

VISUAL TO BE READ IN-CONJUNCTION WITH STRUCTURAL CALCS

JOB NUMBER XJ86170 ACCOUNT MANAGER JR

SCALE 1:10@A2 DRAWN BY ARP

DRAFT

FOR APPROVAL ONLY
DO NOT MANUFACTURE
FROM THIS DRAWING

	INITIAL	DATE
CUT BY		
BENT BY		
FABRICATED BY		
DIMENSIONAL CHECKS BY		
WELD SET No.		
WELDING WIRE LOT/BATCH		
WELDING GAS LOT/BATCH		
WELDED BY		
WELD INSPECTION DURING MULTIRUN		
COMPLETION OF MANUFACTURE		
CHECKED BY RWC YES NO		
REWORK YES NO	DATE:	
	NCR No.	

ANY REWORK MUST RELATE TO NCR AND FOLLOW NDT PROCEDURE
WELD DEFECT TO BE COMPLETELY REMOVED AND REWELDED TO THE ORIGINAL PROCEDURE.

GAS FLOW CHECK		
VISUAL INSPECTION	100%	PASS / FAIL
MPI	%	
DPI	%	

PRE PAINT CHECK BY

ON COMPLETION THIS DRAWING MUST BE SIGNED AND GIVEN TO THE QA/WORKSHOP SUPERVISOR.
SIGNATURE AND DATE

WELDING PLAN

01 23/02/21 INITIAL DRAWING ISSUED TO PRODUCTION

COLOUR SPECIFICATION

SILVER TBC

CLIENT
PURE PIERCING

VISUAL
9 ROYAL EXCHANGE

ASTRA GROUP
UNIT 1 FIRST AVENUE
EUROPA VILLAGE
MANCHESTER M17 1JZ

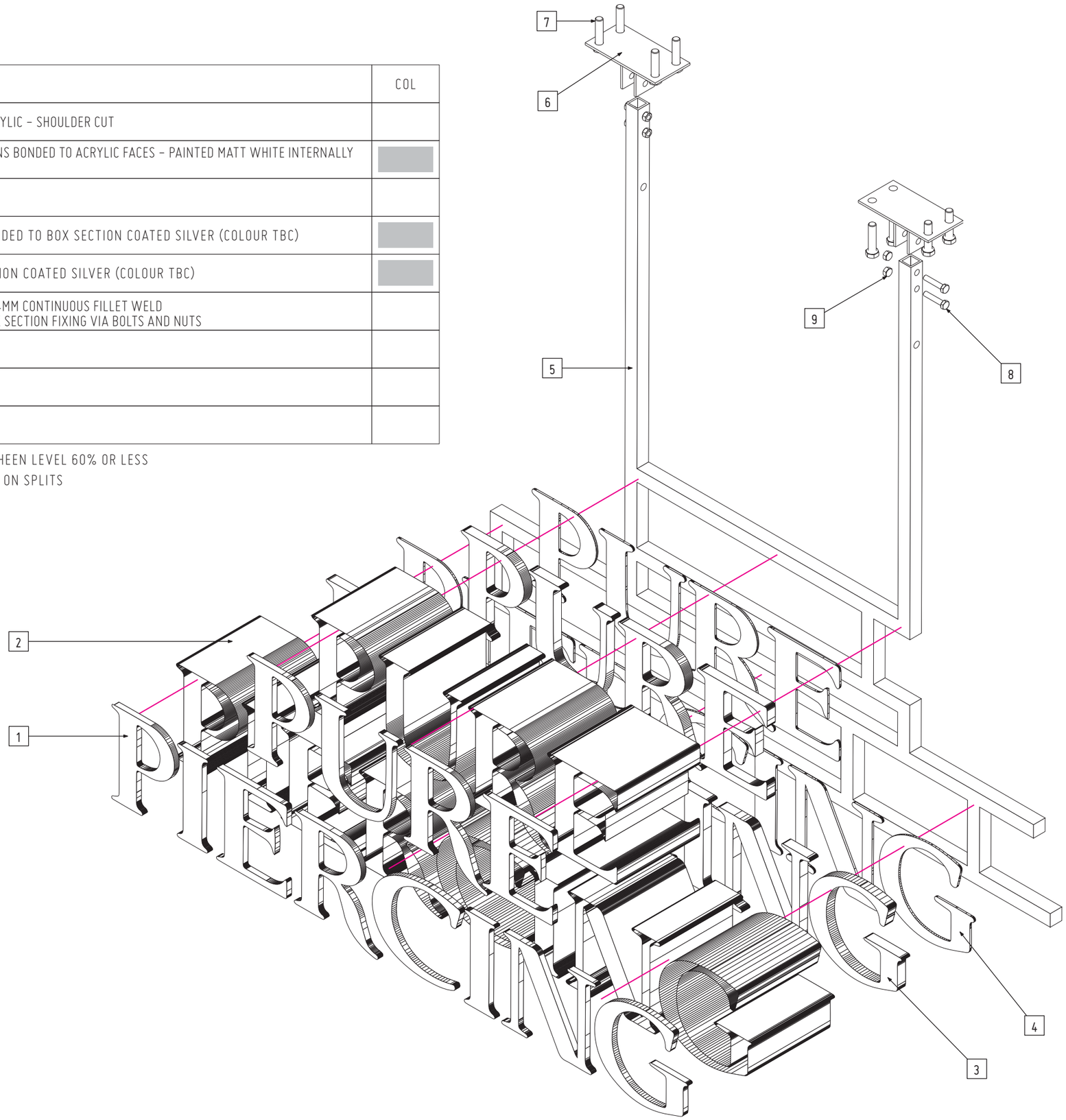
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	** ALL SIZES IN MM **	COL
01	5MM THICK LED SPECTRUM ACRYLIC - SHOULDER CUT	
02	1.2MM ALUMINIUM COILD RETURNS BONDED TO ACRYLIC FACES - PAINTED MATT WHITE INTERNALLY SILVER (COLOUR TBC)	
03	10MM FOAMEX	
04	3MM ALUMINIUM PLATE WELDED TO BOX SECTION COATED SILVER (COLOUR TBC)	
05	25MM ALUMINIUM BOX SECTION COATED SILVER (COLOUR TBC)	
06	4MM ALUMINIUM PLATE WITH 4MM CONTINUOUS FILLET WELD 4MM ALUMINIUM TABS FOR BOX SECTION FIXING VIA BOLTS AND NUTS	
07	M12 X 50 X 30-N	
08	M8 X 40 X 22-N	
09	M8 - W - N	

