NYS SkillsUSA Standards

WELDING FABRICATION

PURPOSE

To evaluate each competitor's preparation for employment and to recognize outstanding students for excellence and professionalism in the field of welding fabrication.

ELIGIBILITY (TEAM OF THREE)

Open to active NYS SkillsUSA members enrolled in programs with welding as an occupational objective. This is a team event composed of three student members from the same school and training program.

CLOTHING REQUIREMENTS

NYS SkillsUSA Weld/Mach Attire:

- White crew neck short- sleeved T-shirt
- work pants
- leather or steel toed work shoes
- safety glasses or goggles, (Prescription glasses can be used only if they are equipped with side shields. If not, they must be covered with goggles.)

Extra

- **Both the pants and shirt must be 100% cotton**

Note: Competitors must wear their official competition clothing to the competition orientation meeting.

EQUIPMENT AND MATERIALS

1. Supplied by the technical committee:
   a. All necessary welding equipment and materials.
   b. All drawings and procedures
2. Supplied by the competitor team:

(a) Hearing and/or ear protection
(b) Welding helmet with appropriate filter plate/lens and protective cover plate/lens in a flip or slide front. Auto darkening shields are permissible.
(c) Spare spatter and filter lenses/plates for arc welding helmet and oxy acetylene goggles.
(d) Pocket calculator
(e) Lead pencil and/or ballpoint pen
(f) Soapstone with holder
(g) Scribe with magnet
(h) Combination square set
(i) Fillet weld gauge
(j) Center punch
(k) Chipping hammer with or without wire brush
(l) Stainless-steel wire brush
(m) 4 ½ inch grinder
(n) Consumables Required
(o) 40 Grit Flap Disc
(p) Abrasive Cut-Off wheel
(q) Grinding Disc
(r) Any additional hand tools that are necessary to complete project will be allowed
(s) NO fixtures, jigs or power tools allowed unless specified above
(t) All competitors must create a one-page resume. See "Resume Requirement" below for guidelines.

RESUME REQUIREMENT

Competitors must create a one-page resume to submit at orientation. Failure to submit a resume will result in a 10-point penalty.

PROHIBITED DEVICES

Cell phones or other electronic devices not approved by the NYS Chairperson will be collected by the contest chair during the competition. Chairpersons will announce their acceptance by listing it on their standard or at the orientation meeting. In case of emergencies advisors should allow the competitors to take their phones to the contest areas.

If the competitor uses their device in a manner which compromises the integrity of the competition, the competitor's score may be penalized.

SCOPE OF THE COMPETITION

The scope of the competition is defined by industry standards as identified by the following companies: American Welding Society Inc., Harris Products Group, Hobart Brothers Co., Lincoln Electric Co., Linweld Inc., and Miller Electric Manufacturing Co. All drawings, welding symbols, and welding terms conform to the latest edition of the American Welding Society (AWS) standards.

KNOWLEDGE PERFORMANCE

The competition will include a written knowledge exam that assesses practical knowledge of welding, including safety, measurement, and blueprint reading. Other common fabrication operations will also be assessed, such as saw operation, drilling, grinding, and material handling. Competitors are also required to take the SkillsUSA Professional Development Test. Competitors will take the NYS Skills PDT online.

SKILL PERFORMANCE

The skill performance assessment includes the completion of a metal project and a demonstration of the ability to weld carbon steel, aluminum, or a stainless-steel project in various positions using a variety of filler metals. Competitors will be involved in completing a metal project involving various manufacturing methods.

COMPETITION GUIDELINES

1. Competitors must correctly use the welding equipment during the competition. The competition chair and competition coordinator may stop competitors at any section of the competition if they deem a competitor's manner to be hazardous to either him- or herself or others. Such a stoppage shall disqualify the participant for that section of the competition. If the competitor is warned a second time, he or she will be disqualified as a competition participant.
2. While the competition is in progress, there shall be no communication between the competing teams or anyone else, except as directed by a judge, competition coordinator or competition chair. It is expected that team members will communicate with each other.
3. Time limits will be established on the competition procedure sheets for all segments of the test.
4. Evaluation of the completed project will be judged visually. Nondestructive and/or destructive tests may be used to complete the project evaluation.

5. Welding and cutting operation instructions will be specified in drawings and procedure sheets provided to the competitors.
6. Welding equipment used in the competition may be obtained from a variety of manufacturers and may include transformers, rectifiers, and/or inverters.
7. Filler metals will be compatible with the metals being welded and will be detailed on the competition procedure sheet. Instructions to the competitors will define more specifically the filler metals that may be used.
8. Welds will be evaluated visually using a rating system as established by the SkillsUSA technical committee. Nondestructive and/or destructive tests may be used to complete the project evaluation.
9. Final judging of the welded projects will be evaluated according to the difficulty of the assigned task and by using the following visual inspection criteria: dimensional accuracy, including distortion; conformity to drawing requirements, including determination of whether all welds have been completed and whether the finished welds conform to the required size and contour; and visual examination of the welds for cracks, undercut, overlap, crater fill, spatter, arc strikes, porosity, convexity, and reinforcement.

STANDARDS AND COMPETENCIES

WF 1.0—Identify safety standards on a test in accordance with ANSI Z49.

1.1. Demonstrate proper use and inspection of equipment used for protection of personnel.
1.2. Model proper work area operation.
1.3. Demonstrate proper use and inspection of equipment used for ventilation.
1.4. Demonstrate proper Hot Zone operation.
1.5. Demonstrate proper procedures for working in confined spaces.
1.6. Understand precautionary labeling.
1.7. Model proper use and inspection of equipment used for each required welding or thermal cutting process.

WF 2.0 — Demonstrate an understanding of practical measurement.

2.1. Identify basic metal-working tools used in measuring.
2.2. Use visual measuring tools to accuracy of $\frac{1}{64}$ of an inch.
2.3. Employ the components of a combination square set.
2.4. Use layout and marking tools as required.
2.5. Determine wire feed speed as indicated on drawing.

WF 3.0 — Read and interpret blueprints.

3.1. Apply information found in the information block of the drawing.
3.2. Read and understand three-dimensional drawings.
3.3. Identify the basic views used in blueprints including assembly, detail, and fit-up drawings.
3.4. Identify common types of lines, abbreviations, and symbols in accordance with national drawing standards (ANSI).
3.5. Identify basic welding symbols and components of a symbol (such as arrow, reference line, tail, size, or length) in accordance with the current national welding symbol standard, AWS A 2.4, current edition.

WF 4.0 — Produce welds using a Shielded Metal Arc Welding (SMAW) process to AWS QC10 standards.

4.1. Demonstrate safety procedures for SMAW.
4.2. Demonstrate ability to correctly set up SMAW power sources and related welding equipment and do basic process and equipment troubleshooting.
4.3. Correctly identify base metal prior to welding.
4.4. Set up and shut down equipment for welding carbon steel and/or stainless-steel.
4.5. Select the correct type of filler metal size of electrode based on carbon steel and/or stainless-steel plate (¼-inch to ½-inch thickness).
4.6. Prepare carbon steel and/or stainless-steel for welding.
4.7. Start, stop, and restart stringer beads on carbon steel and/or stainless-steel in the flat, horizontal, vertical up and down, and overhead positions.
4.8. Weld a pad with a multiple-pass weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and down, and overhead positions.
4.9. Weld a lap joint with a single-pass, fillet weld on carbon steel and stainless-steel sheet/plate in flat, horizontal, vertical up and down, and overhead positions.
4.10. Weld a lap joint with a multiple-pass, fillet weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and down, and overhead positions.
4.11. Weld a T-joint with a single-pass, fillet weld on carbon steel and stainless-steel sheet/plate in the flat, horizontal, vertical up and down, and overhead positions.
4.12. Weld a T-joint with a multiple-pass, fillet weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and down, and overhead position.
4.13. Weld a butt joint with a single-pass, square groove weld on carbon steel and stainless-steel sheet/plate in the flat, horizontal, vertical up and down, and overhead positions.
4.14. Weld a butt joint with a partial joint penetration, single pass, double V-groove weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and down, and overhead positions.
4.15. Weld a butt joint with a multiple-pass, V-groove weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and down, and overhead positions.
4.16. Weld a butt joint with complete joint penetration, multiple pass, double groove weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and down, and overhead positions.
4.17. Weld 2- to 8-inch diameter, schedules 40 to 80 carbon steel and stainless-steel pipe, single/multiple-pass V-groove weld in the 2G, 5G and 6G positions.
4.18. Lay out, weld, cut and prepare coupons for evaluation.
4.19. Test the prepared coupon.

WF 5.0—Produce welds using a Gas Metal Arc Welding (GMAW) process to AWS QC10 standards.

