



NOTES
 ALL PARTS TO BE TRIAL ASSEMBLED PRIOR TO GALVANISING & DELIVERY.
 GENERAL FINISH NOTES TO BE ADHERED TO.
 ALL SHARP EDGES MUST BE REMOVED.
 INSPECTION TO CHECK QUALITY OF DELIVERED ITEMS.
 A & J FABRICATORS TO ASSEMBLE ALL PARTS ONTO BRIDGE BEAMS BEFORE DELIVERY TO SITE.

GENERAL FINISH & METAL PROTECTION
 Weld spatter, drill odour & other foreign bodies should be removed & all sharp edges dressed.
 GALVANISED SURFACES-- Apply strictly to specification with smooth finish & minimum amount of oxide. Reports should be made by thoroughly cleaning & wire brushing followed by a coat of 'Zinc' in accordance with manufacturers instructions.
 PAINTED SURFACES-- Should be strictly in accordance with specification & applied according to manufacturers instructions.
 B2P SURFACES-- Not allowed when unprotected.
 MACHINED SURFACES-- To be given two coats of machine shellic over clean metal surfaces, unless otherwise stated.
 BRIGHT METAL SURFACES-- To be as specification.

COMPONENT PARTS-- Motors, gearboxes, bearings etc. may require further protection. See specification for instructions.
FABRICATION TOLERANCES U.O.S.
 0 TO 300 ±0.75mm
 300 TO 1000 ±1.00mm
 1000 TO 1500 ±1.50mm
 1500 TO 4150 ±3.00mm

All machined dimensions on all parts to be to ±0.25mm

NOTES
 CORROSION PROTECTION
 U.O.S. DIMENSIONS EXCEPT
 ALL STEELWORK OTHER THAN HANDRAILING, DECKING & LAUNDERS SHALL BE GALVANISED TO BS EN ISO 1461:1999
 HANDRAILING, DECKING & LAUNDERS SHALL BE GALVANISED TO BS EN ISO 1461:1999
 GALVANISING TO BS EN ISO 1461:1999
 DIM OF 115 MICRONS
 DIM OF 115 MICRONS
 BELOW WATER
 WHEELS 2.01 TABLE 2
 SURFACE PREPARATION & WASH
 1 COAT COAL TAR EPOXY BLACK
 H-28 @ 75 MICRONS DFT
 1 COAT COAL TAR EPOXY BROWN
 H-28 @ 150 MICRONS DFT
 1 COAT COAL TAR EPOXY BLACK
 H-28 @ 150 MICRONS DFT
 WHEEL GUARD COLOUR-- SAFETY RED
 NOTE
 ALL PAINT COLOURS TO BE SHIP APPLIED. SITE TOUCH UP ONLY.
EXHIBITS
 SCRAPER BLADES & ANCHOR BOLTS ALL PARTS TO BE SHIP APPLIED. SITE TOUCH UP ONLY.
 ALL PARTS THAT ARE REMOVABLE FOR MAINTENANCE TO ALL PARTS BELOW WATER THAT ARE NOT REMOVABLE TO BE GALVANISED.
 ALL PARTS ABOVE WATER TO BE GALVANISED.
 SCRAPER BLADES & ANCHOR BOLTS TO BE SHIP APPLIED.
 DESIGN SPEC TO WMS 2.01

REF DRGS DY00589-223-P3
 DY00589-224-P1

No.	DETAILS	DATE	DRN
F			
E			
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C			
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CLIENT	ACWA Services Ltd
PROJECT	ASHFORD STW
	2 No 8.539M Dig HALF BRIDGE SCRAPERS
DRAWN	K.A.A.
DATE	25/02/08
SCALE	1:25/1:40
CHECKED	
TITLE GENERAL ARRANGEMENT OF HALF BRIDGE SCRAPERS	
PLATEWORK FABRICATORS TO IS TANK STEEL WORKERS TO THE CONCRETE INDUSTRY STANDARD FOR INDUSTRIAL STEEL CONCRETS AND TANKS A&J FabTech Ltd WILKINS WORKS, MANULY CAME ROAD, BRISTOL, BRISTOL, BRISTOL Tel: 01274 453371 Fax: 01274 453371 Website: www.aandjfabtech.com	
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REVISION	