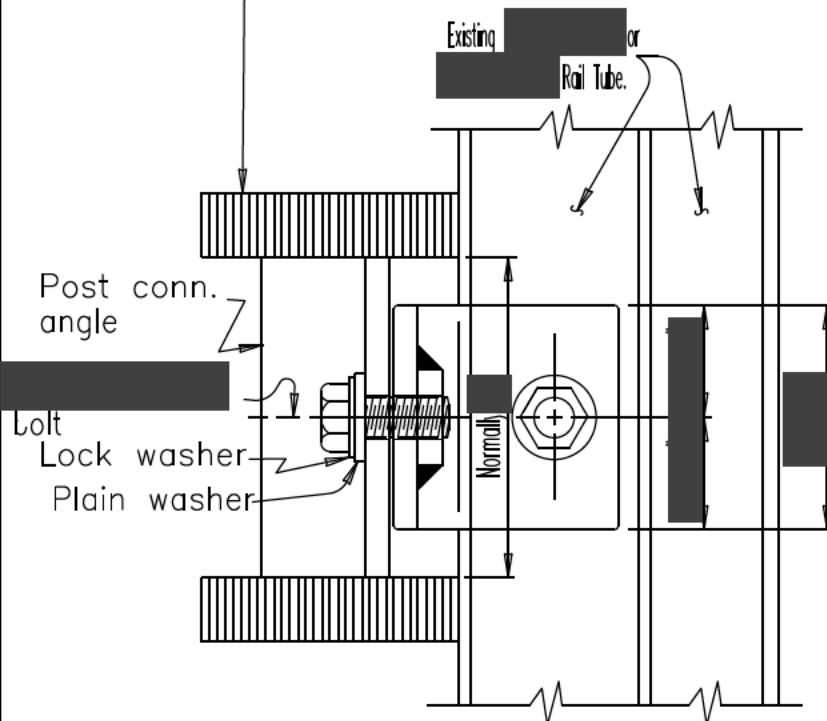


PARTIAL ELEV.



PARTIAL PLAN VIEW

STEEL BR. RAIL REPLACEMENT CLAMP

1. Chamfer all edges and corners of the clamp by grinding prior to galvanizing so that all sharp edges are removed.
2. All dimensions related to the fabrication of the clamp shall have a tolerance of ± 0.005 after galvanizing.
3. Locate and punch $\frac{1}{4}$ Dia. holes in the top and bottom legs of the rail clamp as shown on this sheet.
4. Using the prepunched holes in the top and bottom leg of the clamp as a guide, drill a $\frac{1}{4}$ Dia. hole in the top and bottom of the rail tube. Any damage to the galvanizing caused by the drilling operation shall be repaired according to Material Spec. 719-01.
5. Drill and tap the nut plate and vertical leg of the railing clamp to accommodate the $\frac{1}{4}$ Dia. hole after welding together.
6. If the bolts connecting the clamp to the post angles bear against the tube when in the final position, additional plain washers shall be added to prevent the bolt from bearing against the tube.
7. The bolts shall be torqued snug tight (Approximately 100 ft-lb).