

GENERAL NOTES

- 1. **GENERAL:**
 - A. THIS DRAWING PROVIDES CONSTRUCTION DETAILS AND REQUIREMENTS FOR ONE (1) WALKWAY EXTERNAL ACCESS DOOR (EAD).
 - B. WHERE REFERRED TO IN THIS DRAWING, THE ENGINEER OF RECORD (EOR) IS THE DESIGNATED PUGET SOUND NAVAL SHIPYARD AND INTERMEDIATE MAINTENANCE FACILITY (PSNS & IMF) CODE 2370.24 ENGINEERING POINT OF CONTACT.
 - C. WHERE SPECIFICATIONS AND STANDARDS ARE NOTED ON THIS DRAWING, THE LATEST REVISIONS SHALL BE IN EFFECT UNLESS A SPECIFIC REVISION IS NOTED.
 - D. THE WALKWAY EAD SHALL BE CONSTRUCTED OFF-SITE AND SHIPPED TO PSNS & IMF IN BREMERTON, WA.
 - E. THE WALKWAY EAD SHALL BE FULLY ERECTED AND ASSEMBLED TO THE EXTENT OF THIS DRAWING. AFTER ASSEMBLY OF DOOR AND WELDMENT, VERIFY SMOOTH OPERATION OF DOOR AND COMPONENTS.
 - F. THE WALKWAY EAD SHALL BE SHIPPED FULLY ASSEMBLED AND INDIVIDUALLY CRATED FOR FINAL INSTALLATION BY PSNS & IMF. CRATE EAD SO THAT THE DOOR IS IMMOBILIZED DURING SHIPPING. INDICATE ON THE OUTSIDE OF EACH CRATE THE DRAWING NUMBER AND THE DOOR/FRAME HANDING.
- 2. **DOOR ASSEMBLY REQUIREMENTS:**
 - A. DOOR/FRAME SPECIFICATIONS ARE IN ACCORDANCE W/ SDI A250.8.
 - B. DOOR FUNCTION: ENTRY AND EXIT, NO LATCHSET OR STRIKE
 - C. NOMINAL DOOR OPENING: 3' 0" (WIDTH) x 6' 8" (HEIGHT)
 - D. DOOR/FRAME CLASSIFICATION: LEVEL 3, EXTRA HEAVY DUTY
 - E. DOOR/FRAME HANDING: INDICATED IN CONTRACT DOCUMENTS
 - F. DOOR:
 - 1. MATERIAL: STAINLESS STEEL, TYPE 304/316, NO. 4 BRUSH FINISH
 - 2. MANUFACTURERS STANDARD GAGE (MSG) NO.: 16 GAGE
 - 3. DOOR DESIGN: FLUSH
 - 4. DOOR THICKNESS: 1-3/4"
 - 5. CONSTRUCTION: SEAMLESS, BEVELED EDGES, TOP END CAP, BOTTOM INVERTED CHANNEL
 - 6. CORE: POLYSTYRENE
 - 7. DOOR FACES SHALL NOT HAVE A CUTOUT FOR LATCHSET
 - 8. HINGE PREPARATION: THREE (3) 4-1/2" HEAVY WEIGHT BUTT HINGE
 - 9. REINFORCED FOR SURFACE MOUNTED CLOSER
 - G. DOOR FRAME:
 - 1. MATERIAL: STAINLESS STEEL, TYPE 304/316, NO. 4 BRUSH FINISH
 - 2. MSG NO.: 16 GAGE
 - 3. TYPE: DOUBLE RABBET
 - 4. JAMB DEPTH: 5-3/4"
 - 5. FACE WIDTH: 2"
 - 6. CONSTRUCTION: FULL PROFILE WELDED, GROUND & POLISHED
 - 7. MOUNTING: CONCEALED EXISTING WALL ANCHORS WITH CAPS, FOUR (4) PER JAMB
 - 8. HINGE PREPARATION: THREE (3) 4-1/2" HEAVY WEIGHT BUTT HINGE
 - 9. REINFORCED FOR SURFACE MOUNTED CLOSER
 - H. DOOR HARDWARE:
 - 1. CLOSER: NORTON 8501M – NON-HOLD OPEN, PARALLEL ARM MOUNTING, STAINLESS STEEL (630) FINISH
 - 2. HINGES: THREE (3) 4-1/2" HEAVY WEIGHT BUTT, FULL MORTISE, NON-REMOVABLE PIN, STAINLESS STEEL BALL BEARINGS, STAINLESS STEEL
 - 3. WEATHERSTRIPPING: PEMKO 379CR – STOP MOUNTED, ADJUSTABLE JAMB WEATHER STRIP, CLEAR ANODIZED ALUMINUM (628) FINISH
 - 4. DOOR BOTTOM: PEMKO 420APKL – FULL MORTISE AUTOMATIC DOOR BOTTOM
 - 5. DOOR THRESHOLD: PEMKO 175SS, 4" DEEP, 1/2" TALL, STAINLESS STEEL
 - 6. DRIP EDGE: PEMKO 345C – DOOR BOTTOM DRIP EDGE, CLEAR ANODIZED ALUMINUM (628) FINISH

