

ITEM No	DRAWING NO / CATALOGUE No	TITLE / DESCRIPTION	QTY	Material	REMARKS
1	SI-6292-612_01	SIDE MEMBER	2	Steel	SEE NOTE 1
2	SI-6292-612_02	CROSS MEMBER	2	Steel	SEE NOTE 1
3	SI-6292-612_03	CROSS BRACE	6	Steel	SEE NOTE 1
4	SI-6292-612_04	LEG	3	Steel	
5	SI-6292-612_05	SIDE MEMBER	2	Steel	SEE NOTE 2
6	SI-6292-612_06	CROSS MEMBER - LOWER	4	Steel	SEE NOTE 2
7	SI-6292-612_07	END MEMBER	2	Steel	SEE NOTE 2
8	SI-6292-612_10	FRAMEWORK FRONT FOOT	3	Steel	SEE NOTE 3
9	SI-6292-612_11	BEARING PLATE	16	STAIN STEEL	
10	SI-6292-612_12	LUG	32	Steel	SEE NOTE 3
11	SI-6292-612_13	FOOT PAD	4	Steel	SEE NOTE 3
12	SI-6292-612_14	SUPPORT	8	Steel	SEE NOTE 2
13	SI-6292-612_16	WEB	44	Steel	SEE NOTE 3

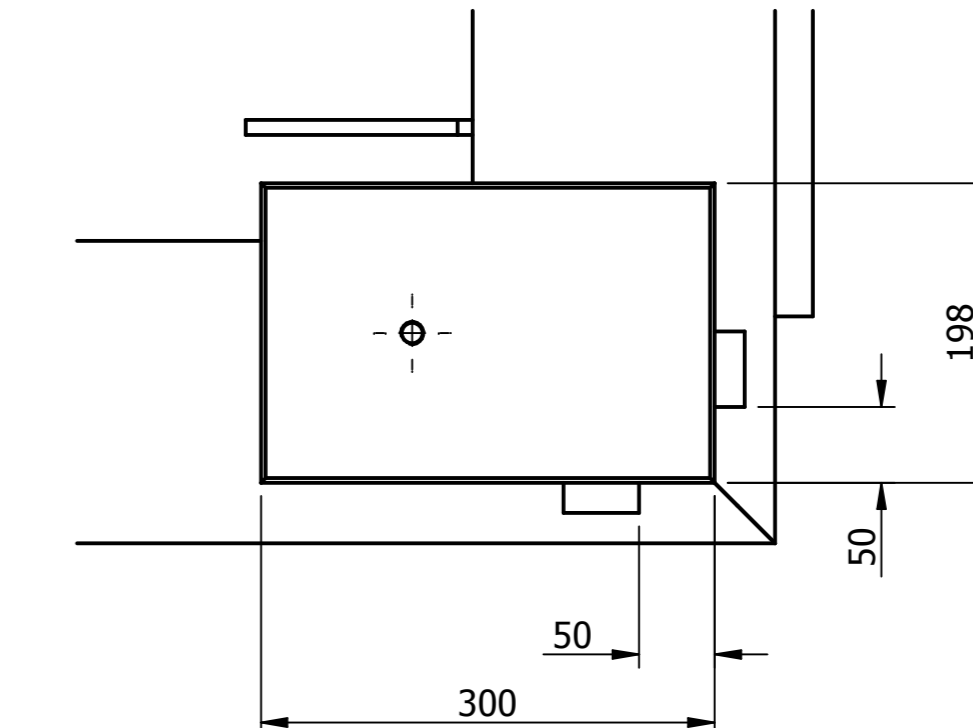
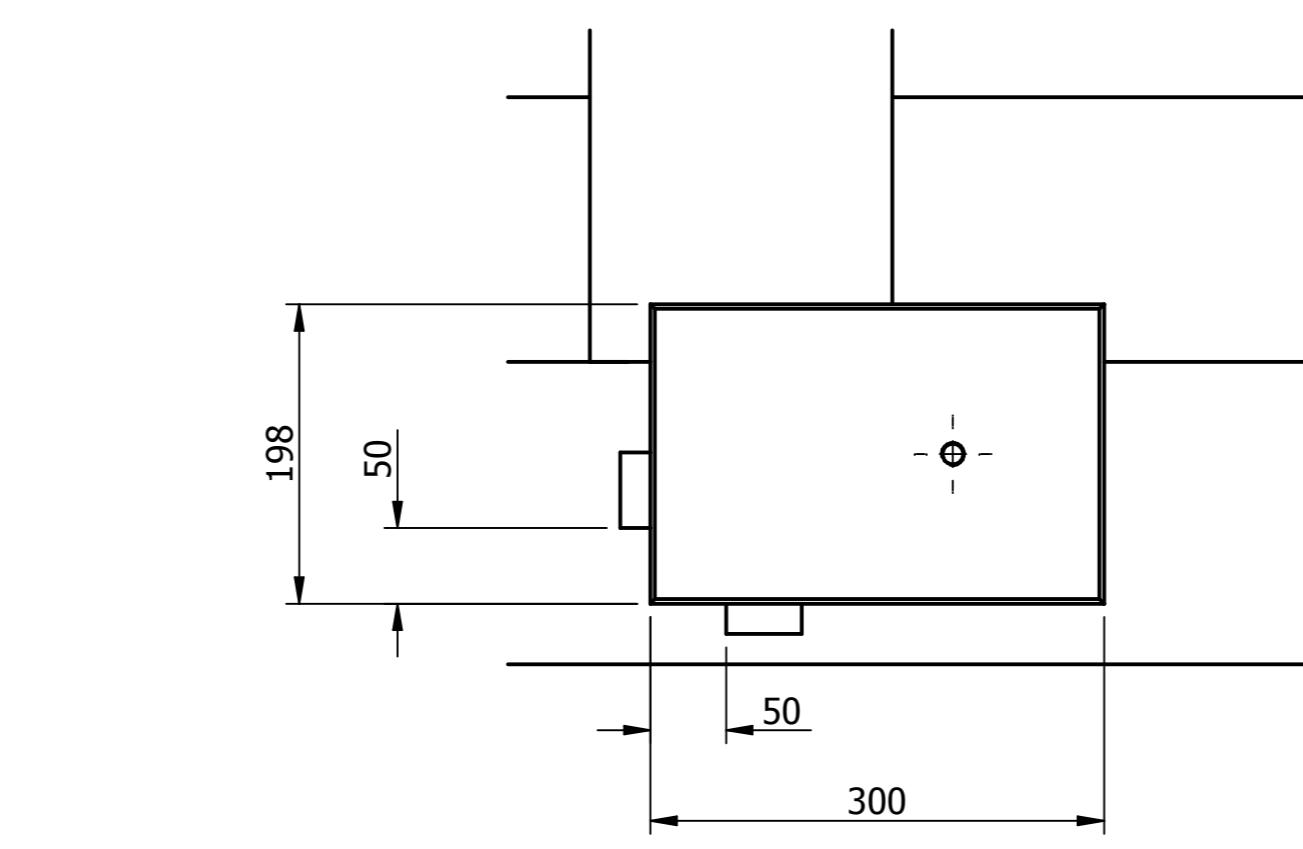
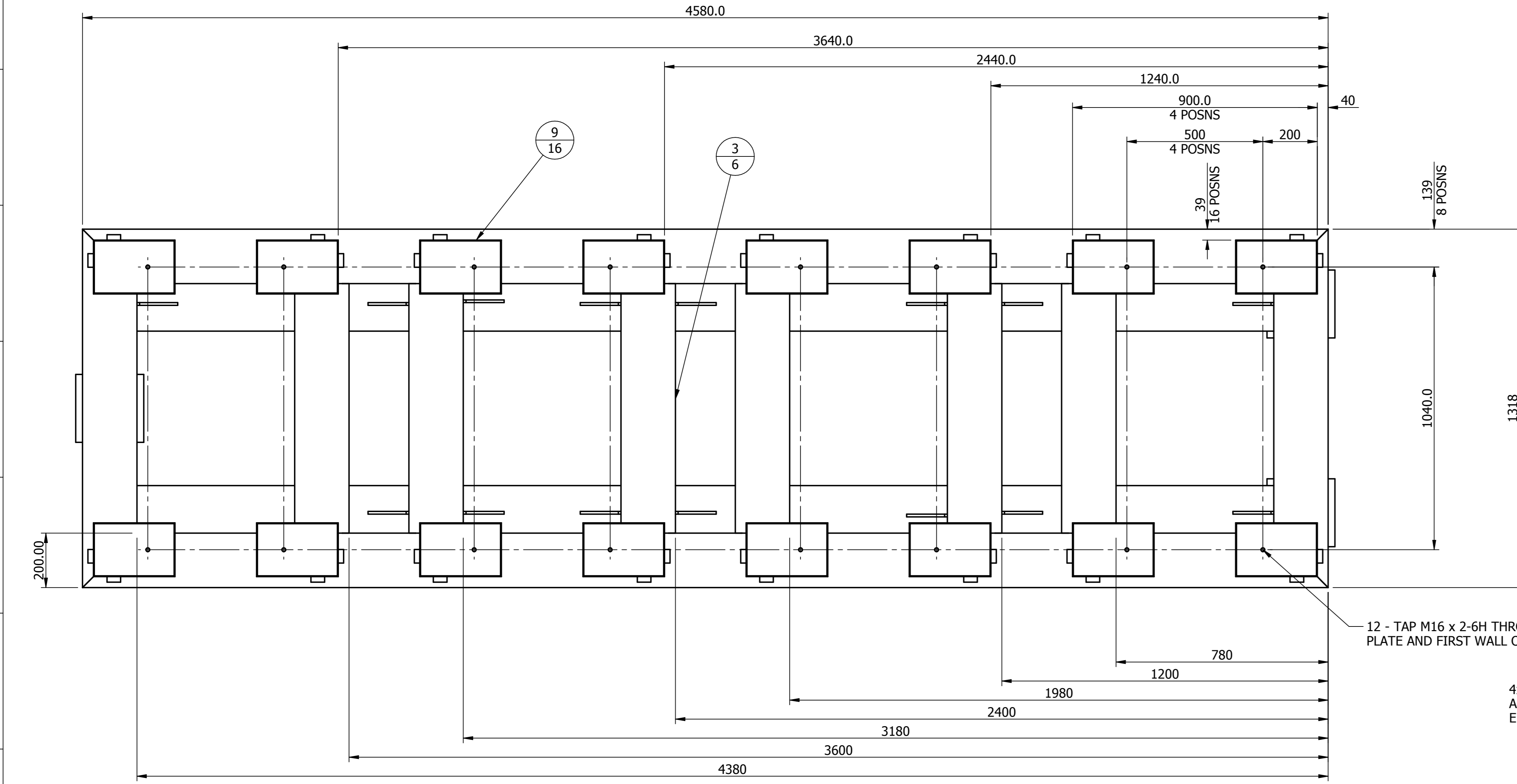
