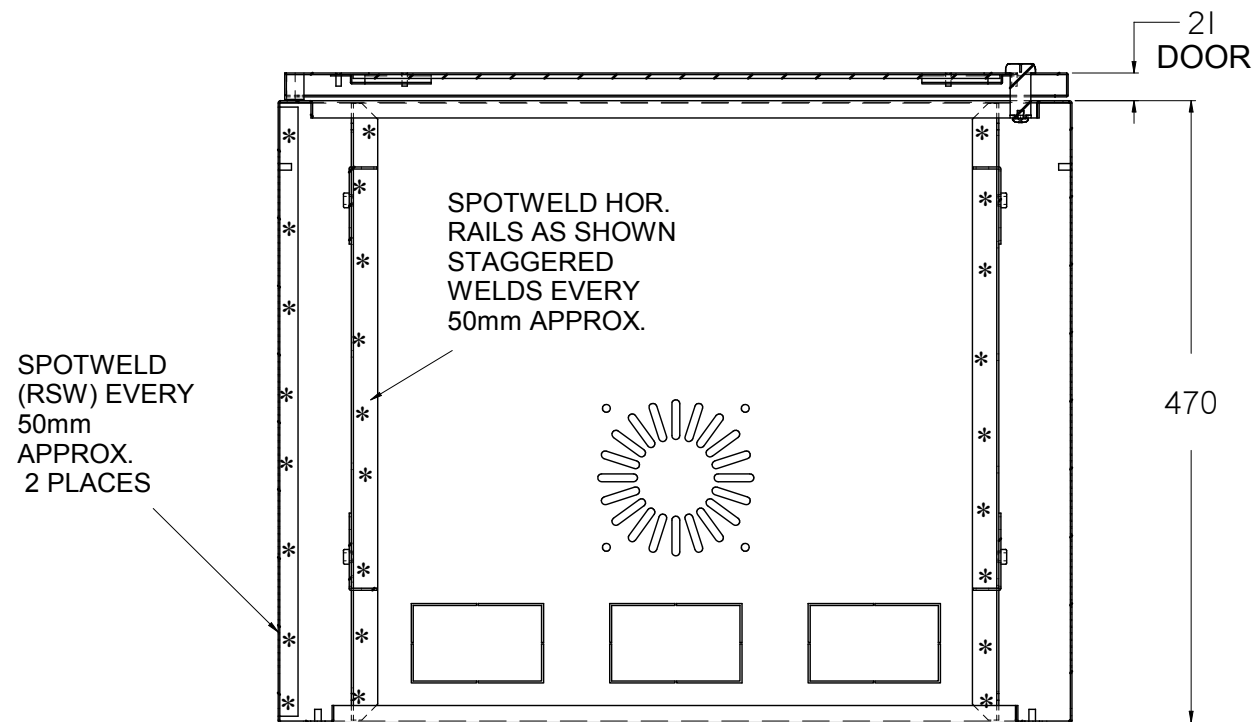
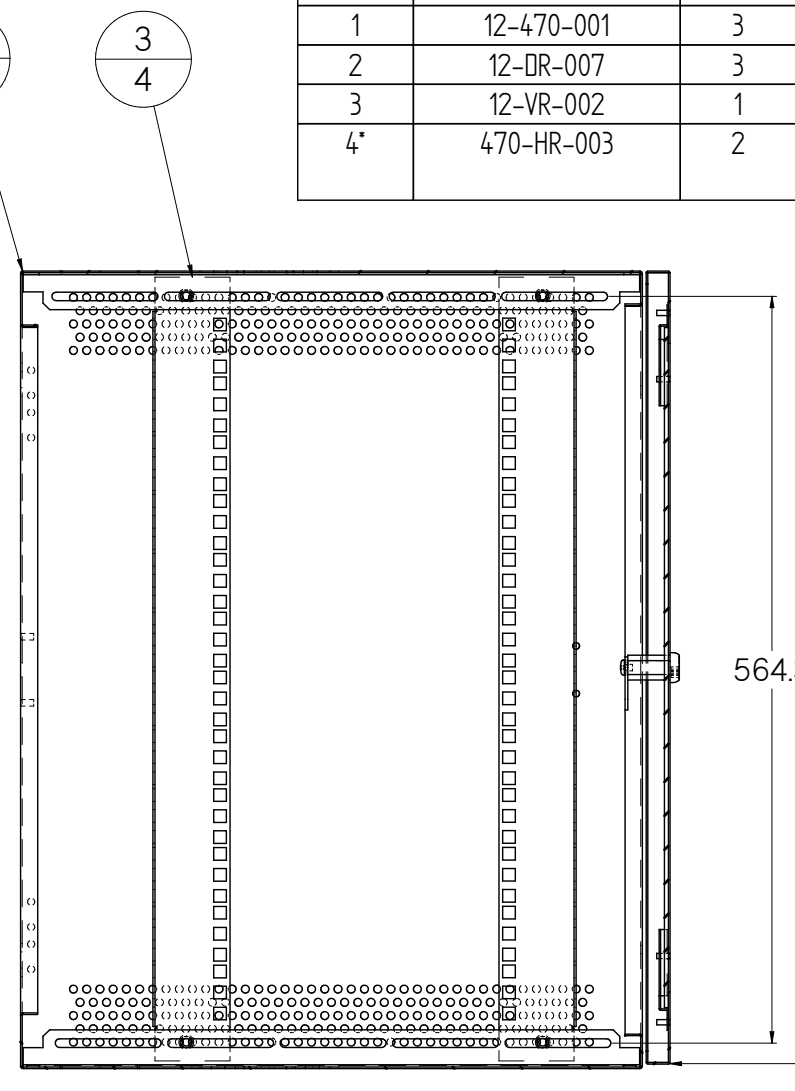
