

## HEPI BSC Pier – Housing Location Procedure

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DCC RELEASE							

### 1. SCOPE

The purpose of this document is to provide step-by-step instructions in drilling and tapping the mounting holes for the HEPI housing, in the correct locations on top of the BSC piers.

### 2. APPLICABLE DOCUMENTS

Listed below are all of the applicable and referenced documents for this task procedure:

D040083 HEPI BSC Pier Holes Template	D040084 HEPI Housing Installation Sleeve
D020004 HEPI Housing	D040001 HEPI BSC Top Assembly
E040011 HEPI Assembly and Installation Procedure	

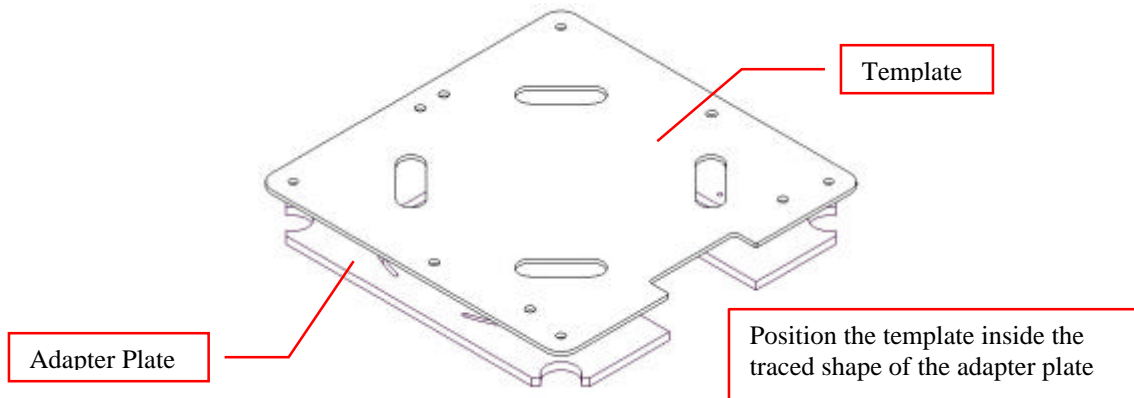
### 3. INSTALLING THE BSC PIER HOLES TEMPLATE

1. Take the payload off one corner of the BSC beam by using the lifting plate (D040078-A) and remove the existing installation (scissors table, etc) as described in E040011 HEPI Assembly and Installation Procedure. DO NOT remove the adaptor plate already placed on top of the pier.
2. Trace the sides of the adaptor plate with a permanent marker in the exact position it is clamped down, then remove it from the top of the pier.
3. Lift the BSC Pier Holes Template (D040083-B) up at the same level as the top of the pier by using a forklift or crane with straps attached to the four lifting and handling slots in the plate.

**Caution: Show extra care when lifting the template into position – the steel plate weighs approx. 30 lbs and could cause serious damage or injury if dropped from the top of the BSC pier.**

4. The template should then be positioned at the exact same location as the adapter plate, with its location defined by the matching traced shape of the adapter plate. Use C-clamps on each corner of the plate and attach it firmly to the top of the pier.

**Note: Make sure that the template is accurately positioned before clamping it down. The location of the mounting holes on top of the pier defines the position of the HEPI housing and has to be accurate.**

