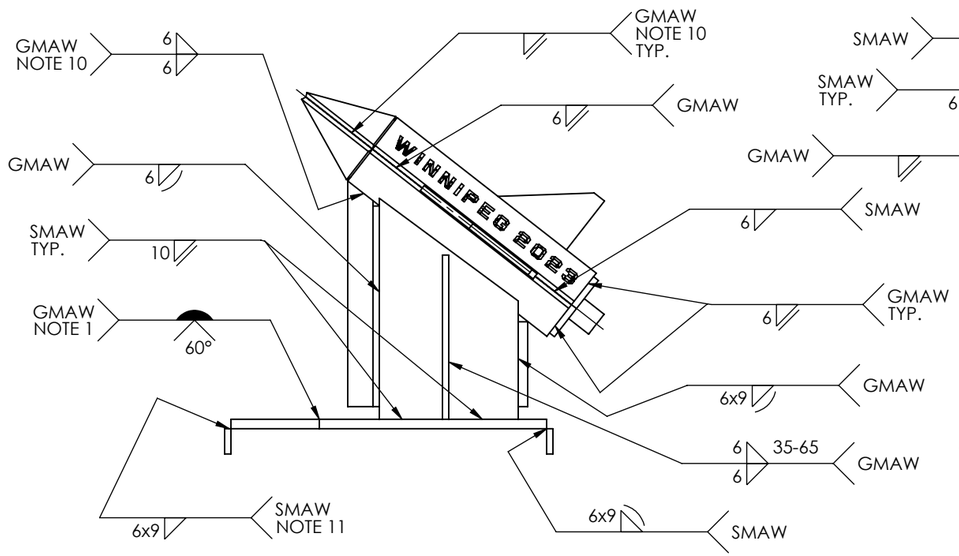
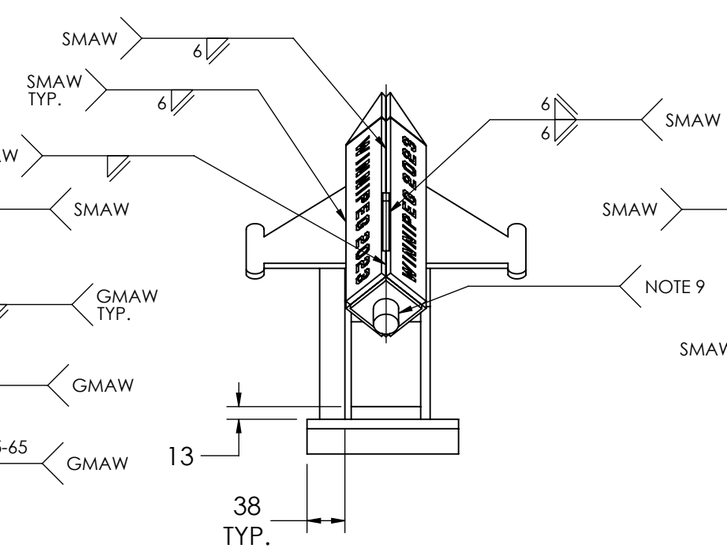
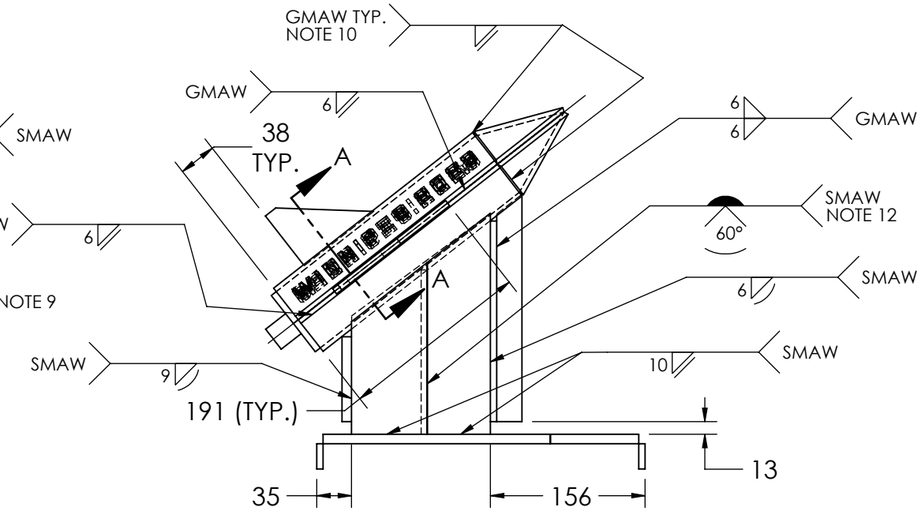


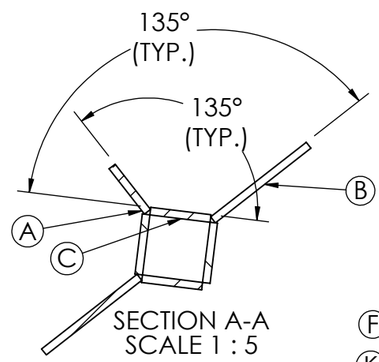




NOTE: No edging is required. Winnipeg 2023 will not be engraved into the jet for the Provincial Skills Canada Competition.