- 3. **MATERIAL REQUIREMENTS:**
 - A. MATERIAL SPECIFICATIONS FOR THE WELDMENT ARE PROVIDED IN THE BILL OF MATERIAL LISTED ON SHEET 2 OF THIS DRAWING.
 - B. MATERIAL SUBSTITUTIONS ARE NOT AUTHORIZED.
 - C. SEALANT: SILICONE IN ACCORDANCE WITH ASTM C920, TYPE S, GRADE NS, CLASS 50, COLOR GREY; MUST BE NON-COMBUSTIBLE AND HAVE A FLAME SPREAD INDEX OF 0-25 AND SMOKE DEVELOPED INDEX OF 0-450 WHEN TESTED IN ACCORDANCE WITH ASTM E84 OR ANSI/UL 723.
- 4. **FABRICATION REQUIREMENTS:**
 - A. UNLESS NOTED OTHERWISE ON THE DRAWING, ALL DIMENSIONS ARE IN INCHES AND ALL TOLERANCES SHALL BE SPECIFIED IN THE DRAWING BLOCK IN THE LOWER RIGHT CORNER OF THE DRAWING.
 - B. BREAK ALL SHARP EDGES TO 1/32" CHAMFER (MINIMUM).
 - C. HOLES SHALL NOT BE FORMED BY THERMAL CUTTING. LASER CUTTING OF HOLES IS PERMITTED.
 - D. AT CONTRACTOR'S OPTION, THE USE OF SLOT AND TAB TO INDEX POSITION OF PARTS FOR MANUFACTURE IS ALLOWED. SLOT AND TAB JOINTS SHALL BE PLUG WELDED AND GROUND FLUSH. THE USE OF ETCHING ON MATERIAL FOR ALIGNMENT IS ALSO ALLOWED.
 - E. FRAME WELDMENT SURFACES SHALL BE FREE OF SCRATCHES, MILL SCALE, MARKINGS, OIL AND GREASE. IN GENERAL ALL SURFACES SHALL BE SMOOTH ENOUGH TO PERMIT WIPING SURFACES WITH CLEANING CLOTH WITHOUT SNAGGING THE CLOTH. DO NOT PAINT OR MARK STAINLESS STEEL WITH ANY PRODUCTS THAT CANNOT BE COMPLETELY REMOVED WITH A CLEANING CLOTH.
 - F. AFTER WELDING, ALL SURFACES OF THE FRAME WELDMENT SHALL BE BLASTED WITH GLASS BEADS IN ACCORDANCE WITH ASTM A380. ENSURE ALL BLAST MATERIAL IS CLEANED FROM WELDMENT.
- 5. **WELDING REQUIREMENTS:**
 - A. WELD SYMBOLS SHOWN ARE IN ACCORDANCE WITH AWS A2.4.
 - B. WELDING AND INSPECTION SHALL BE IN ACCORDANCE WITH AWS D1.6. VISUALLY INSPECT WELDS.
 - C. WELDS SHALL BE SEQUENCED TO MINIMIZE DISTORTION. IF DISTORTION DOES OCCUR, STRAIGHTENING SHALL BE PERFORMED PER AWS D1.6.
 - D. IN ADDITION TO WELD CALLOUTS IN THIS DRAWING, SEAL WELD ALL CREVICES, JOINTS AND BEND RELIEFS TO ELIMINATE JOINTS THAT COULD TRAP LOOSE MATIERAL.
 - E. WELDED SURFACES SHALL BE FREE OF CRACKS, CRATERS, BURRS, SHARP EDGES AND WELD SPLATTER. THE WELD SURFACE SHALL BE GENERALLY SMOOTH TO THE TOUCH.
- 6. **DELIVERABLES:**
 - A. ONE (1) WALKWAY EXTERNAL ACCESS DOOR
 - B. MILL CERTIFICATION FOR STAINLESS STEEL PLATE
 - C. MANUFACTURER'S PRODUCT DATA FOR SEALANT
 - D. MANUFACTURER'S PRODUCT DATA FOR DOOR AND FRAME
 - E. MANUFACTURER'S PRODUCT DATA FOR ALL DOOR HARDWARE
- 7. **REFERENCES:**
 - A. ANSI/SDI A250.8; SDI-100 RECOMMENDED SPECIFICATIONS FOR STANDARD STEEL DOORS AND FRAMES
 - B. ANSI/UL 723; STANDARD FOR TEST FOR SURFACE BURNING CHARACTERISTICS OF BUILDING MATERIALS
 - C. ASTM A240/A240M; STANDARD SPECIFICATION FOR CHROMIUM AND CHROMIUM-NICKEL STAINLESS STEEL PLATE, SHEET, AND STRIP FOR PRESSURE VESSELS AND FOR GENERAL APPLICATIONS
 - D. ASTM A380/A380M; STANDARD PRACTICE FOR CLEANING, DESCALING, AND PASSIVATION OF STAINLESS STEEL PARTS, EQUIPMENT, AND SYSTEMS
 - E. ASTM C920; STANDARD SPECIFICATION FOR ELASTOMERIC JOINT SEALANTS
 - F. ASTM E84; STANDARD TEST METHOD FOR SURFACE BURNING CHARACTERISTICS OF BUILDING MATERIALS
 - G. AWS A2.4; STANDARD SYMBOLS FOR WELDING, BRAZING, AND NONDESTRUCTIVE EXAMINATION
 - H. AWS D1.6/D1.6M; STRUCTURAL WELDING CODE – STAINLESS STEEL