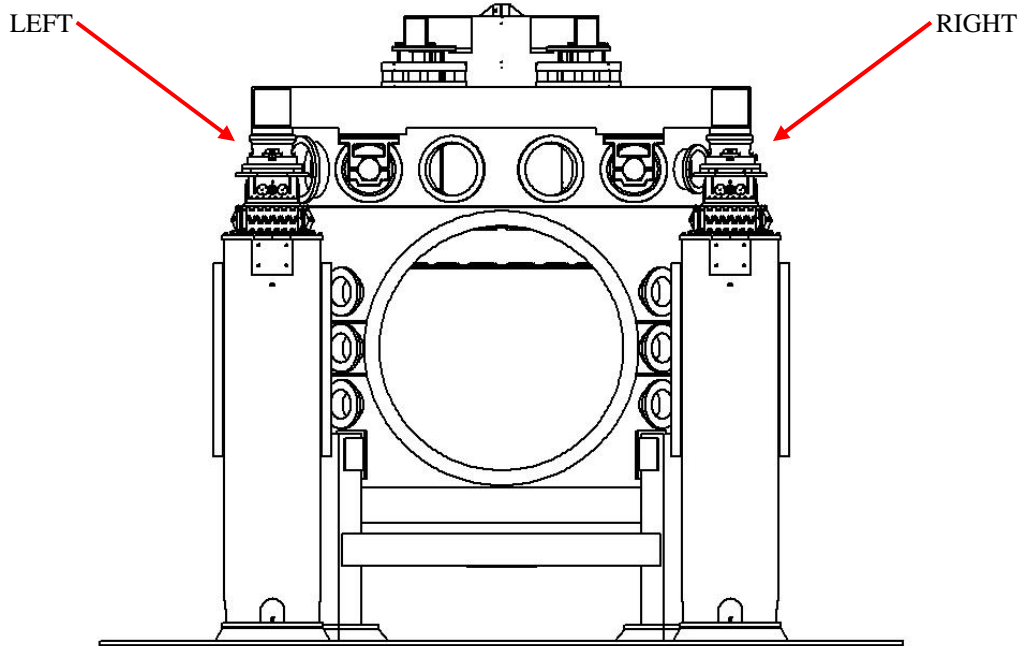




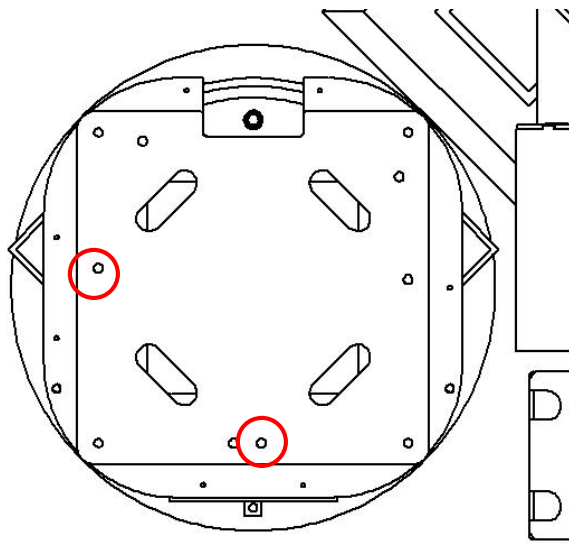
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### 4. DRILLING AND TAPPING THE LEFT SIDE MOUNTING HOLES

1. Identify the LEFT and RIGHT sides of the BSC crossbeam as shown below.



2. If positioned on a correctly identified LEFT side pier, create a punch mark through the two 1/2" clearance holes labeled LEFT (hole locations as shown below).



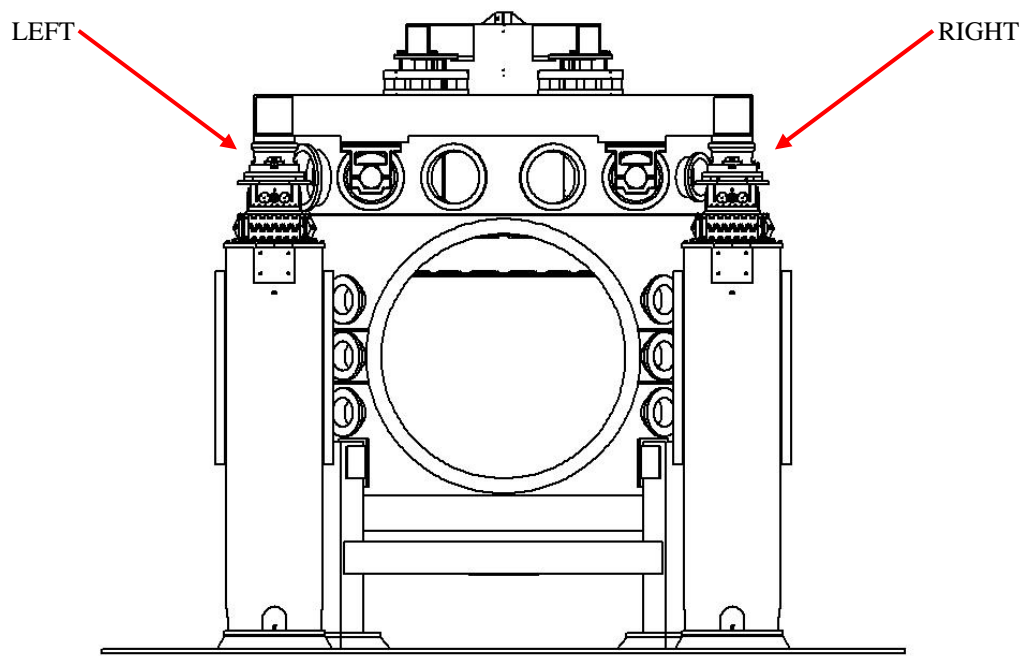
3. Position the mag-drill over each of these holes and drill through the top plate of the pier, then tap with 1/2-13.
4. Carefully clean the plate of any remains of the drill and tap operations and remove the template from the pier.