5.1. Demonstrate correct safety procedures for GMAW.
5.2. Demonstrate ability to correctly set up GMAW power sources and related welding equipment and do basic process and equipment troubleshooting.
5.3. Correctly identify base metal prior to welding.
5.4. Set up and shut down equipment for short circuiting, globular, spray and pulsed transfer welding of carbon steel, stainless-steel and/or aluminum.

5.5. Select the correct type of filler metal size of electrode, type of shielding gas, wire feed speed and voltage based on carbon steel, stainless-steel and/or aluminum sheet and/or plate (1⁄16-inch to 3⁄8-inch thickness).
5.6. Prepare the carbon steel, stainless-steel and/or aluminum for welding.
5.7. Start, stop, and restart stringer beads on carbon steel, stainless-steel and aluminum steel sheet/plate in the flat, horizontal, vertical up and down, and overhead positions.
5.8. Weld a pad with a multiple-pass weld on carbon steel, stainless-steel and aluminum sheet/plate in the flat, horizontal, vertical up and down and overhead positions.
5.9. Weld a lap joint with a single-pass, fillet weld on carbon steel, stainless-steel and aluminum sheet/plate in flat, horizontal, vertical up and down and overhead positions.
5.10. Weld a lap joint with a multiple-pass, fillet weld on carbon steel, stainless-steel and aluminum plate in the flat, horizontal, vertical up and down and overhead positions.
5.11. Interrupt root pass at midpoint and restart arc.
5.12. Weld a T-joint with a single-pass, fillet weld on carbon steel, stainless-steel and aluminum sheet/plate in the flat, horizontal, vertical up and down and overhead positions.
5.13. Weld a T-joint with a multiple-pass, fillet weld on carbon steel, stainless-steel and aluminum plate in the flat, horizontal, vertical up and down and overhead positions.
5.14. Weld a butt joint with a single-pass, square groove weld on carbon steel, stainless-steel and aluminum sheet/plate in the flat, horizontal, vertical up and down and overhead positions.
5.15. Weld a butt joint with a partial joint penetration; single-pass and double V-groove weld on carbon steel, stainless-steel and aluminum plate in the flat, horizontal, vertical up and down and overhead positions.
5.16. Weld a butt joint with a multiple-pass, V-groove weld on carbon steel, stainless-steel and aluminum plate in the flat, horizontal, vertical up and down and overhead positions.
5.17. Weld a butt joint with complete joint penetration; multiple-pass and double V-groove weld on carbon steel, stainless-steel and aluminum plate in the flat, horizontal, vertical up and down and overhead positions.
5.18. Weld 2- to 8-inch diameter, schedule 40 to 80 carbon steel, stainless-steel and aluminum pipe, single/multiple pass V-groove weld in the 2G, 5G and 6G positions.
5.19. Lay out, weld, cut and prepare coupons for evaluation.
5.20. Test prepared coupons.

WF 6.0 — Produce welds using a Fluxed Cored Arc Welding (FCAW) process to AWS QC10 standards.

6.1. Demonstrate correct safety procedures for FCAW.
6.2. Demonstrate ability to correctly set up FCAW power sources and related welding equipment and do basic process and equipment troubleshooting.
6.3. Correctly identify base metal prior to welding.
6.4. Set up and shut down equipment for welding carbon steel and/or stainless-steel.
6.5. Select the correct type of filler metal, size of electrode, type of shielding gas (if needed), wire feed speed and voltage based upon carbon steel and/or stainless-steel sheet and/or plate (1⁄16-inch to 3⁄8-inch thickness).
6.6. Prepare carbon steel and/or stainless-steel for welding.
6.7. Start, stop, and restart stringer beads on carbon steel and stainless-steel sheet/plate in the flat, horizontal, vertical up and overhead positions.

6.8. Weld a pad with a multiple-pass weld on carbon steel and stainless-steel sheet/plate in the flat, horizontal, vertical up and overhead positions.
6.9. Weld a lap joint with a single-pass, fillet weld on carbon steel and stainless-steel sheet/plate in flat, horizontal, vertical up and overhead positions.
6.10. Weld a lap joint with a multiple-pass, fillet weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and overhead positions. Stop and restart in the middle of the joint.
6.11. Weld a T-joint with a single-pass, fillet weld on carbon steel and stainless-steel sheet/plate in the flat, horizontal, vertical up and overhead positions.
6.12. Weld a T-joint with a multiple-pass, fillet weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and overhead positions.
6.13. Weld a butt joint with a single-pass, square groove weld on carbon steel and stainless-steel sheet/plate in the flat, horizontal, vertical up and overhead positions.
6.14. Weld a butt joint with a partial joint penetration, single pass, double V-groove weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and overhead positions.
6.15. Weld a butt joint with a multiple-pass, V-groove weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and overhead positions.
6.16. Weld a butt joint with complete joint penetration, multiple-pass, double V-groove weld on carbon steel and stainless-steel plate in the flat, horizontal, vertical up and overhead positions.
6.17. Weld 2- to 8-inch diameter, schedules 40 to 80 carbon steel and stainless-steel pipe, single/multiple pass V-groove weld in the 2G, 5G and 6G positions.
6.18. Lay out, cut, and prepare coupons for evaluation.
6.19. Test prepared coupons.

WF 7.0 — Produce welds using a Gas Tungsten Arc Welding (GTAW) process to AWS QC10 standards.

7.1. Demonstrate safety procedures for GTAW.
7.2. Demonstrate ability to correctly set up GTAW power sources and related welding equipment and do basic process and equipment troubleshooting.
7.3. Correctly identify base metal prior to welding.
7.4. Set up and shut down equipment for regular and pulsed welding of aluminum, stainless-steel and/or carbon steel.
7.5. Select the correct size and type of tungsten and/or filler metal based on aluminum, stainless-steel or carbon steel sheet and/or plate ($\frac{1}{16}$-inch to $\frac{1}{4}$-inch thickness).
7.6. Prepare aluminum, stainless steel and/or carbon steel for welding.
7.7. Start, stop, and restart stringer beads on aluminum, stainless-steel and carbon steel sheet/plate in the flat, horizontal, vertical up and down and overhead positions.
7.8. Weld a pad with multiple-pass weld on aluminum, stainless-steel and carbon steel sheet/plate in the flat, horizontal, vertical up and down and overhead positions.
7.9. Weld a lap joint with a single-pass, fillet weld on aluminum, steel, stainless-steel and carbon steel sheet/plate in flat, horizontal, vertical up and down and overhead positions.
7.10. Weld a lap joint with a multiple-pass, fillet weld on aluminum, stainless-steel and carbon steel plate in the flat, horizontal vertical up and down and overhead positions.
7.11. Weld a T-joint with a single-pass fillet weld on aluminum, stainless-steel and carbon steel sheet/ plate in the flat, horizontal, vertical up and down and overhead positions.

7.12. Weld a T-joint with a multiple-pass, fillet weld on aluminum, stainless-steel and carbon steel plate in the flat, horizontal, vertical up and down and overhead positions.
7.13. Weld a butt joint with a single-pass, square groove weld on aluminum, stainless-steel and carbon steel sheet/plate in the flat, horizontal, vertical up and down and overhead positions.
7.14. Weld a butt joint with a partial joint penetration, single-pass, double V-groove weld on aluminum, stainless-steel and carbon steel plate in the flat, horizontal vertical up and down and overhead positions.
7.15. Weld a butt joint with a multiple-pass, V-groove weld on aluminum, stainless-steel and carbon steel plate in the flat, horizontal, vertical up and down and overhead positions.
7.16. Weld a butt joint with complete joint penetration, multiple-pass and double V-groove weld on aluminum, stainless-steel and carbon steel plate in the flat, horizontal, vertical up and down and overhead positions.
7.17. Weld 2- to 8-inches diameter, schedules 40 to 80 aluminum, stainless-steel, carbon steel pipe, single/multiple pass V-groove weld in the 2G, 5G and 6G positions.
7.18. Lay out, weld, cut and prepare coupons for evaluation.
7.19. Test prepared coupons.

WF 8.0 — Produce cut materials using an Oxygen Fuel Cutting (OFC) process to AWS QC10 standards.

8.1. Demonstrate safety procedures for OFC.
8.2. Demonstrate ability to correctly set up the OAC equipment for cutting and do basic process troubleshooting.
8.3. Correctly identify base metal prior to cutting.
8.4. Set up and shut down equipment for cutting carbon steel plates.
8.5. Select correct tip size and gas pressure for serving carbon steel plate (1⁄4-inch to 1⁄2-inch thickness).
8.6. Prepare carbon steel for cutting.
8.7. Cutting operations will be specified in drawings and procedure sheets provided to the competitors.
8.8. Properly light, adjust the flame on and shut down the oxygen fuel equipment.
8.9. Use a straight edge and soapstone laying out the prescribed pattern.
8.10. Make a square cut on carbon steel in flat, horizontal, vertical, and overhead positions.
8.11. Make a bevel cut (45-degree angle) on a carbon steel plate in the flat, horizontal, vertical, and overhead positions.
8.12. Pierce a hole in carbon steel in the flat, horizontal, vertical, and overhead position.
8.13. Make a pipe and tubing cut on carbon steel pipe in flat, horizontal, vertical, and overhead positions.
8.14. Make a gouge and groove cut on carbon steel in flat, horizontal, vertical, and overhead positions.
8.15. Lay out, weld, cut and prepare coupons for evaluation.
8.16. Test prepared coupon.