* RECOMMENDED EXTERNAL SHEEN LEVEL 60% OR LESS

INTERLOCKING CHANNEL USED ON SPLITS



JOB NUMBER XJ86170 ACCOUNT MANAGER JR

SCALE 1:10@A3 DRAWN BY ARP

DRAFT

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WELDING WIRE LOT/BATCH		
WELDING GAS LOT/BATCH		
WELDED BY		
WELD INSPECTION DURING MULTIRUN		
COMPLETION OF MANUFACTURE		
CHECKED BY RWC YES NO		
REWORK YES NO	DATE: NCR No.	

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DPI	%	

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COLOUR SPECIFICATION

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CLIENT

PURE PIERCING

VISUAL

9 ROYAL EXCHANGE

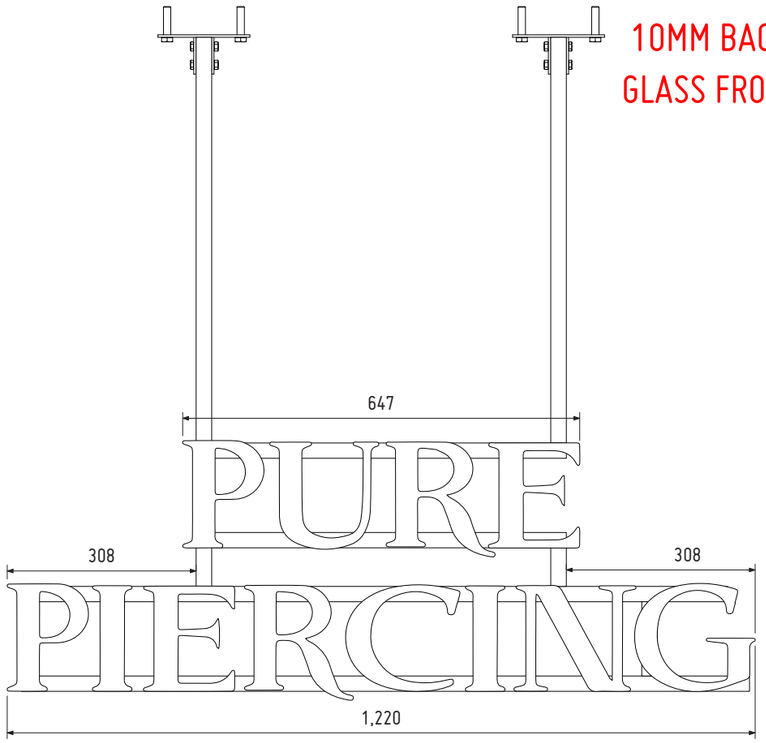
ASTRA GROUP

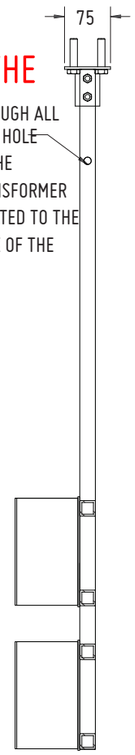
UNIT 1 FIRST AVENUE
EUROPA VILLAGE
MANCHESTER M17 1JZ

