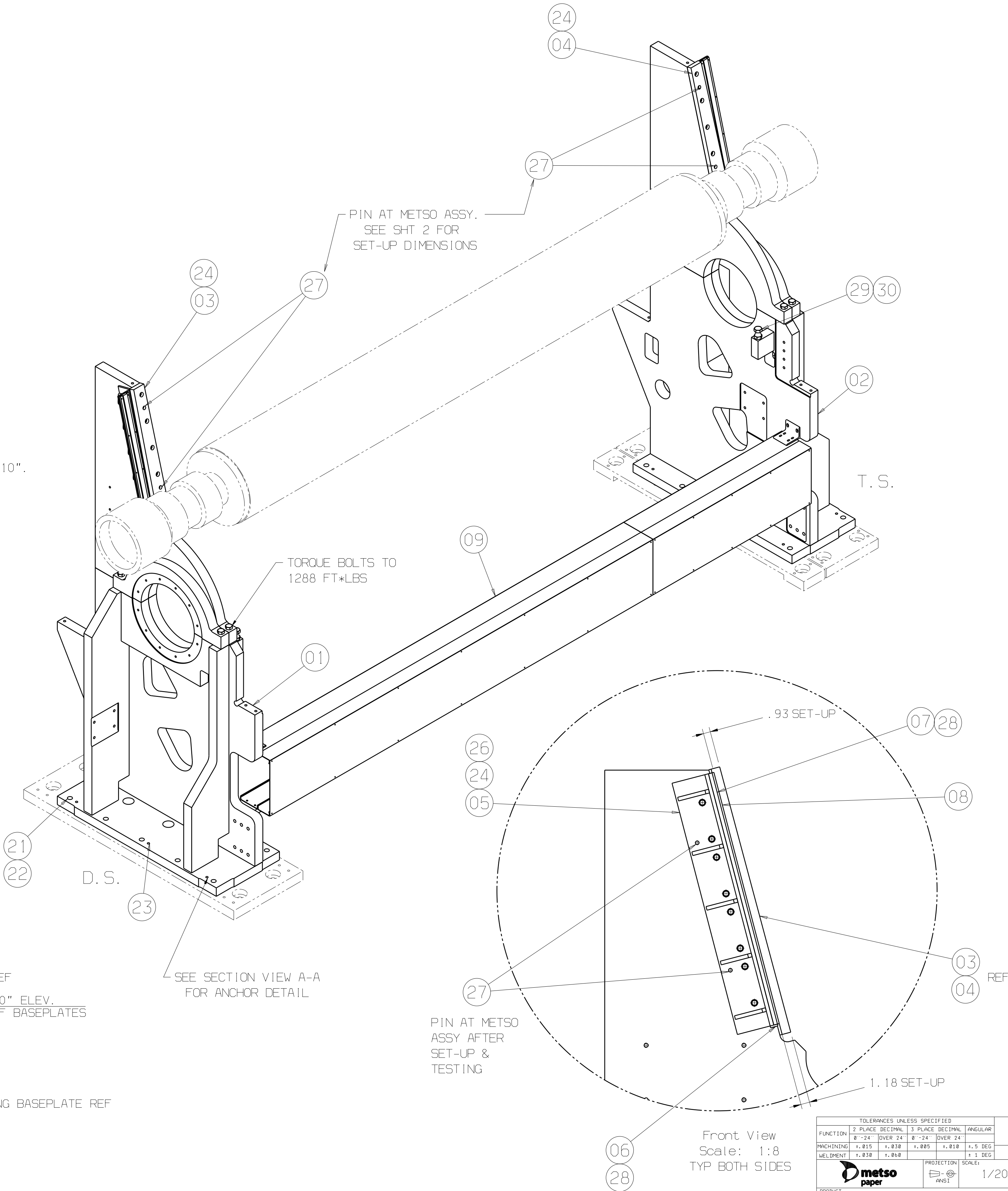


ERECTION NOTES:

1. REMOVE THE UPPER HALF OF BOTH FRAMES.
2. SET THE D.S. FRAME FIRST. CLEAN BOTTOM OF FRAME FREE OF RUST AND GREASE. PLACE D.S. FRAME ONTO THE PRE-DRILLED EXISTING BASEPLATE. POSITION SO THAT DISTANCE BETWEEN MACHINE CENTERLINE AND MACHINED SURFACES ON OUTSIDE OF FRAME PAD (120.081") ARE WITHIN 0.020".
3. SQUARE D.S. FRAME TO WITHIN 0.005" OF MACHINE  $\phi$  OR PLUG LINE.
4. CLEAN BOTTOM OF FRAME FREE OF RUST AND GREASE. PLACE THE T.S. FRAME ONTO THE PRE-DRILLED EXISTING BASEPLATES. POSITION SO THAT THE DISTANCE BETWEEN THE MACHINED SURFACES ON THE OUTSIDE OF THE FRAME PADS (240.161") ARE WITHIN 0.020".
5. SQUARE T.S. FRAME TO WITHIN 0.005" OF D.S. FRAME.
6. VERIFY DISTANCE BETWEEN MAIN BRG COUNTERBORES (217.161 +/- 0.020")
7. LOCATE FRAMES IN MACHINE DIRECTION TO WITHIN 0.005" USING MACHINED SURFACES ON THE FRAME PAD.
8. SET ELEVATION OF SPLIT-LINE (70.25") ABOVE HIGHEST POINT OF EXISTING BASEPLATES. LEVEL FRAMES TO WITHIN .005" USING SUPPLIED LEVELING SCREWS (ITEM 23). THERE WILL BE A NOMINAL .25" GAP TO EXISTING BASEPLATES. ONCE LEVEL, RECHECK PREVIOUS STEPS.
9. TAPE THE THREADED PORTIONS OF THE HOLD-DOWN BOLTS EXPOSED TO THE GROUT. PRE-TORQUE HOLD-DOWN BOLTS TO 225 FT\*LBS.
10. INSTALL DRUM AND UPPER HALF OF FRAMES. VERIFY DRUM IS BOTH LEVEL AND SQUARE TO WITHIN 0.010".
11. CONTRACTOR TO GROUT BETWEEN BASEPLATES AND FRAME PADS. CAUTION: ALIGNMENT CORRECTIONS ARE NOT POSSIBLE ONCE GROUTING TAKES PLACE.
12. AFTER GROUT IS FULLY CURED, RELEASE TENSION ON LEVELING SCREWS (BACK-OFF 1/8 TURN) AND FINAL TORQUE HOLD-DOWN BOLTS TO 644 FT\*LBS.