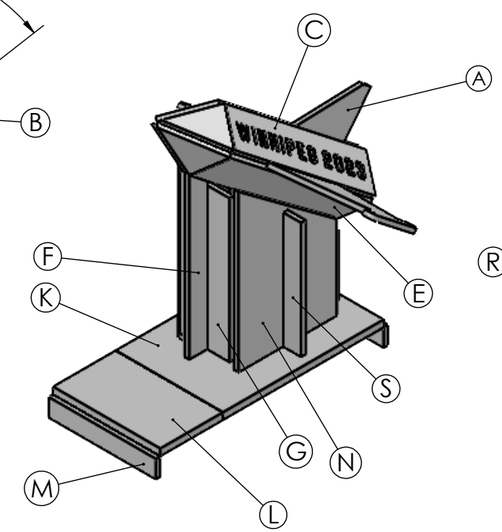
1. ROOT GAP AND ROOT FACE FOR GROOVE WELDS, COMPETITOR'S CHOICE
2. UNLESS OTHERWISE STATED, USE E4918 FOR ALL SMAW AND ER49S-6 FOR ALL GMAW
3. ALL VERTICAL WELDS TO BE VERTICAL UP UNLESS OTHERWISE NOTED
4. FIT AND TACK ONLY, THEN OBTAIN SIGN-OFF BEFORE WELDING
5. ONCE TACKED, BASE PLATES (K & L) MUST REMAIN FLAT FOR ALL WELDING, WELDS ARE DONE IN-POSITION
6. BLEND ALL WELDS
7. TACK "JET ASSEMBLY" TO CENTER OF ITEMS G & P
8. CENTER ITEM F ON ITEM G
9. CENTER ITEM Q ON ITEM R, TACK WELD WITH 4 SMALL TACKS, 90°APART
10. VERTICAL DOWN IS PERMITTED FOR WELDS WITH THIS NOTE ONLY
11. USE E4310 ELECTRODES FOR WELDS WITH THIS NOTE
12. E4310 ROOT / E4918 FILL&CAP

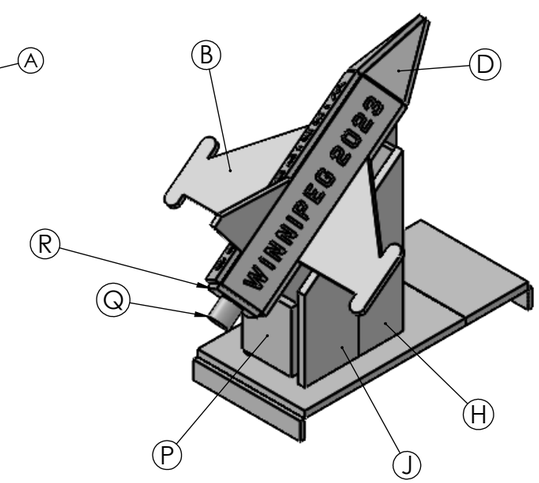
REMARQUE:

1. ESPACE RACINAIRE ET FACE RACINAIRE POUR RAINURE SOUDURES, LE CHOIX DU CONCURRENT
2. SAUF INDICATION CONTRAIRE, UTILISER E4918 POUR TOUS SMAW ET ER49S-6 POUR TOUS GMAW
3. TOUTES LES SOUDURES VERTICALES DOIVENT ÊTRE À LA VERTICALE À MOINS QUE AUTREMENT NOTÉ
4. FIT AND TACK UNIQUEMENT, PUIS OBTENEZ L'APPROBATION AVANT LE SOUDAGE
5. UNE FOIS FIXÉES, LES PLAQUES DE BASE (K & L) DOIVENT RESTEZ À PLAT POUR TOUTES LES SOUDURES, LES SOUDURES SONT FAIT EN POSITION
6. MÉLANGER TOUTES LES SOUDURES
7. FIXER « JET ASSEMBLY » AU CENTRE DES ARTICLES G & P
8. CENTRER ITEM F SUR ITEM G
9. CENTRER ITEM Q SUR ITEM R, SOUDURE PAR POINTAGE AVEC 4 PETITS TACKS, À 90°
10. LA DESCENTE VERTICALE EST AUTORISEE POUR LES SOUDURES AVEC CETTE NOTE SEULEMENT
11. UTILISER E4310 POUR LES SOUDURES AVEC CETTE NOTE
12. E4310 PASSE RACINE/ E4918 PASSES DE REMPLISSAGE ET DE CAPUCHON




