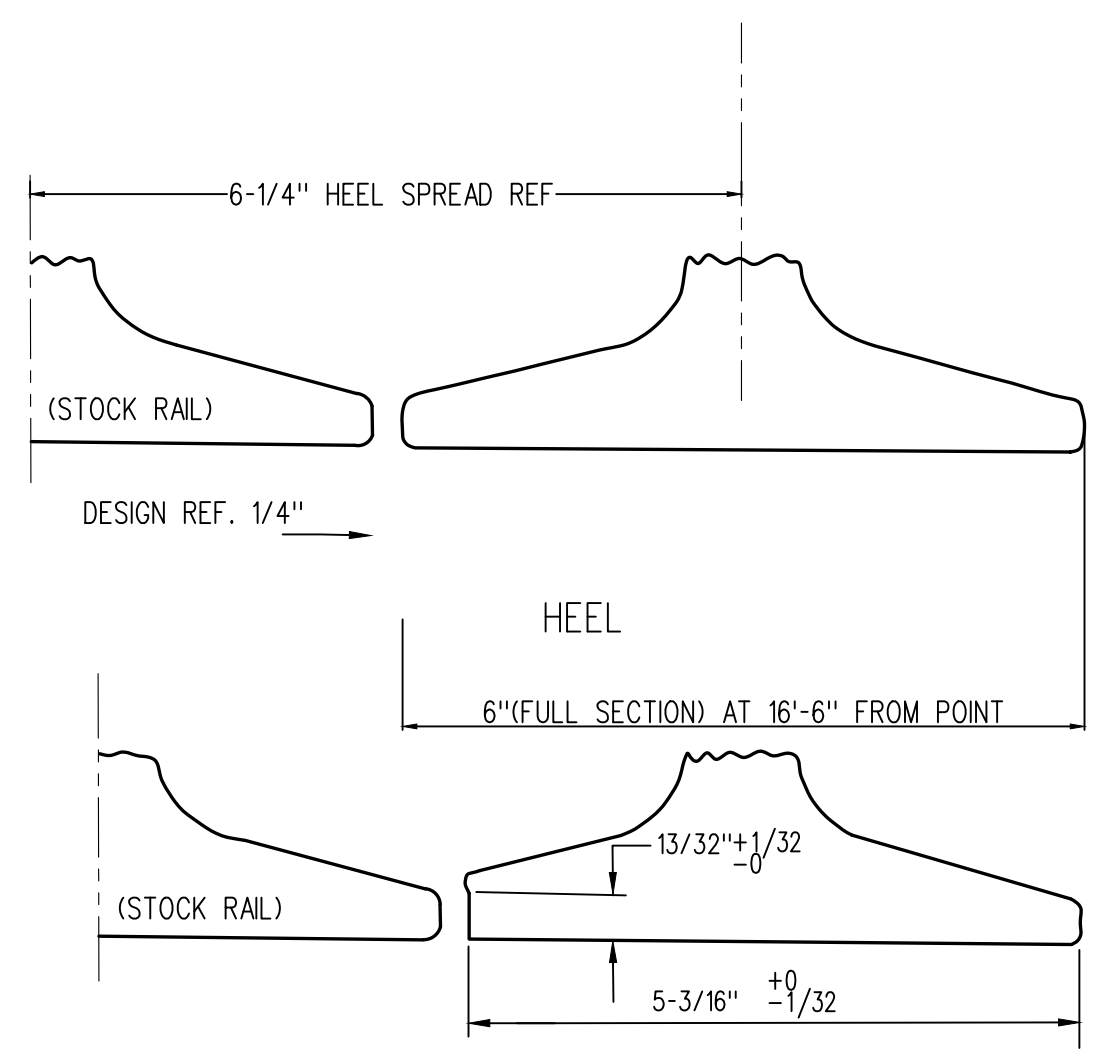


POINT RAIL MACHINING SEQUENCE

- 1 MACHINE SLOT IN STOCK RAIL SIDE REINFORCING BAR GTS-342J.
- 2 DRILL RAIL AND WEB REINFORCING BARS IN PLACE.
- 3 DEBURR ALL HOLES BY REMOVING REINFORCING BARS-REMOVE ALL CUTTINGS- REASSEMBLE WITH 3 BOLTS.
- 4 BEND POINT RAIL 1-9/32" IN 7-3 5/16"
- 5 MACHINE GAUGE SIDE HEAD CUT
- 6 MACHINE FIRST TOP CUT FOR 6'-0" LENGTH
- 7 MACHINE SECOND TOP CUT FOR 1'-0" LENGTH