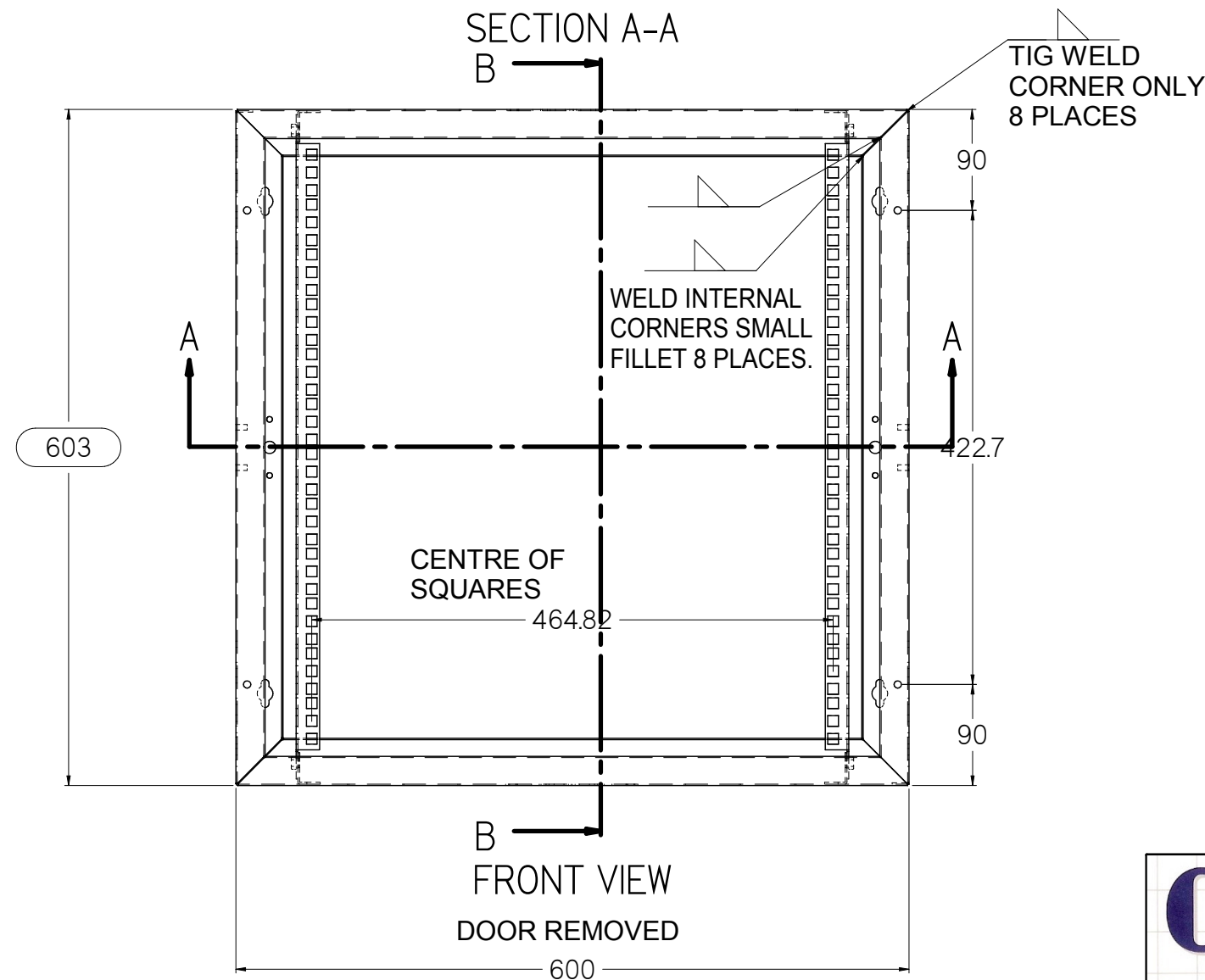