WF 9.0—Produce cut materials using a Plasma Arc Cutting (PAC) process to AWS QC10 standards.

9.1. Demonstrate safety procedures for PAC.
9.2. Demonstrate ability to correctly set up the PAC power sources and related cutting equipment and do basic process and equipment troubleshooting.
9.3. Correctly identify base metal prior to cutting.
9.4. Set up and shut down equipment for cutting carbon steel, stainless-steel and/or aluminum.
9.5. Select correct cutting head and gas pressure for severing carbon steel, stainless-steel or aluminum plate and/or sheet (1⁄16-inch to ¼-inch thickness).
9.6. Prepare carbon steel, stainless steel and/or aluminum for cutting.
9.7. Cutting operations will be specified in drawings and procedure sheets provided to the competitors.
9.8. Properly adjust and use the plasma arc equipment.
9.9. Use a straight edge and soapstone laying out the prescribed pattern.
9.10. Make a square cut on carbon steel, stainless-steel and aluminum sheet/plate in flat, horizontal, vertical, and overhead positions.
9.11. Make a bevel cut (45-degree angle) on carbon steel, stainless-steel and aluminum sheet/plate in the flat, horizontal, vertical, and overhead positions.
9.12. Pierce a hole on carbon steel, stainless-steel and aluminum sheet/plate in the flat, horizontal, vertical, and overhead position.
9.13. Make a pipe and tubing cut on carbon steel, stainless-steel and aluminum pipe in the horizontal position.
9.14. Make a gouge and groove cut on carbon steel, stainless-steel and aluminum sheet/plate in the flat position.
9.15. Lay out, cut, and prepare coupons for evaluation.
9.16. Test prepared coupon.

WF 10.0 — Demonstrate knowledge of visual inspection.

10.1. Examine and measure undercut.
10.2. Examine and measure porosity.
10.3. Measure fillet size.
10.4. Examine and measure weld reinforcement.
10.5. Determine acceptability of welded samples in accordance with provided acceptance criteria.

WF 11.0 — SkillsUSA Framework

The SkillsUSA Framework is used to pinpoint the Essential Elements found in Personal Skills, Workplace Skills, and Technical Skills Grounded in Academics. Students will be expected to display or explain how they used some of these Essential Elements. Please reference the graphic, as you may be scored on specific elements applied to your project. For more, visit: [www.skillsusa.org/who-we-are/skillsusa-framework/.](www.skillsusa.org/who-we-are/skillsusa-framework/)

COMMITTEE IDENTIFIED ACADEMIC SKILLS

The technical committee has identified that the following academic skills are embedded in this competition.

Math Skills

- Use fractions to solve practical problems.
- Measure angles.
- Construct three-dimensional models.

Science Skills

- Describe and recognize solids, liquids, and gases.
- Use knowledge of principles of electricity and magnetism.

Language Arts Skills

- Provide information for oral presentations.

CONNECTIONS TO NATIONAL STANDARDS

State-level academic curriculum specialists identified the following connections to national academic standards.

Math Standards

- Geometry
- Measurement
- Problem Solving
- Communication
- Connections
- Representation

Source: *NCTM Principles and Standards for School Mathematics. For more information, visit: www.nctm.org.*

Science Standards

- Understands the structure and properties of matter.
- Understands the sources and properties of energy.
- Understands forces and motion.
- Understands the nature of scientific inquiry.

Source: *McREL compendium of national science standards. To view and search the compendium, visit: www2.mcrel.org/compendium/.*

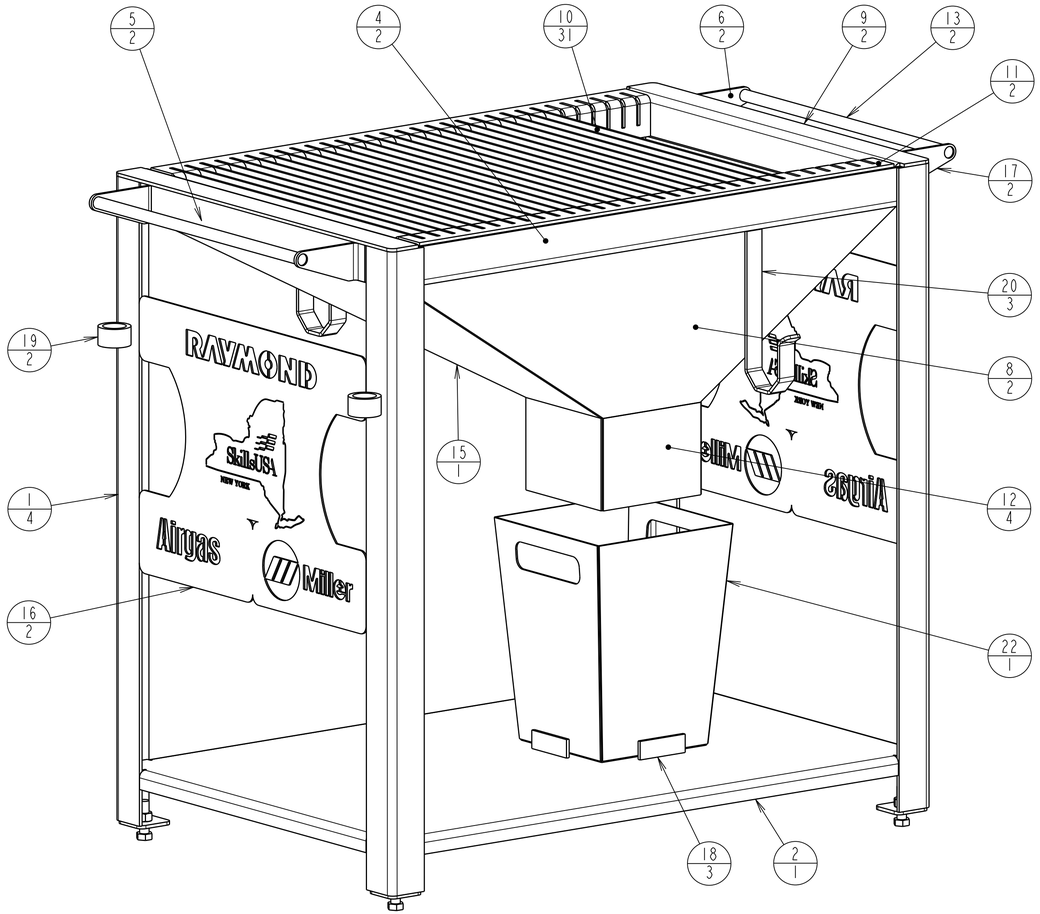
Language Arts Standards

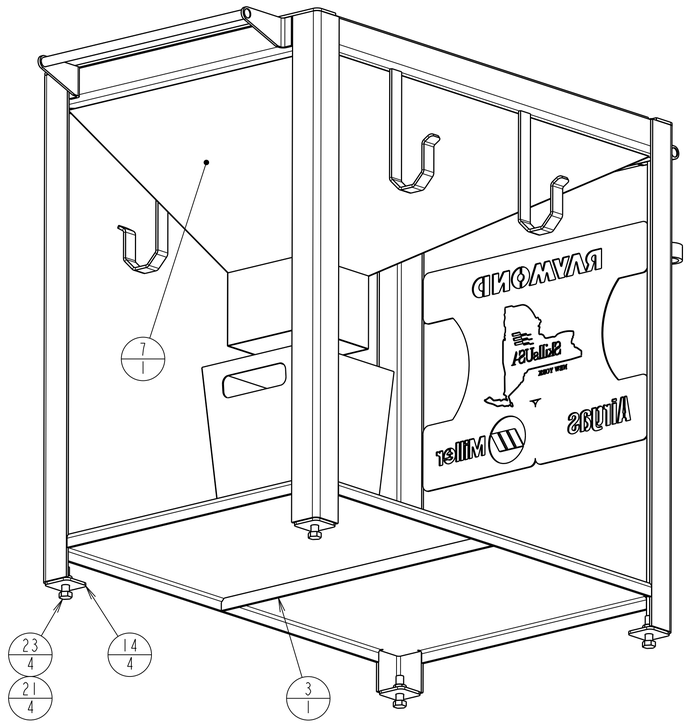
- Students apply a wide range of strategies to comprehend, interpret, evaluate, and appreciate texts. They draw on their prior experience, their interactions with other readers and writers, their knowledge of word meaning and of other texts, their word identification strategies and their understanding of textual features (e.g., sound-letter correspondence, sentence structure, context, graphics).

