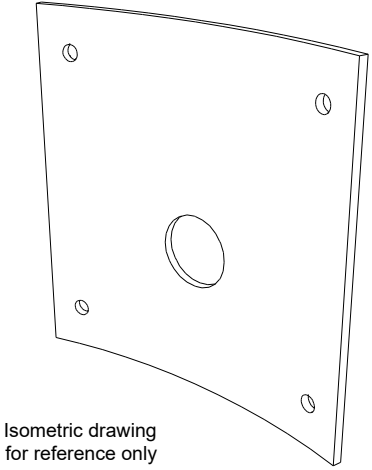
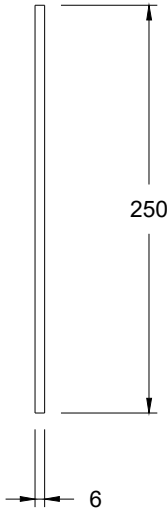
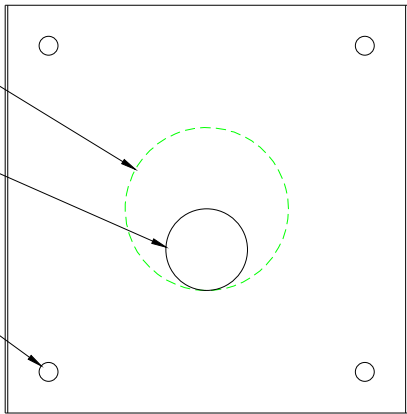


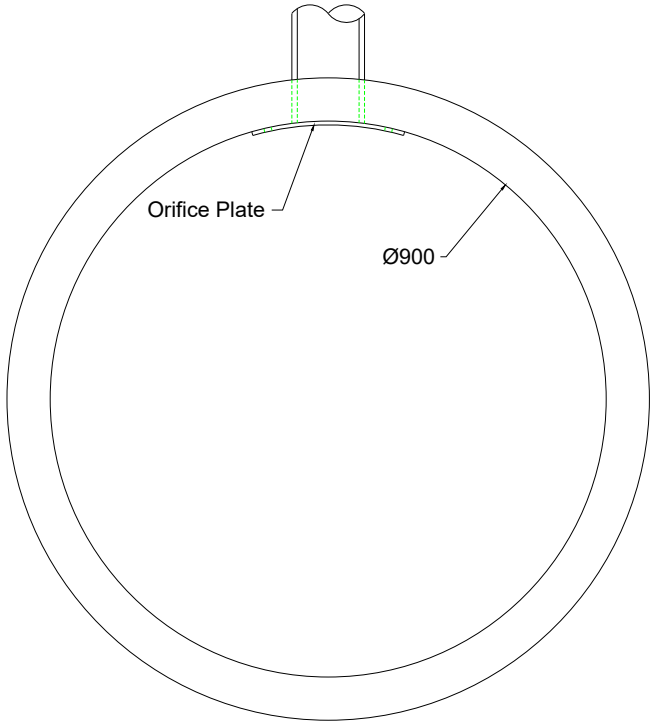
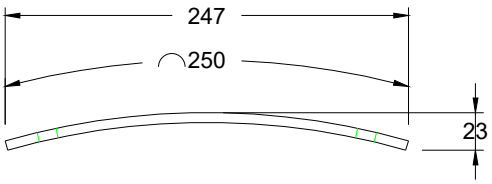
Ø100
Pipe Diameter

Opening made to
specified diameter

Fixing Points



Isometric drawing
for reference only



DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nn
- M10 (16mm Wrench) - 25 - 40Nn
- M12 (18mm Wrench) - 28 - 40Nn
- M16 (24mm Wrench) - 28 - 40Nn
- M20 (30mm Wrench) - 28 - 40Nn
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO: DATE: DESCRIPTION:



ADDRESS: ALTHON LIMITED
VULCAN ROAD SOUTH
NORWICH
NR6 6AF
TEL: 01603 488700
FAX: 01603 488598
EMAIL: sales@althon.co.uk
WEBSITE: www.althon.co.uk

PROPRIETARY & CONFIDENTIAL

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DRAWING TITLE:

Stainless Steel 316
100mm Curved Orifice Plate
for 900mm dia Chamber
250 x 250 x 6mm

FINISH:

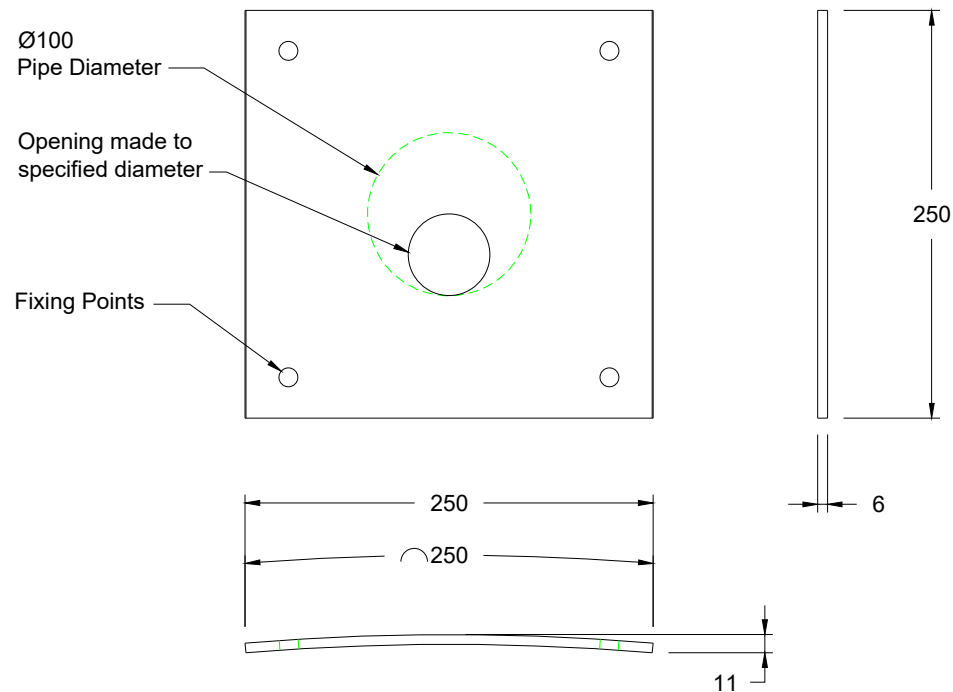
Stainless Steel 316

SCALE: PAPER: DATE:
NTS A4 26 - 09 - 19
SHEET NO: WEIGHT:
01 OF 01 kg

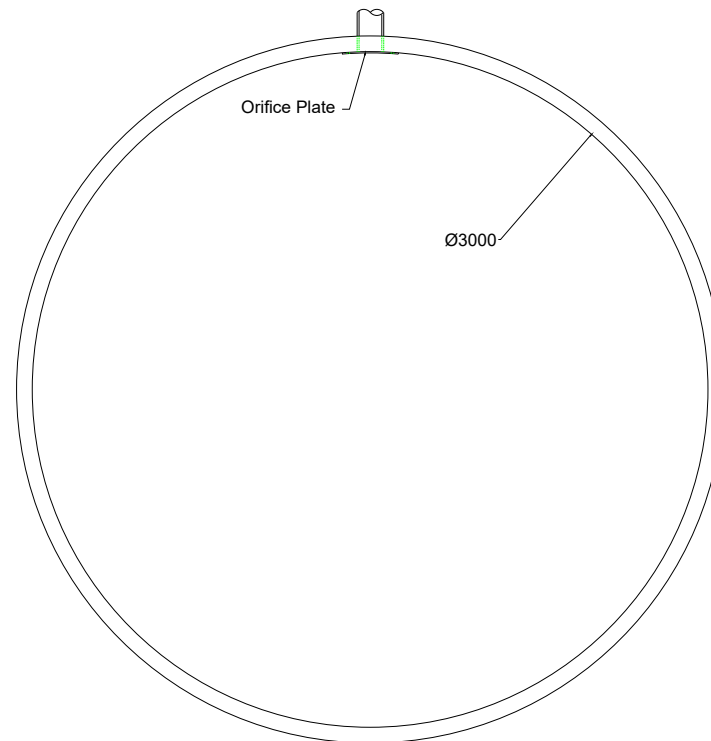
PRODUCT NAME:
Stainless Steel 316 100mm Curved Orifice Plate
for 900mm dia Chamber

CODE:

316COP100900



Isometric drawing
for reference only



DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nm
- M10 (16mm Wrench) - 25 - 40Nm
- M12 (18mm Wrench) - 28 - 40Nm
- M16 (24mm Wrench) - 28 - 40Nm
- M20 (30mm Wrench) - 28 - 40Nm
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO:	DATE:	DESCRIPTION:
		

ADDRESS: ALTHON LIMITED VULCAN ROAD SOUTH NORWICH NR6 6AF	TEL: 01603 488700 FAX: 01603 488598 EMAIL: sales@althon.co.uk WEBSITE: www.althon.co.uk
---	--

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DRAWING TITLE:

Stainless Steel 316
100mm Curved Orifice Plate
for 3000mm dia Chamber
250 x 250 x 6mm

FINISH:

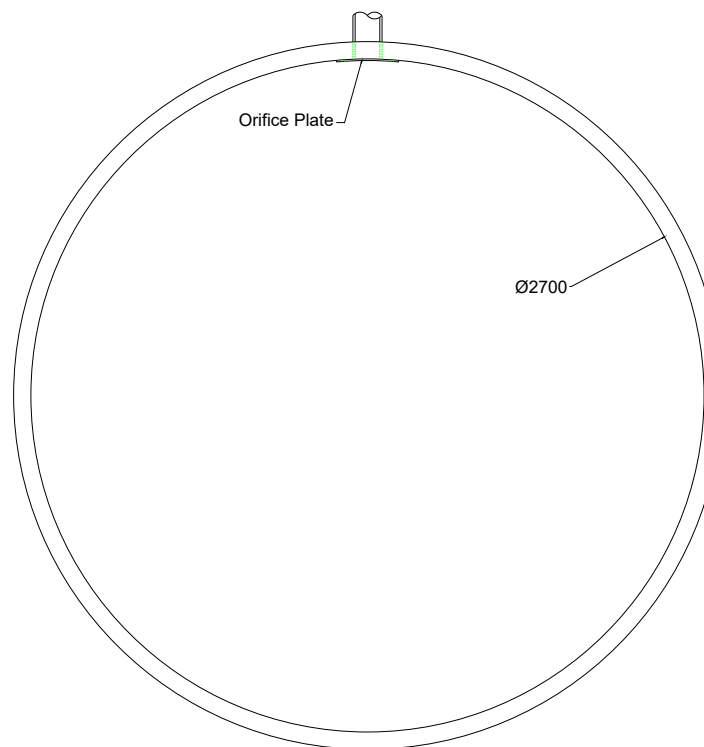
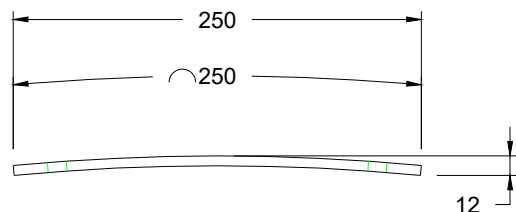
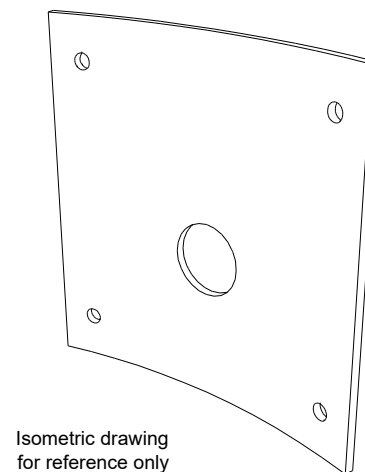
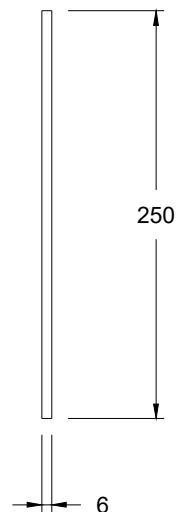
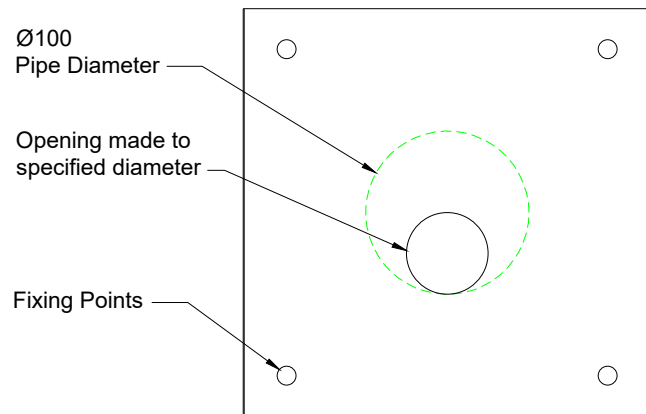
Stainless Steel 316

