



Alameda International Division
Rocky Flats Plant
P.O. Box 484
Golden, Colorado 80401

INFORMATION ONLY

Reference

STANDARD FOR
DCT-7A FIBERGLASS COATED PLYWOOD BOX
FOR > LSA WASTE
(Inspection Form)

INFORMATION ONLY

B	Change note 5 on Dwg. 25884-1 DCA X 212-1	FJEGN	MAR	RHIV	7-31-80	TRH	SEE	1982
A	ORIGINAL ISSUE	FJEGN	SCM	KDM	8/7/77	FWC	SEE	1978
ISSUE	DESCRIPTION	QE&C	WP	HS&E	DATE	BY	APPR'D	CLASS. REVIEW
DESIGN ENGRG. DEPT.								

Revision to this standard shall be accomplished by Design Engineering MECHANICAL
Section and approved by: HEALTH SAFETY & ENVIRONMENT - WASTE PROCESSING - QUALITY
ENGR. & CONTROL



9604

ROCKY FLATS PLANT STD NO. SX-212

(Formerly P.E. No. P14434)

TL

**STANDARD FOR
DOT-7A FIBERGLASS COATED PLYWOOD BOX
FOR > LSA WASTE
(Inspection Form)**

ITEM NO.	SPECIFICATION	INSPECTION ENTRY	DRAWING NUMBER	SERIAL NUMBER												
1	Quantity in lot		D25884-1													
2	Record Identification numbers		OTHER IDENTIFYING NUMBERS, IF ANY STANDARD SX-212													
3	Contents limited per DOT SP 5948															
4	Contents packed and box closed per user's written procedure															
5	Box sealed with FRP & visually free of cracks and defects															
6	5000 pounds maximum gross weight															
7	Box marked per D25894-1		<table border="1"> <tr> <th colspan="4">DIMENSIONAL INSPECTION</th> </tr> <tr> <td>INSPECTED BY</td> <td>DATE INSPECTED</td> <td colspan="2">SHIFT</td> </tr> <tr> <td>ACCEPTED</td> <td>REJECTED</td> <td>BY</td> <td>DATE</td> </tr> </table>		DIMENSIONAL INSPECTION				INSPECTED BY	DATE INSPECTED	SHIFT		ACCEPTED	REJECTED	BY	DATE
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ACCEPTED	REJECTED	BY	DATE													
8	Radioactive material diamond label, 2 places		<table border="1"> <tr> <th colspan="4">RADIOGRAPHIC INSPECTION</th> </tr> <tr> <td>ACCEPTED</td> <td>REJECTED</td> <td>RADIOGRAPHIC REPT. NO.</td> <td>DATE</td> </tr> <tr> <td>ACCEPTED</td> <td>REJECTED</td> <td>BY</td> <td>DATE</td> </tr> </table>		RADIOGRAPHIC INSPECTION				ACCEPTED	REJECTED	RADIOGRAPHIC REPT. NO.	DATE	ACCEPTED	REJECTED	BY	DATE
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			<table border="1"> <tr> <th colspan="2">ILLUSTRATION</th> </tr> <tr> <td colspan="2" style="height: 100px;"></td> </tr> </table>		ILLUSTRATION											
			ILLUSTRATION													

NOTE: THIS FORM LISTS THE 'PRELIMINARY DETERMINATION' REQUIRED PRIOR TO THE FIRST USE OF ANY PACKAGE AS SPECIFIED BY ERDA MANUAL, CHAPTER 0529.

**STANDARD
FOR
APPLICATION OF FRP TO PLYWOOD BOXES
(FOR HAZARDOUS MATERIALS)**

1. SCOPE

This Standard gives the minimum requirements for the application of a fiberglass reinforced polyester (FRP) laminate to plywood boxes.

2. REQUIREMENTS

2.1 ASSEMBLY

Each box shall be assembled in accordance with Rocky Flats Plant (RFP) Standard SX-211. Any material to be furnished by the Buyer shall be specified in the purchase order.