Source: *IRA/NCTE Standards for the English Language Arts. To view the standards, visit: www.ncte.org/standards.*

NOTES:

1. SMAW PROCESS WILL USE E7018 1/8"
2. GMAW PROCESS WILL USE ER70S-6 .030"/8mm WELD WIRE.





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6		20	PLASMA_TABLE-20	120-025	.179 LASERCUT & FORMED	3
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6		18	PLASMA_TABLE-18	120-045	.179 X 1.0 X 3.0	3
6		17	PLASMA_TABLE-17	120-045	.179 LASERCUT & FORMED	2
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6		9	PLASMA_TABLE-09	120-045	.179 LASERCUT & FORMED	2
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6		6	PLASMA_TABLE-06	120-045	.179 LASERCUT & FORMED	2
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4		3	PLASMA_TABLE-03	120-045	.179 LASERCUT	1
4		2	PLASMA_TABLE-02	120-045	.179 LASERCUT & FORMED	1
4		1	PLASMA_TABLE-01	120-045	.179 LASERCUT & FORMED	4
SHT	REMARKS	ITEM	NAME	MTL	SIZE	QTY

PRODUCTION PLASMA_TABLE

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE INCHES
TOLERANCES ARE:
DEGREES ± 1.0°
TWO PLACE DECIMALS ±0.12
THREE PLACE DECIMALS ±0.005

MATERIAL

HEAT TREAT ---

THIRD ANGLE PROJECTION

DATE 231218

DRAWN SCOTT.SHELDON

ENGR. APPROVAL

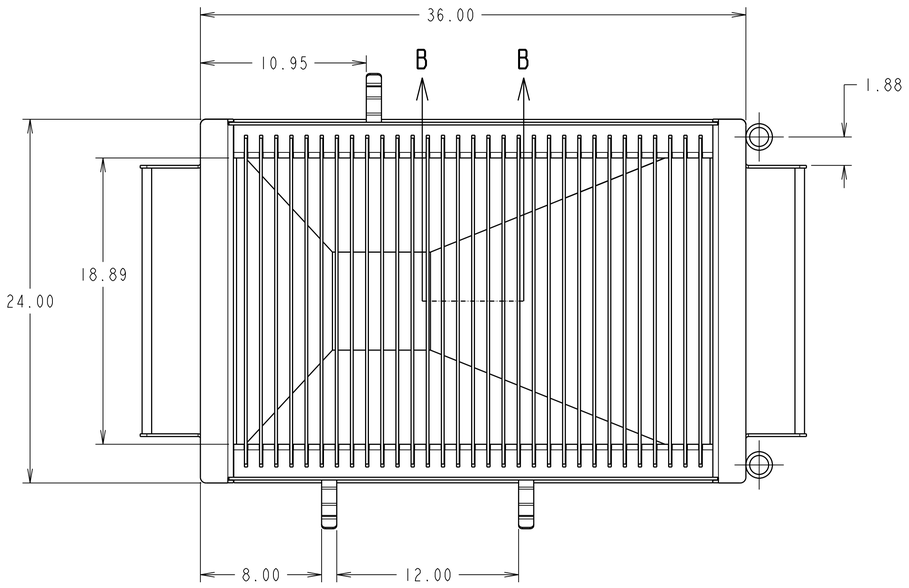
RAYMOND
THE RAYMOND CORPORATION GREENE, NY 13778 USA

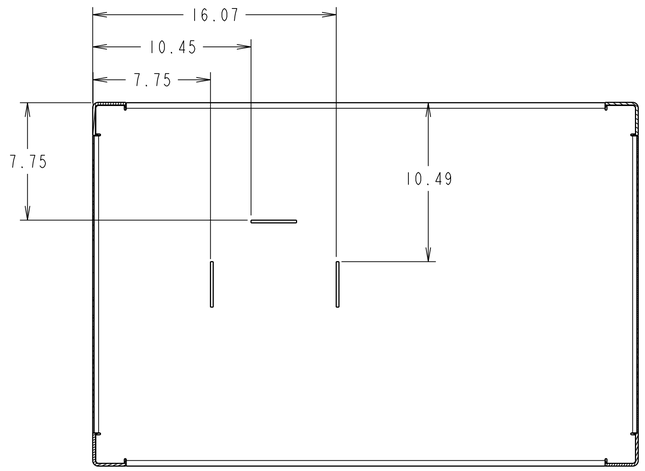
NAME PLASMA TABLE

SIZE D | DWG. NO. PLASMA_TABLE | REV. A

SCALE 1/2 | SHEET 1 OF 7

PRODUCED IN PRO/E





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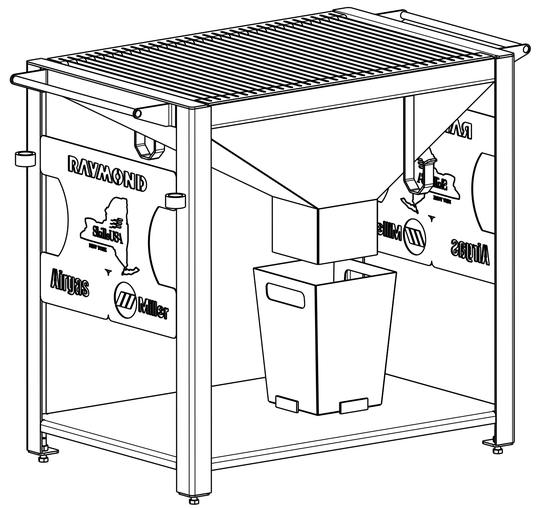
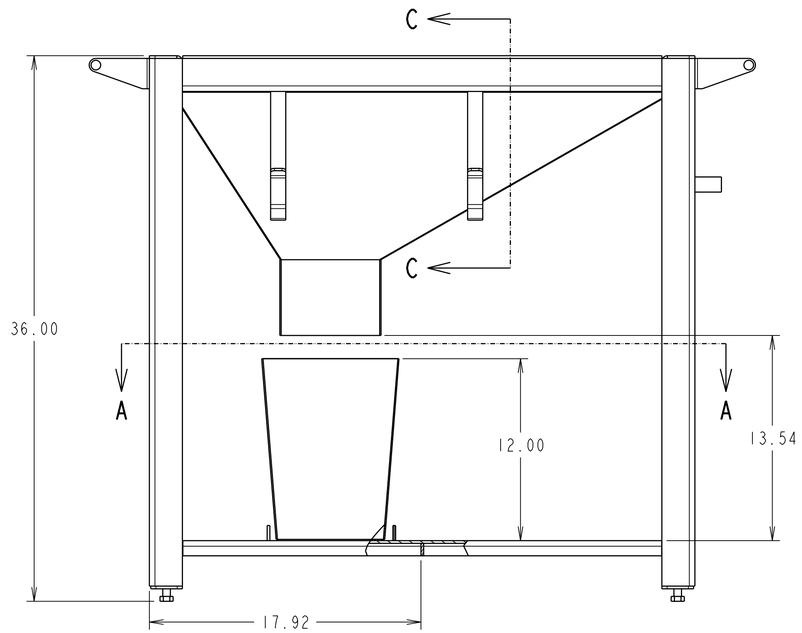
SCALE 1/5





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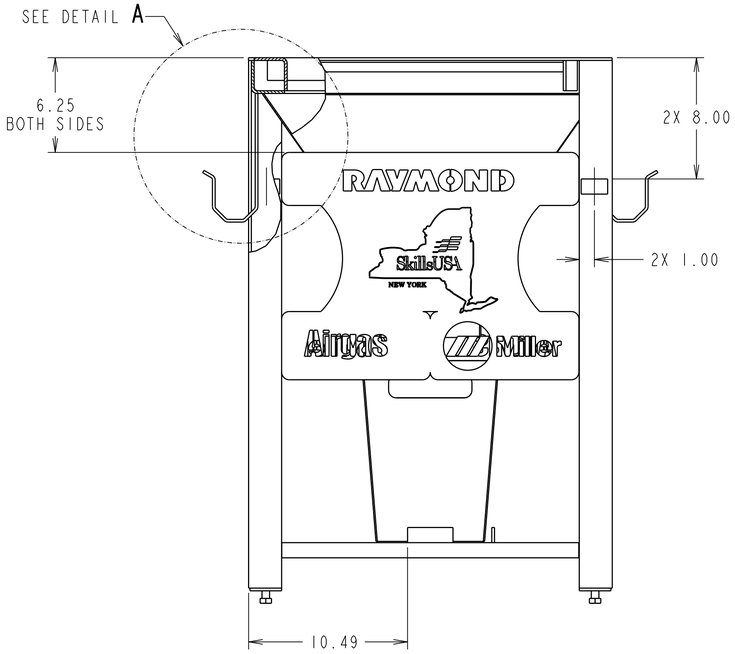
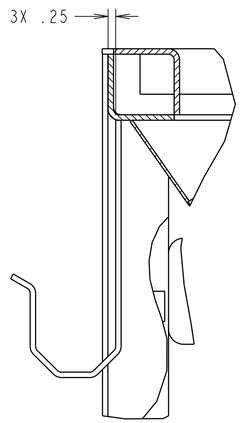
SCALE 1/5