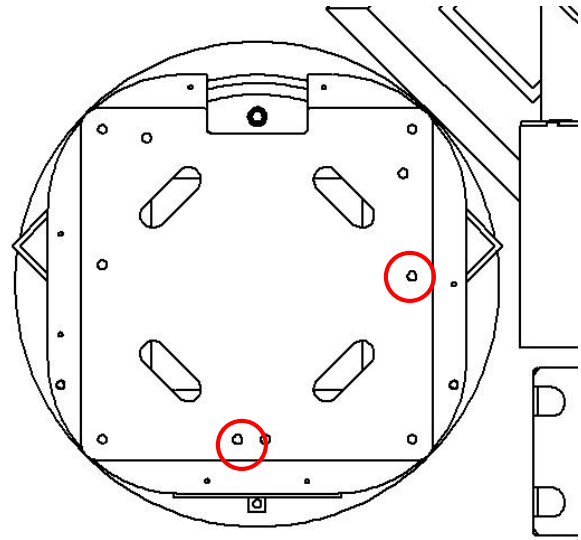
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### 5. DRILLING AND TAPPING THE RIGHT SIDE MOUNTING HOLES

1. Identify the LEFT and RIGHT sides of the BSC crossbeam as shown below.



2. If positioned on a correctly identified RIGHT side pier, create a punch mark through the two 1/2" clearance holes labeled RIGHT (hole locations as shown below).



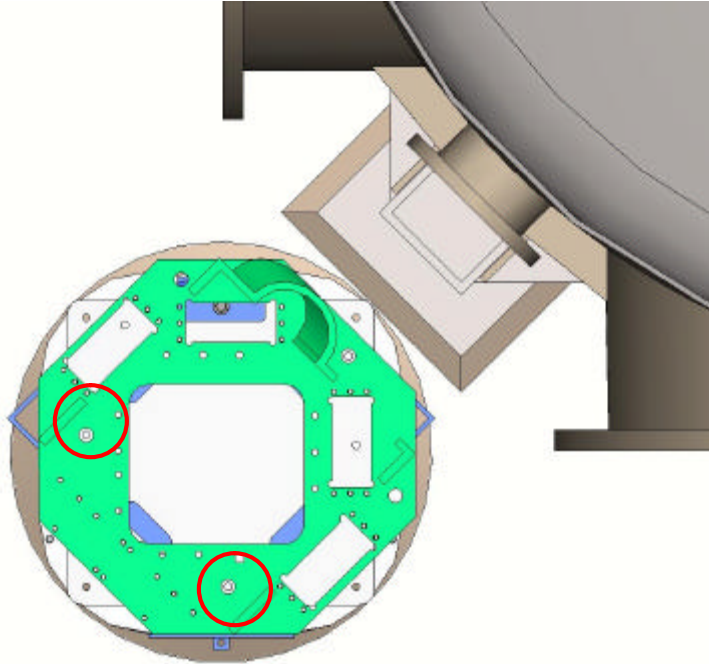
3. Position the mag-drill over each of these holes and drill through the top plate of the pier, then tap with 1/2-13.
4. Carefully clean the plate of any remains of the drill and tap operations and remove the template from the pier.



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**APPENDIX – LOCATION OF MOUNTING HOLES VERIFICATION**

*LEFT SIDE*



*RIGHT SIDE*