2.2 MATERIAL

2.2.1 Resin

Resin shall be a flame-resistant polyester suitable for spray-up application. To facilitate visual inspection of lamination quality, no fillers, pigments, or dyes permitted, except as necessary to obtain the specified flame resistance and Buyer-approved UV inhibitors.

2.2.2 Fiberglass

The fiberglass reinforcement shall be noncontinuous roving with a red tracer. Strand length shall be 0.5 to 2.0 in.

2.3 FRP LAMINATE

2.3.1 Application

The FRP laminate shall be applied to the outside surface of the assembled box to a thickness outlined in Paragraph 2.3.2. In order to facilitate closing the box, taper the FRP thickness from 0.125 in., 9 to 11 in. away from the top body and lid edges, down to almost zero thickness as it approaches these same edges. (See Attachment 1).

2.3.2 Thickness

The FRP laminate shall be 0.125 in. minimum thickness throughout, except 10 percent of the flat surfaces may be 0.094 in. minimum thickness. Corners and bottom shall not be less than 0.125 in. thick.

2.3.3 Finish

The laminate shall exhibit a uniform high quality finish. Exposed fibers, sharp projections, and crazing shall be limited per the workmanship provisions of Paragraph 5.2. Air bubbles and other voids larger than 0.125 in. diameter shall be limited to a total of 3 in.² in any square foot of surface.

2.3.4 Physical Properties

The FRP laminate shall have the following physical properties:

2.3.4.1	Barcol hardness	30 minimum per ASTM-D2583
2.3.4.2	Ultimate tensile strength	9,000-psi minimum per ASTM-D638
2.3.4.3	Flexural strength	16,000-psi minimum per ASTM-D790
2.3.4.4	Fiberglass content	27-35 weight percent per ASTM-D258
2.3.4.5	Flammability	Self-extinguishing per ASTM-D635 or Flame spread classification of 25 maximum per ASTM-E84.

2.4 SKIDS

After fiberglassing box, bond skids in place using resin. After skids are bonded, coat the skids with fiberglass using either glass roving or matt. The FRP laminate shall be 0.125-in. minimum thickness. After the skids are coated, they shall meet the spacing requirements of RFP Standard SX-211. The finished bottom surface of skids shall be coplanar (flat) within 3/8-in. of each other.

2.5 PREPRODUCTION SAMPLE

Prior to the start of production, the Seller shall fabricate one box using production processes and materials. This sample box will be evaluated by the Buyer for compliance with RFP Standard SX-207. After a sample has been accepted, the Seller may proceed with his production. The sample may be retained by the Buyer for a standard of workmanship.

3. PACKAGING AND SHIPPING

Good commercial handling and shipping methods shall be used to assure damage free delivery of product. Lids shall be secured to body to resist blowing off in high winds. (See detail in RFP Standard SX-211.)

4. REPAIR OF FRP-COATED BOXES

Emphasis should be placed on producing boxes with precise cut, quality lumber. It should also be stressed that a fabricator's self-inspection of boxes or box panels prior to fibreglassing is an important quality check. In these cases where a framing member must be replaced or drawn after fibreglassing, the following steps constitute an approved repair procedure:

4.1.1 Remove framing member (2 x 4) when necessary. Cut off or clinch protruding fasteners.

4.1.2 Drill or core FRP coating in typical nailing pattern shown on panel detail drawing, each hole not to exceed 1-in. diameter. Flat bottom of each hole to be within ±0.04 in. of plywood outer surface.

