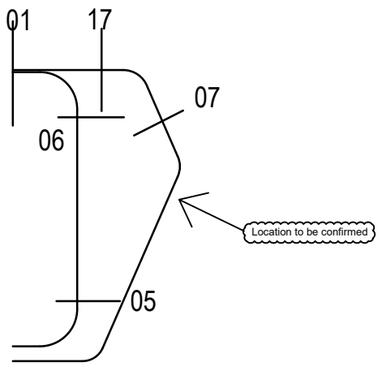
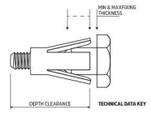
SO5722 - Greenwall sign - Greenheys - Manchester Science Park



Thin Wall Bolt Product Specification

Product Code	Hole Diameter	Depth Clearance	Clamping Range Min	Clamping Range Max
TW5ZF-10	8	35	2	10
TW5ZF-16	8	40	8	16
TW6ZF-10	10	35	2	10
TW6ZF-16	10	40	8	16
TW8ZF-10	13	45	2	10
TW8ZF-16	13	50	8	16



www.blindbolt.co.uk - TW bolts.

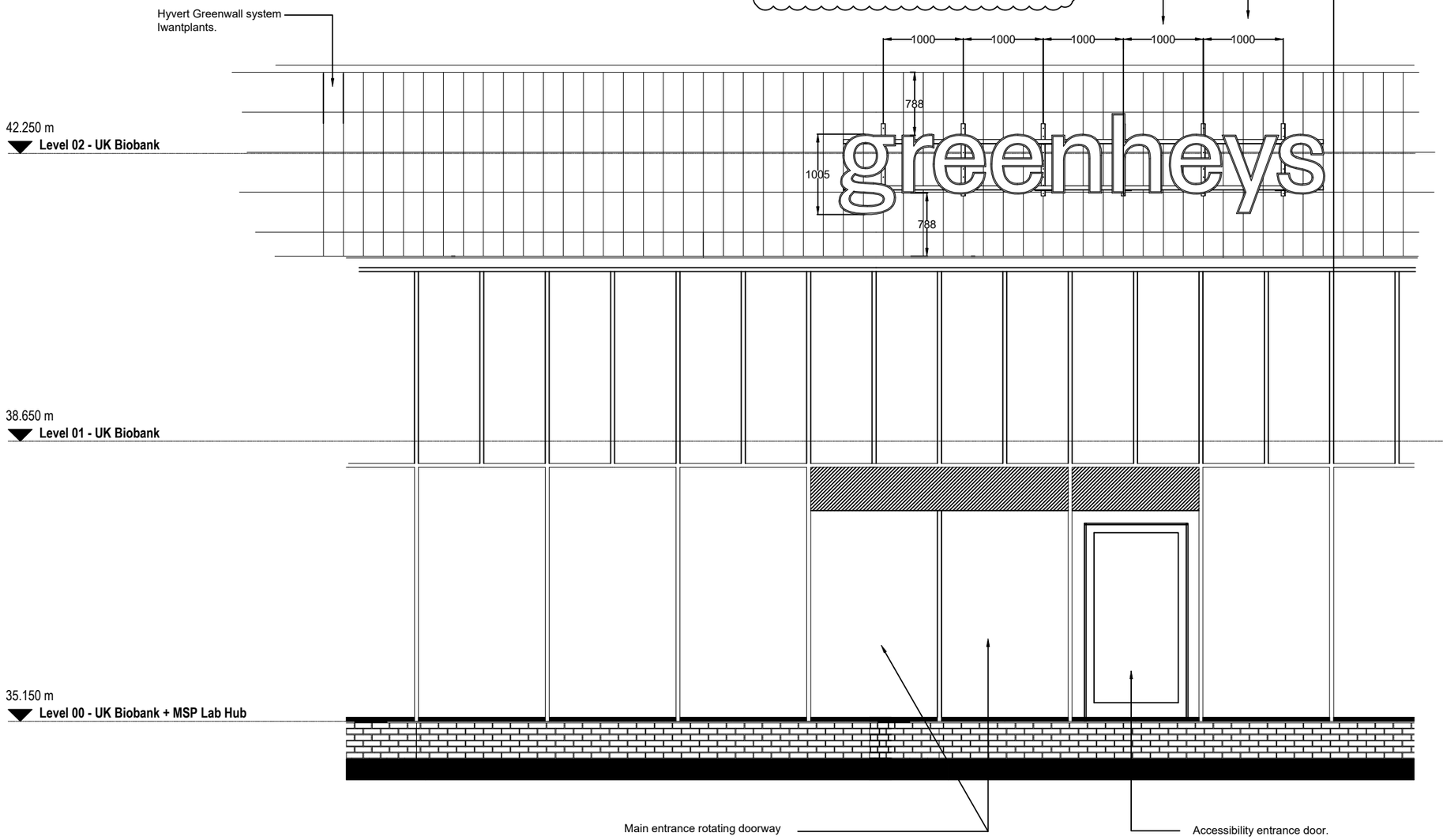
Bracket options as follows:

Sign including brackets approx 125kg.
1./ Split over 6No brackets @ 21kg per bracket - fixed to existing SFS rails at 500mm centres. Actual setting out may be different therefore allowed for individual brackets that fit to unistrut for full adjustable horizontally. - see 3D model drawing.
2./ Option for upto 11No brackets at 500mm centres (adjustable on unistrut) - weight per brackets comes down to 11.36kg per bracket.
3./ Existing SFS system. blind fixing using hollow wall anchors, TW Blindbolts or similar.

Setting out subject to SFS rail positions.
Actual rail postions may vary from proposed 500mm centres

Curved section

Hyvert Greenwall system
Iwantplants.



JOB CARD-F006

WELD SET No.		
WELDING WIRE LOT/BATCH		
WELDING GAS LOT/BATCH		
ISSUE TO FAB	INITIALS:	
CUT BY	INITIALS:	
BENT BY	INITIALS:	
DIMENSIONAL CHECKS	INITIALS:	
FABRICATED BY	INITIALS:	
WELDED BY	INITIALS:	
WELD INSPECTION DURING MULTIRUN	INITIALS:	
COMPLETION OF MANUFACTURE	DATE:	
CHECKED BY RWC YES NO	DATE:	
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 GALV CHECK		
POST GALV CHECK		

ON COMPLETION THIS DRAWING MUST BE SIGNED AND GIVEN TO THE QA/RWC
SIGNATURE AND DATE:

WELDING PLAN-F014

-ALL WELDS 6mm LEG LENGTH FILLET UNO
-ALL STEELWORK TO EXC2
-ALL TOLERANCES TO MEET BS 1090-2
-MAKE SURE SURFACE IS FREE FROM GREASE & MILL SCALE
-ACCEPTABLE CRITERIA TO BS EN 5817 (QUALITY LEVEL C)
-LAMELLA TEARING TO BE AVOIDED BY GOOD JOINT DESIGN
-CORRECT MATERIALS, WELDING SEQUENCE AND TECHNIQUE
-RESTRAINTS APPLIED , CLAMPS AND BRACES (IF REQUIRED)
-TURNING OF COMPONENTS BY O/H CRANE AND 'a' FRAMES
-MEASURES TO AVOID DISTORTION PRE-HEAT POST-HEAT

WPS 01 SL FW(135) z <8.5mm
WPS 02 ML FW(135) Z >8.5mm
WPS 06 SL FW(141) ALU
WPS 09 BW(135)
WPS 03 SL FW(135)
PIPE TO PLATE
WPS 05 SL FW(141)
STAINLESS
WPS 08 SL FW(141)
SS PIPE-PLATE

isGroup
CUTTING EDGE SIGNAGE
Enterprise House, Unit
1 Aber Park Industrial Estate
Flintshire, CH6 5EX
t: 01352 792000
e: info@is-group.co.uk
w: www.is-group.co.uk

QTY	AS DETAILED
MATERIAL GRADE	AS DETAILED
SURFACE FINISH AND BS No.	

SITE			
TITLE			
SCALE			
DATE	07.04.2026		
DRAWN	RH	CHECKED	
SHEET No.	2	SO No.	5722
DRAWING No.	SO5722-Greenwall		

STRUCTURAL ENGINEERS JOB No. 000000 COLUMN TO BASEPLATE 00mm FILLET WELD

DRAWING ISSUE | INFORMATION | REVISION.

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