

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 ± 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: |
|---------|-------|--------------|



ADDRESS: ALTHON LIMITED
VULCAN ROAD SOUTH
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NR6 6AF

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

PROPRIETARY & CONFIDENTIAL

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DRAWING TITLE:

Galv. 100mm Curved Orifice Plate
for 900mm dia Chamber
250 x 250 x 6mm

FINISH:

Galvanised

| | | |
|--------|--------|--------------|
| SCALE: | PAPER: | DATE: |
| NTS | A4 | 24 - 09 - 19 |

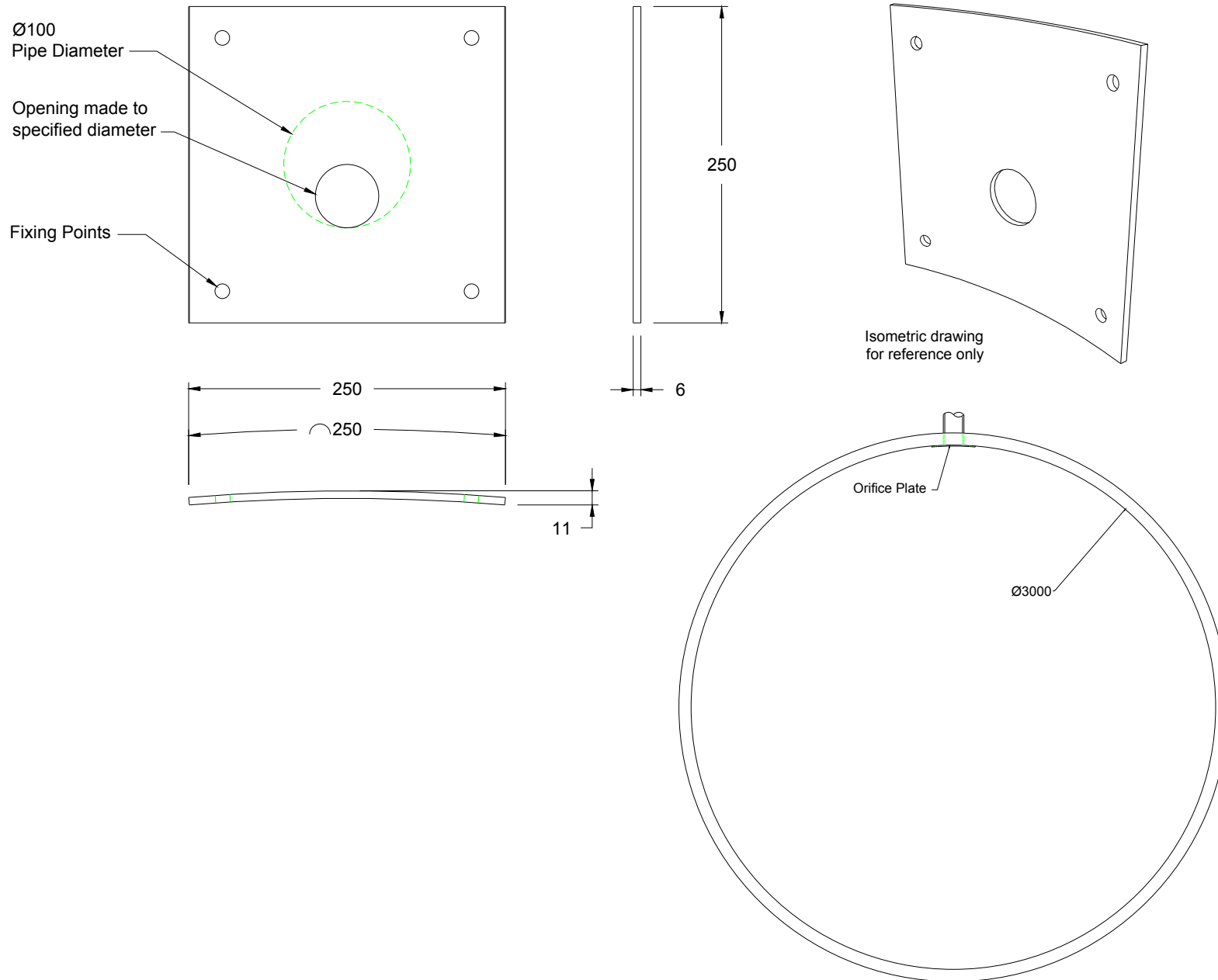
| | |
|-----------|---------|
| SHEET NO: | WEIGHT: |
| 01 OF 01 | kg |

