

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 ± 1mm

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:

**150mm Orifice Plate
Galvanised**

CLIENT:

SCALE:	PAPER:	DATE:
NTS	A4	04 - 04 - 18

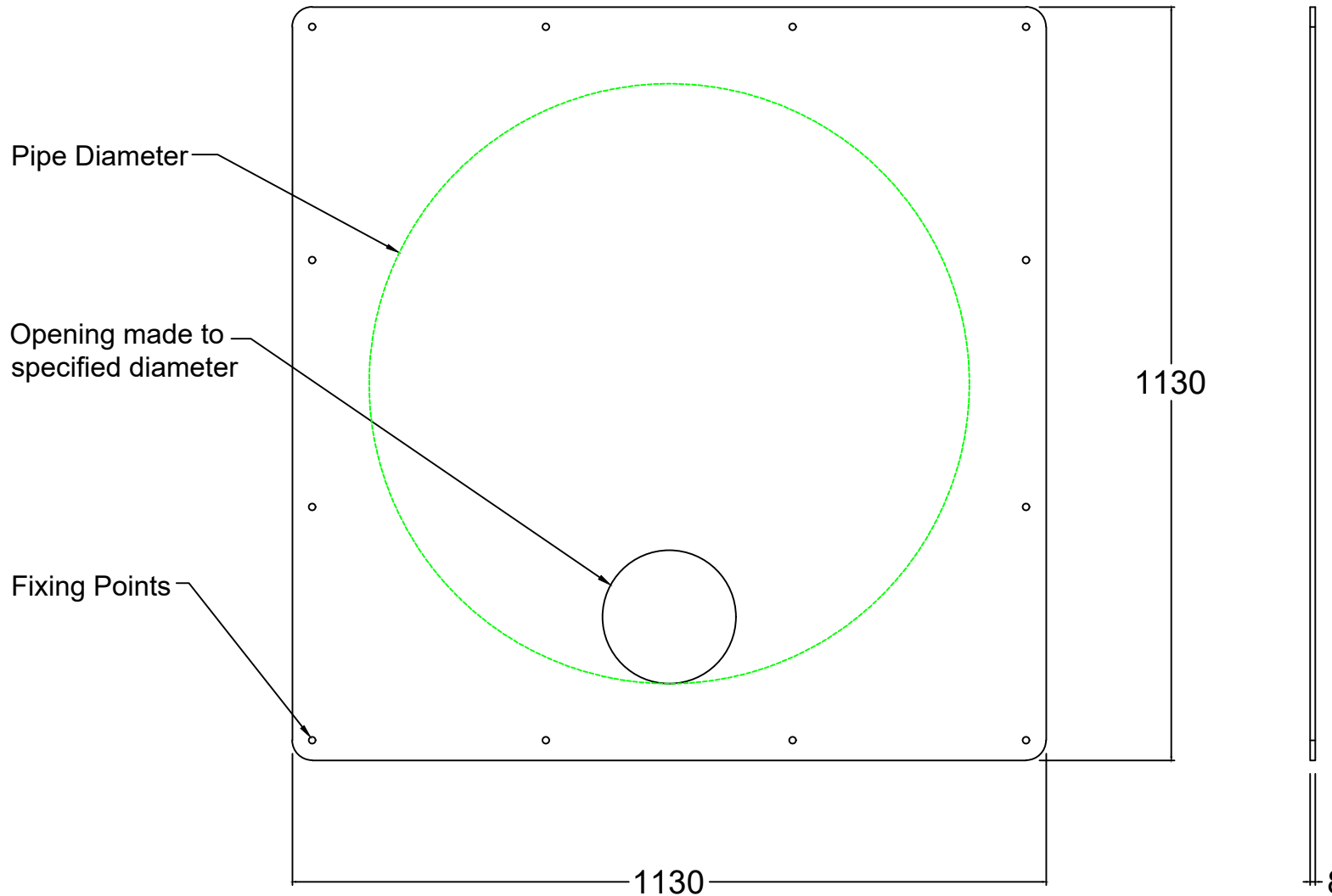
SHEET NO:	WEIGHT:
01 OF 01	1.6kg

PRODUCT NAME:

150mm Orifice Plate

DRAWING No:

DO NOT SCALE DRAWING



Notes

Manufacturing Tolerances

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3. All measurements ± 1 mm

Fabrication Specification

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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.

