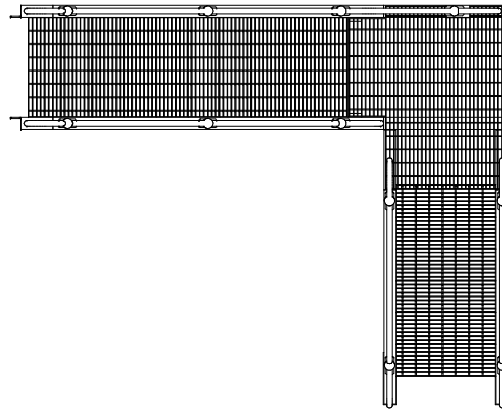


GENERAL ASSEMBLY NOTES:

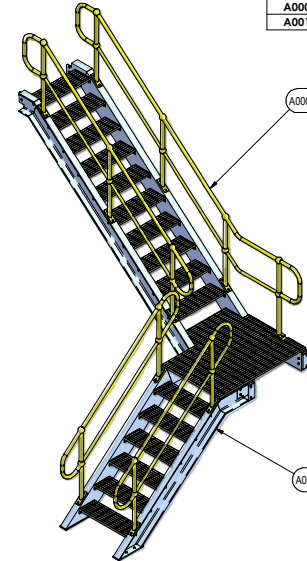
1. DIMENSIONS ARE EXACT WITH NO ALLOWANCE FOR CUTTING OR WELDING UNLESS OTHERWISE STATED.
2. SURFACE FINISH TO BE N8 FOR MACHINED PARTS UNLESS OTHERWISE STATED.
3. APPLY SHAFT PRESERVATIVE TO ALL MACHINED SURFACES IN PLACE OF PAINT.
4. ALL EDGES AND HOLES TO BE DEBURRED.
5. ALL HOLES IN STRUCTURE TO BE DRILLED OR PUNCHED - NOT GAS CUT.
6. REMOVE ALL SHARP WELD IRREGULARITIES, SLAG & SPLATTER.
7. ALL WELDS TO BE 6 MM CONTINUOUS FILLET OR FULL PENETRATION BUTT WELD UNO
8. ALL BUTT JOINTS / MITRE JOINTS TO BE FULL PENETRATION WELDS UNLESS OTHERWISE STATED
9. A BOLTSET CONSISTS OF A BOLT, NUT AND TWO WASHERS.
10. ALL BOLTS TO BE ISO METRIC COARSE UNLESS OTHERWISE STATED.
11. ALL STEELWORK TO BE BLASTED & PAINTED TO CANADIAN PACIFIC LIMITED PAINT SPECIFICATIONS.
12. ALL STRUCTURAL STEEL SHALL BE MILD STEEL IN ACCORDANCE WITH NZS/AS 3678:300 AND AS/NZS 3679:300 OR EQUIVALENTS
13. ALL STRUCTURAL STEEL FABRICATION AND ERECTION EXCEPT WELDING SHALL BE IN ACCORDANCE WITH NZS 3404
14. ALL WELDING TO BE SPECIAL PURPOSE UNO, WORKMANSHIP AND PROCEDURES SHALL BE IN ACCORDANCE WITH AS/NZS 1554
15. ALL BOLTS, NUTS AND WASHERS SHALL BE GRADE 8.8 IN ACCORDANCE WITH NZS 1252
16. ALL WELD METAL TO HAVE MINIMUM TENSILE STRENGTH OF 480 MPA

PART DETAILS						
PART No:	DESCRIPTION	WIDTH	HEIGHT	THICKNESS	LENGTH	MASS
A0006	STAIRS No 02					546.4 kg
A0010	STAIRS No 01					274.0 kg

