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2009 WATERFRONT ENGINEERING SERVICES

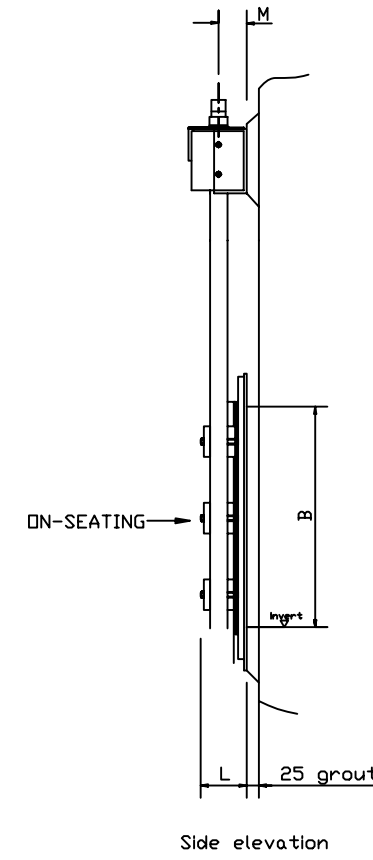
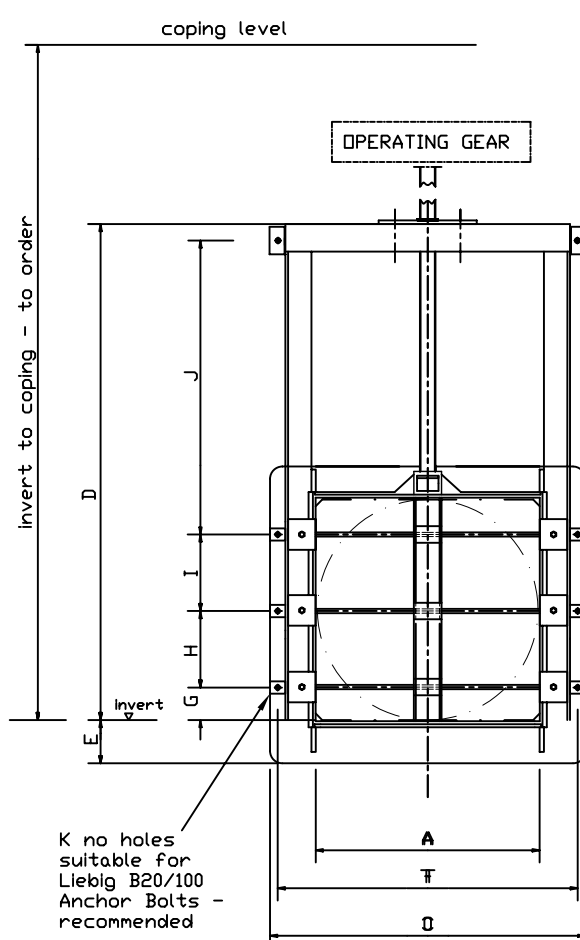
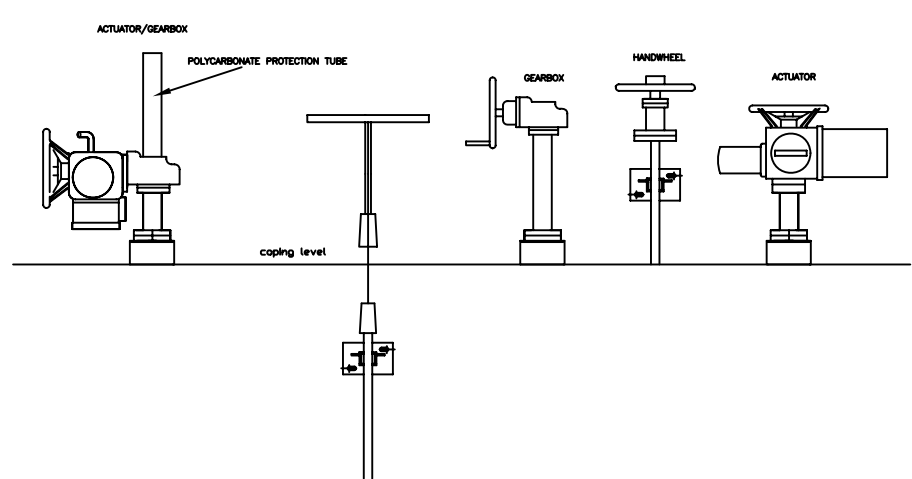
GENERAL MACHINING TOLERANCES:
CAST IRON PENSTOCK:
±0.3mm UP TO 250mm
±0.5mm 250 TO 500mm
±1.2mm OVER 500mm
STAINLESS STEEL PENSTOCK:
±0.2mm ANY SIZE

SURFACE FINISHES:
ROUGH MACHINE:
6.3 µm
FINISH MACHINE:
3.2 µm

THIRD ANGLE PROJECTION

DRAWING NUMBER: WQ1001
ISSUE: 0

OPERATING METHODS



PENSTOCK DIMENSION TABLE													
SIZE	A	B	C	D	E	F	G	H	I	J	K	L	M
700	700	700	1010	1565	135	960	100	500	-	880	6	200	100
750	750	750	1110	1740	160	1060	75	300	300	980	8	200	100
800	800	800	1110	1765	135	1060	100	300	300	980	8	200	100
900	900	900	1210	1965	135	1160	100	350	350	1080	8	200	100
1000	1000	1000	1310	2165	135	1260	100	400	400	1180	8	200	100
1200	1200	1200	1510	2650	135	1460	100	500	500	1420	8	225	110

ISSUE	NAME	DATE	CHECKED	REVISION

DRAWN BY: CS	DATE: 25/03/2009	CHECKED BY: IKB	DATE: 25/03/2009	CONSULTING ENGINEERS:
SCALE: 1/1	DRAWING NUMBER: WQ1001	ISSUE: 0	CUSTOMER:	
JOB no:	PART no:	TITLE: CAST IRON IRON WALL FIXING PENSTOCK - REBATE INVERT		
MATERIAL SPECIFICATION AS LISTED ON DRAWING				

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