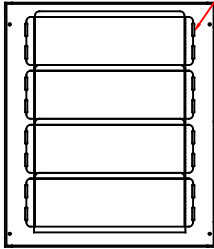
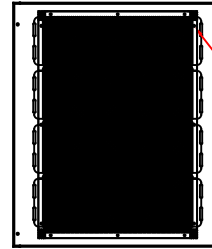


NOTE: THIS PROCEDURE IS THE  
SAME ALL FOUR LOUVERED SIDES

Step 1 insert and stack 4 louvers from the inside and weld 2" stitch weld typ.

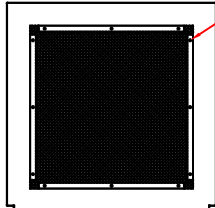


Step 2 stack screening and weld bars  
on top of louvers and spot weld through holes



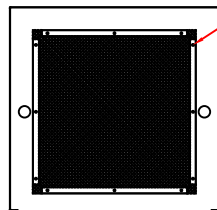
TOP OPENING

Place screening on the inside of the panel for top and bottom opening  
Place weld bars on top and spot weld through the holes



BOTTOM OPENING

Place screening on the inside of the panel for top and bottom opening  
Place weld bars on top and spot weld through the holes



		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	277 METAL Inc.		
		DIMENSIONS ARE IN INCHES	DRAWN	277		TITLE: ENCLOSURE WELD DETAILS		
		TOLERANCES:	CHECKED					
		FRACTIONAL ±	ENG APPR.					
		ANGULAR: MACH ± BEND ±	MFG APPR.					
		TWO PLACE DECIMAL ±.010						
		THREE PLACE DECIMAL ±.005						
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.					
		MATERIAL	COMMENTS:			SIZE	DWG. NO.	REV
NEXT ASSY	USED ON	FINISH				B	EPA1-001	1
APPLICATION		DO NOT SCALE DRAWING				SCALE: 1:8	WEIGHT:	SHEET OF