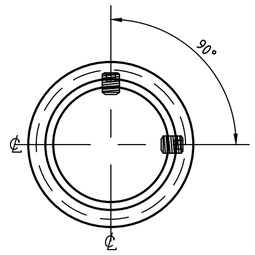
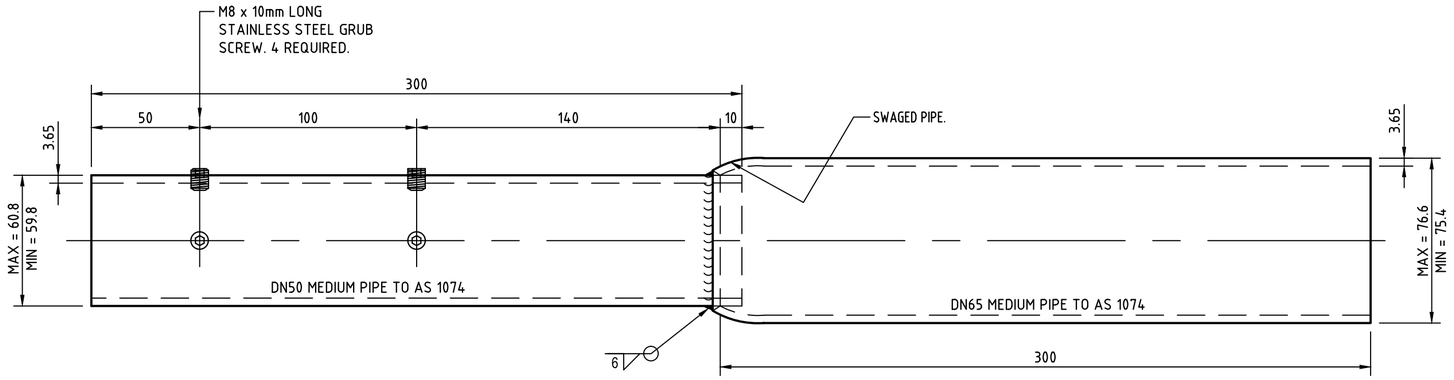


LEFT SIDE VIEW



FRONT VIEW

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 1554.1.
   (a) A WELDING PROCEDURE SHALL BE QUALIFIED BEFORE WELDING.
   (b) A WELDING PROCEDURE SPECIFICATION (WPS) TO BE DEVELOPED FROM THE PROCEDURE QUALIFICATION RECORD (PQR).
   (c) PRODUCE DOCUMENTARY EVIDENCE OF MACRO TEST, TENSILE AND BEND TEST IN ACCORDANCE WITH AS 1554.1
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. AFTER FABRICATION, ALL STEELWORK TO BE HOT DIP GALVANISED TO AS 4680. GALVANISING MINIMUM AVERAGE COATING THICKNESS AND MASS TO BE 125µm, 900g/m^2. AVERAGE THICKNESS SHALL BE DETERMINED IN ACCORDANCE WITH AS 2312.
   SURFACE FINISH : THE GALVANISED COATING TO BE CONTINUOUS, ADHERENT, AS SMOOTH AND EVENLY DISTRIBUTED AS POSSIBLE, AND FREE FROM ANY DEFECT THAT IS DETRIMENTAL TO THE STATED END USE OF THE COATED ARTICLE. ANY RECTIFICATION IS TO CARRIED OUT AS PER CLAUSE 8 OF AS 4680.
   ADHESION : THE GALVANISED COATING SHALL BE SUFFICIENTLY ADHERENT TO WITHSTAND NORMAL HANDLING DURING TRANSPORT AND ERECTION.
10. AFTER GALVANISING, ALL HOLES TO BE CLEARED AND SHARP EDGES TO BE REMOVED.
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. TAPPED HOLES TO BE RE-TAPPED AFTER GALVANISING.
13. ALTERNATIVE DESIGN & MATERIALS MAY BE SUBMITTED FOR APPROVAL PRIOR TO FABRICATION.
14. APPROXIMATE MASS IS 3.44kg.

AUSGRID PART No: PLS16 STOCK CODE : H120683

CAD DRAWING
DO NOT MANUALLY AMEND

AMENDMENTS

0.	INITIAL ISSUE DWN: P.S. CHKED: R.K.	DWN: C.SAWDY	
1	DRAWING BORDER UPDATED. NOTES UPDATED TO CURRENT STANDARDS.	DATE: 19.01.2015	AUTH'D by: P. HUDSON

0 10 20 cm
CENTIMETRES ON ORIGINAL DRAWING AT SCALE 1:2

NETWORK STANDARD
Ausgrid
MECHANICAL DESIGN
570 GEORGE STREET
SYDNEY NSW 2000

SCALE	1 : 2
DESIGNED	
DRAWN	
CHECKED	RWK
APPROVED	G. SKINNER
DATE	28.01.1998
PROJECT NUMBER	
PROJTRAK NUMBER	

STREET LIGHTING
LUMINAIRE FIXING SPIGOT
NOMINAL SIZE DN65
ARRANGEMENT AND DETAILS

SIZE	DRAWING No	SHEET	AMD
A2	520422	1	1

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