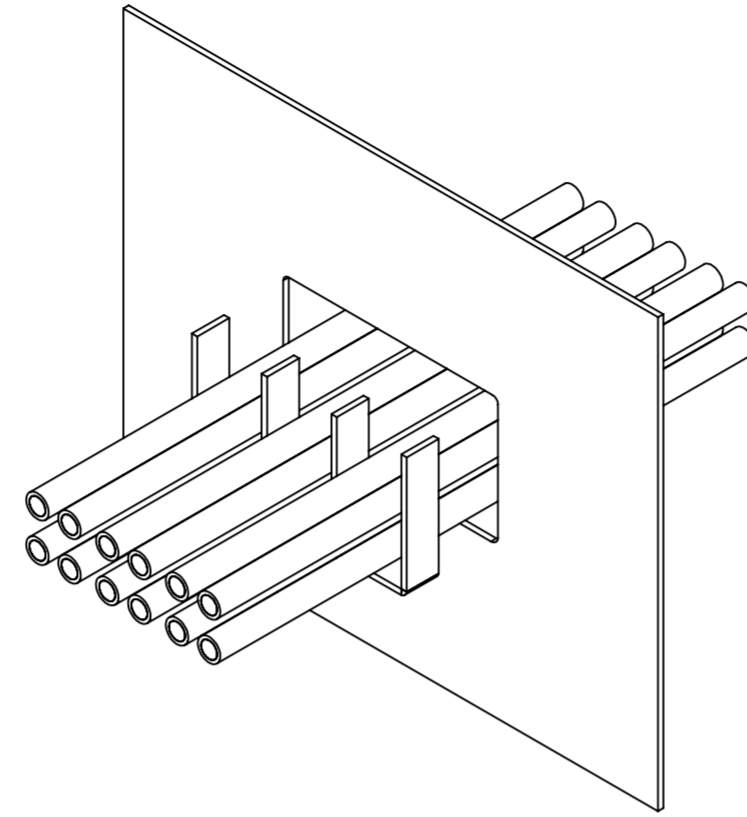


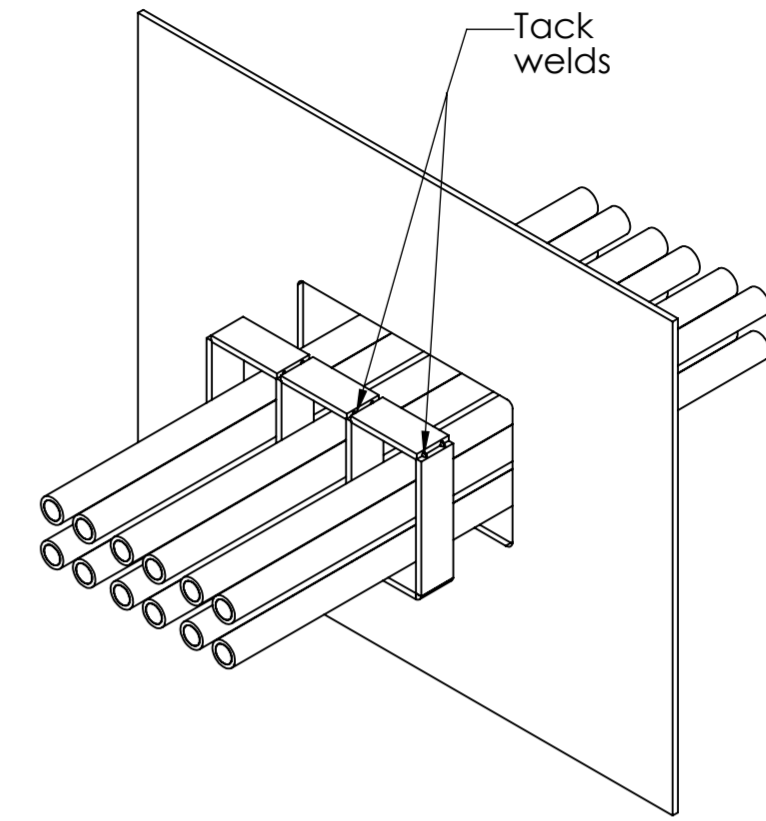
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1. Grind off tack welds and dismantle frame ends.

