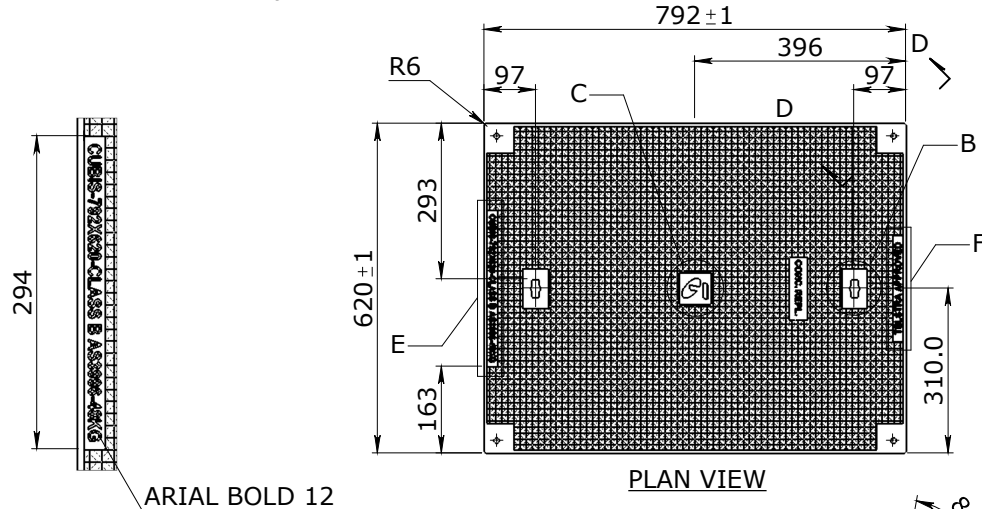
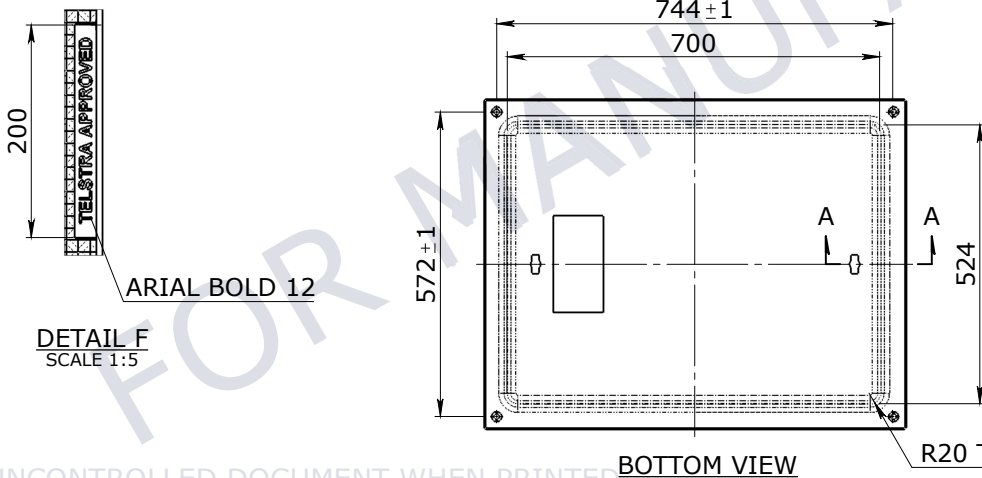


FABRICATION NOTE:

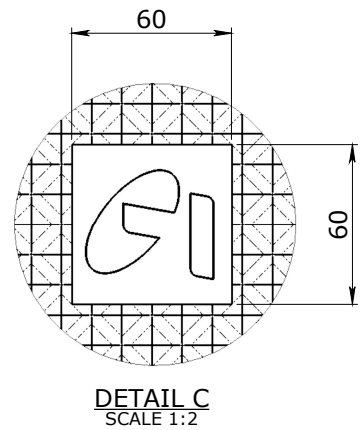
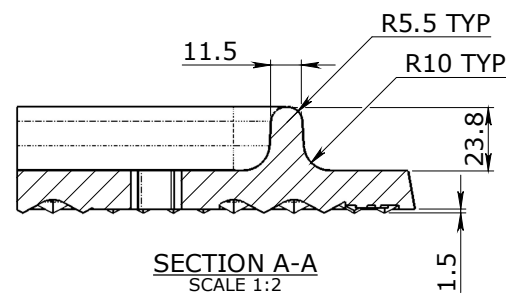
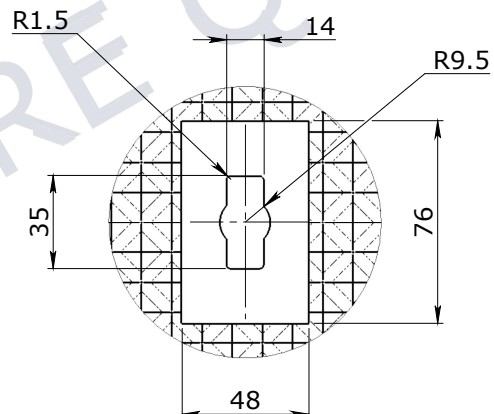
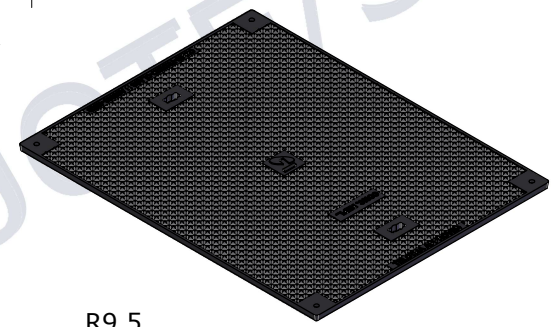
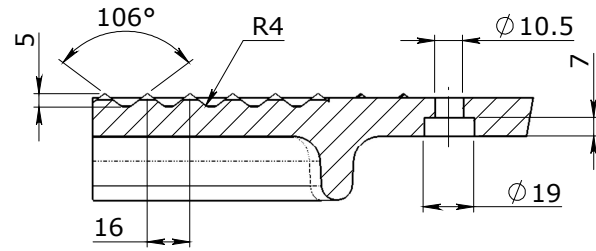
1. REFER TO TOLERANCES - FABRICATION UNO
2. REMOVE ALL BURRS & SHARP EDGES
3. MATERIAL: SG CAST IRON GRADE 500/320/7 TO AS1831
4. MATERIAL CERTIFICATE TO BE SUPPLIED
5. CAST SURFACES PAINTED COLOR BLACK USING SOLVENT BASED ACID ETCH SUPER ETCH PRIMER WATTYLE 239-MCRFC OR EQUIVALENT, SEE WEBSITE: WWW.WATTYL.COM.AU



DETAIL E
SCALE 1:5



DETAIL F
SCALE 1:5



UNCONTROLLED DOCUMENT WHEN PRINTED

1. MATERIAL SPECIFICATIONS UNO
- SECTIONS & FLATS - AS 3679 - GR 300+
- PLATES AS 3678 - GR 250
- SHS AS 1163 - GR 350
2. WELDING TO COMPLY TO AS 1554.1 UNO

Rev	DESCRIPTION	DATE:	BY:	ECO#:

GENERAL TOLERANCES			
NOMINAL SIZE	UP TO 150	ABOVE 150 UP TO 500	ABOVE 500
TOL	±1.0	±2.0	±5.0

TOLERANCES - FABRICATION			REVISION CONTROL		
LINEAR X.XX ± 0.02	FACES SQUARE ⊥ 0.05/100	ANGULAR ∠ X.X ± 0°30' DIA. CONC WITHIN 0.05 TIR			
LINEAR X.X ± 0.1	FACES PARALLEL // 0.05/100	ANGULAR ∠ X ± 1° EDGES CHAMFERED 1.0 x 45°			
LINEAR X. ± 0.25	FACES FLAT ▽ 0.05/100	GENERAL SURFACE FINISH Ra 3.2			

CHK / APPR:	AC
DATE:	11/03/2019
REPEQ DOCUMENT #:	
WEIGHT:	48.81Kg
MATERIAL:	Malleable Cast Iron
SURFACE TREATMENT:	

HEAD OFFICE:
CARNINGHAM ROAD
BALLARAT, VIC 3351
(03) 5335 8741

ENGINEERING & DEVELOPMENT:
2 STRADBROKE STREET
HEATHWOOD, QLD 4110
(07) 3714 0444

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PROJECT DESCRIPTION:					
CUBIS SYSTEMS AUSTRALIA CATALOGUE PRODUCTS					
DRAWING NAME: AX S™ MANHOLE COVER CAST IRON 792x620 CONC REPLACEMENT					
DRAWN TO AS 1100 DO NOT SCALE FROM SHEET	DRAWING No:	50201260	REV:	0	
SHEET: A3	PAGE: 1/1	SCALE UNO: 1:10	DRAFTED DATE: 25/06/2018	DRAFTED BY: YJ SHAN	