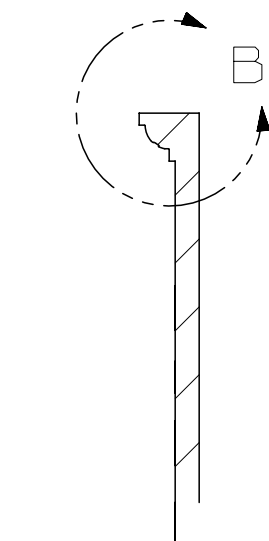


1. MATERIAL: ASTM A48/A 48M - 03, STANDARD SPECIFICATION FOR GRAY IRON CASTINGS (TABLE 1, CLASS NO. 25A)  
PARAGRAPH 9.1  
'THE SURFACE OF THE CASTING SHALL BE FREE OF ADHERING SAND, SCALE, CRACKS, AND HOT TEARS, AS DETERMINED BY VISUAL EXAMINATION.'
2. THE SURFACE TEXTURE SHALL BE SUFFICIENTLY SMOOTH AND FREE OF SURFACE IRREGULARITIES TO INSURE LEGIBILITY OF ALL PLAQUE LETTERING.
3. FINISH: APPLY TWO COATS OF PRIMER AND TWO FINISH COATS, BLACK LOW GLOSS IN COLOR. APPLY TWO COATS OF SILVER ALUMINUM PAINT FOR THE LETTERING AND THE BORDER.  
  
PREFERRED PRODUCT: ALOCIT 28 SERIES  
PRIMER: ALOCIT 28.14 - DARK GRAY  
FINISH: ALOCIT 28.15 - LOW GLOSS BLACK  
LETTERING: SHERWIN WILLIAMS SILVER BRITE ALUMINUM PAINT
4. GUIDANCE: FOLLOW PRESERVATION BRIEF 27, THE MAINTENANCE AND REPAIR OF ARCHITECTURAL CAST IRON, PUBLISHED BY THE NATIONAL PARK SERVICE TECHNICAL PRESERVATION SERVICES.
5. FONT STYLE: ROCK ISLAND ARSENAL STANDARD FOUNDRY PLAQUE PATTERN FONT.

[illegible]

SHRINK RATE	.010 PER IN.
CASTING WEIGHT	365 LBS.

UNLESS OTHERWISE SPECIFIED		
CASTING TOLERANCES		
OVER	INCLUDING	TOL
0.00	3.00	±.03
3.00	7.00	±.06
7.00	20.00	±.09
20.00	AND OVER	±.12
RADIi:		ANGLES:
TOLERANCE NONCUMULATIVE		

ROCK ISLAND ARSENAL TOOL ENGINEERING SECTION			
CASTING NAME			
GETTYSBURG PLAQUE			
OPERATION			
CASTING			
MAJOR ITEM		DISPLAY	
DWG. NO.		REV.	
NONE			
SCALE 1:4		FOR USE IN C.C.	
EX.O. & J.O. NO.		CASTING PART NO.	
R55N8TOOL383			
DESIGNER	C. SCHLADT	GETTYSBURG CD	
DETAILER		CASTING DRAWING NO.	
CHECKER			
APPD. BY		350687	
DATE	12/6/08	SHEET	1 OF 1