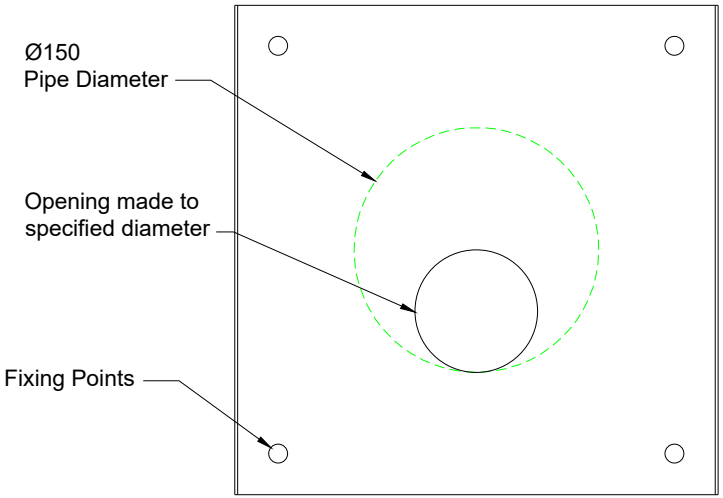
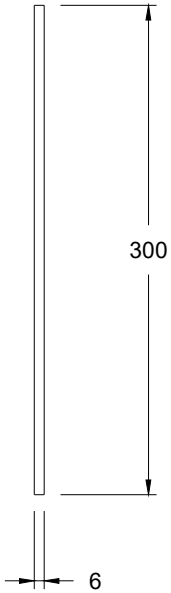
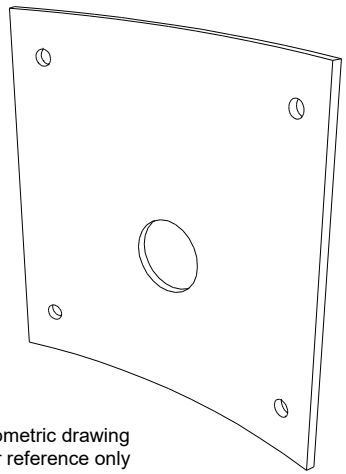
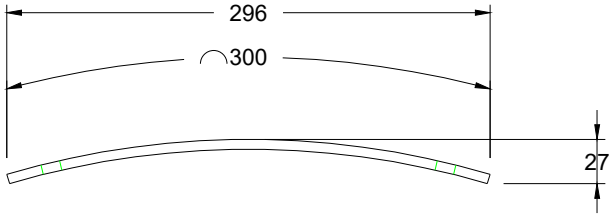
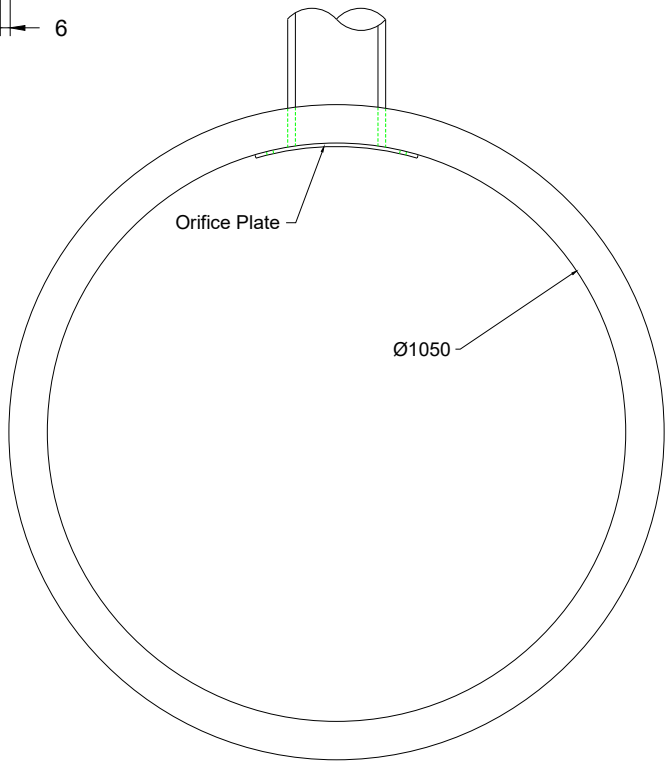






Isometric drawing
for reference only





DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1mm

Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nn
- M10 (16mm Wrench) - 25 - 40Nn
- M12 (18mm Wrench) - 28 - 40Nn
- M16 (24mm Wrench) - 28 - 40Nn
- M20 (30mm Wrench) - 28 - 40Nn
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO:	DATE:	DESCRIPTION:

Althon

ADDRESS: ALTHON LIMITED
VULCAN ROAD SOUTH
NORWICH
NR6 6AF

TEL: 01603 488700
FAX: 01603 488598
EMAIL: sales@althon.co.uk
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DRAWING TITLE:

Galv. 150mm Curved Orifice Plate
for 1050mm dia Chamber
300 x 300 x 6mm

FINISH:
Galvanised

SCALE:	PAPER:	DATE:
NTS	A4	27 - 09 - 19

SHEET NO:	WEIGHT:
01 OF 01	kg

PRODUCT NAME:
Galv. 150mm Curved Orifice Plate
for 1050mm dia Chamber

CODE:
GCOP1501050