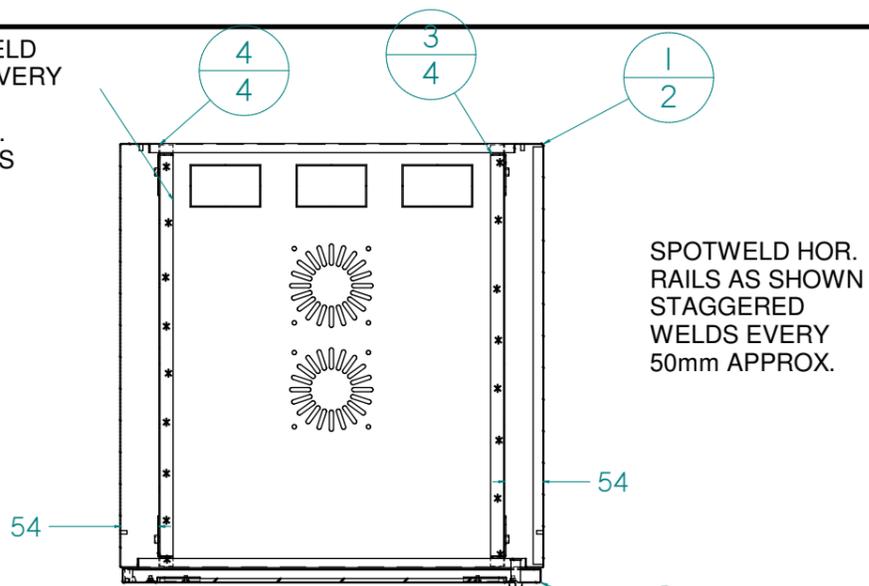


SPOTWELD (RSW) EVERY 50mm APPROX. 2 PLACES



SPOTWELD HOR. RAILS AS SHOWN STAGGERED WELDS EVERY 50mm APPROX.

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

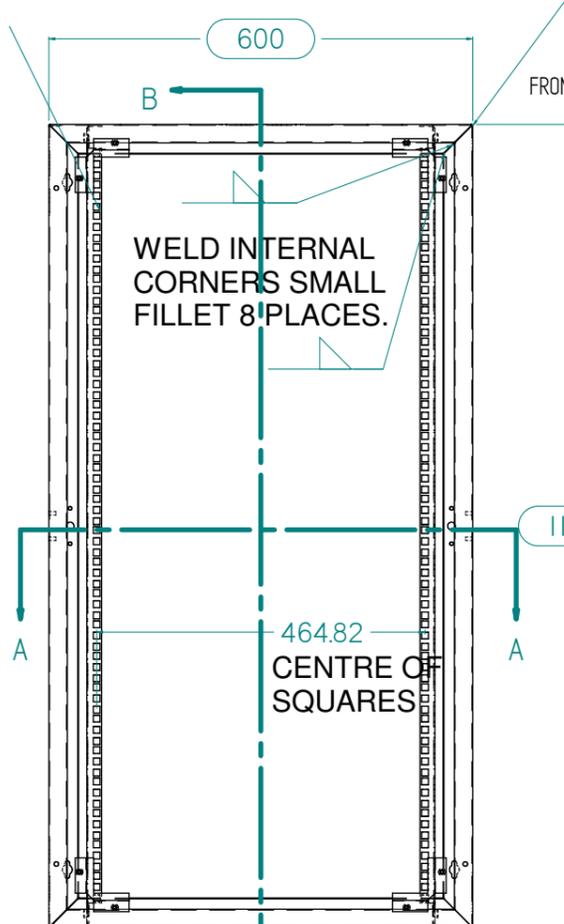
REV.	REVISION HISTORY	DATE
0	FIRST PRODUCTION RELEASE	1/07/2011
1	HONGE HOLES CHANGED TO CL-230-2 HINGE	
2	RE-DRAWN FROM ACTUAL MODEL	21/12/2009
3	EXTRA FAN HOLES ADDED TOP AND BOTTOM	10/02/2010

ADDITIONAL FASTENERS AND HARDWARE REQUIRED FOR COMPLETION
 2 OFF DOOR HINGES PT.NO. EMKA- 1110-U3 (OR CL-230-2)
 4 OFF M5 SERRATED FLANGE HEX NUTS (HINGE TO DOOR)&(ROD MOUNT BKTS TO CABINET)
 2 OFF M5 X 10 HEX SCREW (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	24-600-001	3	1/2 Box Body 24 RU		2
2	24-DR-007	3	DOOR 24RU WALL MOUNT		1
3	24-VR-002	1	24 RU VERTICAL RAIL		4
4	600-HR-003	2	HORIZONTAL RAIL 600 DEEP	15 MS	4

INSIDE OF CABINET TO OUTSIDE OF HOR. RAIL SECTION A-A

24 RU VERTICAL RAILS 4 PLACES



WELD INTERNAL CORNERS SMALL FILLET 8 PLACES.