SCALE:	PAPER:	DATE:
NTS	A4	30 - 09 - 19

SHEET NO:	WEIGHT:
01 OF 01	kg

PRODUCT NAME:
Stainless Steel 316 100mm Curved Orifice Plate
for 3000mm dia Chamber

CODE:
316COP1003000



DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

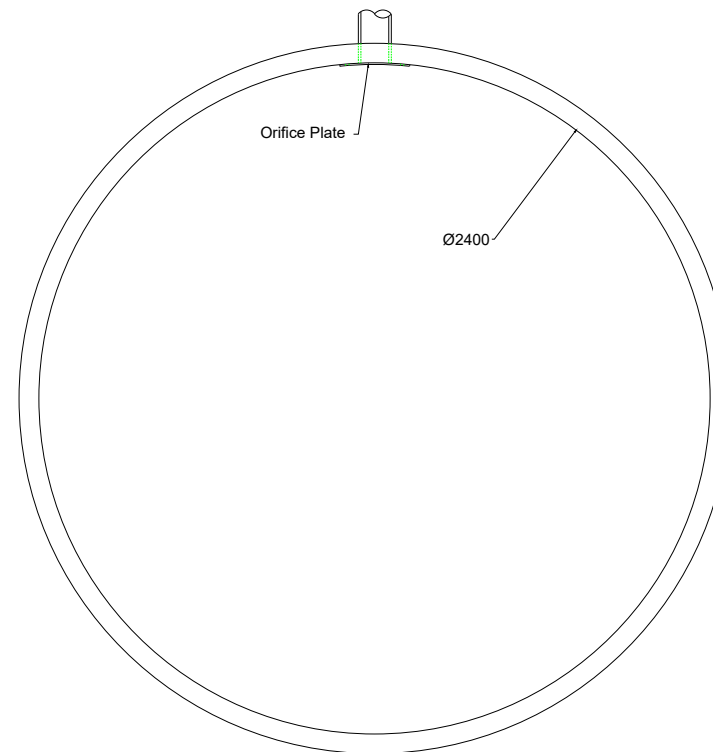
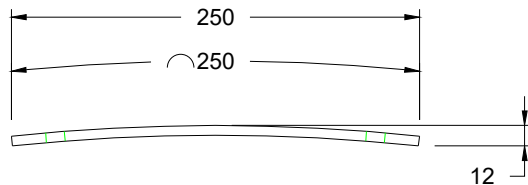
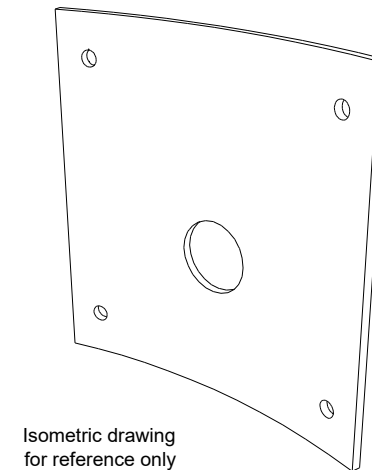
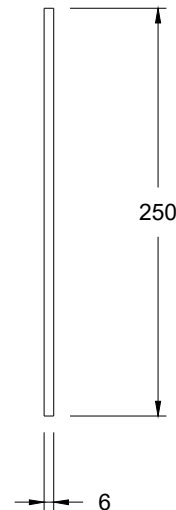
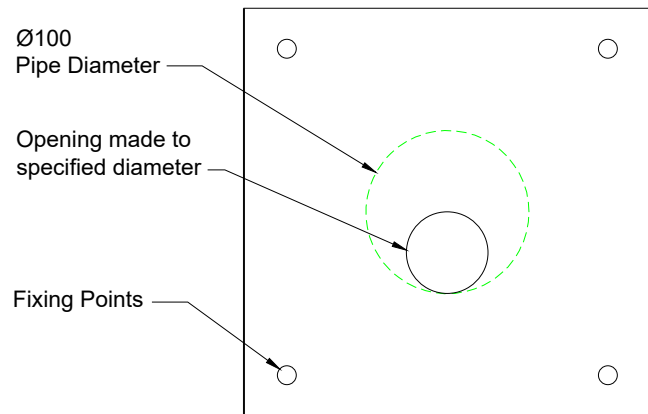
1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nn
- M10 (16mm Wrench) - 25 - 40Nn
- M12 (18mm Wrench) - 28 - 40Nn
- M16 (24mm Wrench) - 28 - 40Nn
- M20 (30mm Wrench) - 28 - 40Nn
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO:	DATE:	DESCRIPTION:
		
ADDRESS: ALTHON LIMITED VULCAN ROAD SOUTH NORWICH NR6 6AF		
TEL: 01603 488700 FAX: 01603 488598 EMAIL: sales@althon.co.uk WEBSITE: www.althon.co.uk		
PROPRIETARY & CONFIDENTIAL		
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DRAWING TITLE:		
Stainless Steel 316 100mm Curved Orifice Plate for 2700mm dia Chamber 250 x 250 x 6mm		
FINISH:		
Stainless Steel 316		
SCALE:	PAPER:	DATE:
NTS	A4	30 - 09 - 19
SHEET NO:	WEIGHT:	
01 OF 01	kg	
PRODUCT NAME:		
Stainless Steel 316 100mm Curved Orifice Plate for 2700mm dia Chamber		
CODE:		
316COP1002700		



DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nn
- M10 (16mm Wrench) - 25 - 40Nn
- M12 (18mm Wrench) - 28 - 40Nn
- M16 (24mm Wrench) - 28 - 40Nn
- M20 (30mm Wrench) - 28 - 40Nn
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO:	DATE:	DESCRIPTION:
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ADDRESS: ALTHON LIMITED VULCAN ROAD SOUTH NORWICH NR6 6AF	TEL: 01603 488700 FAX: 01603 488598 EMAIL: sales@althon.co.uk WEBSITE: www.althon.co.uk
---	--

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DRAWING TITLE:

Stainless Steel 316
100mm Curved Orifice Plate
for 2400mm dia Chamber
250 x 250 x 6mm

FINISH:

Stainless Steel 316

SCALE:	PAPER:	DATE:
NTS	A4	30 - 09 - 19

SHEET NO:	WEIGHT:
01 OF 01	kg

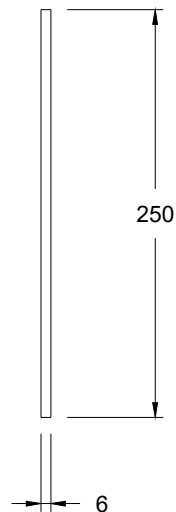
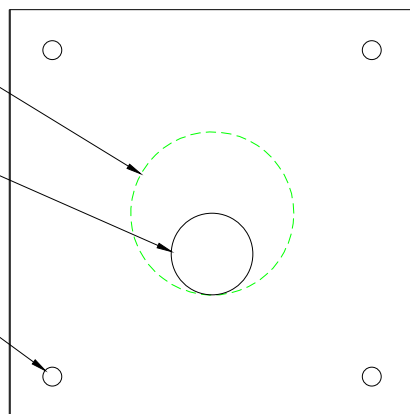
PRODUCT NAME:
Stainless Steel 316 100mm Curved Orifice Plate
for 2400mm dia Chamber

CODE:
316COP1002400

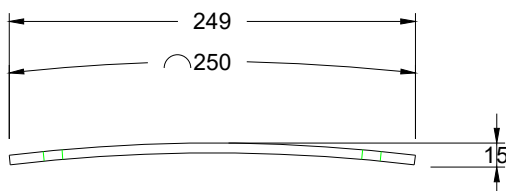
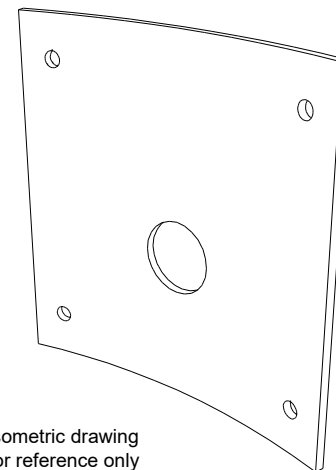
Ø100
Pipe Diameter

Opening made to
specified diameter

Fixing Points



Isometric drawing
for reference only



Orifice Plate

Ø2100

DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nn
- M10 (16mm Wrench) - 25 - 40Nn
- M12 (18mm Wrench) - 28 - 40Nn
- M16 (24mm Wrench) - 28 - 40Nn
- M20 (30mm Wrench) - 28 - 40Nn
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO: DATE: DESCRIPTION:



ADDRESS: ALTHON LIMITED
VULCAN ROAD SOUTH
NORWICH
NR6 6AF

TEL: 01603 488700
FAX: 01603 488598
EMAIL: sales@althon.co.uk
WEBSITE: www.althon.co.uk

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DRAWING TITLE:

Stainless Steel 316
100mm Curved Orifice Plate
for 2100mm dia Chamber
250 x 250 x 6mm

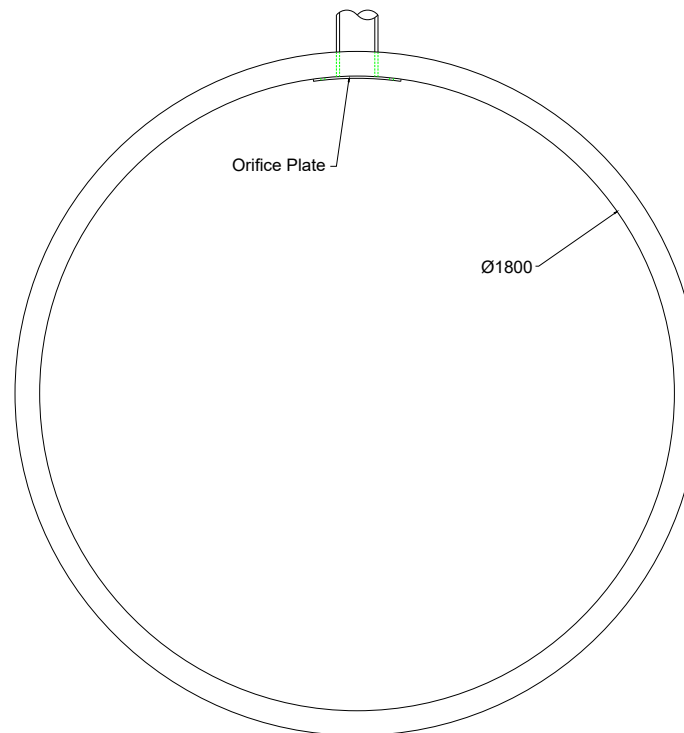
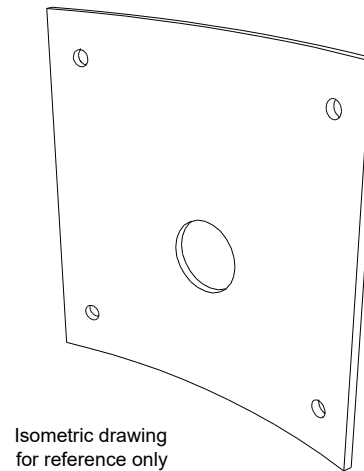
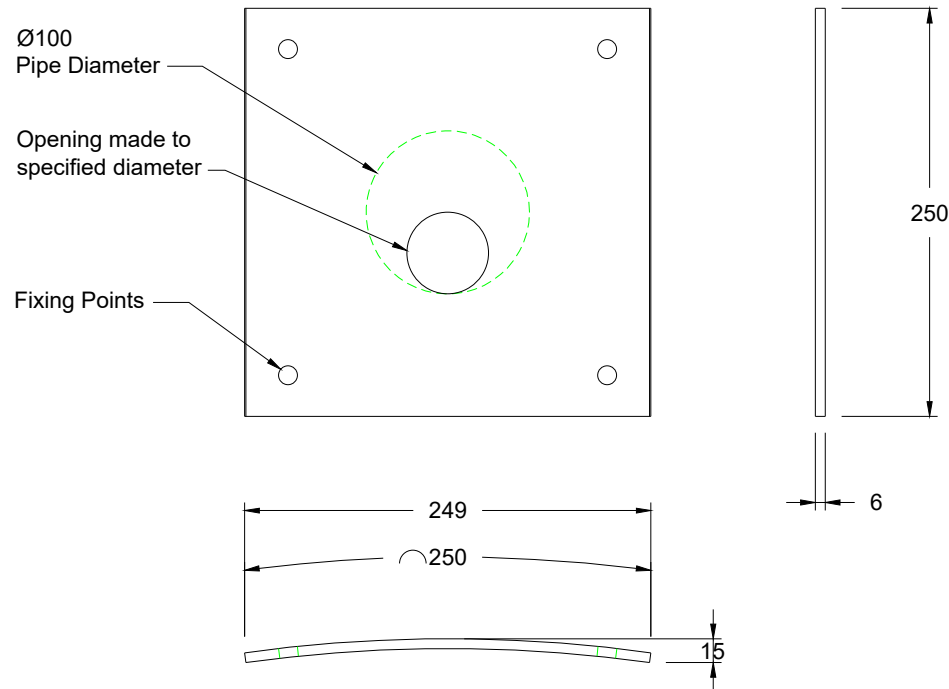
FINISH:
Stainless Steel 316