SECTION A-A
SCALE 1 : 5




ALL DIMENSIONS IN MILLIMETERS/TOUTES LES DIMENSIONS SONT EN MILLIMÈTRES

| TITLE/TITRE | | | | SHEET # NO. DE PAGE: | SIZE/TAILLE: |
|---|---|---|---|---|---|
| PSCC 2023 JET - ASSEMBLY | | | | 1 OF 2 | B |
| DWG. NO./ DESSIN NO: SC2023-SP-2 | REV.: 1 | SCALE ÉCHELLE: 1:4 | CONCEPTION/ DESIGN M. DEUDA<br>DESSIN/DRAWN J. HYDE<br>DATE: 2023-01-28 | | |

READING LECTURE

NUMERACY CALCUL

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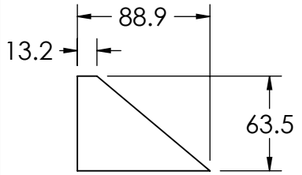
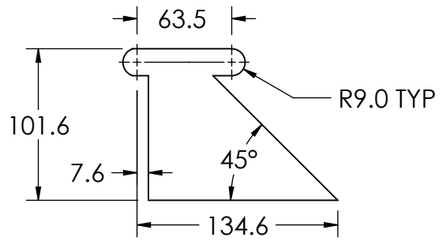
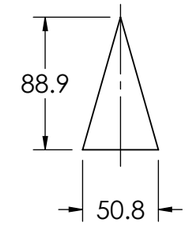



ITEM A




ITEM B

ITEM C

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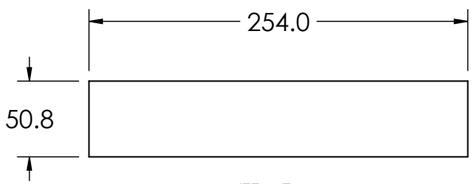
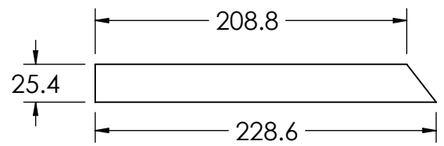



ITEM E

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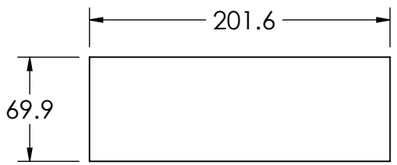


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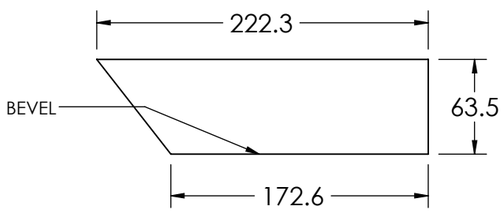


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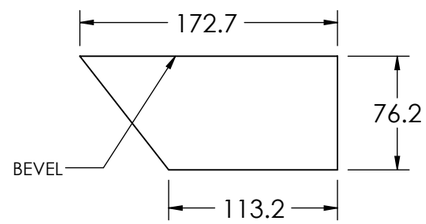


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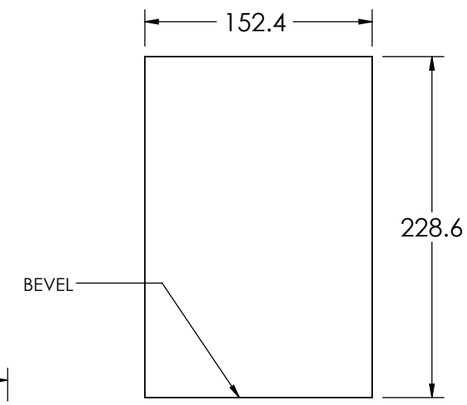


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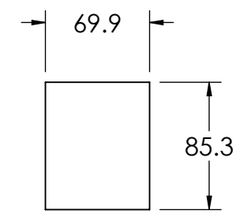


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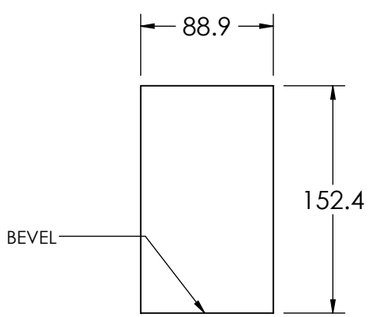


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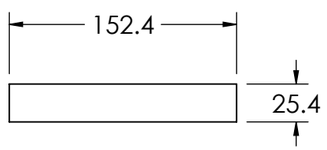