4.1.3 Level edges of each hole to 90° or greater included angle.

4.1.4 Apply fasteners per RFP Standard SX-211.

4.1.5 Fill hole with FRP to minimum thickness specified in RFP Standard SX-207.

4.1.6 Describe the extent of rework on the record required by RFP Standard SX-207.

5. QUALITY PROVISIONS

5.1 RECORDS

Each lot of boxes delivered shall be accompanied by the following records:

- 5.1.1 The Seller's certification that the material used meets the requirements of this Standard.
- 5.1.2 The manufacturer's name, stock number, and batch or lot number for all material used, including resin, flame retardants, fiberglass, and catalysts.
- 5.1.3 The number of boxes in the lot and the inclusive dates of manufacture.
- 5.1.4 Each box should be identified with the manufacturer's name, date of manufacture, and purchase document number.

5.2 ACCEPTANCE

The Buyer's acceptance will be based on dimensional inspection, visual examination, and on destructive and nondestructive tests. Test specimens may be cut from boxes selected at random, or from test panels that the Seller may be required to furnish. All tests will be conducted in accordance with the ASTM test method listed in Section 6, or an approved equivalent. The preproduction sample box required by Section 2 will be used as a standard for finish and workmanship.

6. REFERENCE DOCUMENTS

The following documents constitute the specifications for the application of an FRP laminate to plywood boxes:

- 6.1 SX-207, "RFP Standard for Application of FRP to Plywood Boxes."
- 6.2 SX-211, "RFP Standard for Flush Panel Plywood Box - Assembly."
- 6.3 SX-211, "RFP Standard for Flush Panel Plywood Box - Panel Details."
- 6.4 ASTM-D84, "Surface Burning Characteristics of Building Materials."
- 6.5 ASTM-D635, "Flammability of Self-Supporting Plastics."
- 6.6 ASTM-D638, "Tensile Properties of Plastics."
- 6.7 ASTM-D790, "Flexural Properties of Plastics."
- 6.8 ASTM-D2583, "Indentation Hardness of Plastics by Means of a Barcol Impresser."
- 6.9 ASTM-D2584, "Ignition Loss of Cured Reinforced Resins."

7. ATTACHMENTS

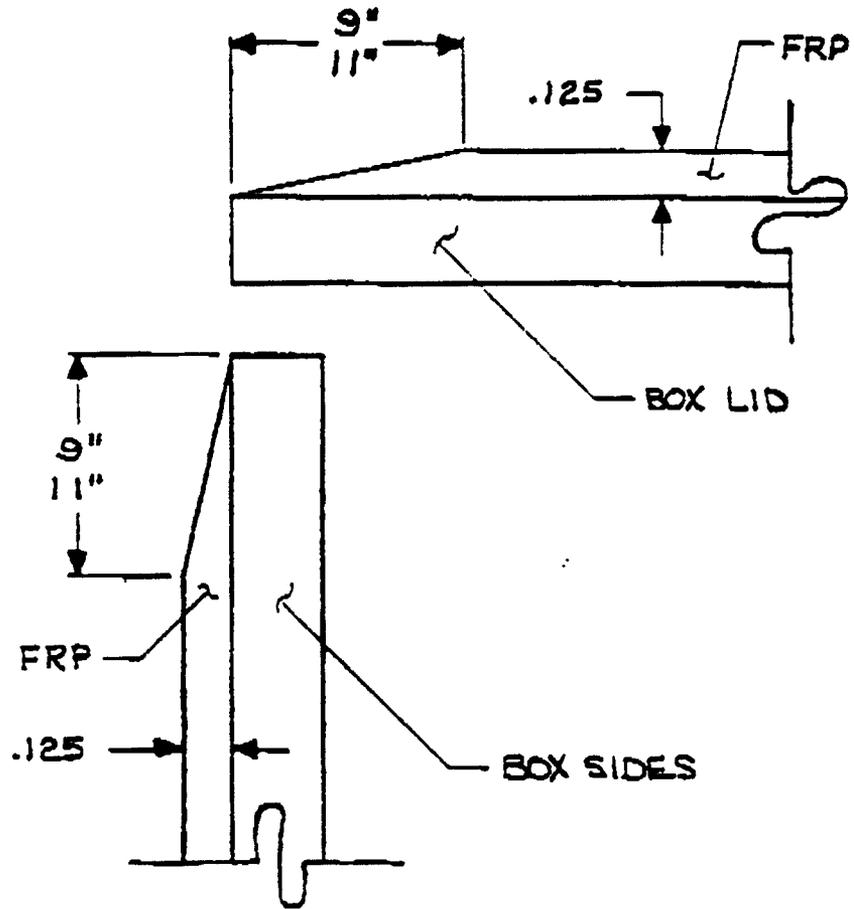
7.1 Attachment 1 - Tapering Illustration