SCALE: NTS PAPER: A4 DATE: 30 - 09 - 19

SHEET NO: 01 OF 01 WEIGHT: kg

PRODUCT NAME:
Stainless Steel 316 100mm Curved Orifice Plate
for 2100mm dia Chamber

CODE:
316COP1002100



DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nm
- M10 (16mm Wrench) - 25 - 40Nm
- M12 (18mm Wrench) - 28 - 40Nm
- M16 (24mm Wrench) - 28 - 40Nm
- M20 (30mm Wrench) - 28 - 40Nm
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO:	DATE:	DESCRIPTION:
---------	-------	--------------



ADDRESS: ALTHON LIMITED
VULCAN ROAD SOUTH
NORWICH
NR6 6AF

TEL: 01603 488700
FAX: 01603 488598
EMAIL: sales@althon.co.uk
WEBSITE: www.althon.co.uk

PROPRIETARY & CONFIDENTIAL

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DRAWING TITLE:

Stainless Steel 316
100mm Curved Orifice Plate
for 1800mm dia Chamber
250 x 250 x 6mm

FINISH:

Stainless Steel 316

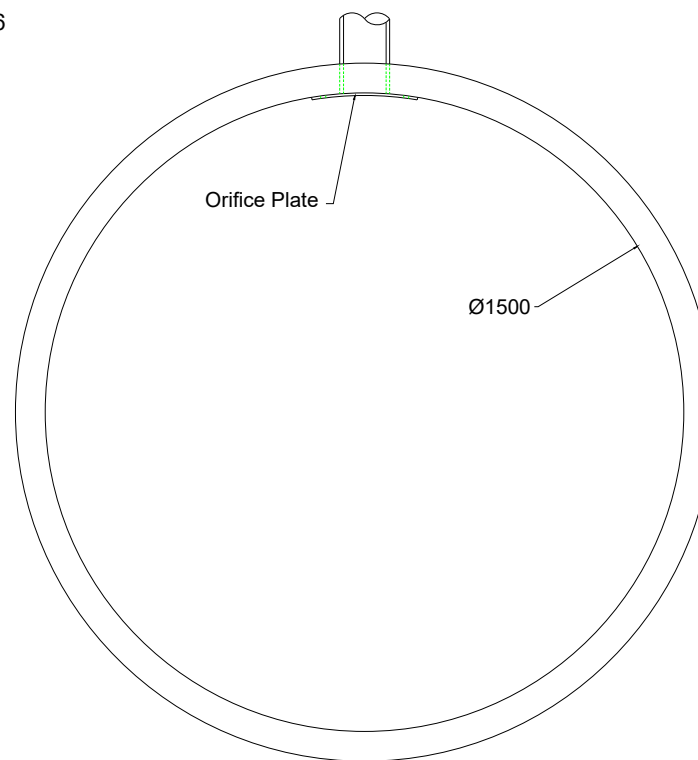
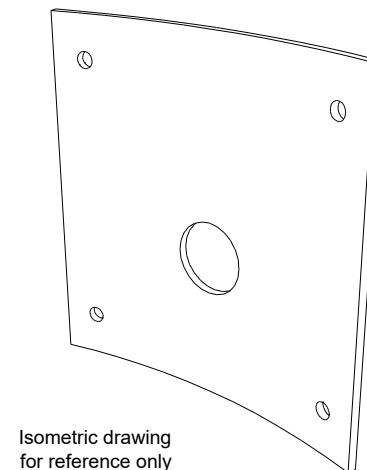
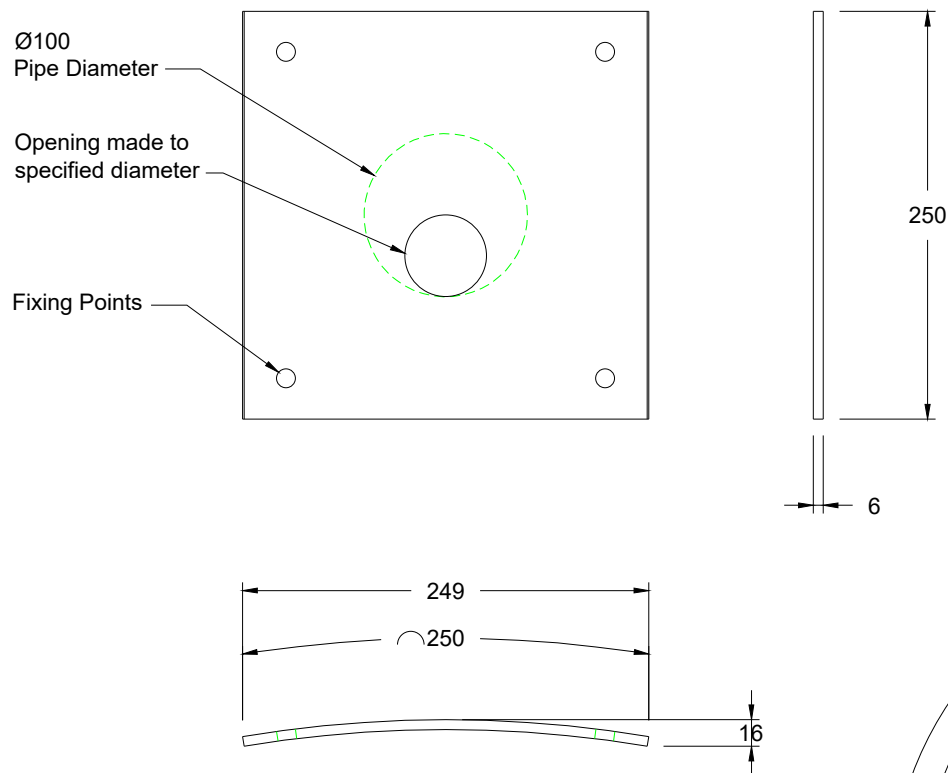
SCALE:	PAPER:	DATE:
NTS	A4	30 - 09 - 19
SHEET NO:	WEIGHT:	
01 OF 01	kg	