PRODUCT NAME:

Galv. 100mm Curved Orifice Plate
for 900mm dia Chamber

CODE:

GCOP100900



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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| | | |



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DRAWING TITLE:

Galv. 100mm Curved Orifice Plate
for 3000mm dia Chamber
250 x 250 x 6mm

FINISH:

Galvanised

| SCALE: | PAPER: | DATE: |
|--------|--------|--------------|
| NTS | A4 | 27 - 09 - 19 |

| SHEET NO: | WEIGHT: |
|-----------|---------|
| 01 OF 01 | kg |

PRODUCT NAME:

Galv. 100mm Curved Orifice Plate
for 3000mm dia Chamber

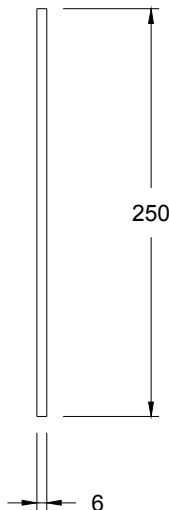
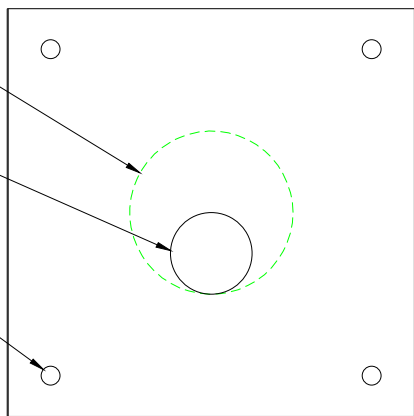
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GCOP1003000

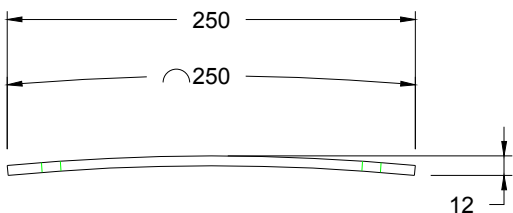
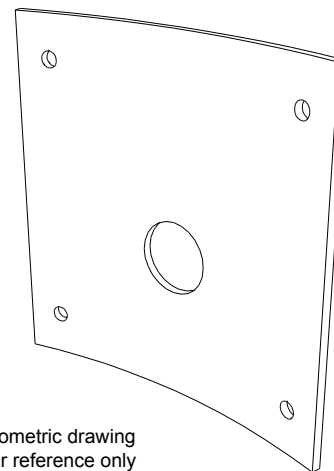
Ø100
Pipe Diameter

Opening made to
specified diameter

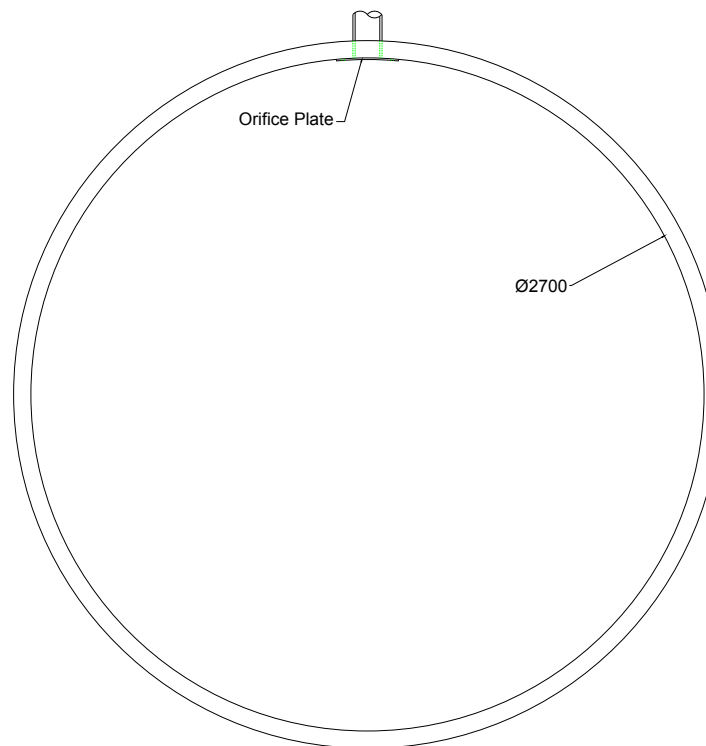
Fixing Points



Isometric drawing
for reference only



Orifice Plate



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.

