

FIGURE 1. MG-20 MAST

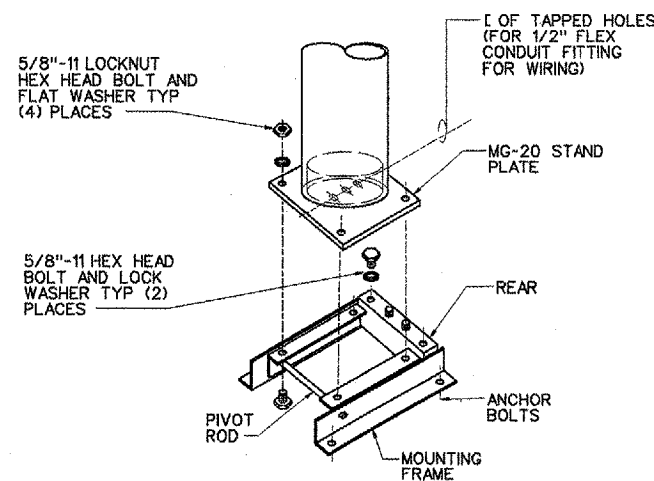


FIGURE 2. MOUNTING STAND ASSEMBLY MG-20

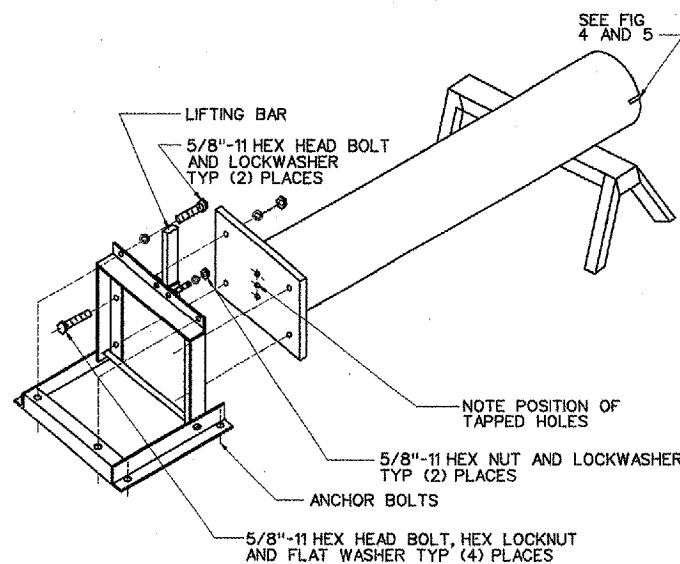


FIGURE 3. MG-20
 ERECTION DETAILS

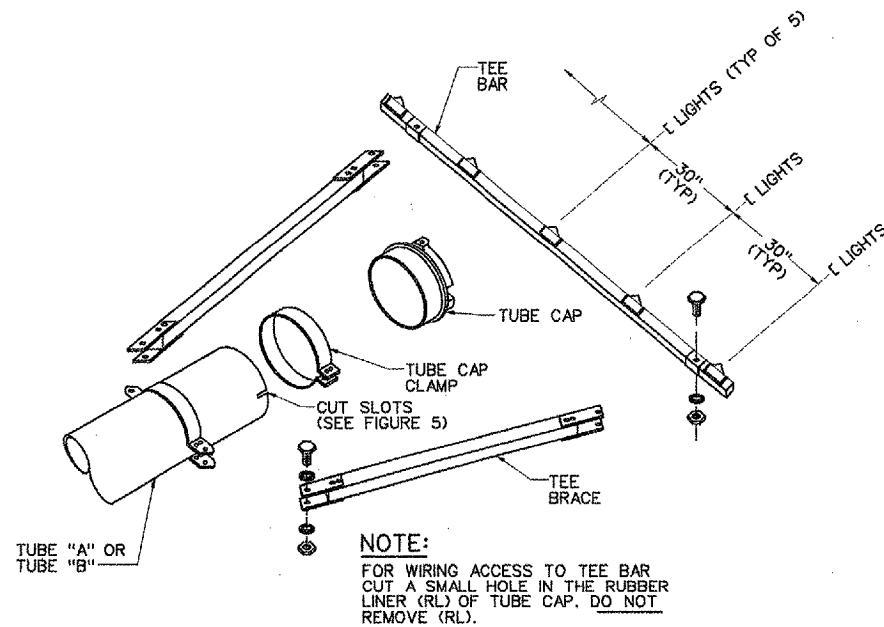


FIGURE 4. TEE-ASSEMBLY

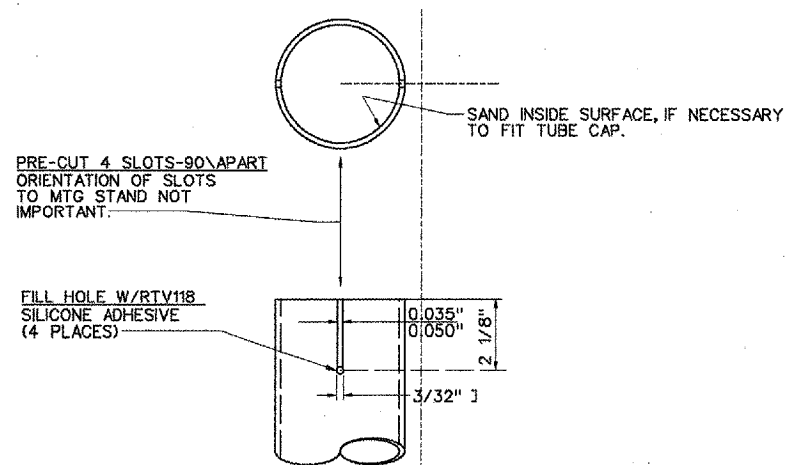
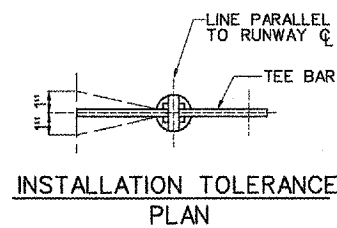