SECTION C-C

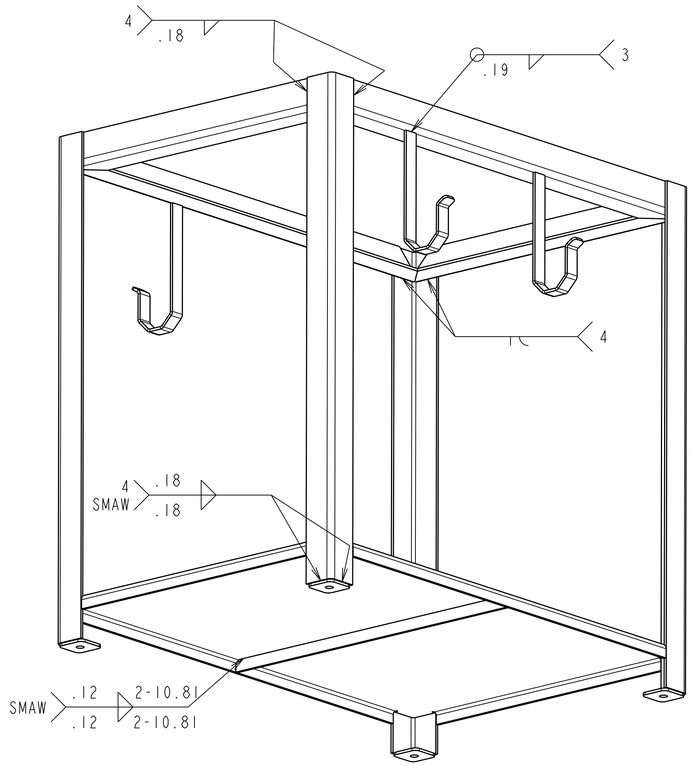


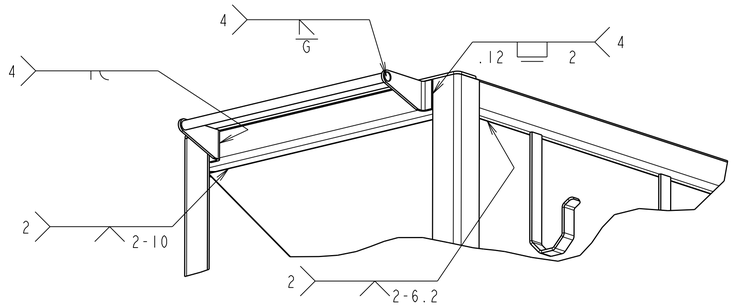
DETAIL A
SCALE 2/5

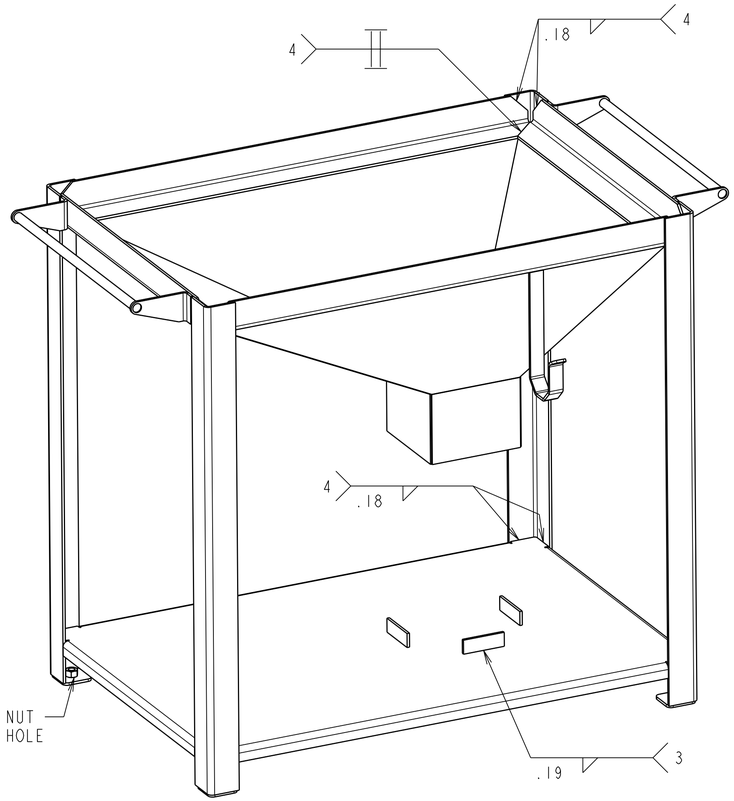
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE INCHES TOLERANCES ARE: DEGREES ± 1.0° TWO PLACE DECIMALS ±0.12 THREE PLACE DECIMALS ± ±0.005 MATERIAL HEAT TREAT	THIRD ANGLE PROJECTION DATE 231218 DRAWN SCOTT.SHELDON ENGR. APPROVAL	RAYMOND THE RAYMOND CORPORATION GREENE, NY 13778 USA NAME PLASMA TABLE SIZE D DWG. NO. PLASMA_TABLE REV. A SCALE 1/2 SHEET 2 OF 7

