### General Notes

1. Field verify controller cabinet bolt pattern and location prior to fabrication.
2. Groove size and fillet size are equal to material thickness.
3. All hardware shall be stainless steel.
4. All welding shall be GTAW.
5. Equipment bonding jumper shall be #8 AWG (min.) x 1' (ft) of tinned braided copper.
6. Place a 1/2" (in) bead of silicone between cabinet riser and foundation. Place a 1/2" (in) bead of silicone between cabinet riser and cabinet.

### Key Notes

1. Equipment bonding jumper
2. Single bonding jumper connection (see note 5)
3. Double bonding jumper connection (see note 6)

### Assembly Installation Steps

1. Liberally coat threads with anti-oxidant compound.
2. Snug nut 1 against back wall.
3. Install flat washers and full circle crimp connector(s).
4. With wrench on nut 1 and nut 2 snug nut 2 to nut 1 - tighten until the belleville spring washer is fully compressed and no further.
5. With wrench on nut 2 and nut 3 snug nut 3 to nut 2.
6. Liberally coat this assembly with anti-oxidant compound.

### Tolerances

- Angle: +1°
- Holes: ±0.02 / ±0.011

GTAW = GAS TUNGSTEN ARC WELDING

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**Notes:**

- **AA = ALUMINUM ALLOY**
- **BOLTS, NUTS, AND WASHERS**
  - Bolt - AA2024-T4 or AA 2024-T351
  - Nut - AA6061-T6
  - Washer - AA7075-T6

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**Material:**

1/8" (IN) SHEET ALUMINUM (3003-H32), MINIMUM THICKNESS. EXTRUDED CHANNEL OR FORMED CHANNEL MAY BE SUBSTITUTED FOR WELDED PLATE.

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**Bolt Hole Details:**

- Bolt hole slot (Typ.)
  - 3/4" (IN) Diam. (Typ.)
  - 18" x 1/2" GTAW (4 Places)

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**Equipment Bonding Jumper Connection Details:**

- SINGLE BONDING JUMPER CONNECTION
  - SEE SINGLE BONDING JUMPER CONNECTION DETAIL
- DOUBLE BONDING JUMPER CONNECTION
  - SEE DOUBLE BONDING JUMPER CONNECTION DETAIL

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**Notes:**

- **BOLTS, NUTS, AND WASHERS**
  - ASTM F593 or A193
  - TYPE 304 OR TYPE 316 STAINLESS STEEL (S.S.)

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**AA = ALUMINUM ALLOY**

- **BOLT - AA2024-T4 OR AA 2024-T351**
- **NUT - AA6061-T6**
- **WASHER - AA7075-T6**
332 RISER ADAPTOR SPLIT BASE

TOP VIEW

BOTTOM VIEW

END VIEW

BOLT HOLE SLOT (TYP.)

FLAT WASHERS

NUTS

RISER ADAPTOR SECTIONS

DETAIL (EXPLODED VIEW)

SECTION A

SECTION B

332 CONTROLLER CABINET RISER DETAILS