PRODUCT NAME:

Stainless Steel 316 100mm Curved Orifice Plate
for 1800mm dia Chamber

CODE:

316COP1001800



DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1 mm


Fabrication Specification

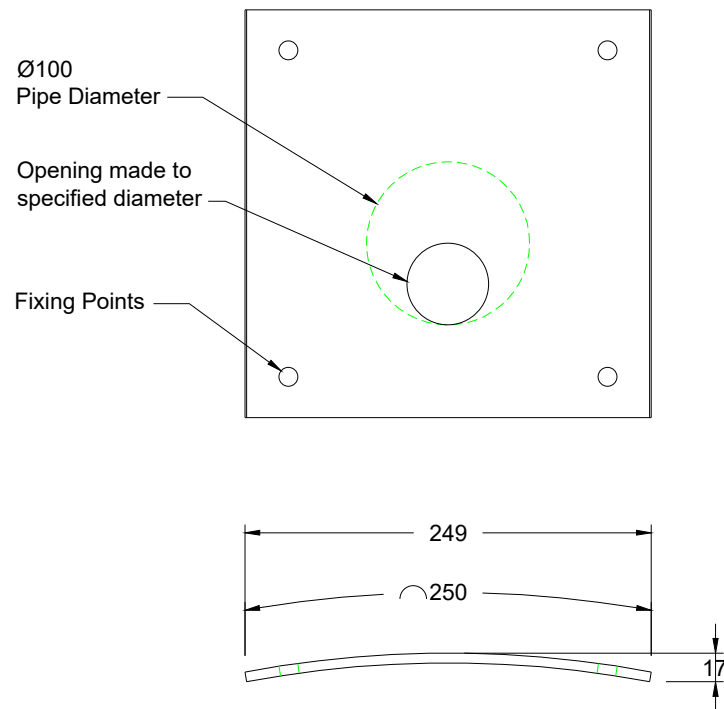
1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

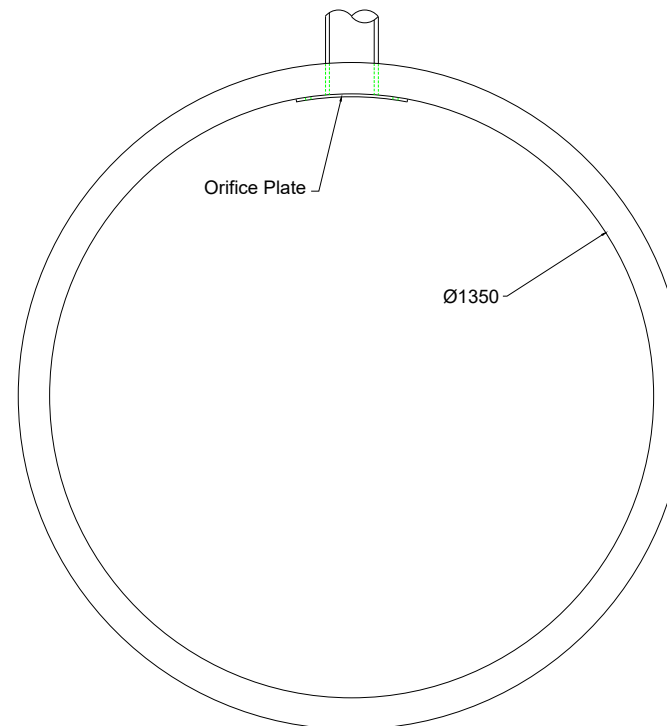
Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nn
- M10 (16mm Wrench) - 25 - 40Nn
- M12 (18mm Wrench) - 28 - 40Nn
- M16 (24mm Wrench) - 28 - 40Nn
- M20 (30mm Wrench) - 28 - 40Nn
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO:	DATE:	DESCRIPTION:
		
ADDRESS: ALTHON LIMITED VULCAN ROAD SOUTH NORWICH NR6 6AF		
TEL: 01603 488700 FAX: 01603 488598 EMAIL: sales@althon.co.uk WEBSITE: www.althon.co.uk		
PROPRIETARY & CONFIDENTIAL		
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DRAWING TITLE:		
Stainless Steel 316 100mm Curved Orifice Plate for 1500mm dia Chamber 250 x 250 x 6mm		
FINISH:		
Stainless Steel 316		
SCALE:	PAPER:	DATE:
NTS	A4	30 - 09 - 19
SHEET NO:	WEIGHT:	
01 OF 01	kg	
PRODUCT NAME:		
Stainless Steel 316 100mm Curved Orifice Plate for 1500mm dia Chamber		
CODE:		
316COP1001500		