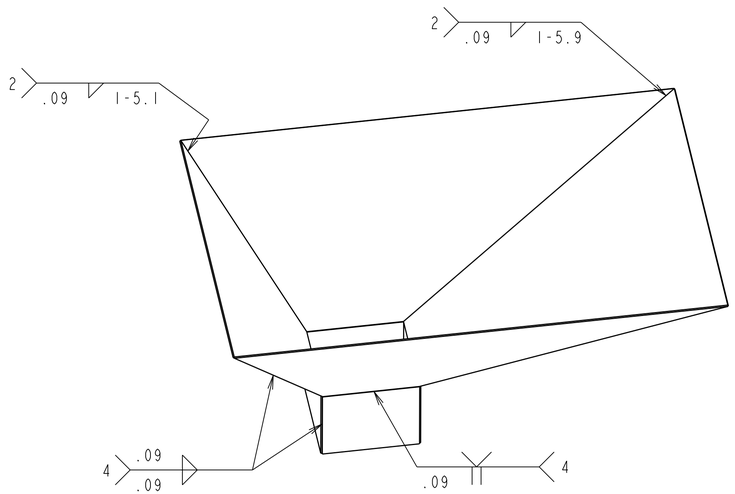
PLASMA_TABLE

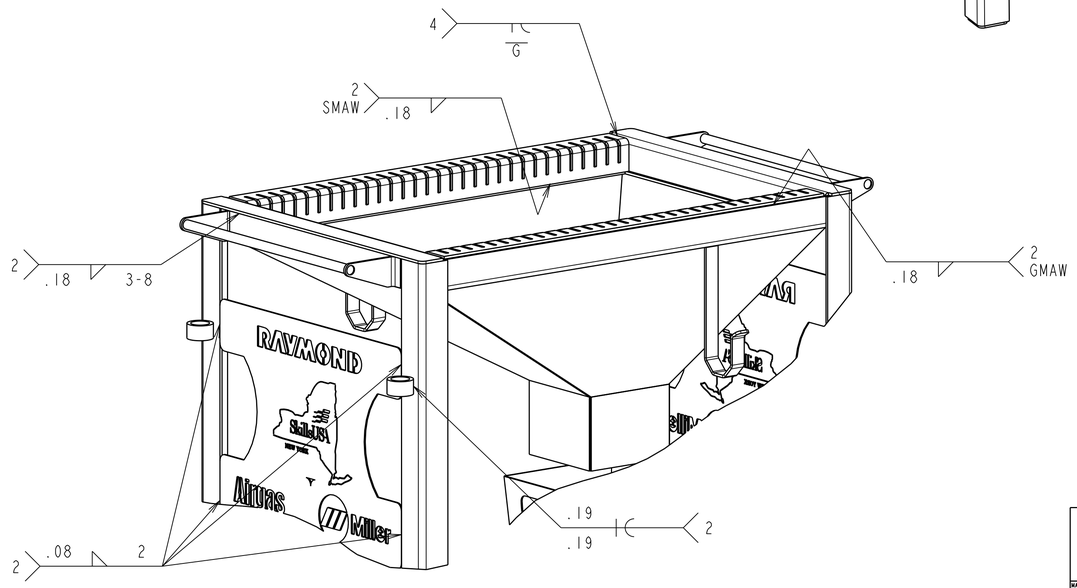
PRODUCED IN PRO/E







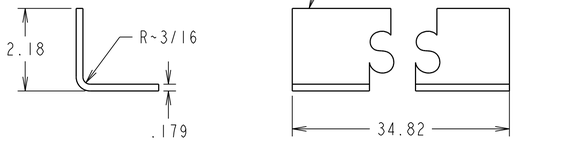




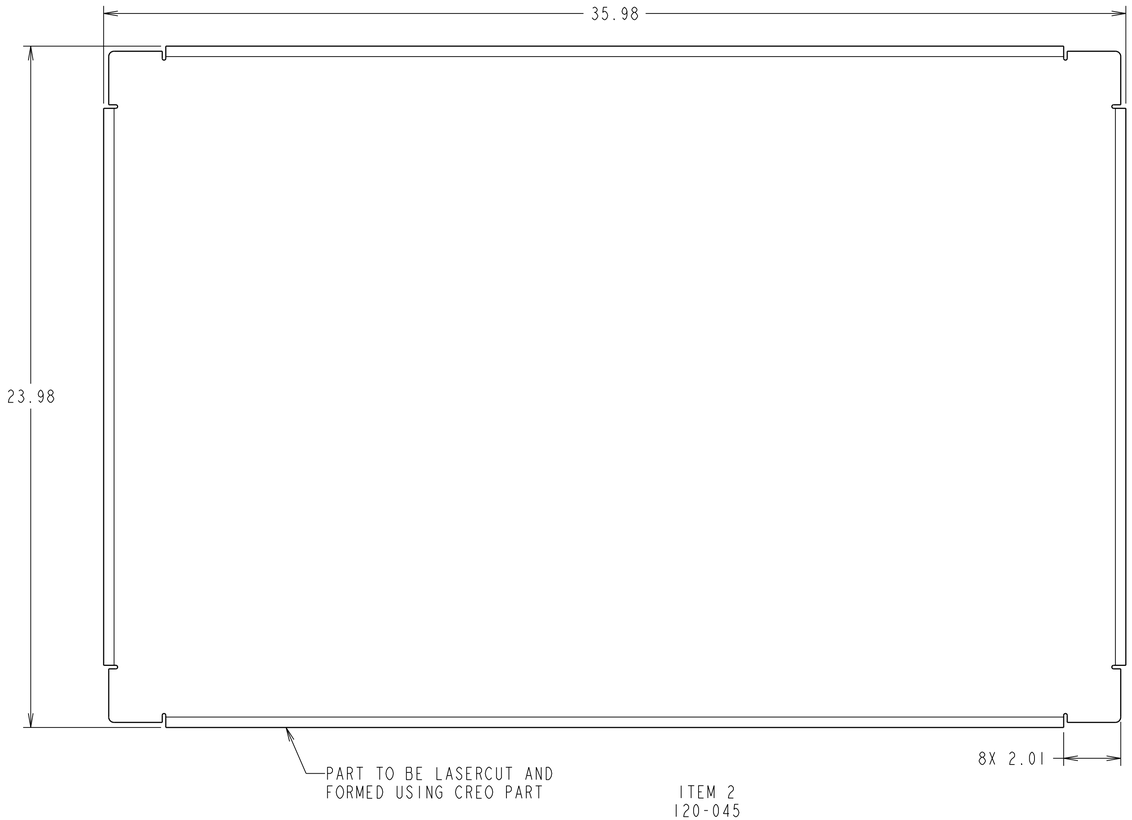
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE INCHES TOLERANCES ARE: DEGREES ± 1° TWO PLACE DECIMALS ±0.12 THREE PLACE DECIMALS = ±0.005	THIRD ANGLE PROJECTION	RAYMOND THE RAYMOND CORPORATION GREENE, NY 13778 USA	
MATERIAL	DATE 231218	NAME PLASMA TABLE	
	DRAWN SCOTT.SHELDON		
HEAT TREAT ---	ENGR. APPROVAL	SIZE D DWG. NO. PLASMA_TABLE REV. A	
		SCALE 1/2 SHEET 3 OF 7	