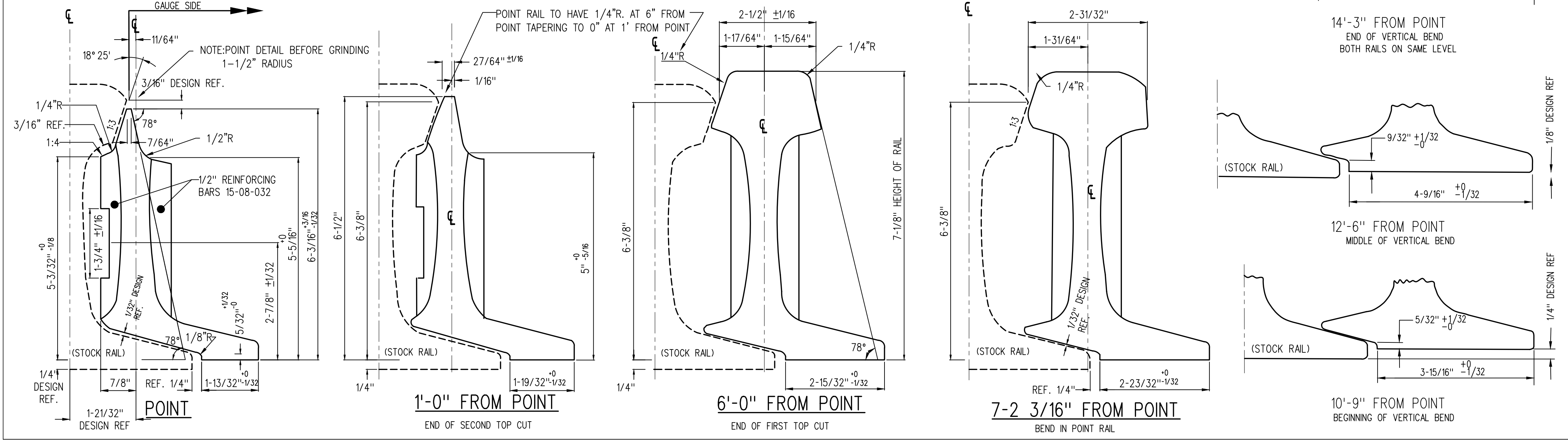
- 8 MACHINE STOCK RAIL SIDE HEAD CUT
- 9 ASSEMBLE ALL REINGORCING BAR BOLTS AS PER GTS-319 OR GTS-320, OMIT CLIPS AND STOPS.
- 10 BEND POINT RAIL AT TWO LOCATIONS FOR VERTICAL BEND
- 11 MACHINE FINAL BASE CUT 1:4 SLOPE
- 12 GRIND BASE RADIUS
- 13 GRIND POINT TO 1-1/2" RADIUS.
- 14 ASSEMBLE CLIPS, STOPS AND TAG AS PER GTS-319 OR GTS-320
- 15 REALIGN OR STRAIGHTEN POINT FROM MACHINE WARP-CHECK FOR 1-9/32" BEND.

LEFT HAND POINT



NOTES:

1. THE MACHINING DETAILS ON THIS DRAWING ARE FOR LEFT HAND SAMSON POINT RAIL ONLY, RIGHT HAND POINTS ARE MACHINED TO OPPOSITE HAND.
2. THIS IS A MACHINING DRAWING FOR SAMSON POINT RAIL-FOR ASSEMBLY SEE GTS-319 A/B 16'-6" POINT RAIL FOR MANUAL OPERATION GTS-320 A/B 16'-6" POINT RAIL FOR POWER OPERATION.
3. MATERIAL:
RAIL: UNLESS OTHERWISE SPECIFIED POINT RAILS SHALL BE ONLY NO.1 RAILS (WITH "A" RAILS ELIMINATED) IN ACCORDANCE WITH SPECIFICATION 12.3 LATEST ISSUE (HEEL OF POINT TO BE HARDENED).
REINFORCING BARS: SEE GTS-342/J
4. ALL HOLES ARE TO BE DRILLED; THE USE OF ACETYLENE TORCH OR OTHER BURNING METHOD FOR THE MAKING OF HOLES OR CUTTING IN THE MANUFACTURE OF POINTS IS ABSOLUTELY PROHIBITED.



METRIC CONVERSION: 1 inch=25.4mm, 1 foot=304.8mm

No.	Date	Revision	By	Approved
1	18/07/27	ADDED IMPERIAL TO METRIC CONVERSION NOTE		

**MACHINING DETAILS-GRATUATED RISER DESIGN
16'-6" SAMSON POINT RAIL
FOR MANUAL & POWER OPERATED 132LB. R.E. RAIL**

Drawn MG Checked GGS Approved [Signature] VP Engineering & Asset Management



Date DEC 15, 2017 Plan Number GTS-0415 Rev 1