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DRAWING TITLE:

**900mm Orifice Plate
Galvanised**

CLIENT:

SCALE:	PAPER:	DATE:
NTS	A4	04 - 04 - 18

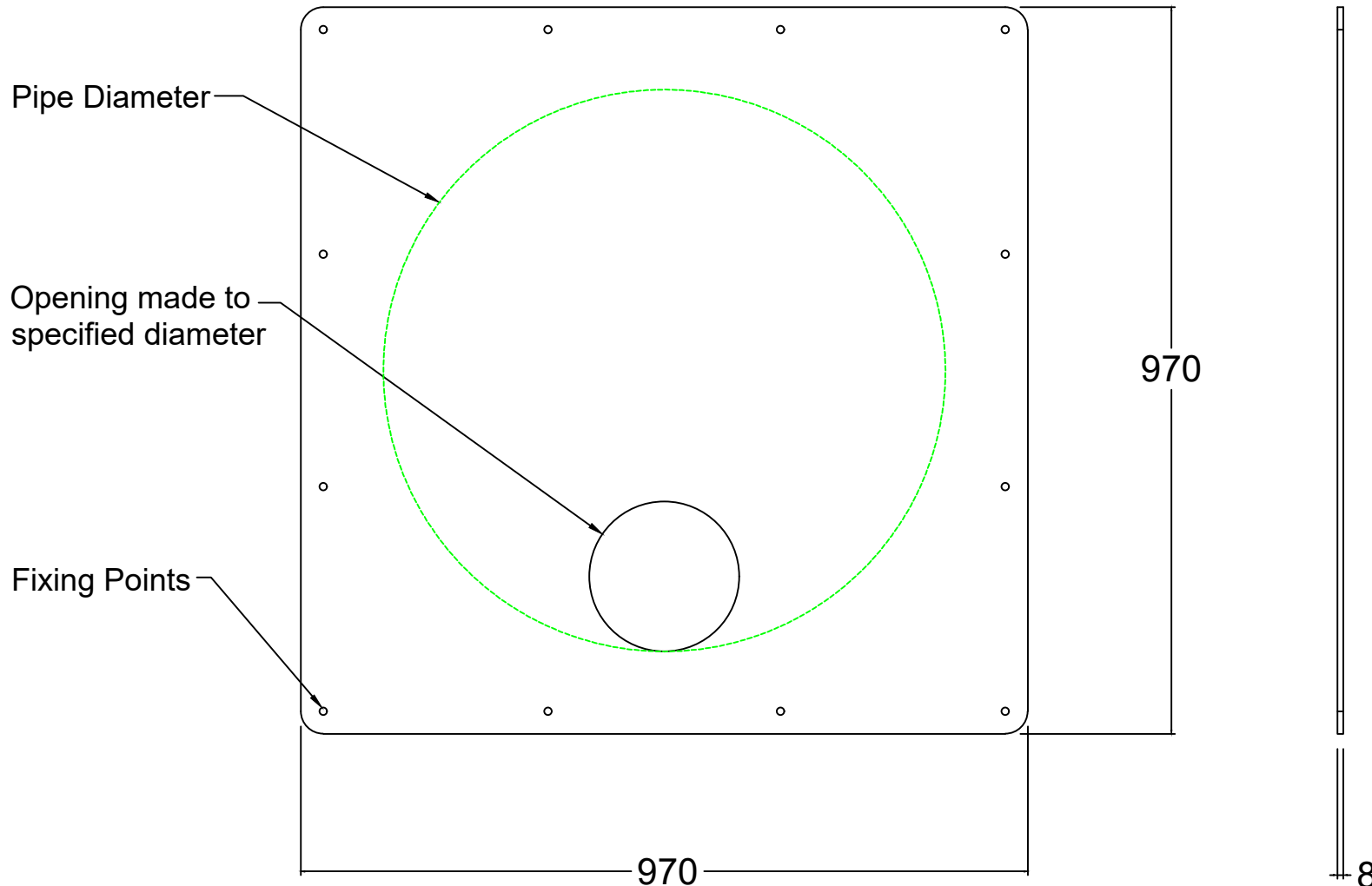
SHEET NO:	WEIGHT:
01 OF 01	78.3kg

PRODUCT NAME:

900mm Orifice Plate

DRAWING No:

DO NOT SCALE DRAWING



DO NOT SCALE DRAWING

Notes

Manufacturing Tolerances

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2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
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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.

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NORWICH
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DRAWING TITLE:

**750mm Orifice Plate
Galvanised**

CLIENT:

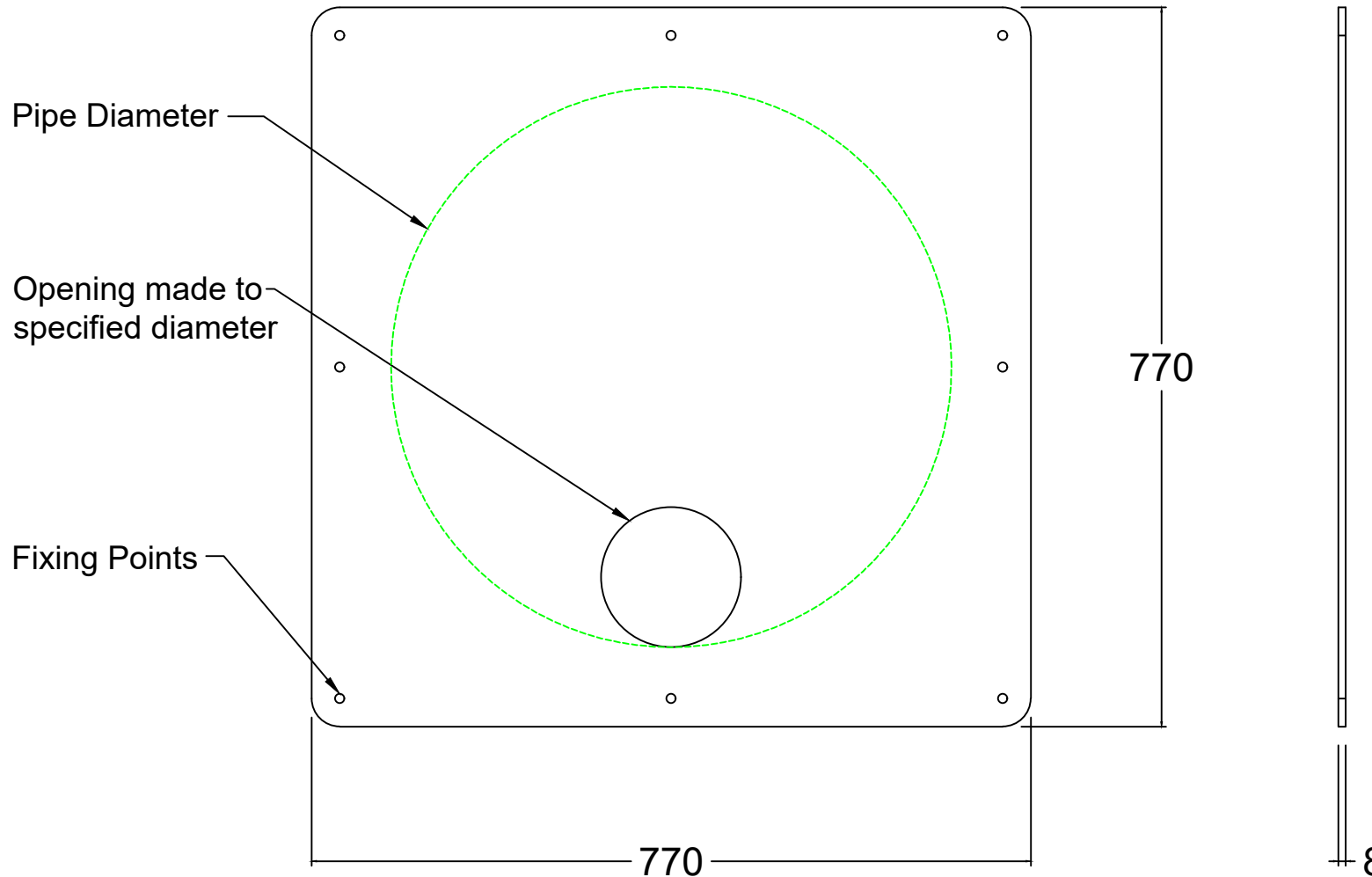
SCALE:	PAPER:	DATE:
NTS	A4	04 - 04 - 18

SHEET NO:	WEIGHT:
01 OF 01	57.2kg

PRODUCT NAME:

750mm Orifice Plate

DRAWING No:



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
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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.

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DRAWING TITLE:

**600mm Orifice Plate
Galvanised**

CLIENT:

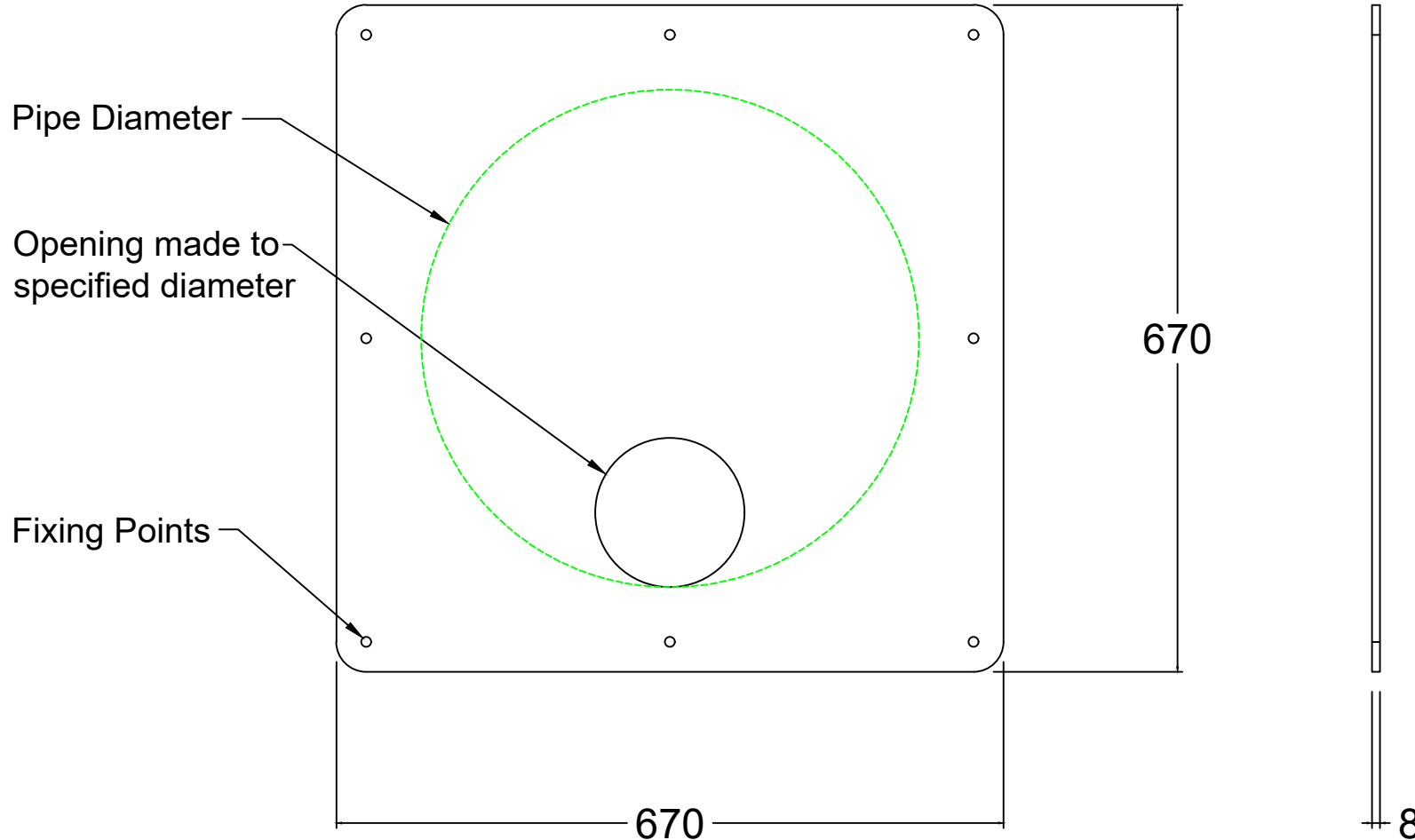
SCALE:	PAPER:	DATE:
NTS	A4	04 - 04 - 18

SHEET NO:	WEIGHT:
01 OF 01	36.1kg

PRODUCT NAME:

600mm Orifice Plate

DRAWING No:



Notes

Manufacturing Tolerances

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3. All measurements ± 1 mm

Fabrication Specification

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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.

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DRAWING TITLE:

**500mm Orifice Plate
Galvanised**

CLIENT:

SCALE:	PAPER:	DATE:
NTS	A4	04 - 04 - 18

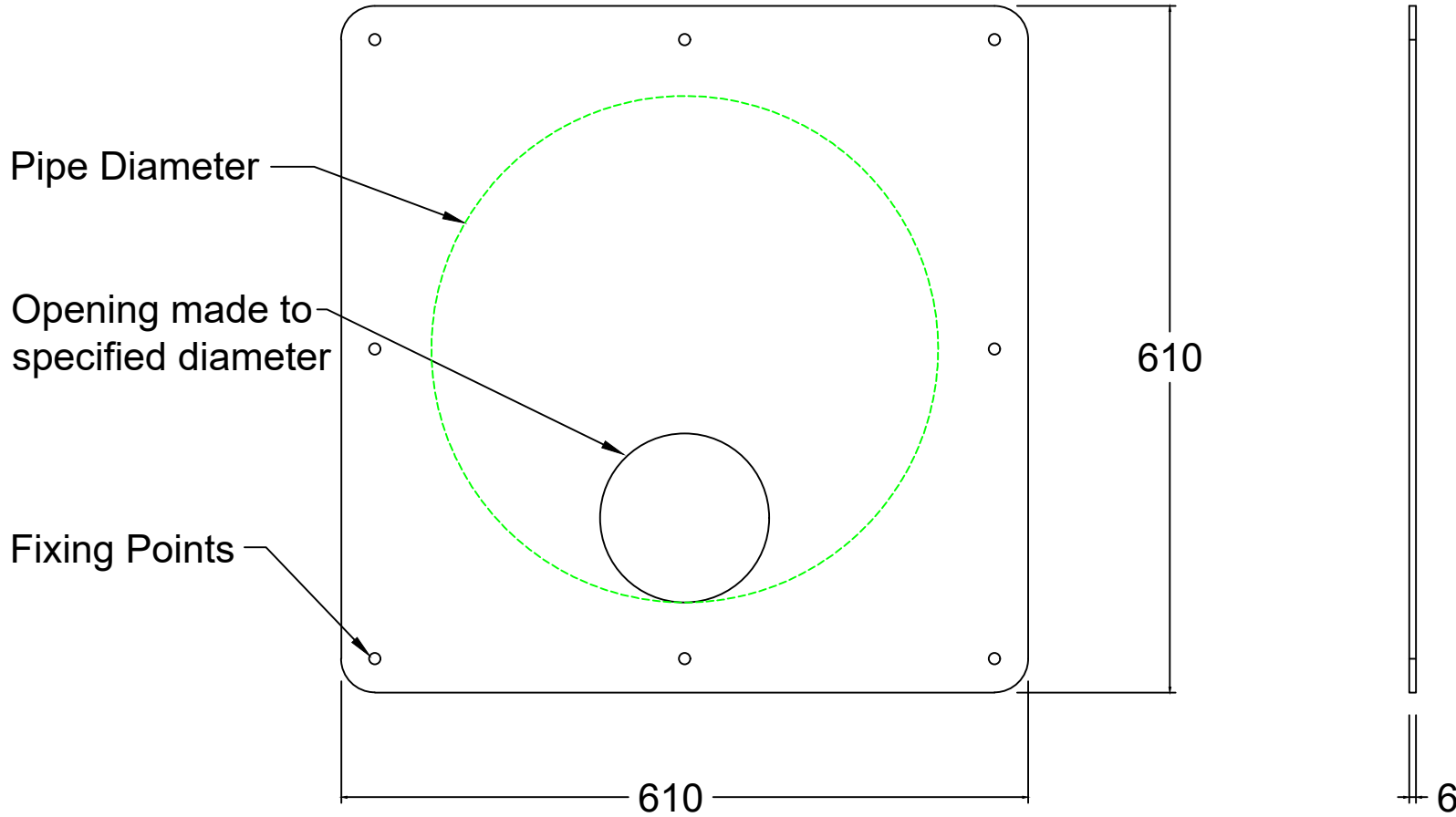
SHEET NO:	WEIGHT:
01 OF 01	27.1kg

PRODUCT NAME:

500mm Orifice Plate

DRAWING No:

DO NOT SCALE DRAWING



Pipe Diameter

Opening made to specified diameter

Fixing Points

610

610

6

Notes

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2. All dimensions in mm U.O.S
3. All measurements ± 1 mm

Fabrication Specification

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Assembly Specification

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

- M8 (13mm Wrench) - 25 - 35Nn
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- M16 (24mm Wrench) - 28 - 40Nn
- M20 (30mm Wrench) - 28 - 40Nn
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DRAWING TITLE:

**450mm Orifice Plate
Galvanised**

CLIENT:

SCALE:	PAPER:	DATE:
NTS	A4	04 - 04 - 18

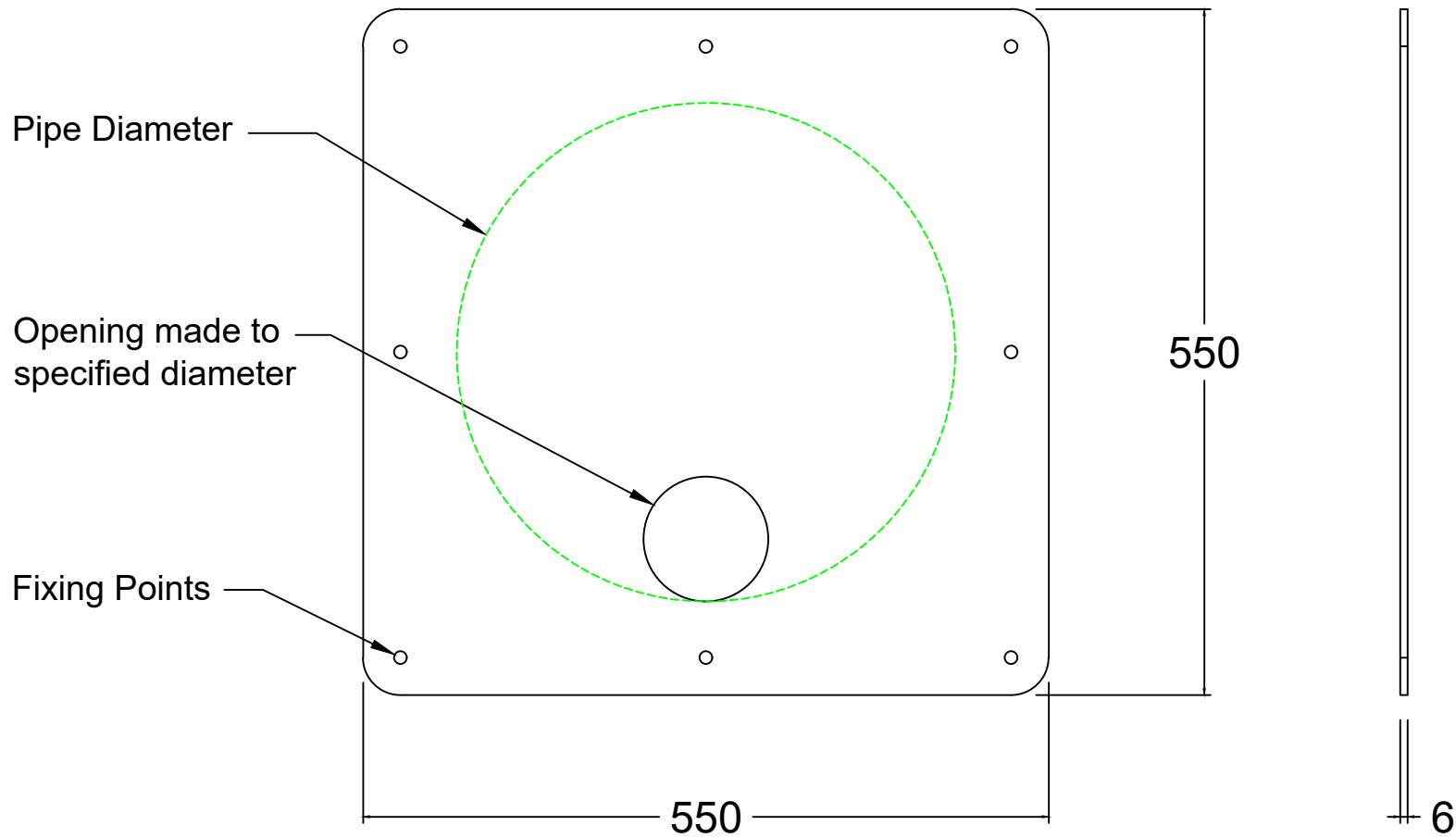
SHEET NO:	WEIGHT:
01 OF 01	16.7kg

PRODUCT NAME:

450mm Orifice Plate

DRAWING No:

DO NOT SCALE DRAWING



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
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7. Remove all welding splatter
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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.

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DRAWING TITLE:

**400mm Orifice Plate
Galvanised**

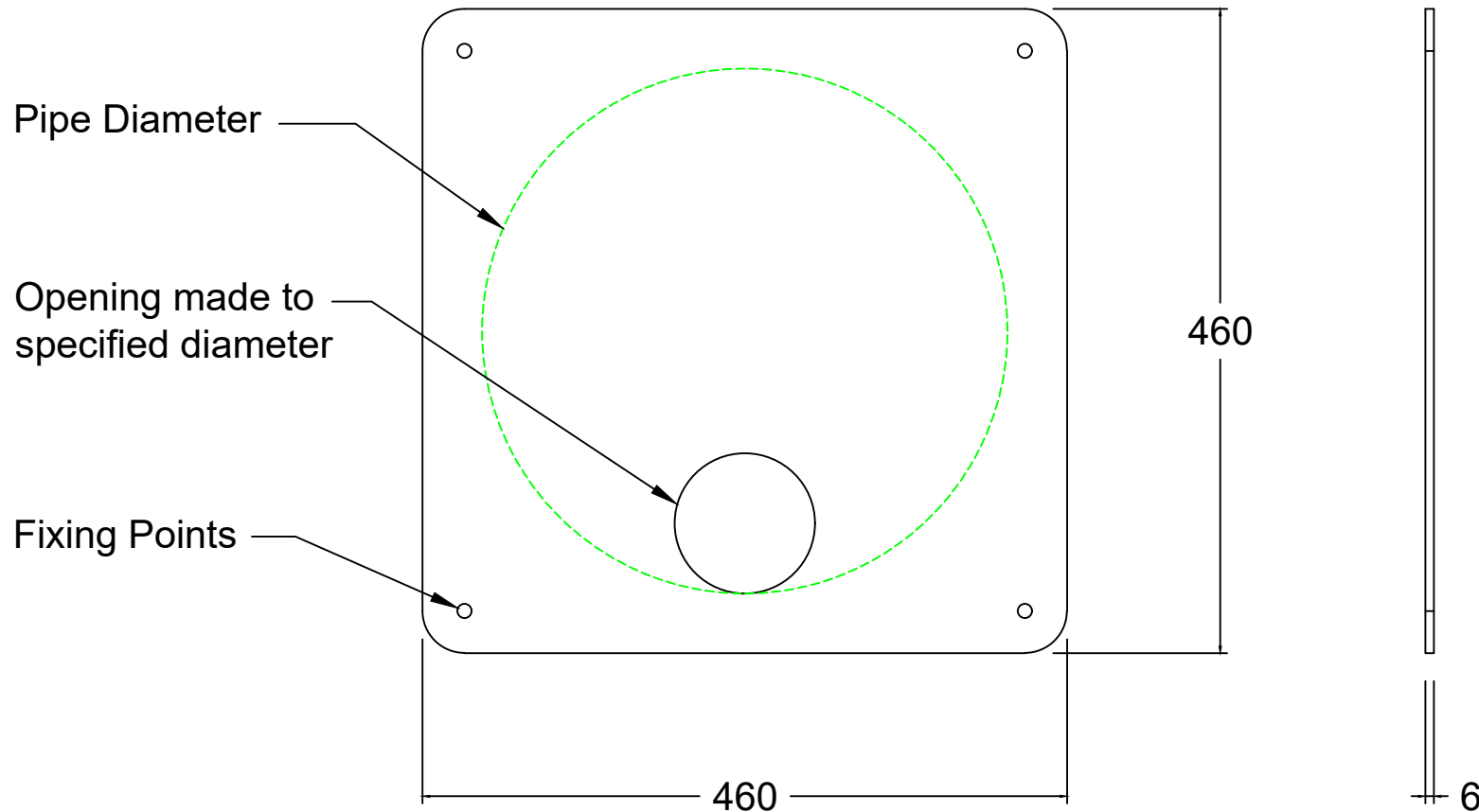
CLIENT:

SCALE:	PAPER:	DATE:
NTS	A4	04 - 04 - 18

SHEET NO:	WEIGHT:
01 OF 01	13.8kg

PRODUCT NAME:
400mm Orifice Plate

DRAWING No:



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
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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.