PRODUCED IN PRO/E

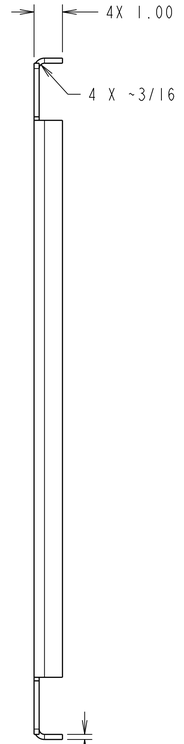
DWG NO. D PLASMA_TABLE

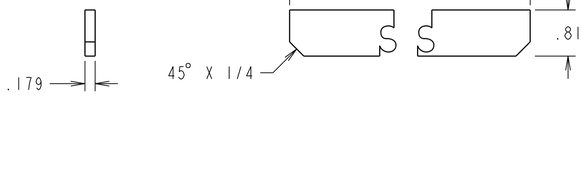


ITEM 1
120-045
4 REQ
SCALE 1/2

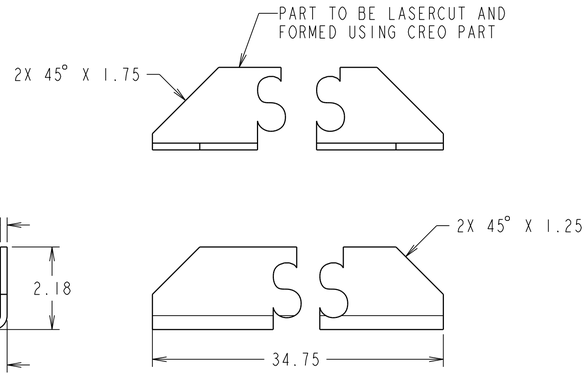


ITEM 2
120-045
1 REQ
SCALE 3/8

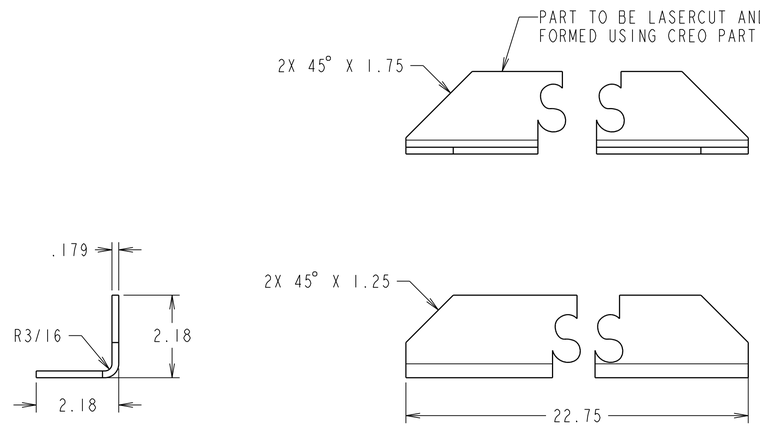




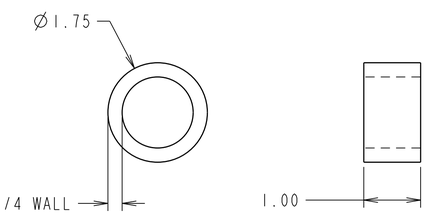
ITEM 3
120-045
1 REQ
SCALE 3/4



ITEM 4
120-045
2 REQ
SCALE 1/2



ITEM 5
120-045
2 REQ
SCALE 1/2

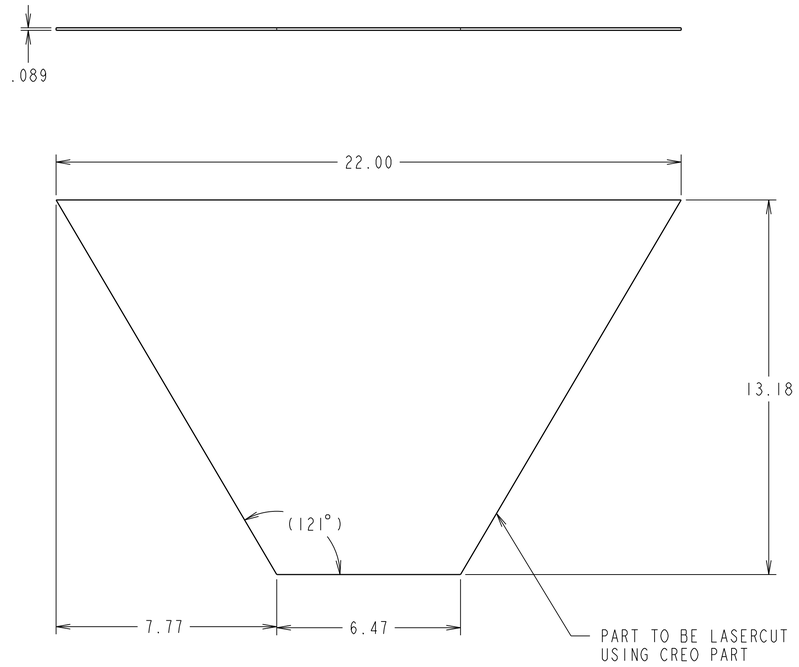


ITEM 19
HRS
2 REQ
SCALE 3/4

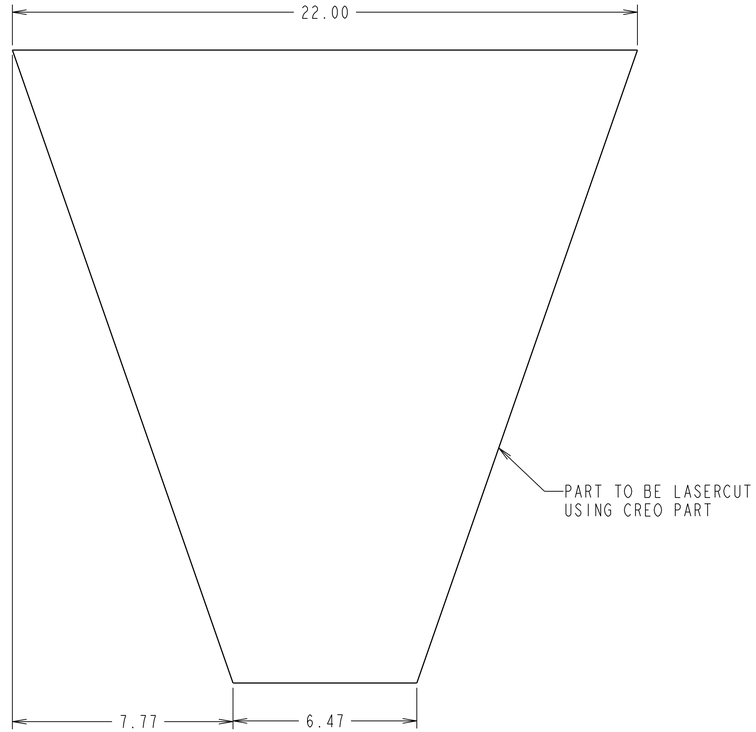
PLASMA_TABLE

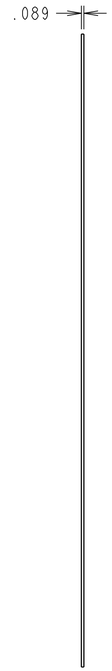
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE INCHES TOLERANCES ARE: DEGREES ± 1.0° TWO PLACE DECIMALS ±0.12 THREE PLACE DECIMALS ± ±0.005	THIRD ANGLE PROJECTION	RAYMOND THE RAYMOND CORPORATION GREENE, NY 13778 USA	
	DATE 231218	NAME PLASMA TABLE	
	DRAWN SCOTT.SHELDON		
MATERIAL	ENGR. APPROVAL	SIZE D DWG. NO. PLASMA_TABLE REV. A	
HEAT TREAT ---		SCALE 1/2	SHEET 4 OF 7

PRODUCED IN PRO/E

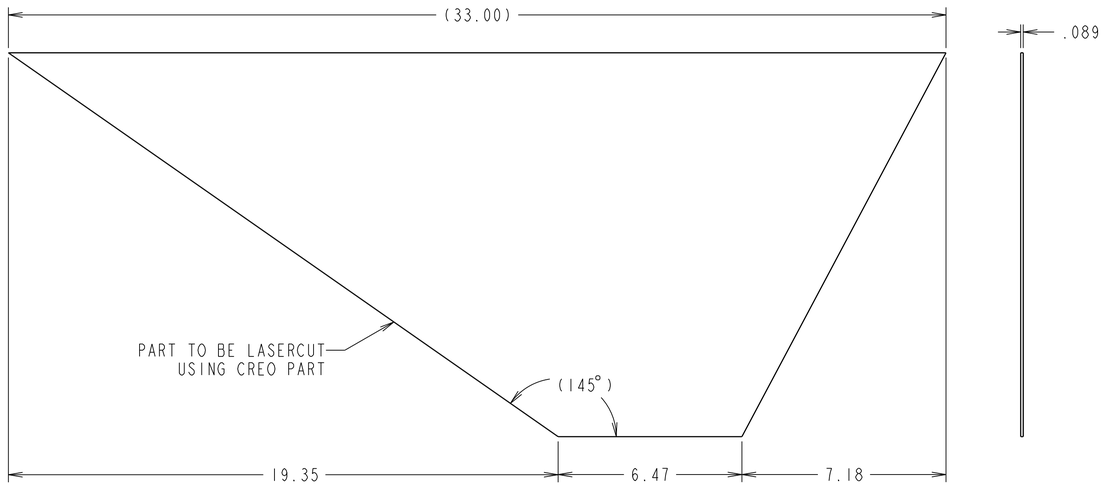


ITEM 7
120-018
1 REQ
SCALE 3/8

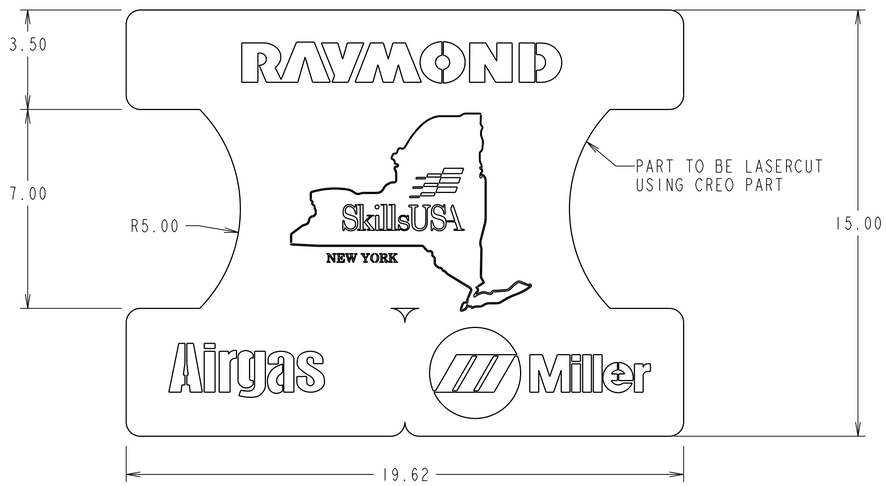




ITEM 15
120-018
1 REQ
SCALE 3/8



ITEM 8
120-018
2 REQ
SCALE 3/8

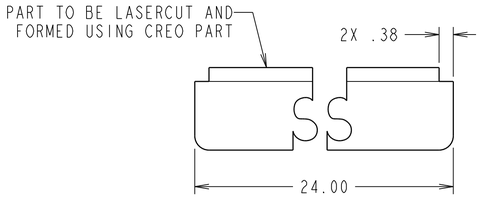


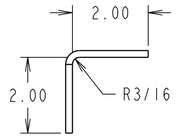
ITEM 16
120-018
2 REQ
SCALE 3/8

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE INCHES TOLERANCES ARE: DEGREES ± 1.0° TWO PLACE DECIMALS ±0.12 THREE PLACE DECIMALS ± ±0.005 MATERIAL HEAT TREAT	THIRD ANGLE PROJECTION DATE 231218 DRAWN SCOTT.SHELDON ENGR. APPROVAL	RAYMOND THE RAYMOND CORPORATION GREENE, NY 13778 USA NAME PLASMA TABLE SIZE D DWG NO. PLASMA_TABLE REV. A SCALE 1/2 SHEET 5 OF 7

