



**FRONT VIEW**

END OF PIPES TO BE SWAGGED TO DIMENSIONS SHOWN. APPROX. LENGTH OF ASSEMBLY - 200mm

**TYPICAL WELDING DETAILS**

**LEFT SIDE VIEW**

**SPIGOT APPLICATION**

**REFERENCE DRAWINGS**

STANDARD STREET LIGHTING BRACKETS 7-2

A3-513953

**NOTES**

1. ALL STEELWORK TO BE FABRICATED IN ACCORDANCE WITH AS 4100.
2. UNLESS NOTED OTHERWISE:
  - (a) ALL HOT ROLLED FLATS TO BE GRADE 250 MINIMUM IN ACCORDANCE WITH AS 1594.
  - (b) ALL HOT ROLLED SECTIONS TO BE GRADE 250 MINIMUM IN ACCORDANCE WITH AS 3679.
  - (c) ALL HOLLOW SECTIONS TO BE GRADE C350 IN ACCORDANCE WITH AS 1163.
3. AFTER FABRICATION, ALL BURRS AND SHARP EDGES TO BE REMOVED.
4. ALL WELDING TO BE IN ACCORDANCE WITH AS 1554 PART 1.
5. CONSUMABLES (ELECTRODES) SHALL BE MATCHED WITH THE STEEL TYPE IN COMPLIANCE WITH AS/NZS 1554.1 TABLE 4.6.1(A) & THE RELEVANT COLUMNS OF THE TABLE DEPENDING ON THE TYPE OF WELDING PROCESS BEING UNDERTAKEN.
6. UNLESS NOTED OTHERWISE:
  - (a) ALL WELDS SHALL BE 6mm CONTINUOUS FILLET WELDS, CATEGORY GP.
  - (b) BUTT WELDS SHALL BE CONTINUOUS FULL PENETRATION, CATEGORY SP.
  - (c) ALL WELDS TO BE CARRIED OUT IN THE SHOP UNLESS NOTED AS 'WELD ON SITE'.
7. WELDS SHALL BE INSPECTED TO AS/NZS 1554.1 CLAUSE 7.3 (VISUAL INSPECTION OF WORK) UNLESS THE WELDING PROCESS IS SUPERVISED AND CARRIED OUT BY QUALIFIED PERSONNEL AS DEFINED IN AS/NZS 1554.1 CLAUSE 4.12.1 AND CLAUSE 4.12.2.
8. AFTER FABRICATION, ALL WELDS TO BE CHIPPED FREE OF SLAG.
9. STEELWORK TO BE HOT DIP GALVANISED TO AS 4680 BEFORE MOULDING.
10. AFTER GALVANISING, ALL HOLES TO BE CLEARED, SHARP EDGES TO BE REMOVED & EXCESS GALVANISING REMOVED FROM MATING PARTS.
11. WHERE THE GALVANISING FINISH HAS BEEN DAMAGED, AREA TO BE TREATED WITH COLD GALVANISING PAINT SIMILAR TO ZINCFIX. COATINGS TO BE APPLIED IN ACCORDANCE WITH THE MANUFACTURERS INSTRUCTIONS.
12. TOTAL MASS OF ADAPTER IS 0.7Kg.
13. IF ANY MATERIAL SIZE AS DETAILED ON EA. DRAWING IS TO BE CHANGED, PRIOR APPROVAL MUST BE OBTAINED FROM EA.

0 5 10 cm  
CENTIMETRES ON ORIGINAL DRAWING AT SCALE 1:1

CAD DRAWING  
DO NOT MANUALLY AMEND  
A M E N D M E N T S  
4. DRAWING BORDER  
UPDATED. SECURING  
SCREWS ALTERED. NOTES  
UPDATED.  
C.SAWDY 13.06.2013  
APPROVED: PHIL HUDSON

STOCKCODE  
H77149



MECHANICAL DESIGN  
570 GEORGE STREET  
SYDNEY NSW 2000

SCALE	1 : 2
DESIGNED	
DRAWN	P.S.
CHECKED	G. SKINNER
APPROVED	G. SKINNER
DATE	09.08.1999
PROJECT NUMBER	
PROJTRAK NUMBER	

STREET LIGHTING  
ADAPTER SPIGOT  
DN32 TO DN25 CLAMP TYPE  
ARRANGEMENT AND DETAILS

SIZE	DRAWING No	SHEET	AMD
A3	514011	1	4