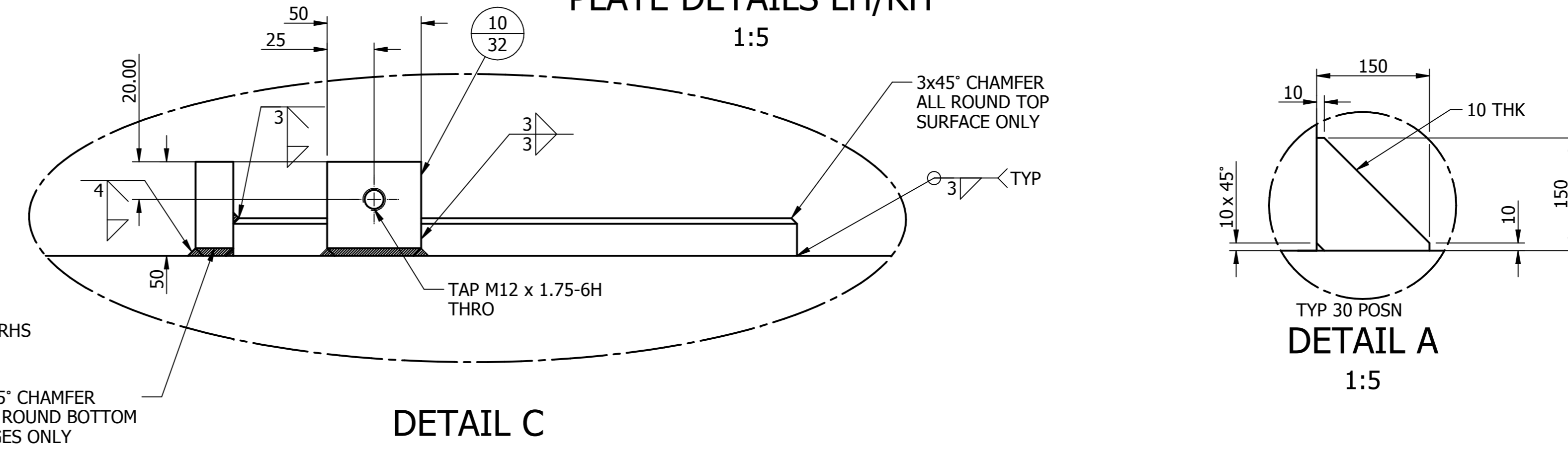
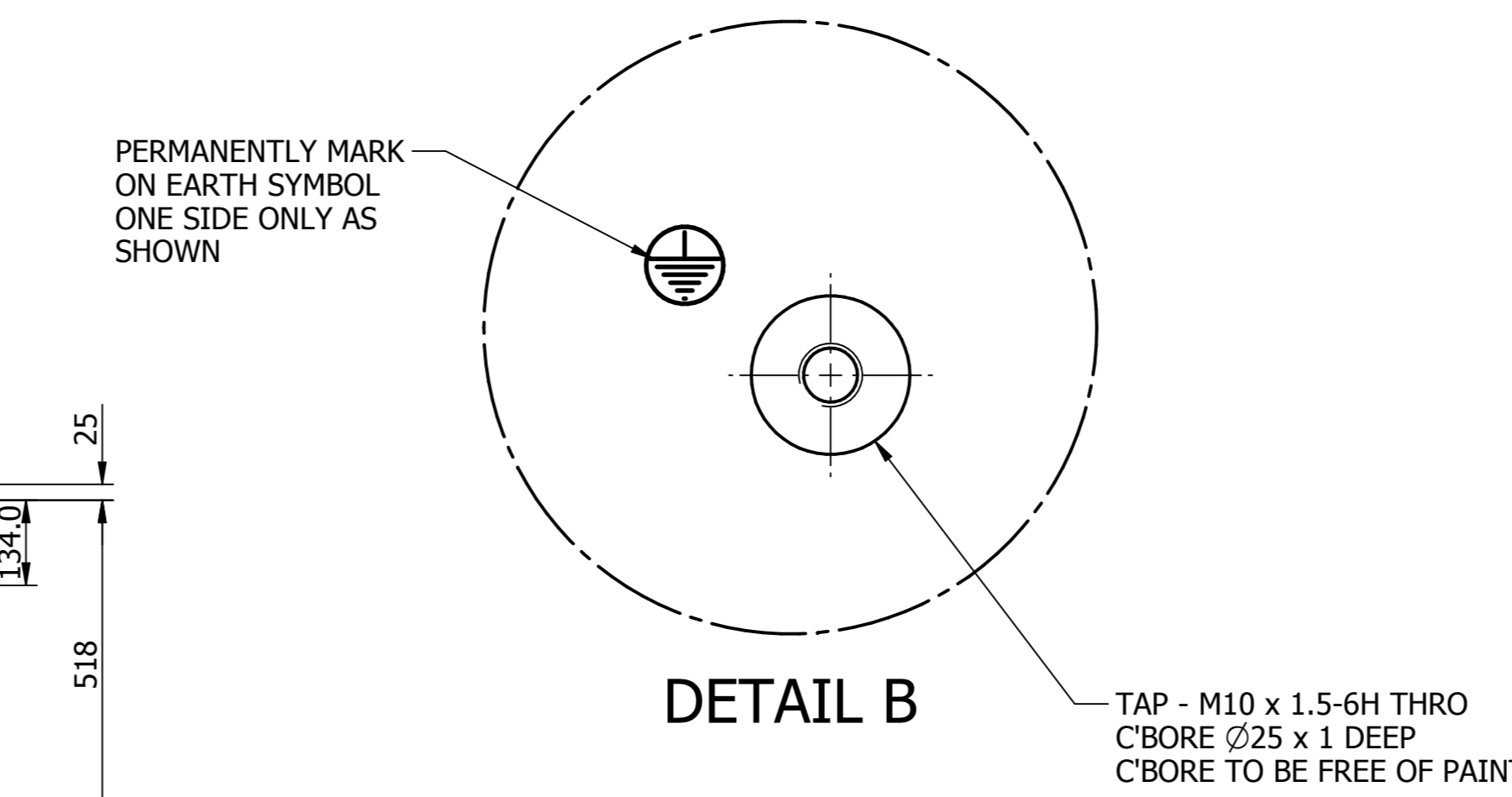
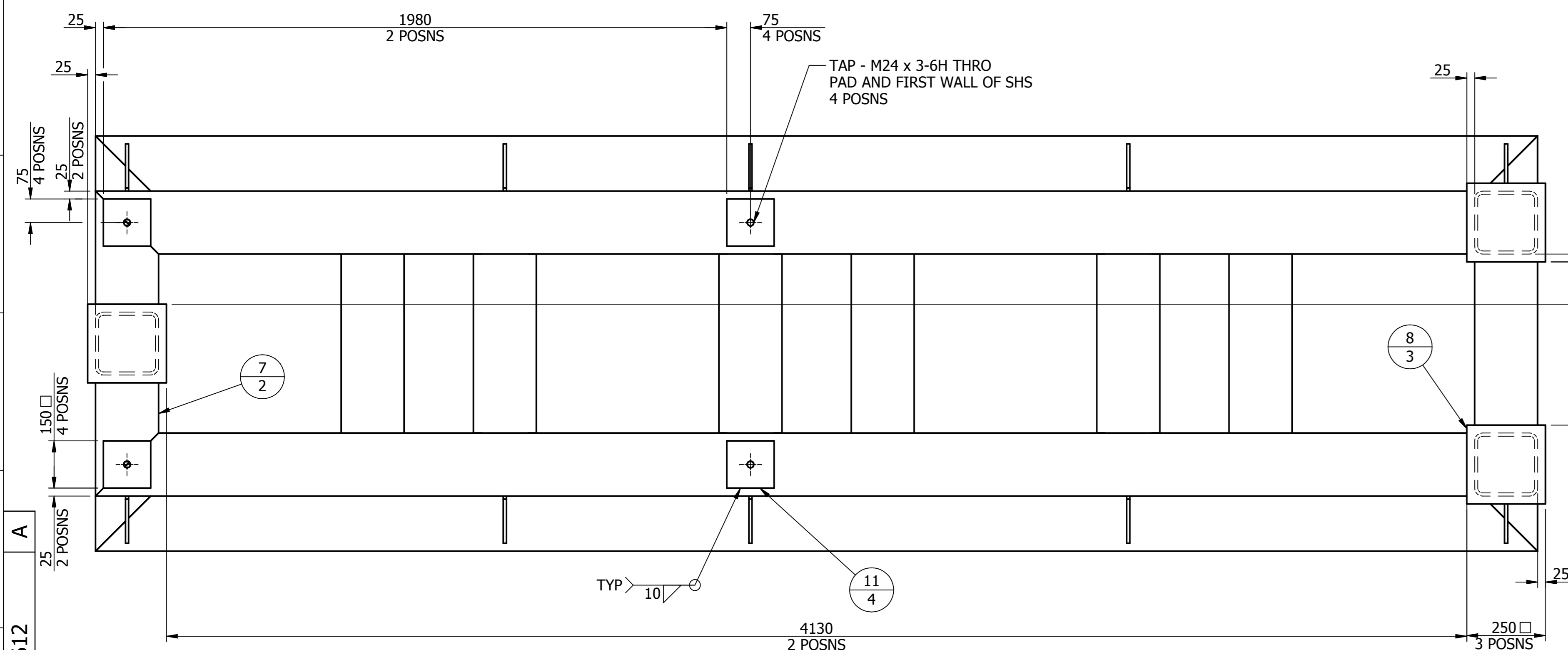
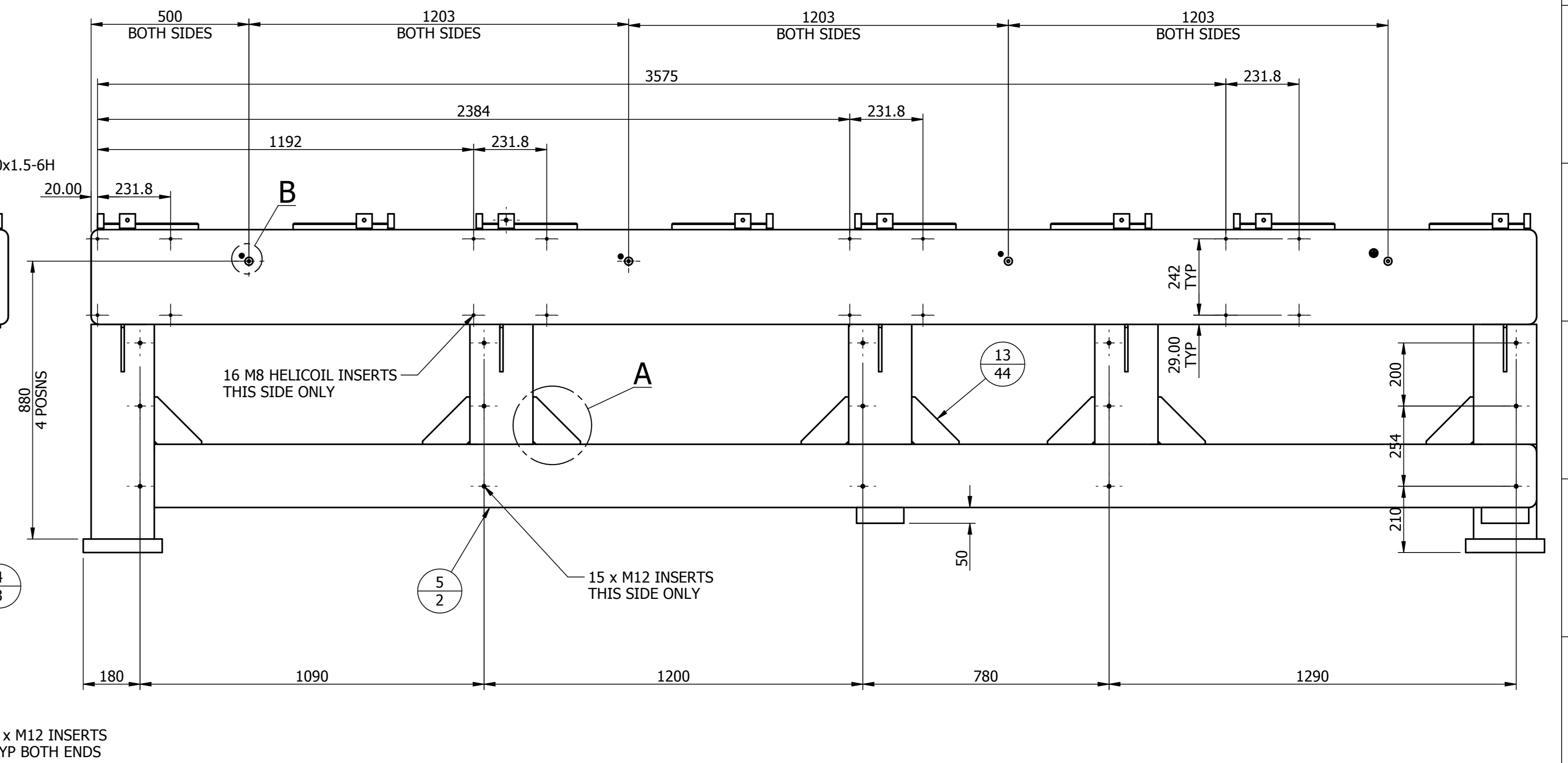
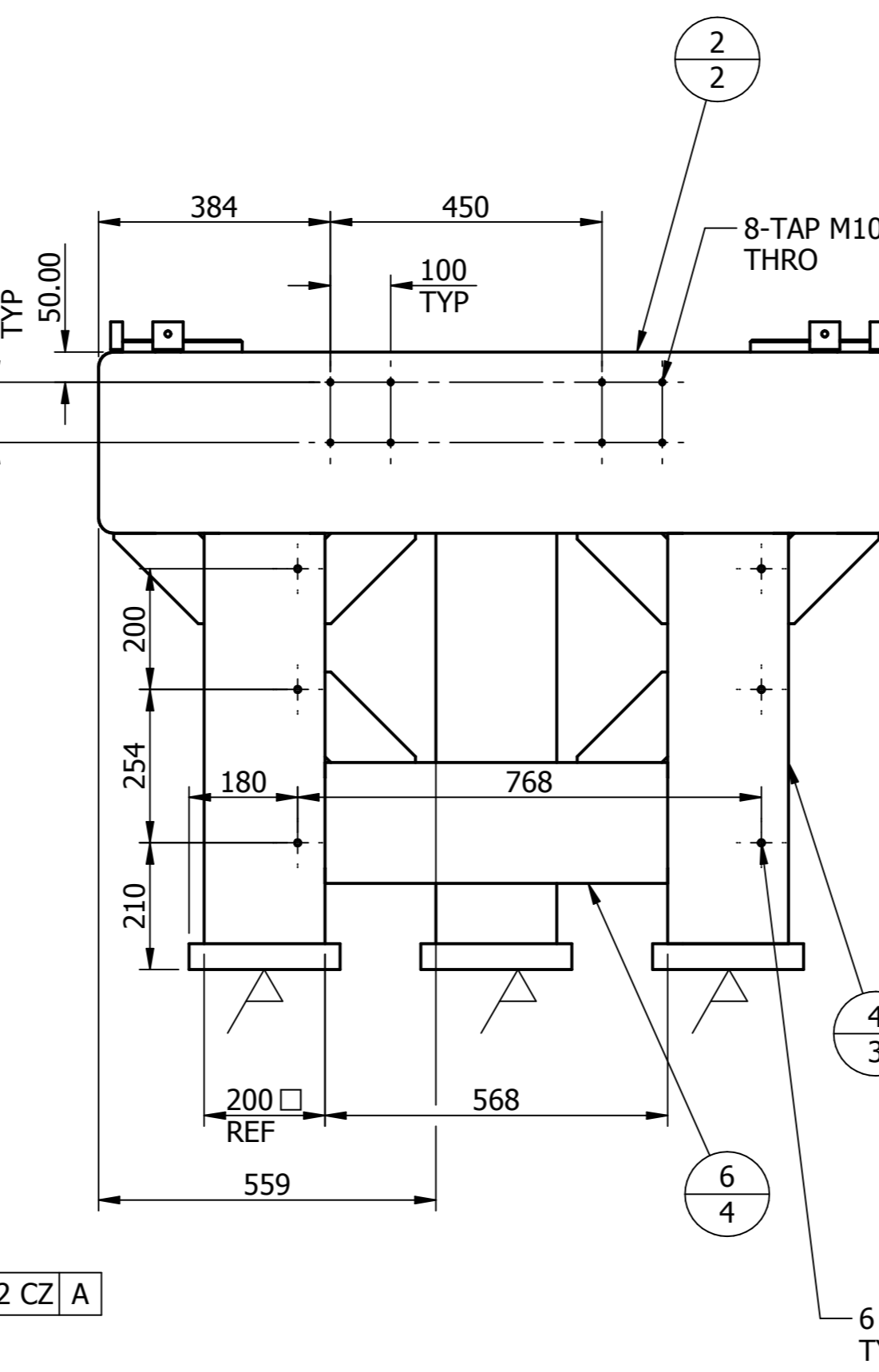
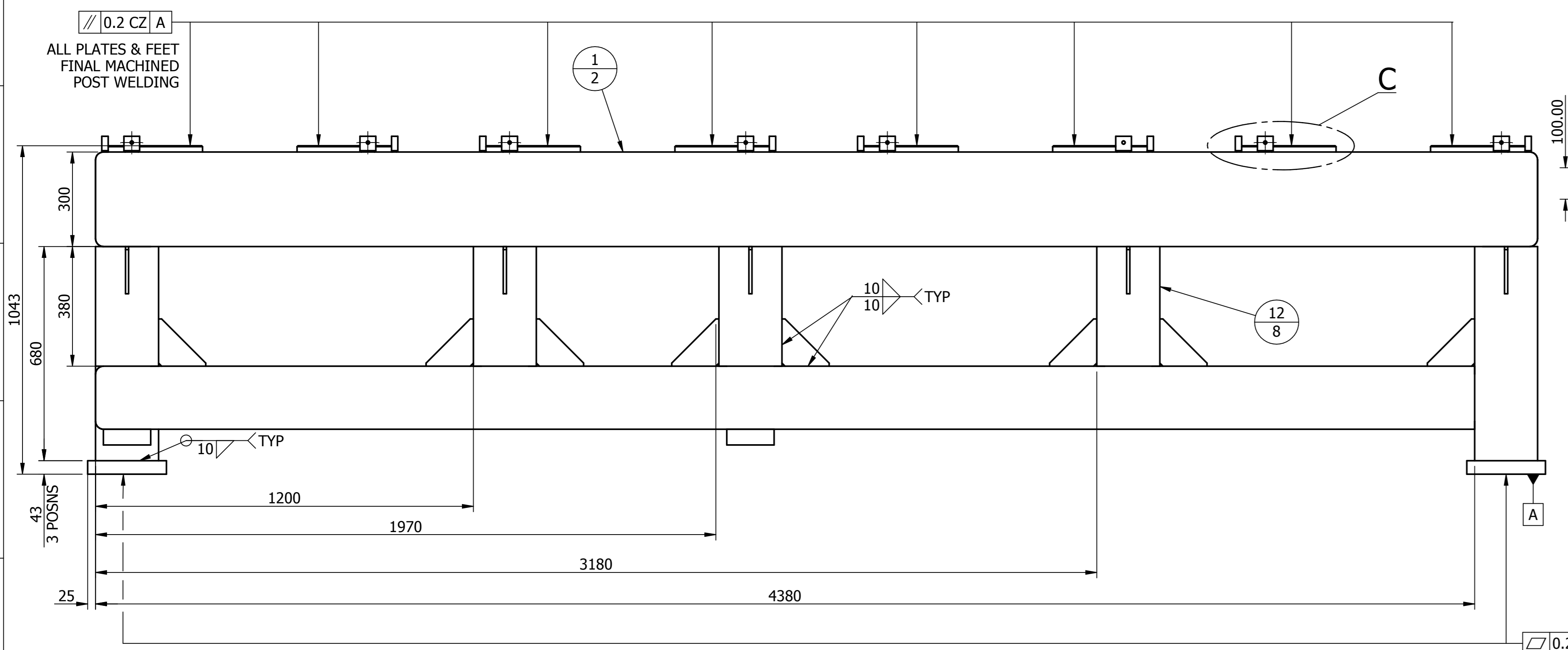


PLATE DETAILS LH/RH

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DETAIL C

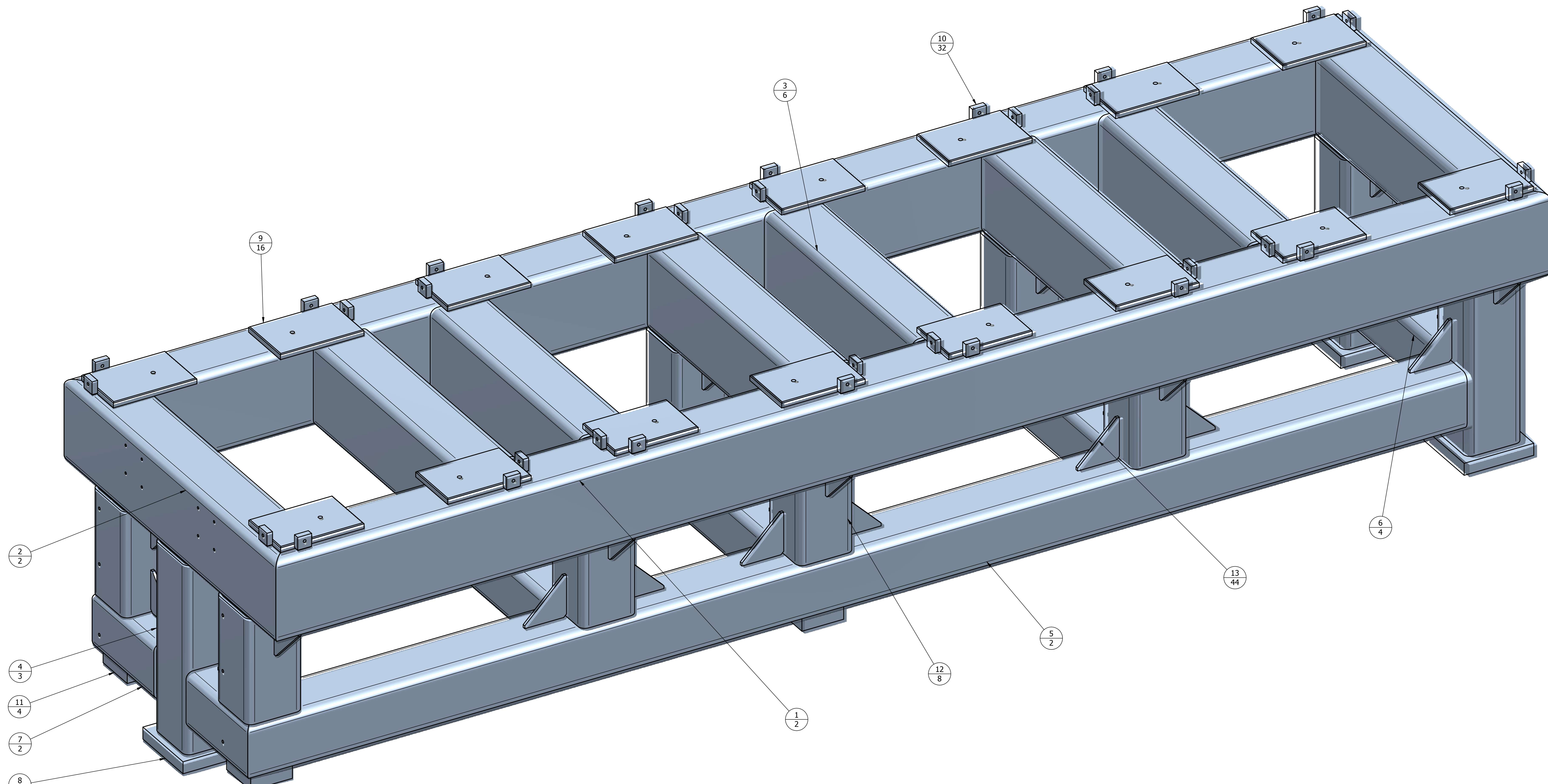


DETAIL B

NOTES

