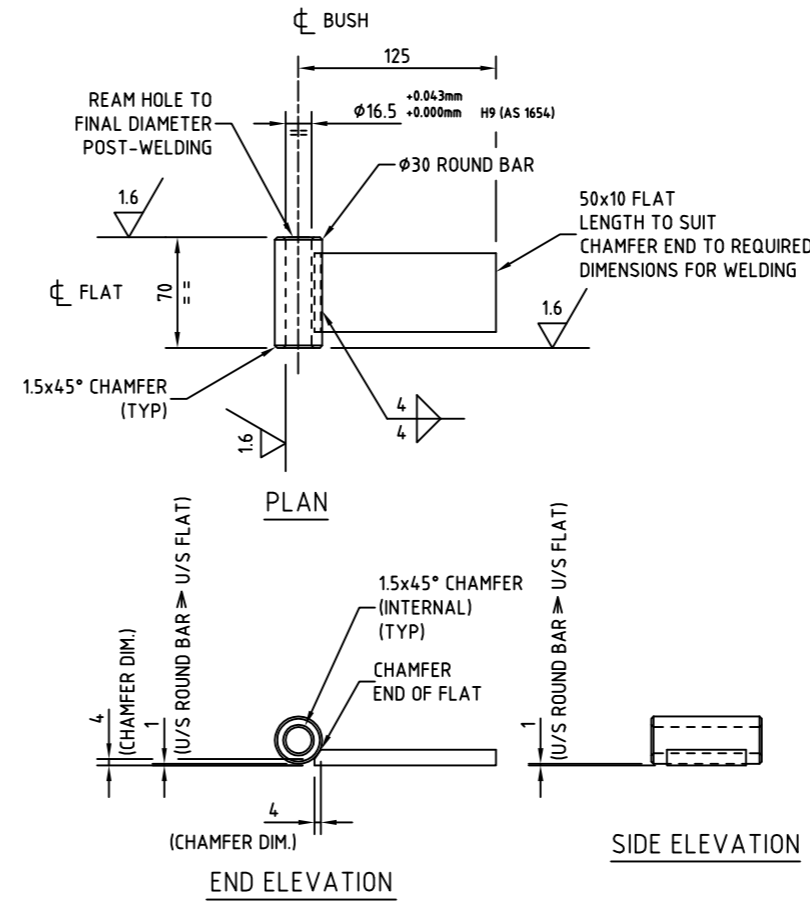
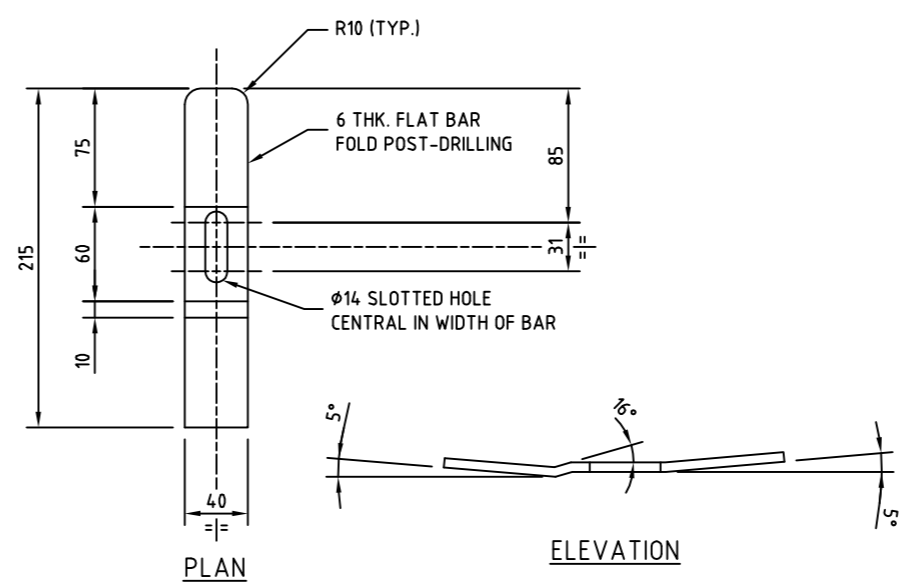


NOTES:

- 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 AS1554.6. 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.
- MAXIMUM VERTICAL LIFTING WEIGHT OF EACH LID SHALL BE 20KG WITH THE MAXIMUM PULLING FORCE OF EACH LID TO BE 30KG.