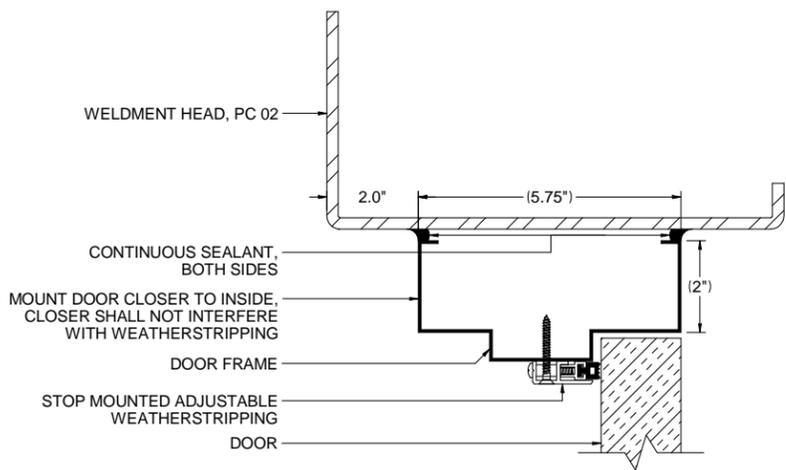
DISTRIBUTION STATEMENT: N/A

A.D.C. REVIEW		
SIGNATURE	DATE	
IS\ RT WHEELER	02-02-2016	
CONCURRENCE		
CODE	SIGNATURE	DATE
APPROVAL		
SIGNATURE	DATE	
BRANCH SUPERVISOR IS\ JM BYRNES	02-02-2016	
ENGINEER OF RECORD IS\ SL WENTZ	02-02-2016	
DRAWN IS\ RT WHEELER	02-02-2016	
CHECKED IS\ SL WENTZ	02-02-2016	
IS\ SIGNATURE ON FILE		
PUGET SOUND NAVAL SHIPYARD		
CODE 2370 ENGINEERING DIVISION		
NO DEVIATION SHALL BE MADE WITHOUT CODE 2370 APPROVAL		
TITLE WALKWAY EXTERNAL ACCESS DOOR		
DRAWING NO. 2370-1829	REV. ORIG	
SCALE NTS	SHEET SIZE ANSI B	SHEET NO. 1
		NO. OF SHEETS 5

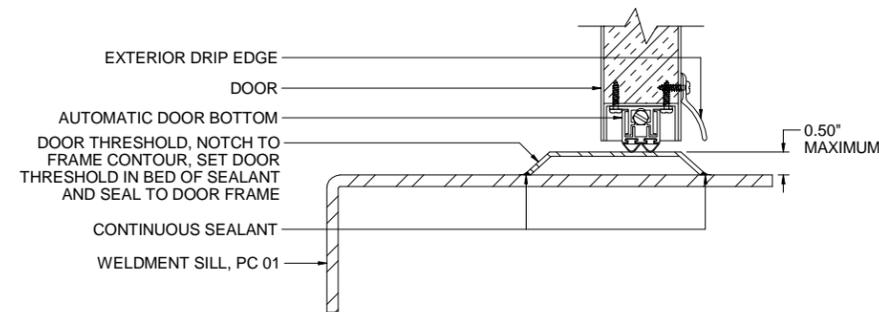
Unless noted otherwise, dimensions are in inches. Drawing dimensional and geometric tolerances per ASME Y14.5M

Decimals:
 X.X = ±0.1
 X.XX = ±0.06
 X.XXX = ±0.005
 X.XXXX = ±0.0005
 Fractions = ±1/16
 Angles = ±1/2°