REV.	REVISION HISTORY	DATE
0	FIRST PRODUCTION RELEASE	18/08/2009
1	HINGE HOLES ADDED	20/11/2007
2	KEYHOLES ADDED TO BODY	5/12/2007



ADDITIONAL FASTENERS AND HARDWARE REQUIRED FOR COMPLETION
 2 OFF DOOR HINGES PT.NO. EMKA- 1110-U3
 4 OFF M5 SERRATED FLANGE HEX NUTS (HINGE TO DOOR)&(ROD MOUNT BKTS TO CABINET)
 4 OFF 4.75 DIA. POP RIVETS CODE 73-AS-6-2 (HINGE TO CABINET)
 4 OFF M6 X 14 THUMB SCREW BLACK AND INTERNAL SHAKEPROOF WASHER (V.RAILS TO H. RAILS)

Item Number	Document Number	Revision	Title	Material	Quantity
1	12-470-001	3	BODY HALF		2
2	12-DR-007	3	DOOR ASSEMBLY 12RU		1
3	12-VR-002	1	12RU VERTICAL RAIL		4
4*	470-HR-003	2	HORIZONTAL RAIL 470 DEEP	1.6MILD STEEL	4



ASSEMBLY PROCEDURE -
 SPOTWELD HORIZONTAL RAILS TO BODY HALVES.
 TIGWELD BODY HALVES TOGETHER ON INNER CORNERS ONLY.
 CHECK SIZE 600mm OVERALL MINIMUM GAPS IN CORNERS
 SPOTWELD BODY HALVES TOGETHER, THEN FUSION WELD OUTER CORNERS.
 MASK THREADS
 POWDERCOAT BODY, THEN FIT V.RAILS AND DOOR

NOTE: ALL DIMENSIONS EXTERNAL UNLESS NOTED OTHERWISE

CRS	DRAWN BY:	INITIAL	TOLERANCES TOLERANCES SET BY NUMBER OF DECIMAL PLACES. ie: 1 decimal - 0.0 = +/- 0.5mm 2 decimals - 0.00 = +/- 0.15mm ANGLES +/- 0.5 deg. ○ DENOTES CRITICAL DIMENSION	MATERIAL	FINISH
	CHECKED BY:	INITIAL		PROJECT	POWDERCOAT GREY NURSE RIPPLE
FLAT PATTERN DISCLAIMER AS INDIVIDUAL MANUFACTURERS TOOLING MAY VARY WIDELY IT IS THE MANUFACTURERS RESPONSIBILITY TO DETERMINE CORRECT FLAT SIZES OR WHETHER THE SUPPLIED FLAT DIMENSIONS ARE ACCURATE	SHEET 1 OF 1		DRAWING NO.	FILENAME:	
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		GENERAL ASSY. 12RU CABINET	2	12/11/2009	