1. MAKE ITEMS 1, 2 & 3 FROM MILD STEEL RHS, 300 x 200 x 10 TO BS EN 10025:2004, Gr S275JR.
2. MAKE ITEMS 4, 5, 6, 7 & 12 FROM MILD STEEL SHS, 200 x 200 x 10 TO BS EN 10025:2004, Gr S275JR.
3. MAKE ITEMS 8, 10, 11 & 13 FROM MILD STEEL TO BS EN 10025:2004, Gr S275JR.
4. FULLY WELDED CONSTRUCTION. ALL FRAME WELDS TO BE 10 mm FILLET, VEE OR BEVEL BUTT AND ALL OTHERS TO BE AS STATED ON DRAWING. ADD VENT HOLES AS REQUIRED.
5. FINISH: PAINT ALL UNMACHINED SURFACES WITH TWO-PACK POLYURETHANE SEMI-GLOSS ENAMEL CONFORMING TO BS EN ISO 12944:1998 OR EQUIVALENT. COLOUR RAL 9002 (GREY WHITE).
- 6.
7. FINAL MACHINING OF PLATES AND FEET TO BE DONE AFTER WELDING.
- 8.
9. FOR CLARIFICATION 'CZ' IS NOTATION FOR COMMON ZONE. TYING THE FLATNESS (& PARALLELISM) OF THE ALL FRAMEWORK FOOT PLATES (ITEMS 9 & 10) TO ALL ITEM 11.