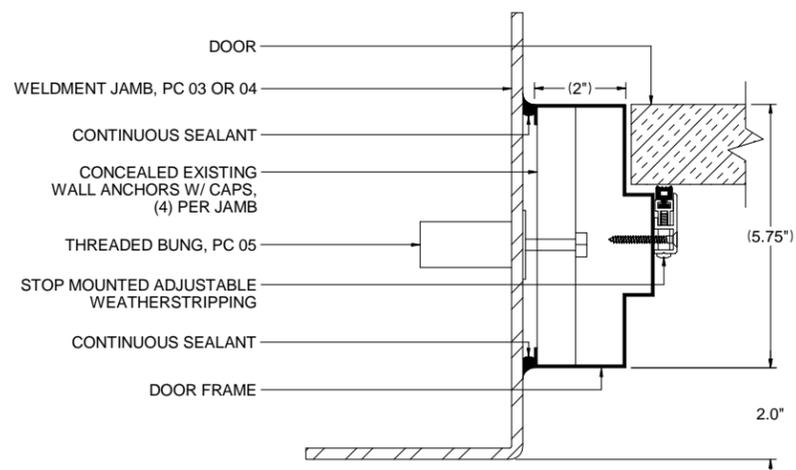
BILL OF MATERIALS						
PC #	QTY	PIECE NAME	DESCRIPTION	MATERIAL	MATERIAL SPEC	REMARKS
01	1	WELDMENT SILL	PL, 1/4"	STAINLESS STEEL	ASTM A240, TYPE 304 OR 316	
02	1	WELDMENT HEAD	PL, 1/4"	STAINLESS STEEL	ASTM A240, TYPE 304 OR 316	
03	1	WELDMENT JAMB LEFT	PL, 1/4"	STAINLESS STEEL	ASTM A240, TYPE 304 OR 316	
04	1	WELDMENT JAMB RIGHT	PL, 1/4"	STAINLESS STEEL	ASTM A240, TYPE 304 OR 316	
05	8	WELDMENT BUNG	THREADED BUNG	STAINLESS STEEL	ASTM A276, TYPE 304 OR 316	THREADS AND SHAPE TO SUIT EXISTING WALL ANCHOR BOLTS
06	1	DOOR ASSEMBLY	DOOR, FRAME AND HARDWARE	STAINLESS STEEL		REFER TO GENERAL NOTES PARAGRAPH 2., DOOR ASSEMBLY REQUIREMENTS, FOR MATERIAL AND PRODUCT SPECIFICATIONS



TYP HEAD



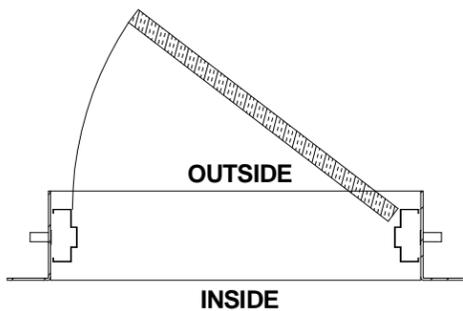
TYP SILL



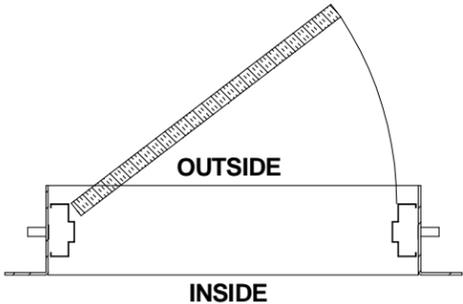
TYP JAMB

NOTE: DOOR HARDWARE IS NOT SHOWN IN SOME DRAWING VIEWS

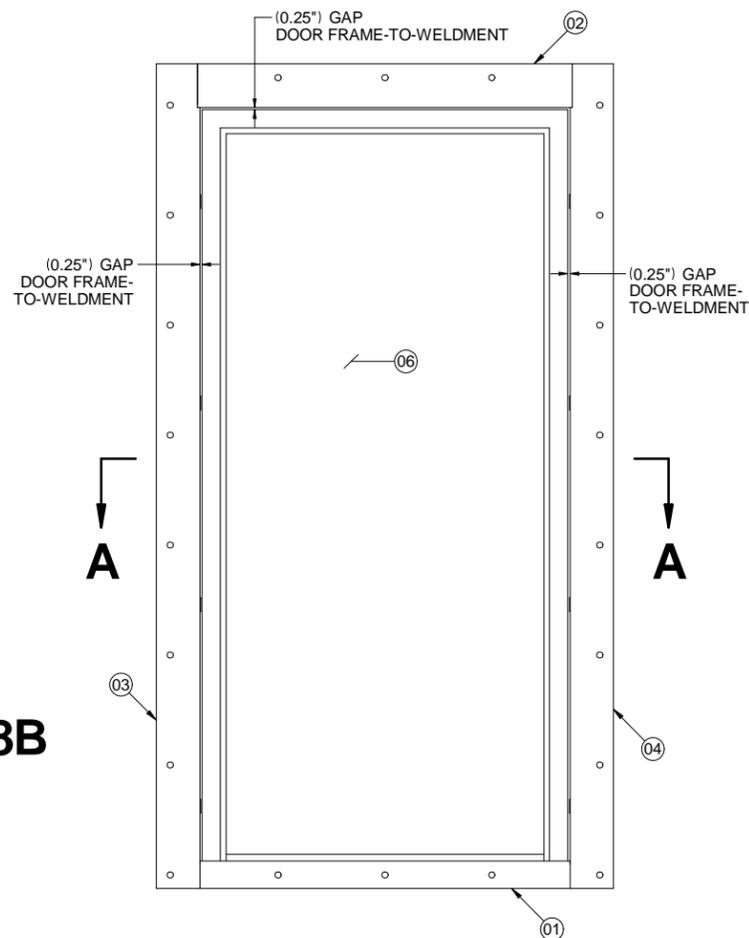
NOTE: DOOR/FRAME HANDING SHALL BE INDICATED IN CONTRACT DOCUMENTS.