FIGURE 5. FACTORY CUT SLOTS & HOLES
 (FOR INSTALLING TUBE CAP)



INSTALLATION TOLERANCE
 PLAN

- CAUTION:** 1. BONDING INVOLVES USE OF CHEMICALS. FOLLOW MANUFACTURER'S PRECAUTIONS.
- CAUTION:** 2. BOND STRENGTH IS SENSITIVE TO SURFACE PREPARATION, TEMPERATURE AND CURE TIME. INCREASED TEMPERATURE CAN REDUCE CURE TIME. FOLLOW MANUFACTURER'S RECOMMENDATIONS.
- INFO:** POLE BASE ADHESIVE TO BE FURNISHED BY THE CONTRACTOR SHALL BE CHEMLOCK 304, PARTS 1 AND 2 - MANUFACTURED BY: LORD CORPORATION, CHEMICAL PRODUCTS GROUP, ERIE, PA., TEL (814) 868-3611
- CAUTION:** 3. 6 INCH I.D. (LIR) POLES: HANDLE WITH CARE. DO NOT LIFT BONDED STAND PLATE/LIR POLE ASSEMBLY BY THE LIR POLE ONLY.
- MATERIAL:** LIR TUBE (FIG. 2): FILAMENT WOUND GLASS REINFORCED PLASTIC.

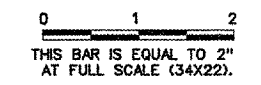
ASSEMBLY INSTRUCTIONS

- FOR MG-20 LIR STRUCTURE, DETERMINE REQUIRED POLE LENGTH BASED ON TOWER HEIGHT SHOWN ON DWG. PLAN AND PROFILE - 2. FIELD VERIFIED.
- BONDING INSTRUCTIONS:
 ROUGHEN SURFACES TO BE BONDED, AS SHOWN IN FIG. 1 USING EMERY CLOTH. CLEAN ROUGHENED SURFACES THOROUGHLY WITH A SOLVENT (TRICHLOROETHYLENE OR ACETONE). MIX EQUAL PARTS OF CHEMLOCK 304-1 EPOXY RESIN AND 304-2 HARDENER, (BOTH CONTRACTOR FURNISHED), STIR THOROUGHLY BUT AVOID AIR INCLUSION. FOR EACH JOINT TO BE BONDED, SPREAD A LIGHT COAT OF MIXED ADHESIVE ON BOTH THE SURFACES TO BE BONDED. FOR MG-20: SLOWLY SLIDE POLE ONTO STAND PLATE WHILE ROTATING IT TO EXCLUDE AIR. CURE 48 HOURS AT ROOM TEMPERATURE ABOVE 67 DEGREES F (SEE NOTE 1) AS REQUIRED.
- ASSEMBLY INSTRUCTIONS:
 IMPORTANT - ALL LIR STRUCTURES ARE TO BE ASSEMBLED IN A HORIZONTAL POSITION (SEE FIG. 3). (ELECTRICAL WORK NOT SHOWN HERE).
 MG-20: USE MOUNTING STAND ASSEMBLY SHOWN IN FIG. 2. SET MOUNTING STAND ON ANCHOR BOLTS, SHIM TO LEVEL. FASTEN WITH (4) 3/4" NUTS. REMOVE 2 5/8" BOLTS AT REAR OF MOUNTING STAND ASSEMBLY AND PIVOT INNER SECTION UP TO VERTICAL POSITION. PLACE STAND PLATE (BOTTOM OF POLE) OVER (4) 5/8" STUDS IN MOUNTING STAND AND FASTEN WITH HEX NUTS. NOTE POSITION OF TAPPED HOLES IN STAND PLATE.

NOTES:

- EACH LIR POLE SHALL BE CUT ACCURATELY, AND BONDED AND CURED PROPERLY IN A SUITABLE WORK ROOM.
- BASE OF EACH LIR STRUCTURE SHALL BE GROUNDED ELECTRICALLY IN FIELD. FOR GROUNDING DETAILS SEE DWG MALS MG-20 LIR TOWER - 2 AND DWG RAIL MG-20 LIR TOWER - 1.
- EACH LIR STRUCTURE SHALL BE MAINTAINED PER MANUFACTURER'S INSTRUCTION BOOK.
- CONTRACTOR SHALL PROVIDE BONDING GLUE SPECIFIED BY POLE MANUFACTURER UNLESS OTHERWISE NOTED.
- THE STAND PLATE AND MOUNTING STAND ASSEMBLIES COME PREASSEMBLED.

REVISIONS		
NUMBER	BY	DATE



BLOOMINGTON-NORMAL AIRPORT AUTHORITY
 CENTRAL ILLINOIS REGIONAL AIRPORT
 BLOOMINGTON, ILLINOIS
 LIR ASSEMBLY DETAILS - 2

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DESIGN BY:	TM
DRAWN BY:	CMT
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APPROVED BY:	RW
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