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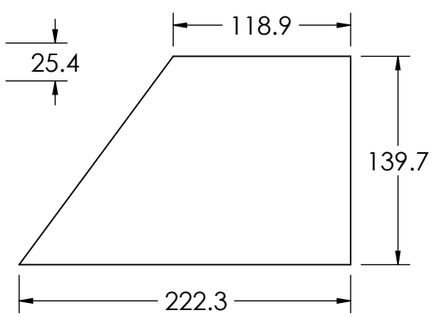


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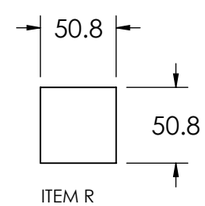
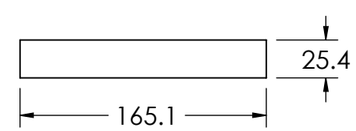



ITEM R



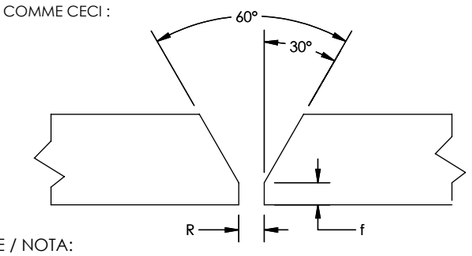

ITEM S

## BILL OF MATERIALS - LISTE DE MATÉRIAUX

| ITEM | QTY / QTÉ | T / ÉP. | W / LARGEUR | L / LONGEUR | WT / POIDS TOTAL | WT UNITS / UNITÉ POIDS | NOTE: |
|---|---|---|---|---|---|---|---|
| A | 1 | 6.35 | 64 | 89 | 0.28 | kg | SHAPE |
| B | 2 | 6.35 | 102 | 144 | 0.00 | kg | SHAPE |
| C | 2 | 6.35 | 51 | 254 | 1.29 | kg | SHAPE |
| D | 4 | 6.35 | 51 | 89 | 0.91 | kg | SHAPE |
| E | 2 | 6.35 | 51 | 254 | 1.29 | kg | |
| F | 1 | 6.35 | 25 | 229 | 0.29 | kg | SHAPE |
| G | 1 | 6.35 | 70 | 202 | 0.70 | kg | |
| H | 1 | 9.53 | 64 | 222 | 1.06 | kg | SHAPE / BEVEL* |
| J | 1 | 9.53 | 76 | 173 | 0.98 | kg | SHAPE / BEVEL* |
| K | 1 | 9.53 | 152 | 229 | 2.60 | kg | BEVEL* |
| L | 1 | 9.53 | 152 | 89 | 1.01 | kg | BEVEL* |
| M | 2 | 6.35 | 25 | 152 | 0.38 | kg | |
| N | 1 | 6.35 | 140 | 222 | 1.55 | kg | SHAPE |
| P | 1 | 9.53 | 70 | 85 | 0.45 | kg | |
| Q | 1 | BAR/BARRE Ø25.4 (1") X 25mm | | | 0.22 | kg | BARSTOCK |
| R | 1 | 6.35 | 51 | 51 | 0.13 | kg | |
| S | 1 | 6.35 | 25 | 165 | 0.21 | kg | |
| | | | | TOTAL | 13.35 | kg | |

## PREPARED GROOVE DIMENSIONS / DIMENSIONS DES RAINURES PRÉPARÉES

* = UNLESS OTHERWISE NOTED, ALL BEVEL AND VEE PREPARATIONS AS FOLLOWS:
* = À MOINS D'INDICATION CONTRAIRE, PRÉPARER TOUTES LES SOUDURES EN V ET EN BISEAU COMME CECI :




NOTE / NOTA:
***R*** and ***f*** are prepared to the preference of the competitor.
The dimension for the plates shown is to a feathered edge and any root gap must be accomodated in overall fitting dimensions.
**R** et **f** sont préparés selon les préférences du concurrent ou de la concurrente. Les dimensions des plaques présentées tiennent compte d'un rebord aminci et tout espacement des racines doit être pris en compte dans l'ensemble des dimensions d'assemblage.

ALL DIMENSIONS IN MILLIMETERS/TOUTES LES DIMENSIONS SONT EN MILLIMÈTRES

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| TITLE/TITRE | | | | SHEET # NO. DE PAGE: | SIZE/TAILLE: |
|---|---|---|---|---|---|
| | PSCC 2023 JET - ASSEMBLY | | | 2 OF 2 | B |
| DWG. NO./ DESSIN NO: SC2023-SP-2 | REV.: 1 | SCALE ÉCHELLE: 1:4 | CONCEPTION/ DESIGN M. DEUDA DESSIN/DRAWN J. HYDE DATE: 2023-01-28 | | |

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