7.2 Attachment 2 - Inspection Form

END OF STANDARD TEXT

ATTACHMENT 1

Tapering Illustration



**ATTACHMENT 2 - RFP STANDARD SX-207
APPLICATION OF FRP TO PLYWOOD BOXES**

INSPECTION FORM

			DRAWING NUMBER		SERIAL NUMBER		
ITEM NO.	SPECIFICATION	INSPECTION ENTRY	D25883-1 & -2 (SX-211)		PO #		
1	QUANTITY IN LOT		RIRS NO.				
2	RECORD MANUFACTURE DATE OF BOXES IN LOT		DIMENSIONAL INSPECTION				
	OLDEST		INSPECTED BY		DATE INSPECTED		SHIFT
	NEWEST		ACCEPT	REJECT	BY	DATE	
3	TEST PANEL FURNISHED BY VENDOR		RADIOGRAPHIC INSPECTION				
4	OVERALL WORKMANSHIP SATISFACTORY		ACCEPT	REJECT	BY	DATE	
5	MATERIAL MEETS THE REQUIREMENTS OF SX-207. VENDORS CERTIFICATION AND MATERIAL LOT IDENTIFICATION FURNISHED		MATERIAL CERTIFICATION				
			ACCEPT	REJECT	BY	DATE	
			OVERALL ACCEPTANCE				
6	TAPERED EDGES PER ATTACHMENT 1		ACCEPT	REJECT	BY	DATE	
7	FIBERGLASS THICKNESS .125 MIN EXCEPT 10% OF SURFACE MAY BE .094 MIN. CORNERS & BOTTOM .125 MIN.		ILLUSTRATION				
8	FINISH PER SX-207						
9	AIR BUBBLES AND VOIDS > .125 LIMITED PER SX-207						
10	SKIDS LOCATED PER DRAWING SX-211 AND COPLANAR WITHIN 0.38						
11	PHYSICAL PROPERTIES* BARCOL HARDNESS: 30 MIN						
	TENSILE STRENGTH: 9,000 psi MIN						
	FLEXUAL STRENGTH: 16,000 psi MIN						
	GLASS CONTENT: 27-35 w/o						
	FLAMMABILITY:						
12	LIDS SECURED PER SX-207						
			APPROVALS		TITLE		
			DATE	TOTAL SHEETS	SIZE	DRAWING NUMBER	
						NUMBER	SHEET
						ISSUE	
	* TO BE DETERMINED PERIODICALLY, RECORD RESULTS OF ANY TESTS PERFORMED						

Rocky Flats Plant
 P.O. Box 464
 Golden, Colorado 80401

STANDARD FOR
 FLUSH PANEL PLYWOOD
 BOX ASSEMBLY
 (For Hazardous Materials)

I	Revised per SRF SX-211-11	FOE	2-13-80	2/29/90	2/29/90	2/29/90	2/29/90	2/29/90	2/29/90
H	Rev. Per DCR SX-211-10		3-12-89	2/12/89	JAN	JAN	JAN	JAN	JAN
G	REVISED INSPECTION FORM PER DCR-8			6/3/87	L.A.B.				
F	Rev. Per DCR-X-211-7			2/13/87	DLS				
E	Removes Stock Number Per DCR X-211-5			11/20/81	JNC				
D	REV "D" Dwgs. D25883-1-2			1/7/81	DLG				
C	REV "C" D25883-2			2/7/81	FMC				
B	TITLE & GENERAL CHGS.			11/21/77	FMC				
A	ORIGINAL ISSUE			8/9/77	FMC				
ISSUE	DESCRIPTION	TRFC	FOE	HC&P	HS&E	DATE	BY	APPR'D	CLASS. REVIEW
DESIGN ENGRG. DEPT.									