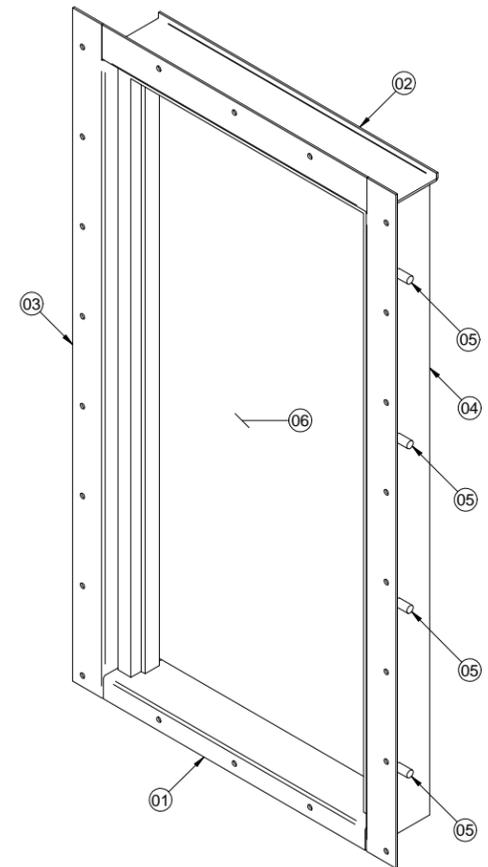
DOOR HANDING DETAIL 8B LEFT HAND REVERSE



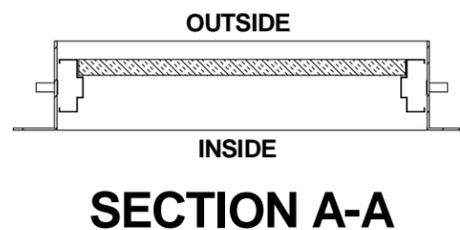
DOOR HANDING DETAIL 8A RIGHT HAND REVERSE