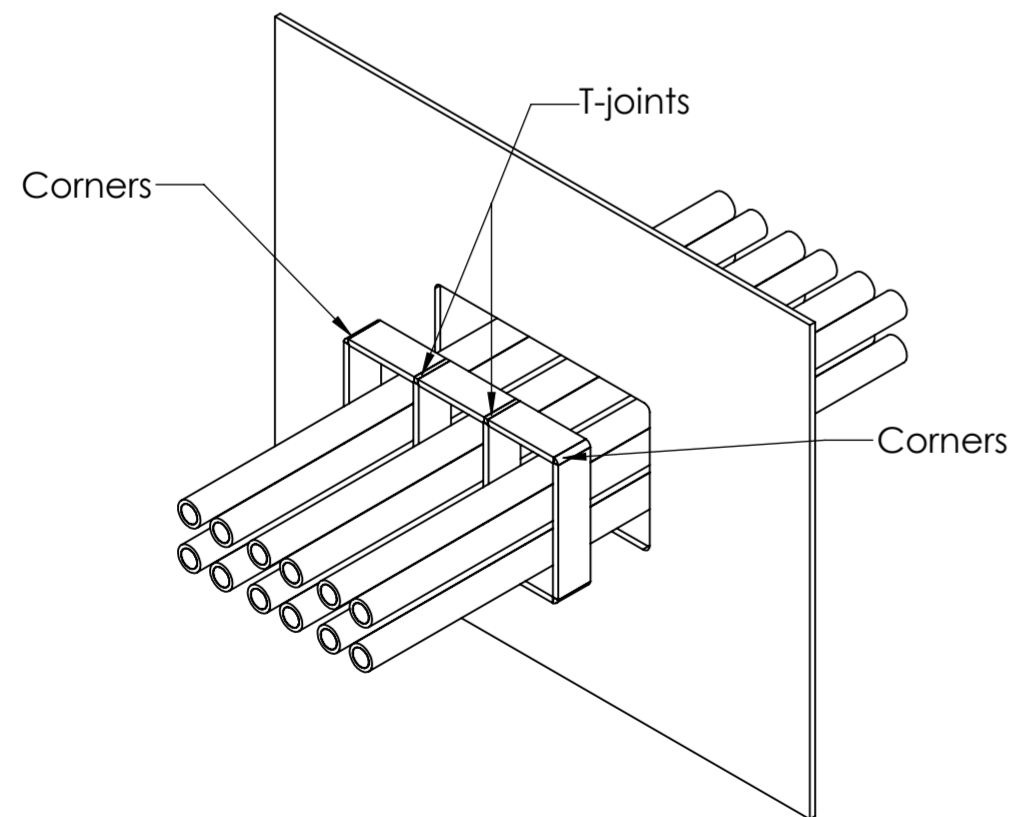


2. Fit the frame around existing cables.  
Protect the cables from heat and weld spatter.

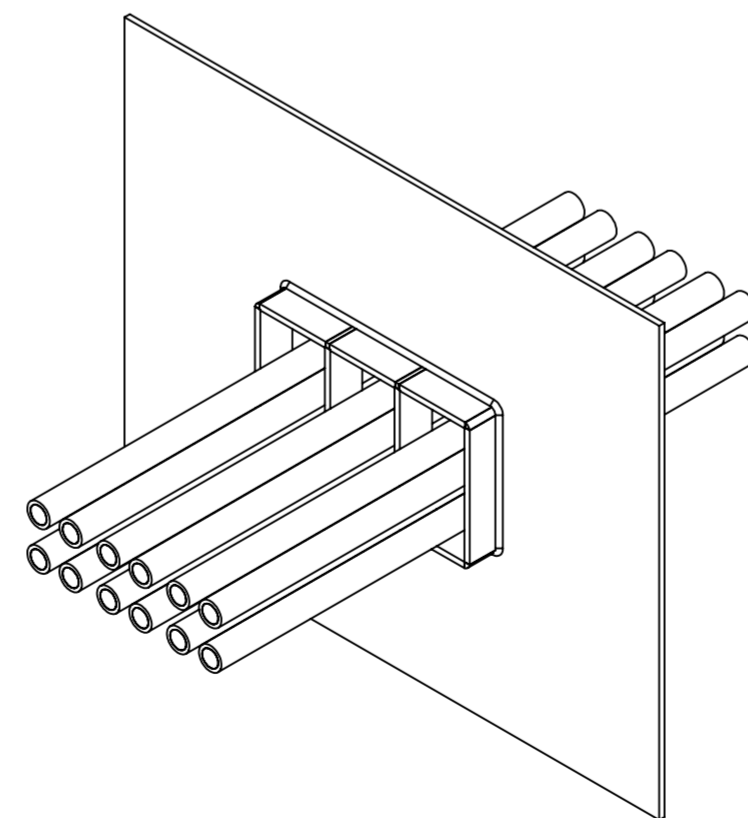


3. Put the frame ends back onto the frame and tack weld them as they were at delivery, make sure that the cables are carefully protected.

Check inside dimensions in the squares they must be within tolerances.  
See dimension table.