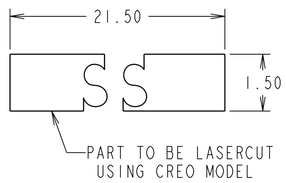
PRODUCED IN PRO/E

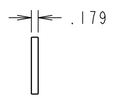
DWG NO. D PLASMA_TABLE



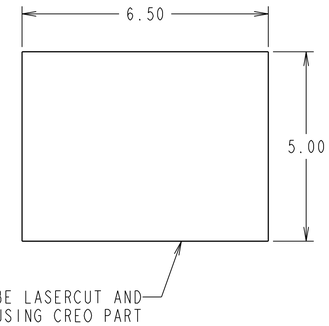


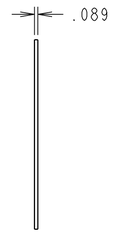
ITEM 9
TUBE
2 REQ
SCALE 1/2



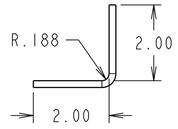


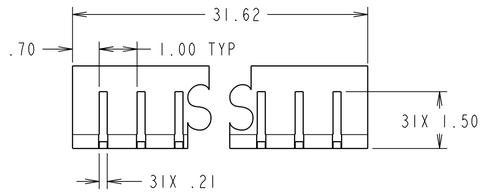
ITEM 10
120-045
31 REQ
SCALE 1/2

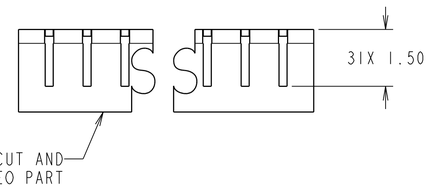




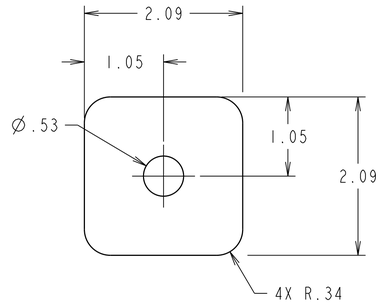
ITEM 12
120-018
4 REQ
SCALE 1/2

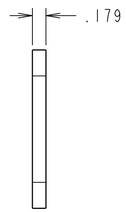




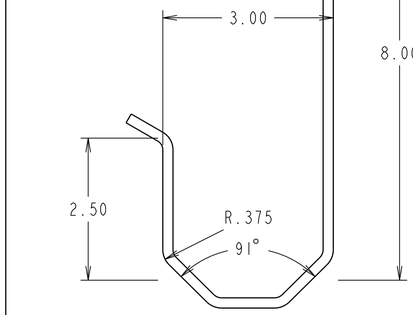


ITEM 11
120-045
2 REQ
SCALE 1/2

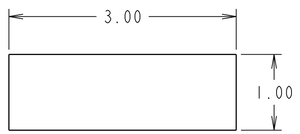


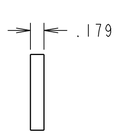


ITEM 14
120-045
4 REQ
SCALE
1/1

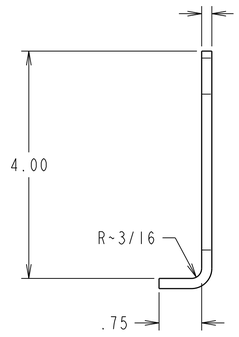


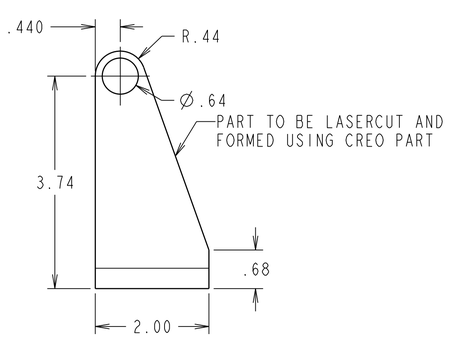
ITEM 20
120-045
3 REQ
SCALE 3/4



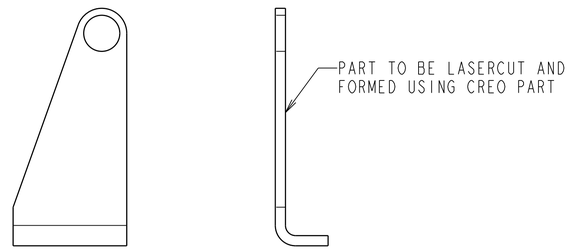


ITEM 18
HRS
3 REQ
SCALE 1/1

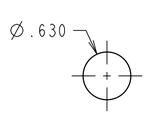


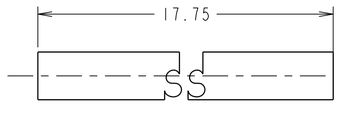


ITEM 6
120-045
2 REQ
SCALE 3/4



ITEM 17
120-045
2 REQ
SCALE 3/4





ITEM 13
HRS
2 REQ
SCALE 1/1

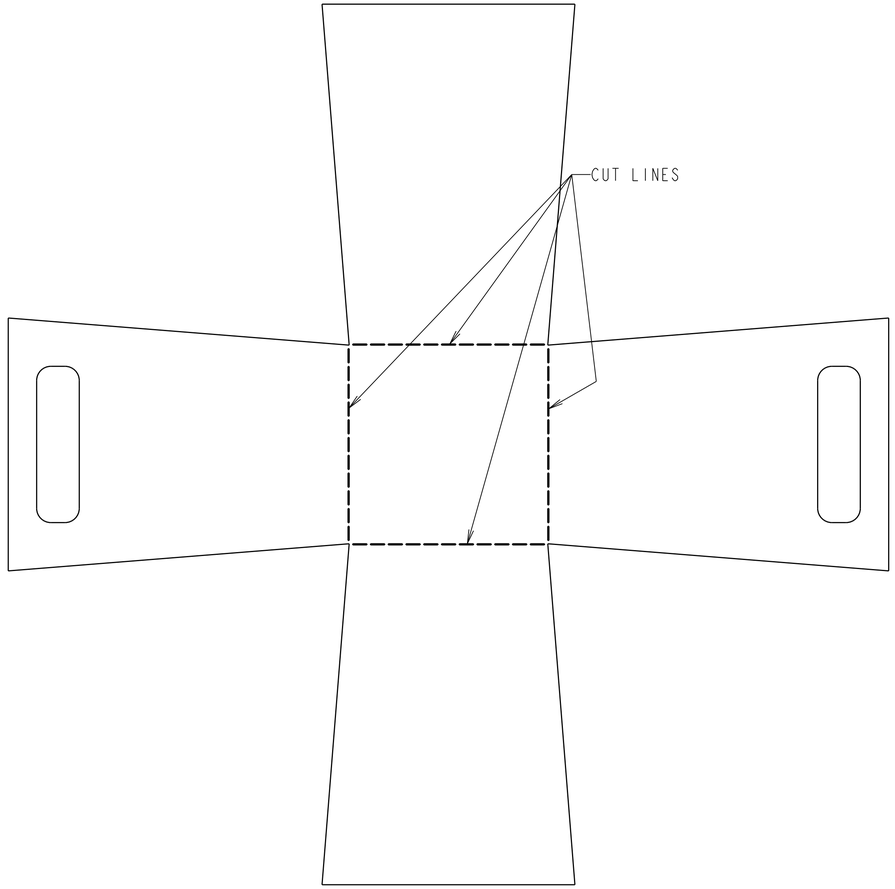
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE INCHES
TOLERANCES ARE:
DEGREES ± 1.0°
TWO PLACE DECIMALS ±0.12
THREE PLACE DECIMALS ± ±0.005
MATERIAL
HEAT TREAT

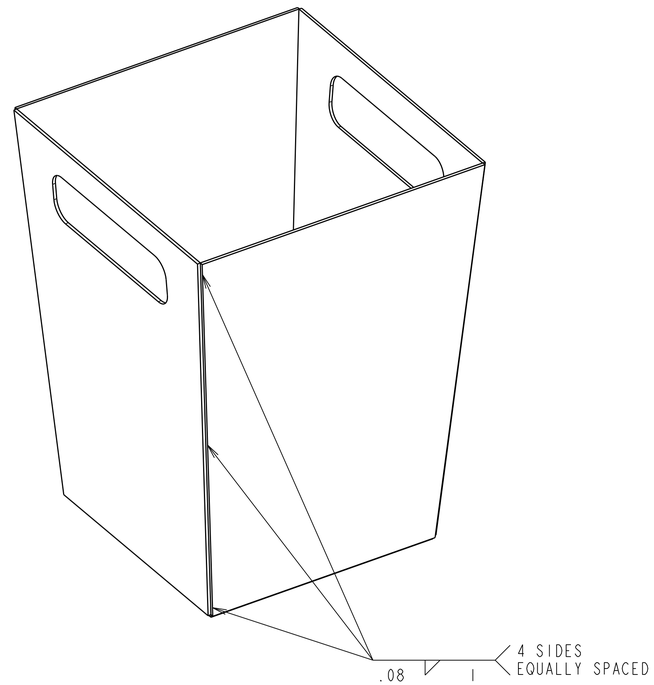
THIRD ANGLE PROJECTION
DATE 231218
DRAWN SCOTT.SHELDON
ENGR. APPROVAL

RAYMOND
THE RAYMOND CORPORATION GREENE, NY 13778 USA
NAME PLASMA TABLE
SIZE D DWG. NO. PLASMA_TABLE REV. A
SCALE 1/2 SHEET 6 OF 7

PRODUCED IN PRO/E

PLASMA_TABLE





PLASMA_TABLE

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE INCHES TOLERANCES ARE: DEGREES ± 1.0° TWO PLACE DECIMALS ±0.12 THREE PLACE DECIMALS ± ±0.005	THIRD ANGLE PROJECTION	RAYMOND THE RAYMOND CORPORATION GREENE, NY 13778 USA	
MATERIAL	DATE 231218	NAME PLASMA TABLE	
HEAT TREAT ---	DRAWN SCOTT.SHELDON	SIZE D	DWG. NO. PLASMA_TABLE	REV. A
	ENGR. APPROVAL	SCALE 1/2	SHEET 7 OF 7

PRODUCED IN PRO/E