FRONT VIEW 7B WALKWAY EAD ASSEMBLY



ISO VIEW 6B WALKWAY EAD ASSEMBLY

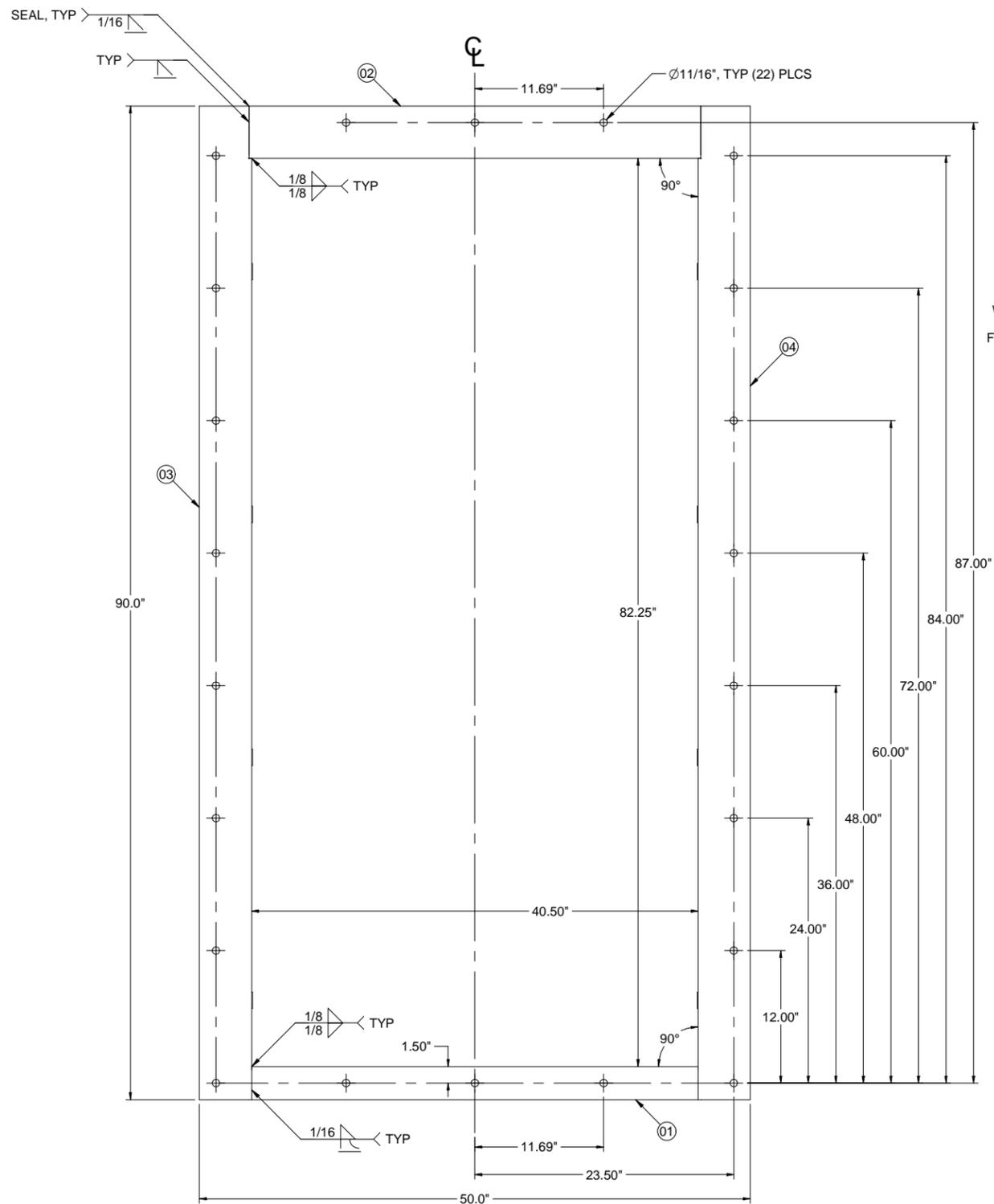


SECTION A-A

Unless noted otherwise, dimensions are in inches. Drawing dimensional and geometric tolerances per ASME Y14.5M

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 X.X = ±0.1
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PUGET SOUND NAVAL SHIPYARD CODE 2370 ENGINEERING DIVISION			
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TITLE WALKWAY EXTERNAL ACCESS DOOR			
DRAWING NO. 2370-1829	REV. ORIG		
SCALE NTS	SHEET SIZE ANSI B	SHEET NO. 2	NO. OF SHEETS 5

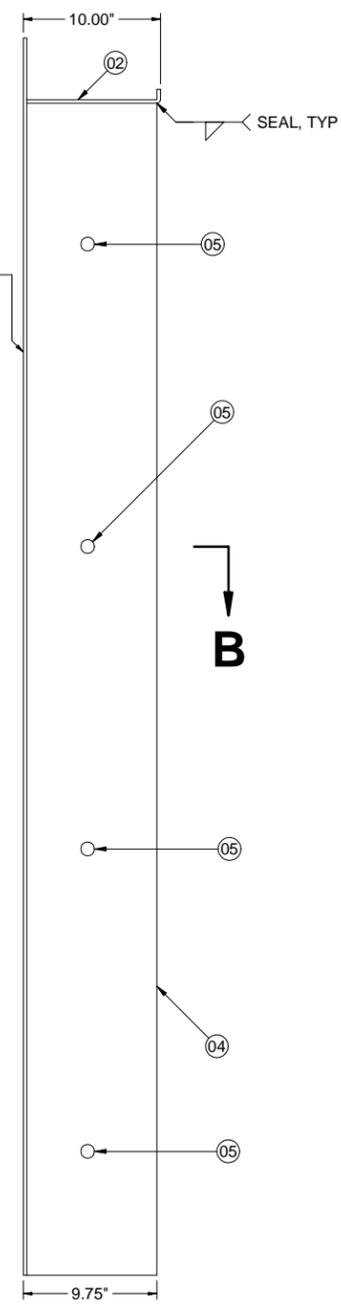


**FRONT VIEW 14A
WELDMENT DIMENSIONS**

NOTE: FRAME WELDMENT IS SYMMETRIC ACROSS THE CENTERLINE

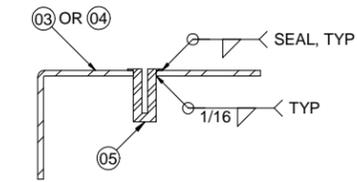
FLANGE FACE OF WELDMENT (PCs 01, 02, 03 AND 04) SHALL BE FLAT WITHIN 1/16" OVER THE ENTIRE SURFACE

**SIDE VIEW 13A
WELDMENT**

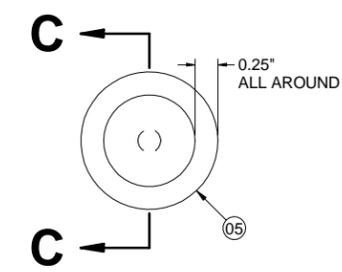


NOTE: LOCATION OF THREADED BUNGS, PC 05, SHALL BE BASED ON DOOR JAMB WALL ANCHOR LOCATIONS. FABRICATOR WILL MATCH, MARK AND DRILL BUNG LOCATIONS FROM DOOR FRAME EXISTING WALL ANCHORS.