4. Weld the frames corners and T-joints according to MCT Brattberg drawing No. 1111374.  
Check inside dimensions again.



5. Put the frame in right position to the bulkhead and weld it according to MCT Brattberg instruction LB 253.  
Check inside dimensions one more time.

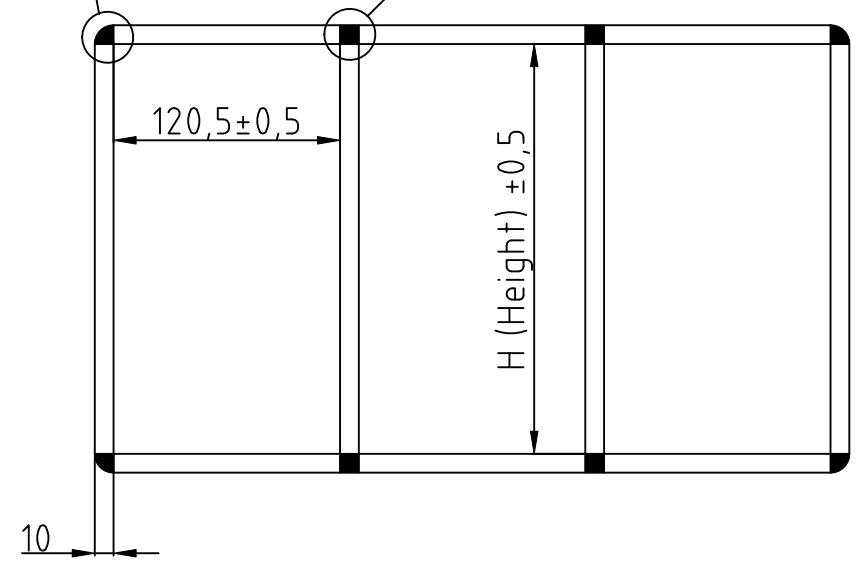
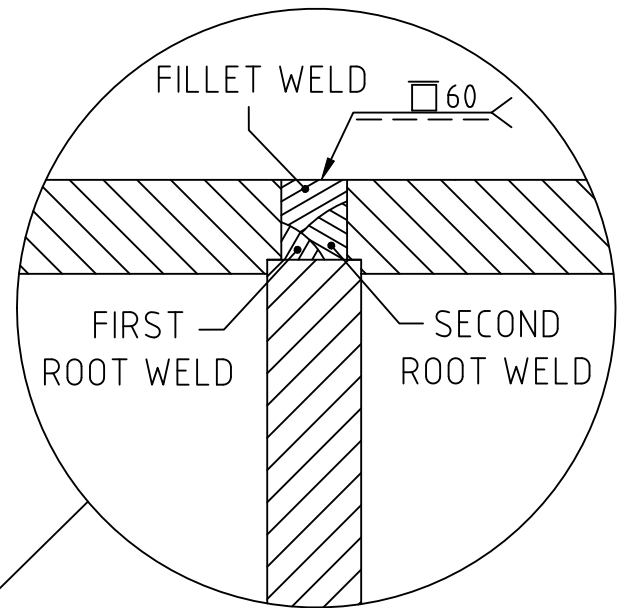
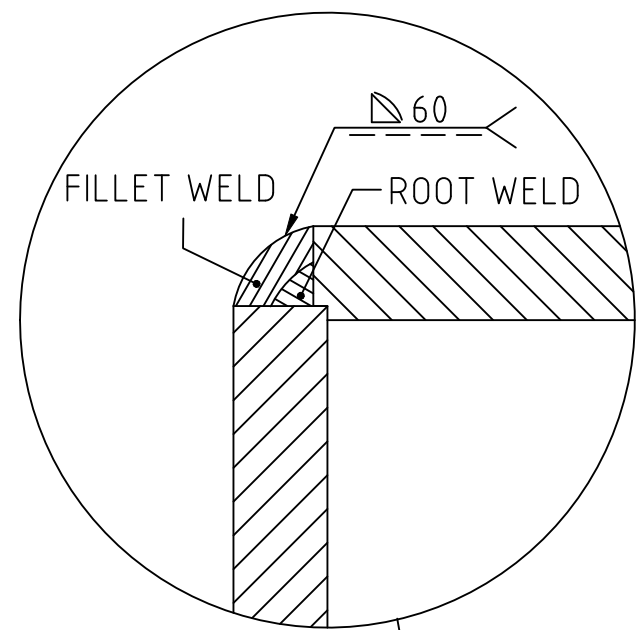
REVISIONS			
REV.	DESCRIPTION	DATE	SIGNATURE
A		2015-03-06	AK