Revision to this standard shall be accomplished by Design Engineering Waste Process and Development Engineering Section and approved by: Traffic, Procur. Qual. Engineering, Waste Compliance & Planning, Health Safety & Environmental, Facilities Quality Engineering

STANDARD
FOR
FLUSH PANEL PLYWOOD
BOX ASSEMBLY

1. SCOPE

This Standard defines the requirements for the construction, identification, shipping, workmanship, and quality of Flush Panel Plywood Boxes.

2. GENERAL

The provisions of this Standard are not intended to prevent the use of alternates or modifications to the standard in individual cases where such alternates or modifications are obviously required to obtain the results desired. Such alternates or modifications must be approved, in writing, by the Buyer.

3. QUALITY ASSURANCE

3.1 The Buyer will prequalify and select qualified Sellers based on evaluation of capability to perform in accordance with the requirements of this Standard. Failure to meet the requirements shall be cause for disqualification.

3.2 The Seller shall prepare a documented quality assurance program, based on the requirements of this Standard, which shall be planned, implemented and maintained by the Seller.

4. INSPECTION AND TESTING

Seller shall be responsible for all tests necessary to ensure that the finished products meet all requirements of this Standard.

5. APPLICABLE DOCUMENTS

- | | |
|--|------------------------|
| 5.1 Rocky Flats Plant Drawings | D-25883-1
D-25883-2 |
| 5.2 US Products Standard For Construction
& Industrial Plywood | PS 1-83 |
| 5.3 WWP Lumber Grading Rules | |
| 5.4 APA Semi Structural Adhesive | AFG-01 |
| 5.5 ASTM D3359 Standard Test Method for
Measuring Adhesion by the Tape Test | |

5.6 ASTM D1535 Standard Test Method of Specifying Color by the Munsell System

6. MATERIALS

6.1 Plywood shall be interior type with exterior glue, unsanded, group I structural, grade CCX or better, 3/4" x 48" x 96".

6.2 Framing lumber shall be structural light framing, select 2" x 4", and structural joints and planks, select 2" x 12".

6.3 Adhesive shall be APA semi structural AFG-01 having flexible glue lines with good gap filling capabilities, and shall cure to develop full strength in 7 to 28 days.

6.4 Glue shall be Modified Polyvinyl-Acetate, resistant to moisture, temperature and creep.

6.5 Nails shall be either 6d, 8d, 10d or 16d cement coated or deformed shank except where 6d smooth shank double headed nails are shown on the Drawings.

6.6 Staples shall be a minimum of 3/8-inch crown width, 2-inches long and plastic coated.

6.7 Screws shall be Phillips head number 8 or 9 wood fasteners, not less than 2-inches long.

6.8 Paint shall be a white, exterior, Class A intumescent, fire retardant coating such as Ocean Coatings No. 477 or equivalent (Seller shall be required to provide proof of equality prior to use).

6.9 Caulk shall be white, acrylic latex, high quality, commercial grade.

7. CONSTRUCTION

7.1 Plywood edges shall be straight and square to provide a tight fit with adjacent panels. A side panel bow of more than 1-inch beyond box width shall not be acceptable. Interior framing members shown flush shall not have gaps of more than 1/16-inch in width which are more than 1-inch in depth. No gaps will be permitted between vertical framing members and horizontal framing members. Edges of side and end panels shall be installed so the panels are flush to 1/8-inch maximum above the bottom of the box.