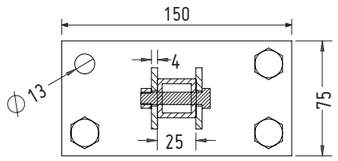
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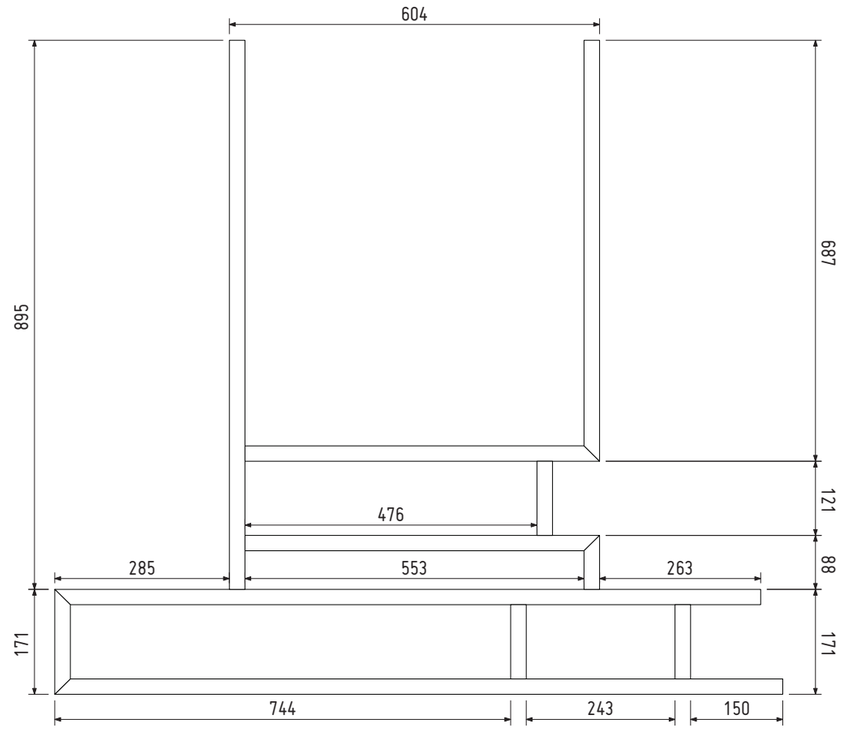
SIGN TO BE LOCATED WITH THE LETTERS 10MM BACK FROM THE GLASS FRONT.

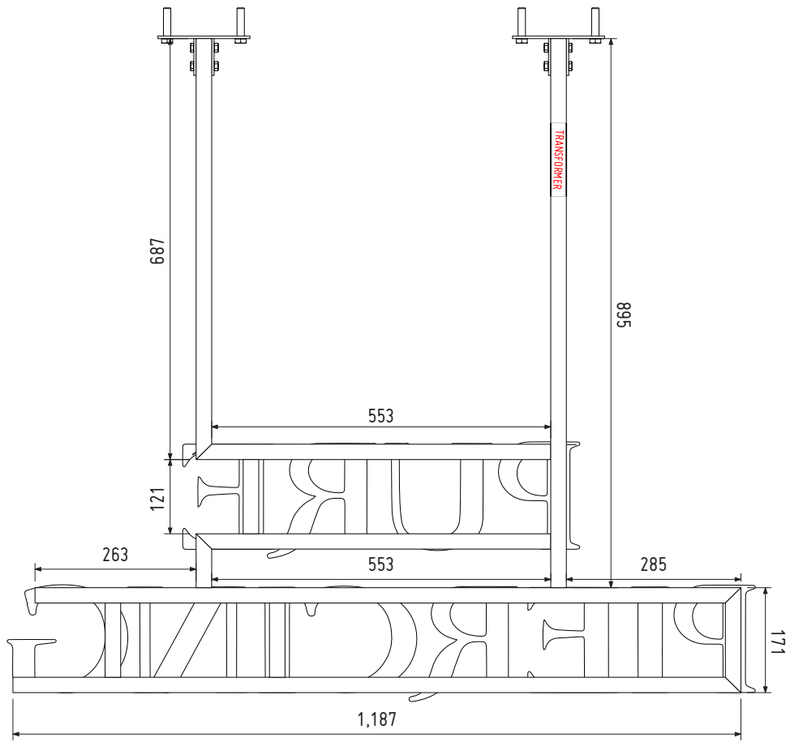


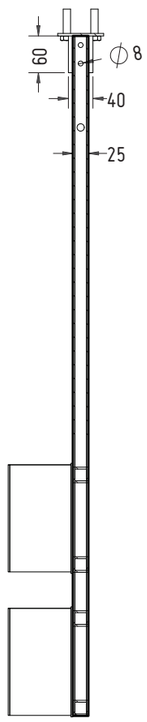




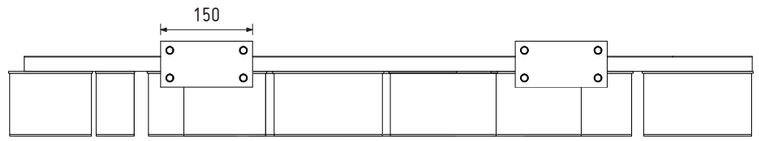
SECTION K-K
SCALE 1 : 2







SECTION J-J



JOB NUMBER XJ86170 ACCOUNT MANAGER JR

SCALE 1:10@A3 DRAWN BY ARP

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RAL 9006
60% GLOSS

CLIENT
PURE PIERCING

VISUAL
9 ROYAL EXCHANGE

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MANCHESTER M17 1JZ

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