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DRAWING TITLE:

**375mm Orifice Plate
Galvanised**

CLIENT:

SCALE:	PAPER:	DATE:
NTS	A4	04 - 04 - 18

SHEET NO:	WEIGHT:
01 OF 01	9.6kg

PRODUCT NAME:
375mm Orifice Plate

DRAWING No:

Notes

Manufacturing Tolerances

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Fabrication Specification

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Assembly Specification

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

- M8 (13mm Wrench) - 25 - 35Nn
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DRAWING TITLE:

300mm Orifice Plate
Galvanised

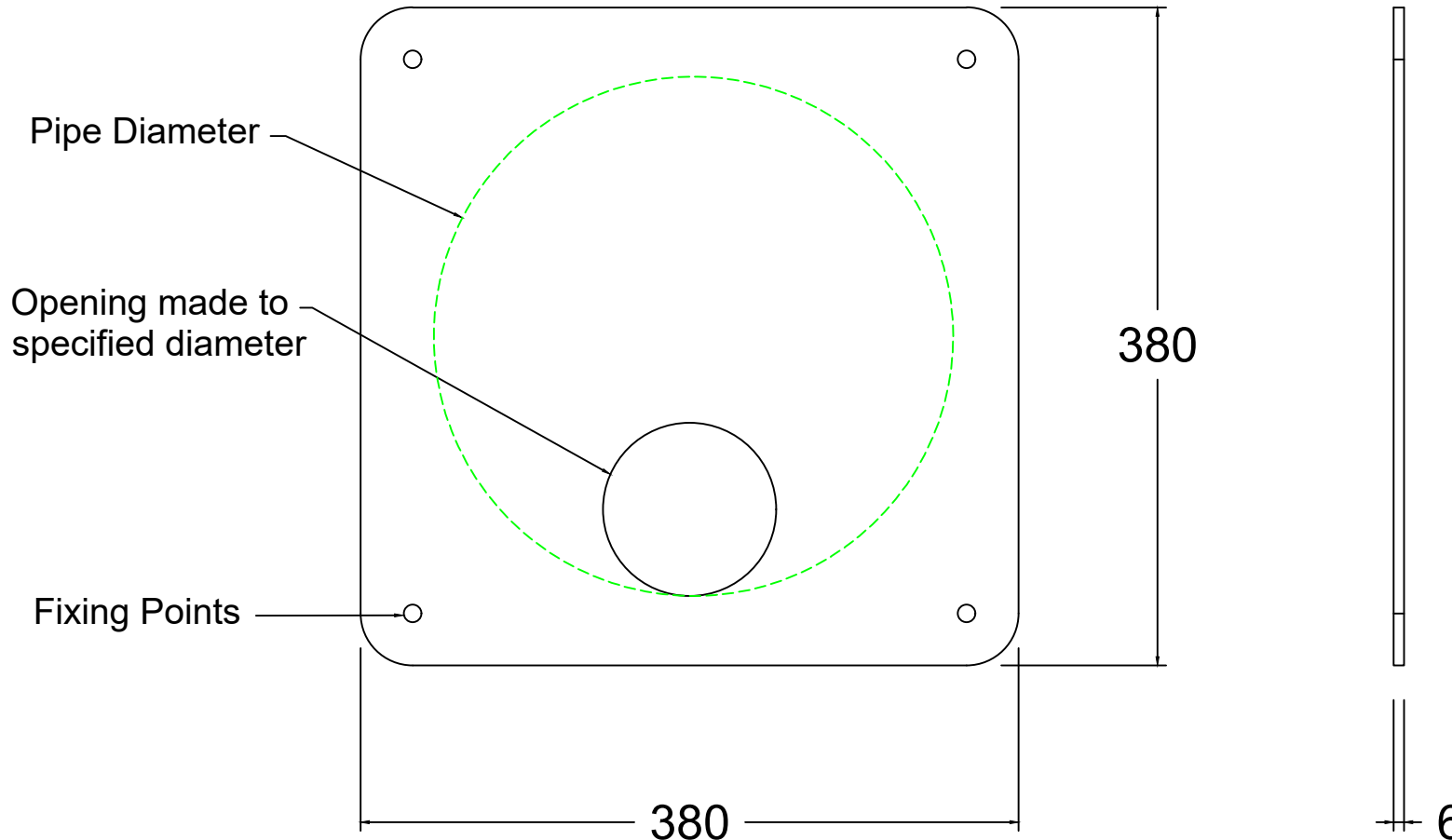
CLIENT:

SCALE:	PAPER:	DATE:
NTS	A4	04 - 04 - 18

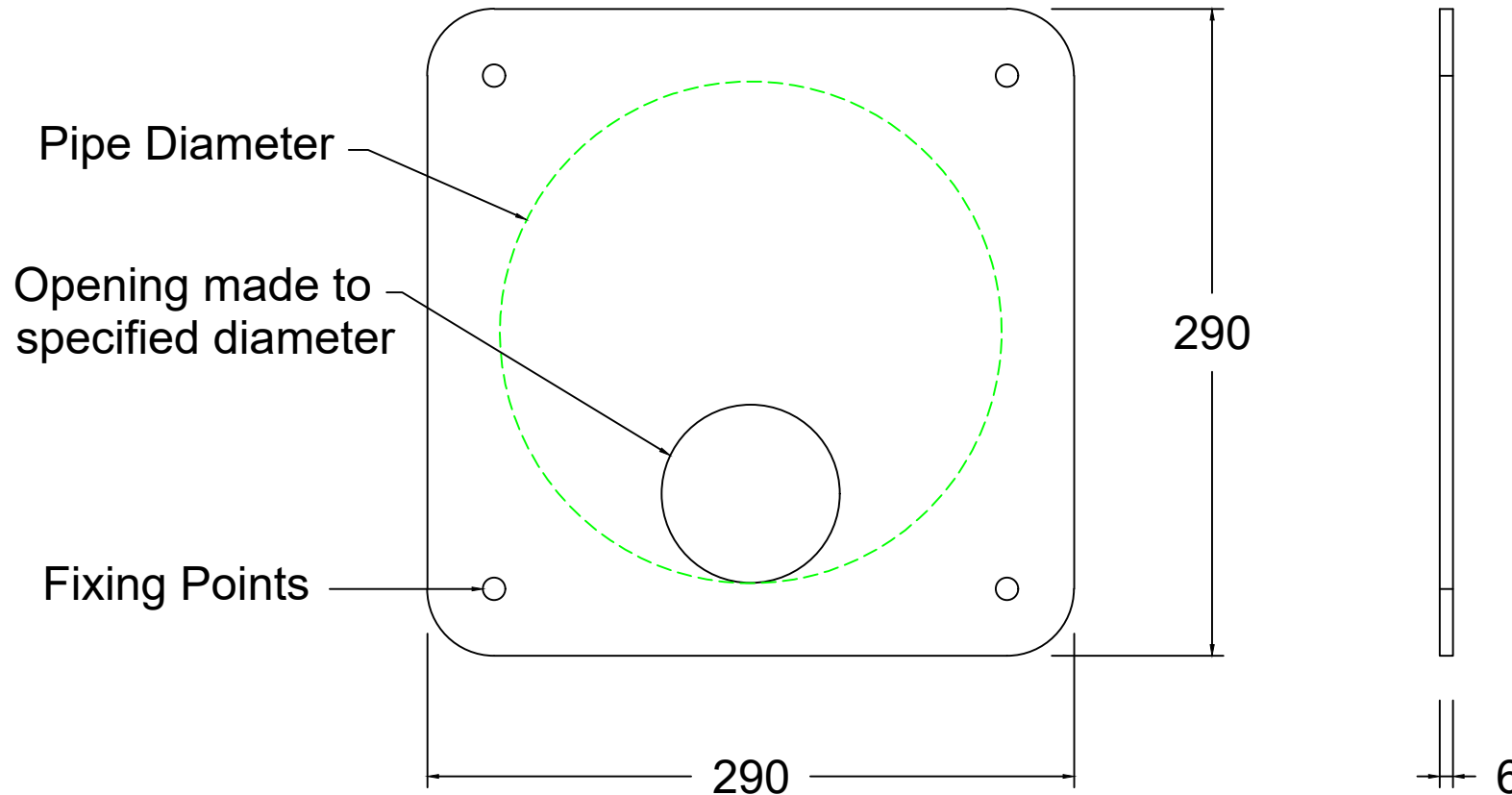
SHEET NO:	WEIGHT:
01 OF 01	6.4kg

PRODUCT NAME:
300mm Orifice Plate

DRAWING No:



DO NOT SCALE DRAWING



Notes

Manufacturing Tolerances

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2. All dimensions in mm U.O.S
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Fabrication Specification

1. Manufacture IAW EN 1090-1 EXC Class 1
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Standard Torque Values (A2 Stainless Steel Bolts - Class 70)

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DRAWING TITLE:

**225mm Orifice Plate
Galvanised**

CLIENT:

SCALE:	PAPER:	DATE:
NTS	A4	04 - 04 - 18

SHEET NO:	WEIGHT:
01 OF 01	3.7kg

PRODUCT NAME:

225mm Orifice Plate

DRAWING No:

DO NOT SCALE DRAWING