7.2 Unavoidable gaps in seams which extend to box interior or gaps between side and end panels and bottom of box shall not exceed 1/8-inch maximum and shall be filled with adhesive in order to maintain the integrity of the box.

7.3 Delamination of the panel shall not exceed three square inches except where directly attributable to knots and knot holes the size of the defect, plus a surrounding band not wider than 3/4-inch, which only affects a single ply.

8. NAILING AND/OR STAPLING

8.1 Additional nails, not to exceed 10d in size, may be used to reduce gaps. Nails or staples which protrude through the material shall be clinched flush or below the surface. Nailing or stapling shall be staggered a minimum of 1/2-inch each side of framing member center line. Nail heads shall be set flush to 1/8-inch maximum below the surface.

8.2 Staples shall be set across the grain of the first ply at not less than a 40 degree angle. A minimum of 25% more staples than nails shall be required if staples are used.

9. ADHESIVE/GLUE

9.1 Semi Structural Adhesive shall be applied in a continuous bead of 1/4-inch minimum diameter to all plywood joining edges.

9.2 Glue shall cover at least 80% of interfacing surfaces between framing members and plywood.

10. PAINTING

10.1 Gaps between 2" x 12" stringers on the bottom of the boxes shall be filled with caulk as required by the Buyer.

10.2 All exterior surfaces shall be painted, as required by the Buyer, in accordance with the paint manufacturer's application instructions to obtain the required thickness and adhesion so as to achieve an Underwriter's Laboratories, Inc. Class A fire rating.

11. IDENTIFICATION

11.1 The top left corners of both ends of the box shall be legibly stenciled with the following information in a minimum of 3/4-inch characters, using a weatherproof ink or black spray paint.

Mfg. Name and/or Symbol
Serial No.
Date of Manufacture

The serial number for the 2' x 4' x 7' box shall be preceded by the letter "H", and the serial number for the 4' x 4' x 7' box shall be preceded by the letter "S".

12. SHIPPING AND INSPECTION

12.1 Boxes shall be handled and shipped using good commercial methods to ensure damage-free delivery. Temporarily secure lids with 6-penny double-headed nails to resist blowing off in high winds during storage or transportation.

12.2 Each box shall exhibit a uniform high quality of workmanship such as; corners square and tight, smooth saw cuts, interior clean and free of debris, etc.

12.3 Each box lot manufactured shall be accompanied by the vendor's certification of compliance to Rocky Flats Plant Standard Requirements.

12.4 The Buyer's acceptance will be based on detailed dimensional inspection, visual examination, and functional test on a representative sample from each lot of boxes supplied. Inspection is not limited to only those items on the Inspection Form. (See Exhibit "A")

12.5 By accepting the contract to which this Standard applies the Supplier agrees that the use of the Tape Test for measuring paint adhesion, as described in ASTM D3359, is acceptable for wood substrates.