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DRAWING TITLE:

Galv. 100mm Curved Orifice Plate
for 2700mm dia Chamber
250 x 250 x 6mm

FINISH:
Galvanised

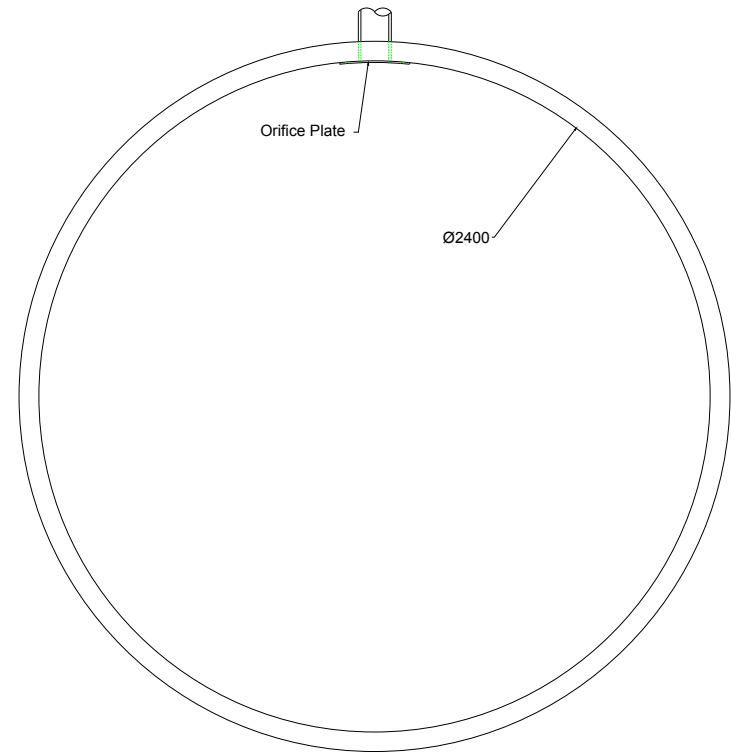
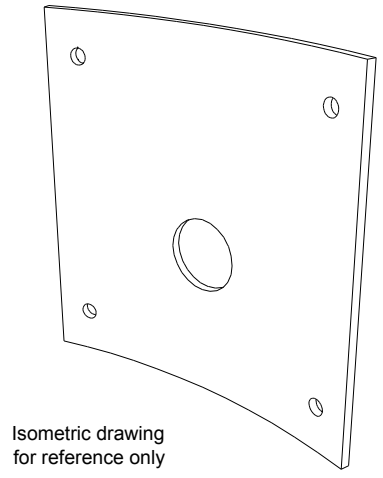
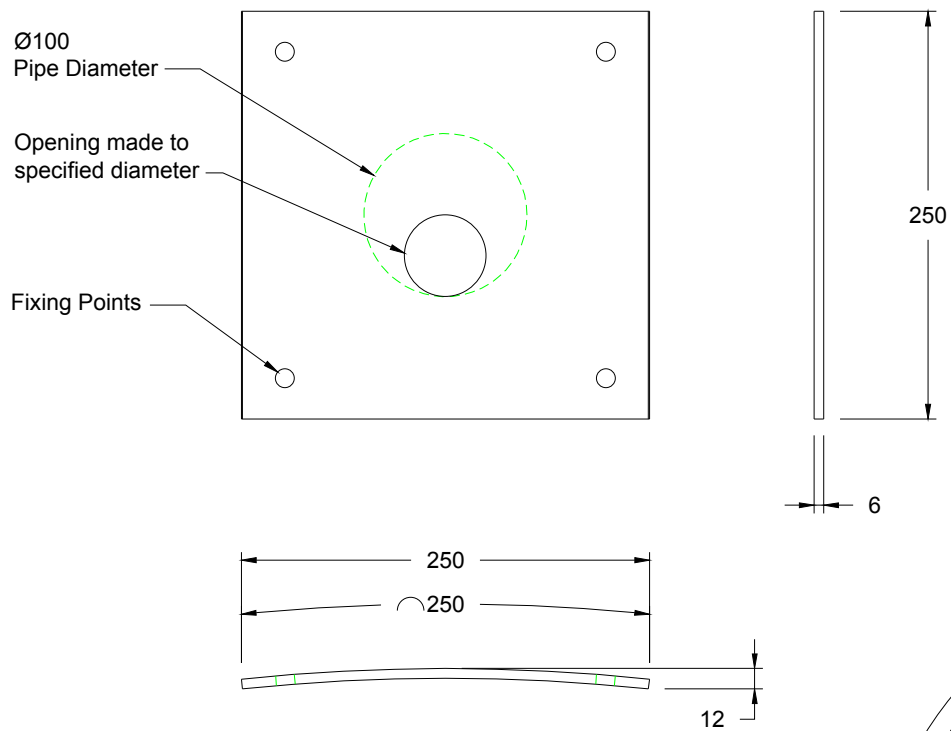
| SCALE: | PAPER: | DATE: |
|--------|--------|--------------|
| NTS | A4 | 27 - 09 - 19 |