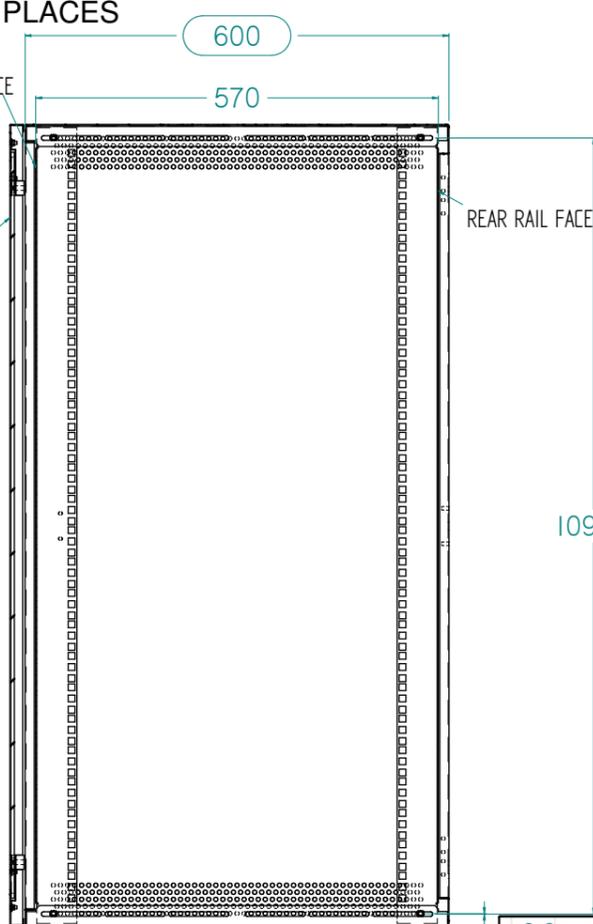
FRONT VIEW 1:10
 DOOR REMOVED FOR CLARITY

TIG WELD CORNER ONLY 8 PLACES

FRONT RAIL FACE

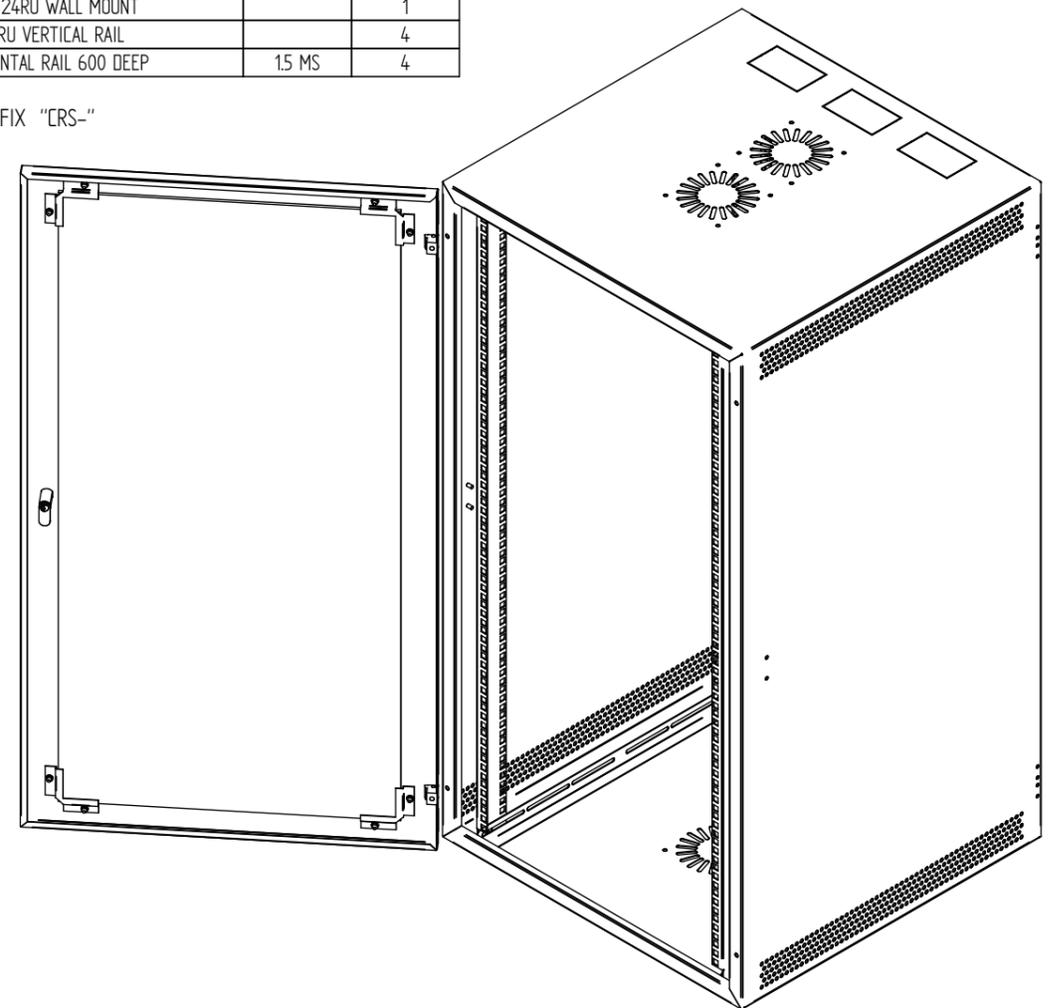
DOOR

REAR RAIL FACE



SECTION B-B

ALL DRAWING NUMBERS MAY HAVE THE PREFIX "CRS-"



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	GREY NURSE RIPPLE
FLAT PATTERN DISCLAIMER AS INDIVIDUAL MANUFACTURERS TOOLING MAY VARY WIDELY IT IS THE MANUFACTURERS RESPONSABILITY TO DETERMINE CORRECT FLAT SIZES OR WHETHER THE SUPPLIED FLAT DIMENSIONS ARE ACCURATE	SHEET 1 OF 1 AS 1100		DRAWING NO.	WALL MOUNT CABINET	
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			TITLE	REV.	DATE
			GENERAL ASSY. 24RU CABINET	3	6/02/2012