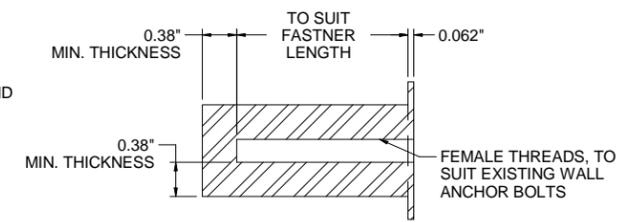
**SECTION B-B
TYP EIGHT (8) PLCS**



**DETAIL VIEW 12B
THREADED BUNG**



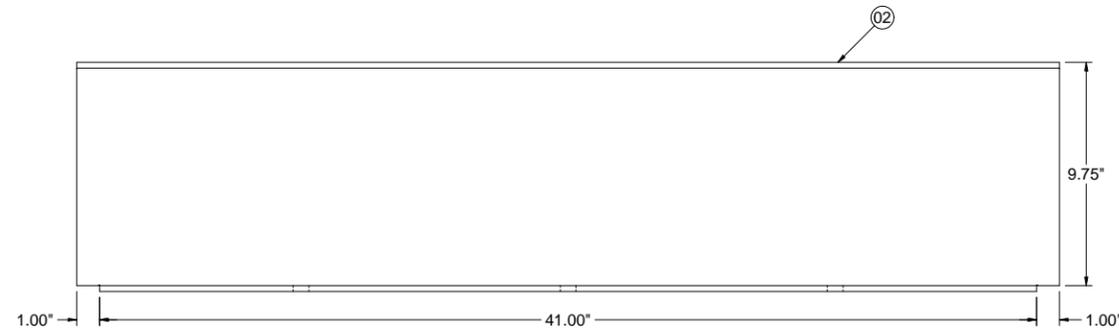
SECTION C-C



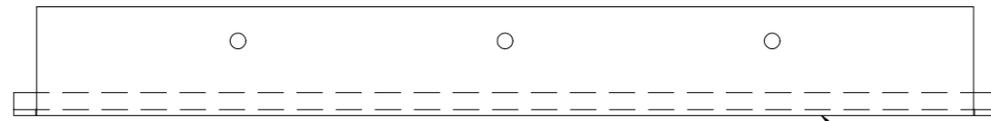
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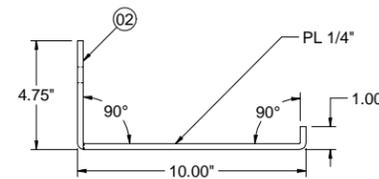
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CODE 2370 ENGINEERING DIVISION			
NO DEVIATION SHALL BE MADE WITHOUT CODE 2370 APPROVAL			
TITLE WALKWAY EXTERNAL ACCESS DOOR			
DRAWING NO.	2370-1829		REV.
SCALE	SHEET SIZE	SHEET NO.	NO. OF SHEETS
NTS	ANSI B	3	5
			ORIG