| SHEET NO: | WEIGHT: |
|-----------|---------|
| 01 OF 01 | kg |

PRODUCT NAME:
Galv. 100mm Curved Orifice Plate
for 2700mm dia Chamber

CODE:
GCOP1002700

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 ± 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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DRAWING TITLE:

Galv. 100mm Curved Orifice Plate
for 2400mm dia Chamber
250 x 250 x 6mm

FINISH:

Galvanised

| | | |
|--------|--------|--------------|
| SCALE: | PAPER: | DATE: |
| NTS | A4 | 27 - 09 - 19 |

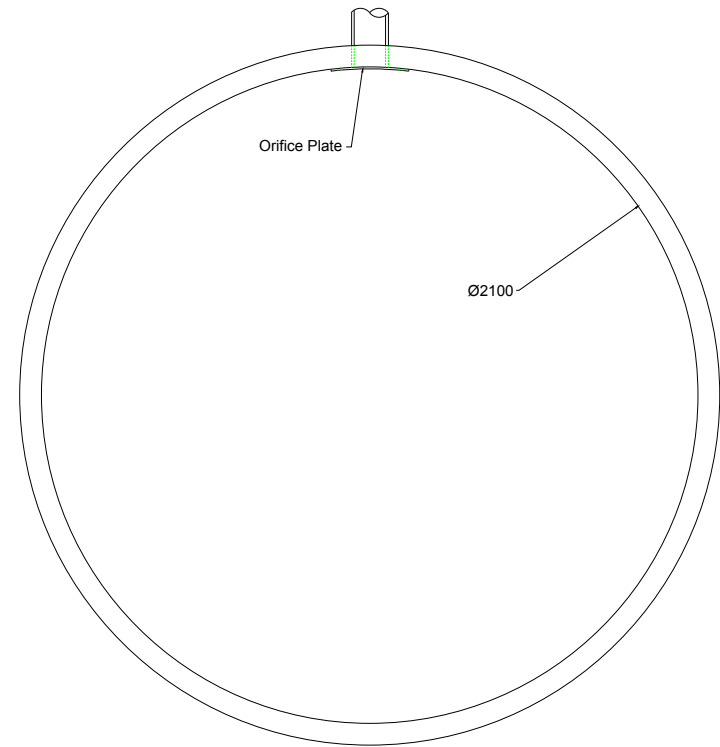
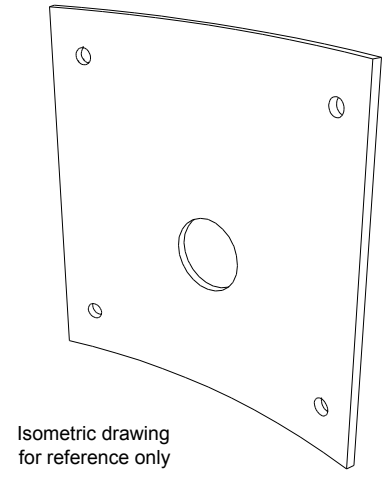
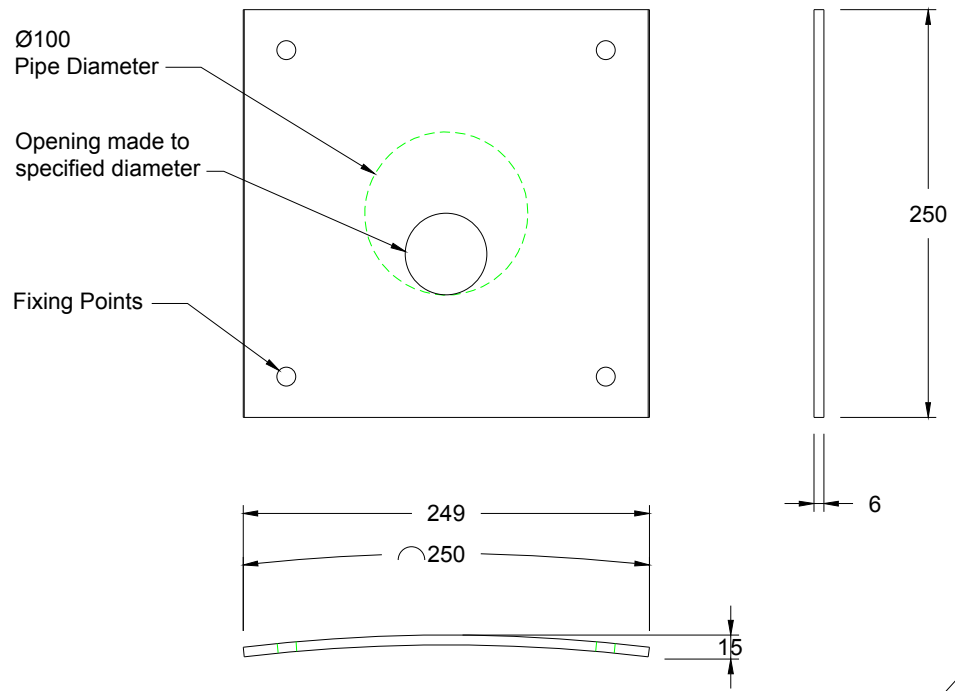
| | |
|-----------|---------|
| SHEET NO: | WEIGHT: |
| 01 OF 01 | kg |