Isometric drawing
for reference only



DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nn
- M10 (16mm Wrench) - 25 - 40Nn
- M12 (18mm Wrench) - 28 - 40Nn
- M16 (24mm Wrench) - 28 - 40Nn
- M20 (30mm Wrench) - 28 - 40Nn
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO:	DATE:	DESCRIPTION:
		

ADDRESS: ALTHON LIMITED VULCAN ROAD SOUTH NORWICH NR6 6AF	TEL: 01603 488700 FAX: 01603 488598 EMAIL: sales@althon.co.uk WEBSITE: www.althon.co.uk
---	--

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DRAWING TITLE:

Stainless Steel 316
100mm Curved Orifice Plate
for 1350mm dia Chamber
250 x 250 x 6mm

FINISH:

Stainless Steel 316

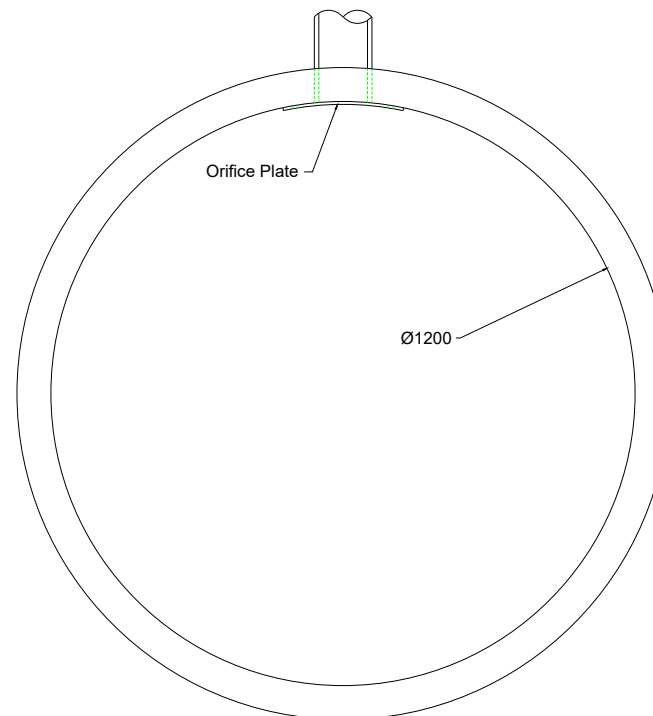
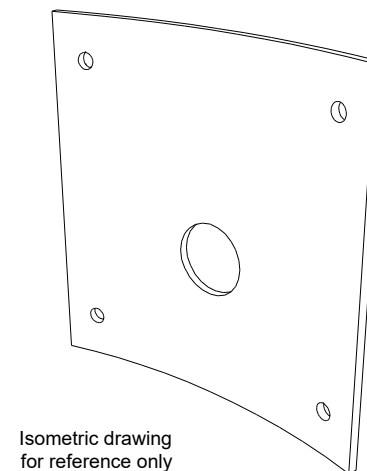
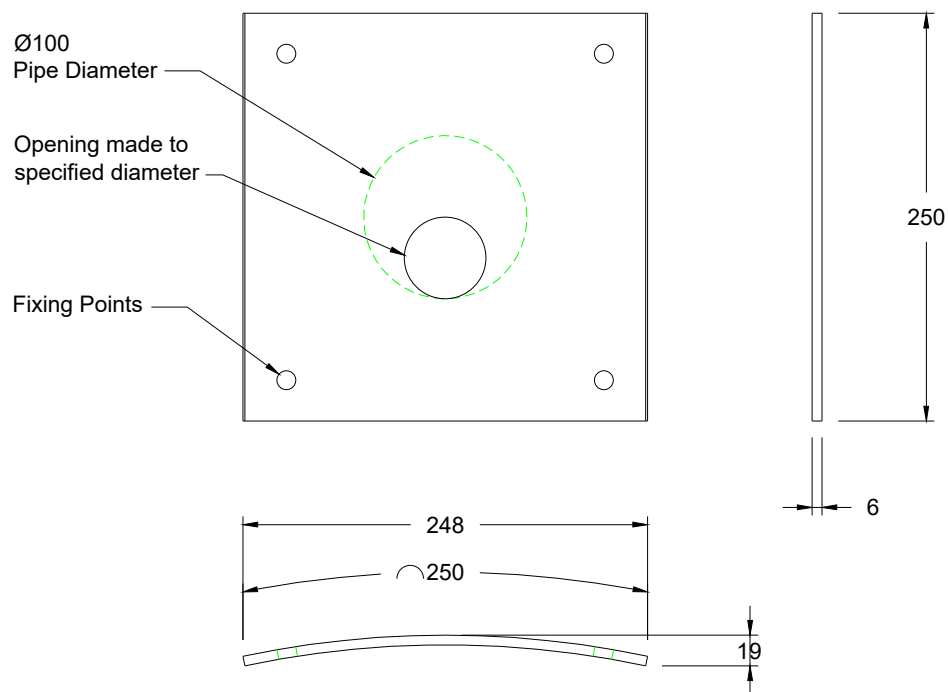
SCALE:	PAPER:	DATE:
NTS	A4	30 - 09 - 19
SHEET NO:	WEIGHT:	
01 OF 01	kg	

PRODUCT NAME:

Stainless Steel 316 100mm Curved Orifice Plate
for 1350mm dia Chamber

CODE:

316COP1001350



DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nn
- M10 (16mm Wrench) - 25 - 40Nn
- M12 (18mm Wrench) - 28 - 40Nn
- M16 (24mm Wrench) - 28 - 40Nn
- M20 (30mm Wrench) - 28 - 40Nn
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO:	DATE:	DESCRIPTION:



