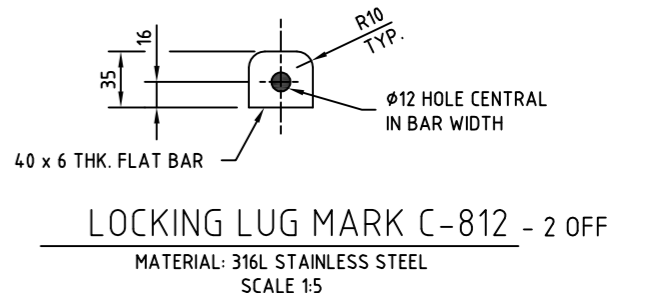


HINGE PIN MARK B-812 - 4 OFF
MATERIAL: 316L STAINLESS STEEL
SCALE 1:5



LOCKING LUG MARK C-812 - 2 OFF
MATERIAL: 316L STAINLESS STEEL
SCALE 1:5

- NOTES:**
- FABRICATION TO REQUIREMENTS OF AS4100. WELDING REQUIREMENTS TO AS1154.6 WITH WELDING UNDERTAKEN BY A WELDER CERTIFIED TO REQUIREMENTS OF AS/NZS 3992. MINIMUM CATEGORY OF WELD 1B & SURFACE FINISH GRADE II(a) TO AS/NZS 1554.6. WELD INSPECTION TO BE 100% VISUAL TO REQUIREMENTS OF AS4037.
 - STAINLESS STEEL MATERIAL SHALL BE GRADE 316L; PLATE TO AS1449; BAR TO AS2837.
 - ALL STAINLESS STEEL ITEMS SHALL BE PASSIVATED PRIOR TO INSTALLATION IN ACCORDANCE WITH THE REQUIREMENTS OF AUSTRALIAN WELDING RESEARCH ASSOCIATION (AWRA) TECHNICAL NOTE 16 - "WELDING STAINLESS STEELS"
 - IT IS RECOMMENDED THAT BOTH HATCH COVERS A-814 BE LOOSE POSITIONED IN THEIR SPATIAL POSITIONS WITHIN SUPPORT FRAME A-812 AND ASSEMBLED HATCH HINGES COMPRISING HINGE PIN B-812 AND HINGE BUSH B-814 BE LOCATED IN THEIR REQUIRED POSITIONS ON HATCH COVER AND SUPPORT FRAME AND TACK WELDED TO FRAME AND COVERS PRIOR TO UNDERTAKING COMPLETE WELDING OF HINGE COMPONENTS.

SUPPORT FRAME MARK A-812
MATERIAL - 316L STAINLESS STEEL
SCALE 1:10

1	FRAME OPENING DIMENSION INCREASED	S.H.	1/06/2016
REV. N°	REVISION	APPROV	DATE
APPROVED		APPROVED	
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STANDARD CONSTRUCTION PRACTICE
SEWERAGE STANDARD
SEWAGE PUMPING STATIONS
GAS-TIGHT WET-WELL COVERS
STEEL WORKS (FRAME)

CAD FILE NAME: SCP-812
SCP-812
ISSUED: 2016