Dimension table RGSO frames	
RGSO Frame Width	120,0 - 121,0
RGSO-2 Height	100,5 - 101,5
RGSO-4 Height	159,0 - 160,0
RGSO-6 Height	217,5 - 218,5
RGSO-8 Height	276,0 - 277,0

Ritad Drawn	Kontr. Check	Granskad Reviewed	Godkänd Approved	Tolerans där ej annat anges Tolerance unless otherwise not stated	Smsl. nr. Assembly drawing no.	Ersätter Replaces	E
AK	AK	JF	TF	Ytjämnhet där ej annat anges. Surface finish otherwise not stated	Material	Ersatt av Replaced of	Vikt Weight
150305	150306	150306	150306			Alla mått och uppgifter avser färdig produkt om ej annat anges. All measures and other information refer to finished products unless otherwise not stated.	
RGSO INSTALLATION INSTRUCTION						Kund ordernr. Customer order no.	
MCT BRATTBERG						Ritn. nr. Draw. no.	Rev.
						1150086	A

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REVISIONS			
REV.	DESCRIPTION	DATE	SIGNATURE
A	FOR INFORMATION	2011-10-13	AK
B	INSERTED DIMENSION TABLE	2015-03-06	AK



FRAME SIZE	H (Height)
RGSO-2	101
RGSO-4	159,5
RGSO-6	218
RGSO-8	276,5

WELDING REQUIREMENTS  
SS-EN ISO 5817 CLASS B OR  
MIL-STD-2035 CLASS B

Pos nr Pos no	Antal No.	Benämning Title		Best. nr./ Ritn. nr / Dimension / material Order no. / Draw. no. / Material		Note Note	
Ritad Drawn	Kontr. Check	Granskad Reviewed	Godkänd Approved	Tolerans där ej annat anges Tolerance unless otherwise not stated.	Smst. nr. Assembly drawing no.	Ersätter Replaces	
AK	AK	JF	TF	Ytjämnhet där ej annat anges Surface finish otherwise not stated.		Ersatt av Replaced of	
111012	150306	150306	150306			Alla mått och uppgifter avser färdig produkt om ej annat anges All measures and other information refer to finished products unless otherwise not stated.	
				SVETSINSTRUKTION RGSO WELDING INSTRUCTION RGSO		Kund ordernr. Customer order no.	
						Ritn. nr. Draw. no.	Rev.
						1111374	B