ADDRESS: ALTHON LIMITED VULCAN ROAD SOUTH NORWICH NR6 6AF	TEL: 01603 488700 FAX: 01603 488598 EMAIL: sales@althon.co.uk WEBSITE: www.althon.co.uk
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PROPRIETARY & CONFIDENTIAL

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DRAWING TITLE:

Stainless Steel 316
100mm Curved Orifice Plate
for 1200mm dia Chamber
250 x 250 x 6mm

FINISH:

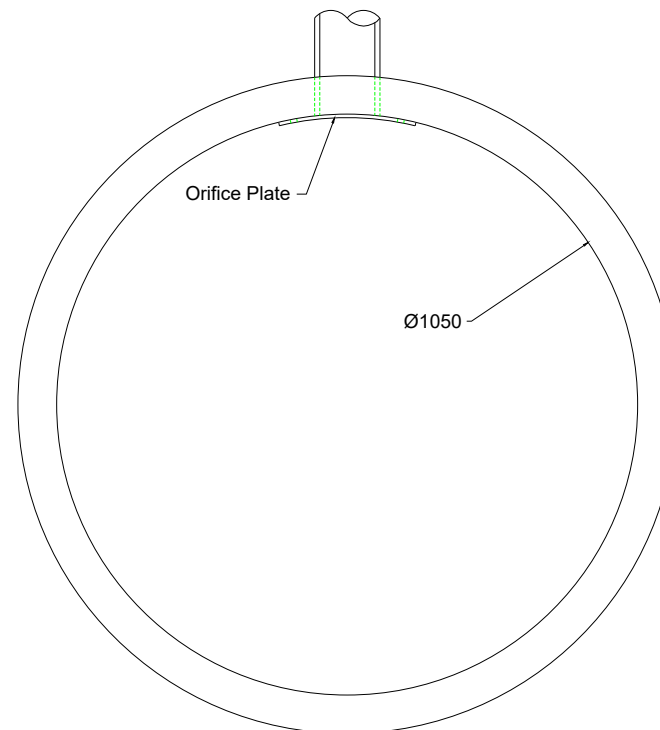
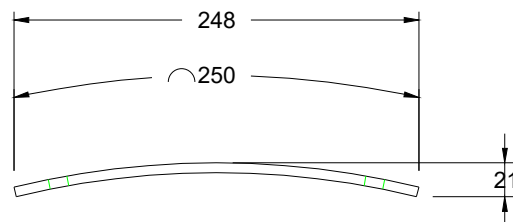
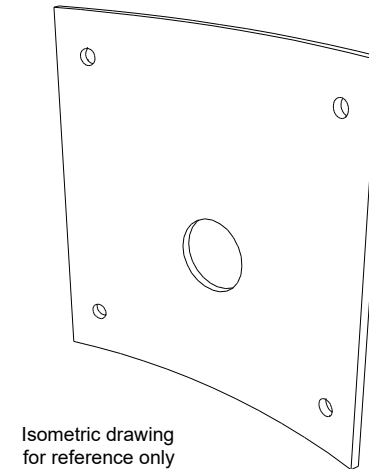
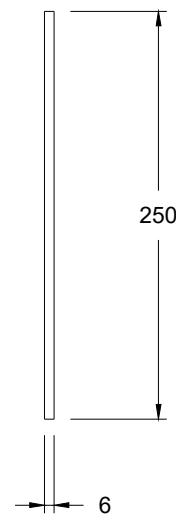
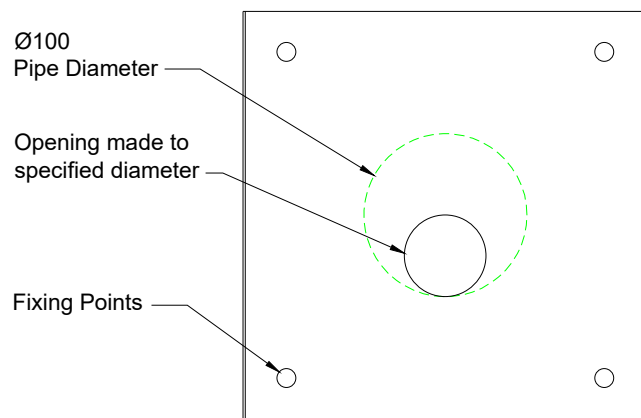
Stainless Steel 316

SCALE:	PAPER:	DATE:
NTS	A4	30 - 09 - 19

SHEET NO:	WEIGHT:
01 OF 01	kg

PRODUCT NAME:
Stainless Steel 316 100mm Curved Orifice Plate
for 1200mm dia Chamber

CODE:
316COP1001200



DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

1. Manufacturing tolerances IAW EN 1090-1 ANNEX D PARA 2.7-2.8
2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
2. Material grade is to be: BS EN 10025 S275
3. Welding carried out IAW EN 1090-1 PARA 7.5.4 - 7.5.18
4. All fillet and butt welds to have a minimum throat thickness of 6mm & joints to be fully welded where possible
5. Ensure vertical flats are fully welded where possible
6. All sharp edges and burrs are to be removed
7. Remove all welding splatter
8. Holes by punching are permitted without reaming
9. Galvanising is carried out after fabrication to BS EN:ISO 1461

Assembly Specification

Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

- M8 (13mm Wrench) - 25 - 35Nn
- M10 (16mm Wrench) - 25 - 40Nn
- M12 (18mm Wrench) - 28 - 40Nn
- M16 (24mm Wrench) - 28 - 40Nn
- M20 (30mm Wrench) - 28 - 40Nn
- Copper Slip must be used when bolting grating to threaded inserts cast into headwall.

REV NO: DATE: DESCRIPTION:



ADDRESS: ALTHON LIMITED
VULCAN ROAD SOUTH
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DRAWING TITLE:

Stainless Steel 316
100mm Curved Orifice Plate
for 1050mm dia Chamber
250 x 250 x 6mm

FINISH:

Stainless Steel 316

SCALE: PAPER: DATE:

NTS A4 30 - 09 - 19

SHEET NO: WEIGHT:

01 OF 01 kg

PRODUCT NAME:
Stainless Steel 316 100mm Curved Orifice Plate
for 900mm dia Chamber

CODE:
316COP1001050