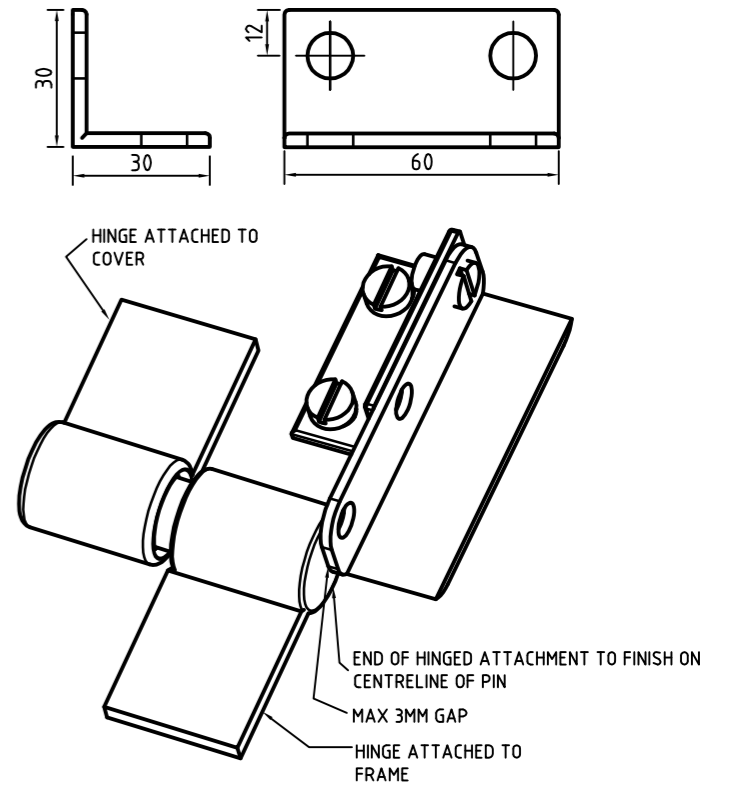
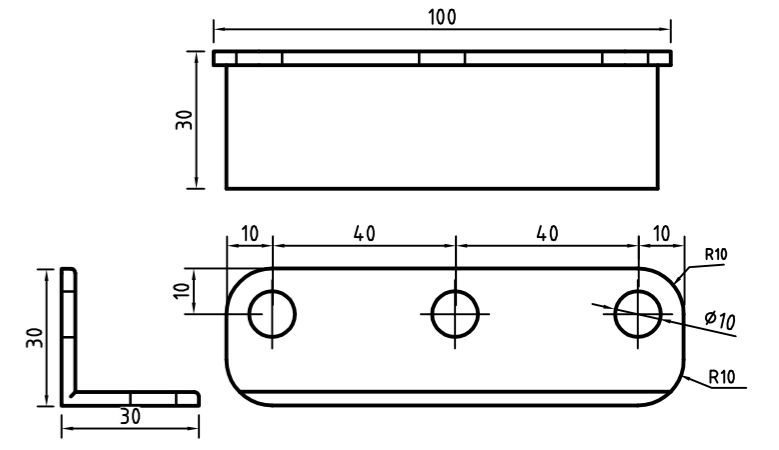
HINGE BUSH MARK B-814 - 4 OFF
MATERIAL: 316L STAINLESS STEEL
SCALE 1:5



LOCKING TAB MARK C-814 - 2 OFF
MATERIAL: 316L STAINLESS STEEL
SCALE 1:5

HINGED COVER RESTRAINT

- NTS
- REQUIREMENTS**
- ALL MATERIAL TO BE 30X30X3MM 316 STAINLESS STEEL ANGLE UNO.
 - HINGE (1 OFF) AND MOUNTING (2 OFF) M10X20 SOCKET HEADED BUTTON SCREWS TO BE FITTED WITH WASHER AND NYLOC NUT.
 - EDGES SHOWN TO HAVE RADIUS OF 1MM.
 - ONE HINGE RESTRAINT PER COVER.
 - TO BE POSITIONED ON THE HINGE THAT LOCATES THE ATTACHMENT CLOSEST TO CENTRELINE OF COVER. SEE SCP-810
 - WHEN LOCKED IN THE OPEN POSITION THE ATTACHMENT MUST CLEAR THE HINGE.



1	ADDITION OF NOTE 5 AND HINGED COVER RESTRAINT DETAILS. COVER SIZE 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 (COVER)

CAD FILE NAME: SCP-814

SCP-814

ISSUED: 2016

A3