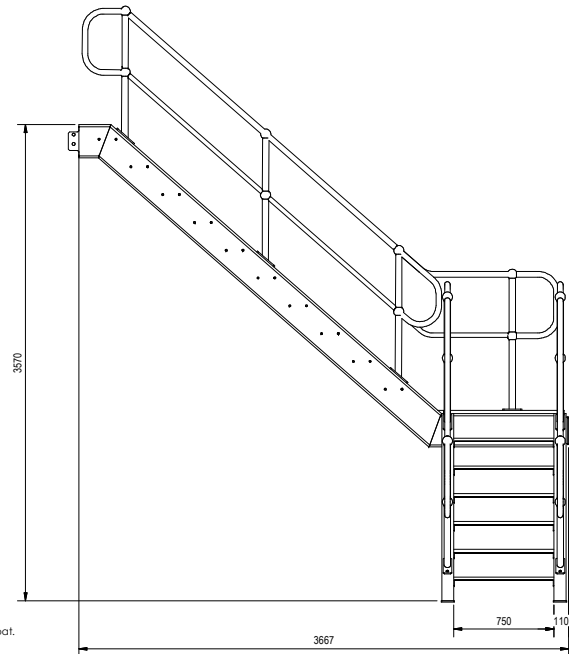
Location of Assembly
You Will Find This Assembly Back In
drawing: 9116b-A0000



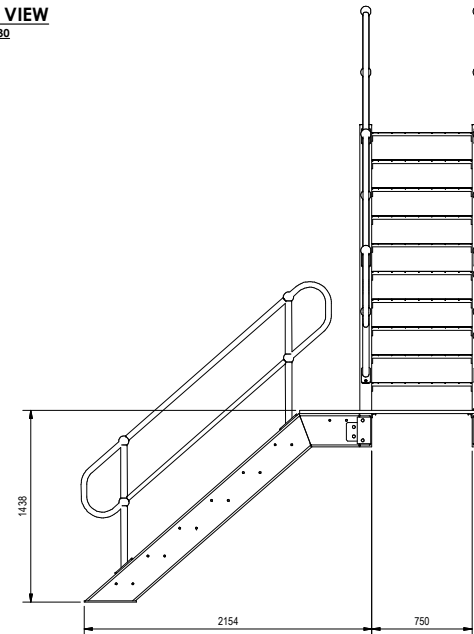
PLAN VIEW
SCALE 1 / 20



ISOMETRIC VIEW
SCALE 1 / 30



ELEVATION VIEW
SCALE 1 / 20



SIDE VIEW
SCALE 1 / 20

PAINT SPEC:
TG-209-0002

Abrasive blast to SSPC SP10 (Sa 2.5) to achieve a uniform jagged blast profile of between 35 and 50µm.
Apply coat 1 (Altra-Zinc 605) to the prepared SP10 substrate.
Apply a stripe coat of coat 2 (Altra-Build 536) (by brush) @ 75 ~ 100µm DFT to all weld seams & leading edges. Allow a minimum of 3 hours cure before overcoating. The stripe coat should be a contrasting colour than that of the next coat.
Apply full coats of coats 3 (Altra-Build 536) and 4 (E-Line 379).
All surfaces must be clean and dry before painting.
All faying surfaces for HSGF bolted joints are to be fully masked after application of coat 1 (Altra-Zinc 605).



DO NOT SCALE
DIMENSIONS IN MILLIMETRES
DRAFTING STANDARD: AS1100.101-1992

AMX Design



CAD
Design Drafting
Ph (07) 542 1849
Fax (07) 572 1445
Mob (021) 82 6278

TOLERANCE TABLE									
REV	REVISION DESCRIPTION	BY	DATE	NOMINAL DIMENSIONS			DIMENSIONS WITH DECIMALS		
				FROM	TO	TOLERANCE	NO. OF DECIMALS	TOLERANCE	
A	ISSUED FOR CONSTRUCTION	AMX	24/06/2010	0	300mm	±1.0mm	X	DECIMALS	
2	ISSUED FOR APPROVAL	AMX	16/06/2010	1000mm	1000mm	±1.5mm	XX	DECIMALS	
	CAD FILE TYPE			300mm	1000mm	±1.5mm	XX	DECIMALS	
	CAD FILENAME			1000mm	3000mm	±2.0mm			

	APP	DATE
3D MODEL	AMX	12/06/2010
PRODUCTION		
SALES		
DESIGN		
DRAFTING	ML	16/06/2010

MATAMATA WWTP
STRUCTURAL STEEL DETAILS
STAIRS

SIZE	SCALE	DRAWING NUMBER	SHEET	REV
A1		9116b-A0005	1 / 1	A