10. ENSURE ALL THREADS ARE FREE OF WELD SPATTER.

A		22.11.2013	RDR	RDR	KGJ	MANUFACTURE ONLY WHEN STATUS IS ISSUED	ISSUED
ISSUE	DATE	MOD. No.	DRAWN BY	CHKD BY	APPO BY	TOLERANCES UNLESS STATED	STATUS
						± 0.5 XX ± 0.3 XXX ± 0.1	
						ANGLE ± 0.2°	
DRAWING CONFORMS TO BS 8888 TOLERANCING ISO 8015						MATERIAL & SPEC. SEE ITEMS LIST	FINISH SEE NOTE 5 REMOVE ALL BURRS
ISIS DESIGN DIVISION		USED ON	SI-6292-611	SI-6292-610			
RUTHERFORD APPLETON LABORATORY, HARWELL OXFORD, DIDCOT, OXFORDSHIRE, OX11 0QX							
TITLE							
FRAME WELDMENT							
TS-1 EPB MAGNETS						DOWNSTREAM EPB1	
A0 SI-6292-612						SHEET 1 OF 2	



ISO VIEW
1:5

A	22.11.2013		RDR	RDR	KGJ	MANUFACTURE ONLY WHEN STATUS IS ISSUED	ISSUED
ISSUE	DATE	MOD. No.	DRAWN BY	CHKD BY	APPO BY	TOLERANCES UNLESS STATED	STATUS
DRAWING CONFORMS TO BS 8888 TOLERANCING ISO 8015			MATERIAL & SPEC. SEE ITEMS LIST		SURFACE TEXTURE UNLESS STATED FINISH SEE NOTE 5 REMOVE ALL BURRS		
ISIS DESIGN DIVISION		USED ON	SI-6292-611	SI-6292-610	TITLE		
RUTHERFORD APPLETON LABORATORY, HARWELL OXFORD, DIDCOT, OXFORDSHIRE, OX11 0QX							
FRAME WELDMENT							
TS-1 EPB MAGNETS						DOWNSTREAM EPB1	
A0 SI-6292-612						SHEET 2 OF 2	