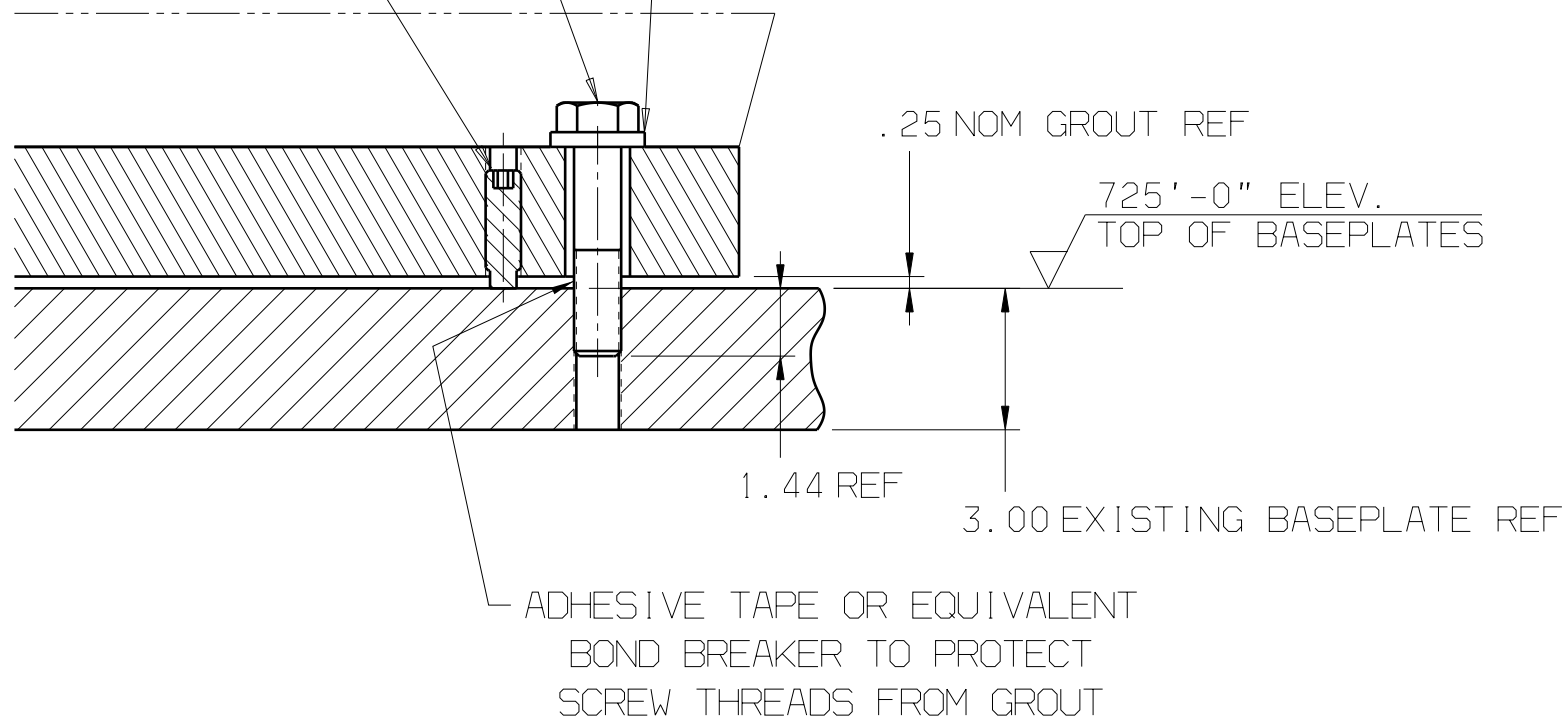


| NOM. BOLT SIZE | FASTENER TORQUE REQUIREMENTS (FT*LBS) |            |            |            |
|----------------|---------------------------------------|------------|------------|------------|
|                | ASTM A449                             |            | ASTM A354  | ASTM A574  |
|                | ZINC PLATED/ DRY                      | PLAIN/ DRY | PLAIN/ DRY | PLAIN/ DRY |
| 1/4-20NC       | 91 IN*LBS                             | 101 IN*LBS | 12         | 14         |
| 5/16-18NC      | 189 IN*LBS                            | 210 IN*LBS | 25         | 29         |
| 3/8-16NC       | 28                                    | 31         | 44         | 51         |
| 7/16-14NC      | 45                                    | 50         | 70         | 82         |
| 1/2-13NC       | 68                                    | 75         | 106        | 124        |
| 9/16-12NC      | 98                                    | 109        | 154        | 173        |
| 5/8-11NC       | 135                                   | 150        | 212        | 238        |
| 3/4-10NC       | 240                                   | 267        | 376        | 423        |
| 7/8-9NC        | 386                                   | 429        | 606        | 682        |
| 1-8NC          | 579                                   | 644        | 909        | 1022       |
| 1-1/8-7NC      | 715                                   | 794        | 1288       | 1449       |
| 1-1/4-7NC      | 1008                                  | 1121       | 1817       | 2044       |
| 1-3/8-6NC      | 1322                                  | 1469       | 2382       | 2680       |
| 1-1/2-6NC      | 1755                                  | 1950       | 3162       | 3557       |

TORQUE = 75% x PROOF LOAD x STRESS AREA. ASTM A449 (SAE A325) 74,000-85,000 MIN. PROOF LOAD. ASTM A354 (SAE A490) 120,000 MIN. PROOF LOAD. ASTM A574 (HEX SOCKET HEAD CAP SCREWS ONLY) 135,000-140,000 MIN. PROOF LOAD.

NECESSARY EXCEPTIONS TO THE ABOVE SHOULD BE SHOWN ON DRAWING.

THE ABOVE ARE FOR "DRY" CONDITIONS (AS PURCHASED). ALL ABOVE TORQUE VALUES TO BE REDUCED IF LUBRICANTS ARE USED.



|         |       |       |                                                       |       |      |         |      |      |           |
|---------|-------|-------|-------------------------------------------------------|-------|------|---------|------|------|-----------|
| 12OCT07 | DRS   | JSK   | AEON005807: ADDED PIPE CHASE. VIEW A-A, & OTHER MISC. | A     | REF. | SUPERS. | D    | DATE | 24SEP2007 |
| DATE:   | NAME: | APPD: | REVISION:                                             | ZONE: | KEY: | WORK    | FILE | 2551 | V5        |

CERTIFIED 21DEC2007