END OF STANDARD

EXHIBIT "A"
SX-211
INSPECTION FORM

ITEM NO.	SPECIFICATION	INSPECTION ENTRY	DRAWING NUMBER D-25883-1-2	PURCHASE ORDER NO.		
1	Quantity in lot		RIRS NO.			
2	Identification Markings Legibly Stenciled in Black Mfg/Name or Symbol Serial No. w/Prefix (H-2X4X7) or (S-4X4X7) Date of Mfg.		DIMENSIONAL INSPECTION			
			INSPECTED BY	DATE INSPECTED	SHIFT	
			ACCEPT	REJECT	BY	DATE
3	Panel Size. Tolerance $\pm 1/8"$ Bottom: 46-1/2" X 82-1/2" Top: 48" X 84" Ends: 46-1/2" X 48" (24)* Sides: 84" X 48" (24)		RADIOGRAPHIC INSPECTION			
			ACCEPT	REJECT	BY	DATE
			MATERIAL CERTIFICATION			
			ACCEPT	REJECT	BY	DATE
4	Framing member location on side panel. Tolerance $\pm 1/8"$ Vertical Struts Outside: 3/4" From Plywood edge Each End. Inside: 27" From Plywood edge to edge of strut. Horizontal ---Flush with edge Strut		OVERALL ACCEPTANCE			
			ACCEPT	REJECT	BY	DATE
			ILLUSTRATION (*Applicable Size)			
5	Fastener Pattern Maximum of 20 fasteners may deviate from 1/2" off-set of center line of struts each box.					
6	Fasteners Maximum 2 missing each strut. Total of 10 per box.					
7	Interior Framing member gaps. Maximum 1/16" extending more than 1" in depth.					
8	Seam & laminate gaps extending to box interior acceptable if filled with adhesive.					
			REV.	DESCRIPTION	DATE	
			APPROVALS			TITLE
			DATE	TOTAL SHEET	SIZE	DRAWING NUMBER
						NUMBER SHEET ISSUE

EXHIBIT "A"
SX-211
INSPECTION FORM

ITEM NO.	SPECIFICATION	INSPECTION ENTRY	DRAWING NUMBER		PURCHASE ORDER NO.			
			D-25883-1-2					
9	Workmanship: Smooth saw cuts. Interior clean.		RIRS NO.					
10	Protruding fasteners clinched flush or below the lumber surface.		DIMENSIONAL INSPECTION					
			INSPECTED BY		DATE INSPECTED		SHIFT	
			ACCEPT	REJECT	BY	DATE		
11	Maximum 20 nail heads not flush or more than 1/8" in depth below plywood surface, each box.		RADIOGRAPHIC INSPECTION					
			ACCEPT	REJECT	BY	DATE		
12	Side and end panels flush to 1/8" maximum above bottom of box.		MATERIAL CERTIFICATION					
			ACCEPT	REJECT	BY	DATE		
13	Skid Spacing: Tolerance $\pm 1/8"$ <u>Outside skids</u> aligned edge to edge with bottom panel ends. <u>Inside skids</u> aligned 27" edge to edge of box ends. +1/2"-0"		OVERALL ACCEPTANCE					
			ACCEPT	REJECT	BY	DATE		
14	Visual Examination: Framing lumber shall be free of: 1) Loose knots or knot holes larger than 3/4". 2) Fixed or tight knot holes larger than 2-1/2". 3) Massed pitch larger than 3 square inches. 4) Splits greater than 1/3 the length the board. 5) Wane - 1/2 thickness 1/3 width 1/4 length		ILLUSTRATION					
			REV.	DESCRIPTION		DATE		
15	Paint (when required) shall be white...		APPROVALS TITLE					
			DATE	TOTAL SHEET	SIZE	DRAWING NUMBER		
						NUMBER	SHEET	ISSUE

EXHIBIT "A"
SX-211
INSPECTION FORM

ITEM NO.	SPECIFICATION	INSPECTION ENTRY	DRAWING NUMBER		PURCHASE ORDER NO.			
			D-25883-1-2					
16	Paint (when required) shall be applied to prevent visual detection of substrate on all exterior surfaces.		RIRS NO.					
			DIMENSIONAL INSPECTION					
			INSPECTED BY		DATE INSPECTED		SHIFT	
			ACCEPT	REJECT	BY	DATE		
			RADIOGRAPHIC INSPECTION					
			ACCEPT	REJECT	BY	DATE		
			MATERIAL CERTIFICATION					
			ACCEPT	REJECT	BY	DATE		
			OVERALL ACCEPTANCE					
			ACCEPT	REJECT	BY	DATE		
			ILLUSTRATION					
			REV.	DESCRIPTION			DATE	
			APPROVALS		TITLE			
			DATE	TOTAL SHEET	SIZE	DRAWING NUMBER		
						NUMBER	SHEET	ISSUE