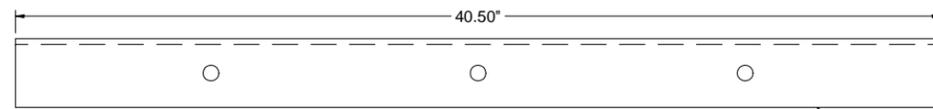
**TOP VIEW 18D
WELDMENT HEAD**



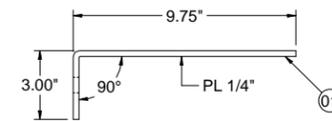
**FRONT VIEW 18C
WELDMENT HEAD**



**SIDE VIEW 17C
WELDMENT HEAD**



**FRONT VIEW 18B
WELDMENT SILL**



**SIDE VIEW 17B
WELDMENT SILL**

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SCALE NTS	SHEET SIZE ANSI B	SHEET NO. 4	NO. OF SHEETS 5

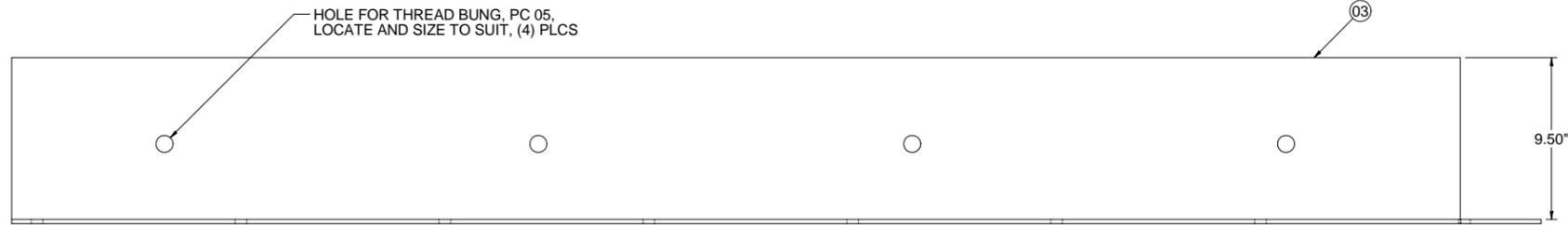
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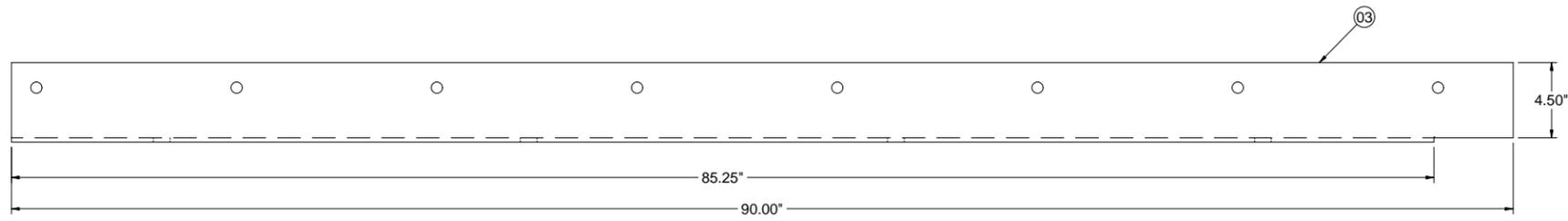
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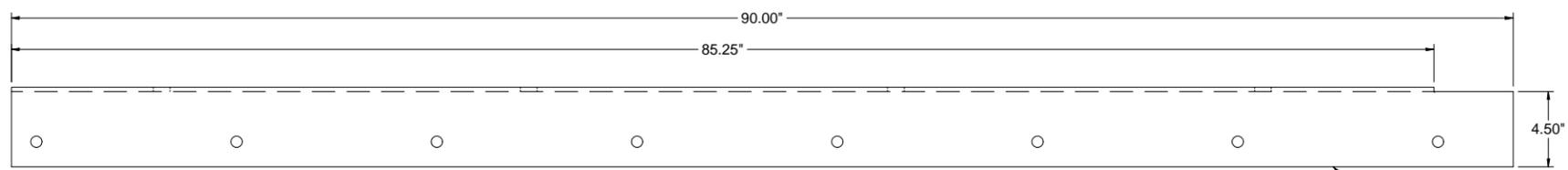
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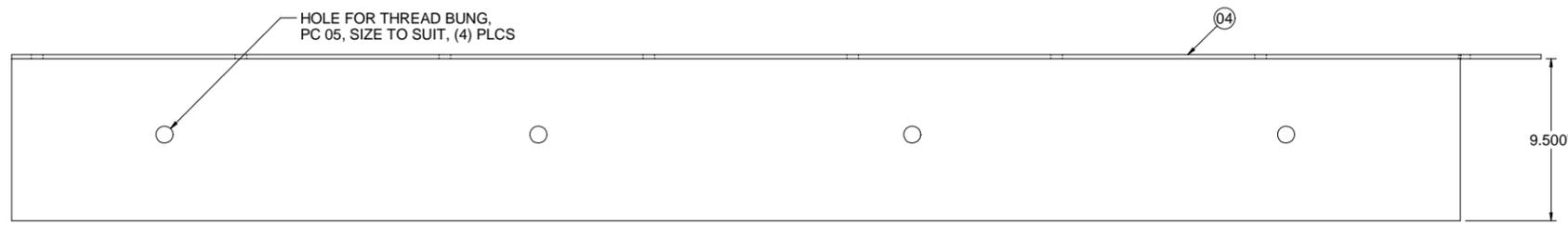
**SIDE VIEW 22D
WELDMENT LEFT JAMB**



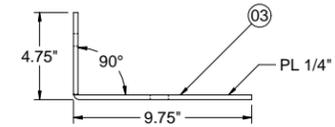
**FRONT VIEW 22C
WELDMENT LEFT JAMB**



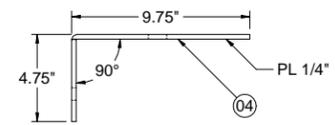
**FRONT VIEW 22B
WELDMENT RIGHT JAMB**



**SIDE VIEW 22A
WELDMENT RIGHT JAMB**



**TOP VIEW 21C
WELDMENT LEFT JAMB**



**TOP VIEW 21B
WELDMENT RIGHT JAMB**

25

24

23

22

21

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NTS	ANSI B	5	5