PRODUCT NAME:

Galv. 100mm Curved Orifice Plate
for 2400mm dia Chamber

CODE:

GCOP1002400



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 ± 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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DRAWING TITLE:

Galv. 100mm Curved Orifice Plate
for 2100mm dia Chamber
250 x 250 x 6mm

FINISH:

Galvanised

| SCALE: | PAPER: | DATE: |
|--------|--------|--------------|
| NTS | A4 | 27 - 09 - 19 |

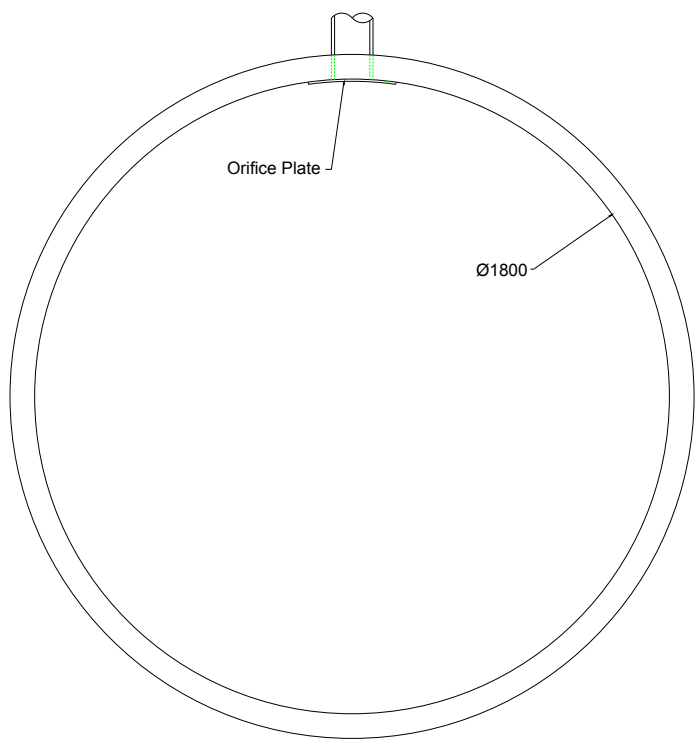
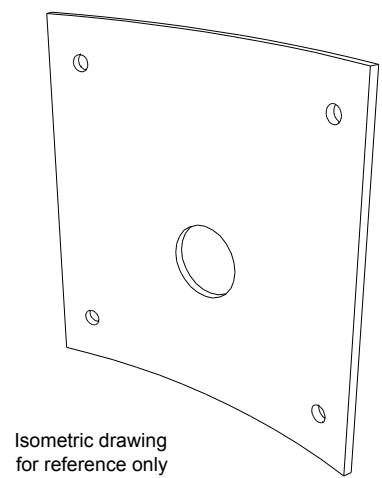
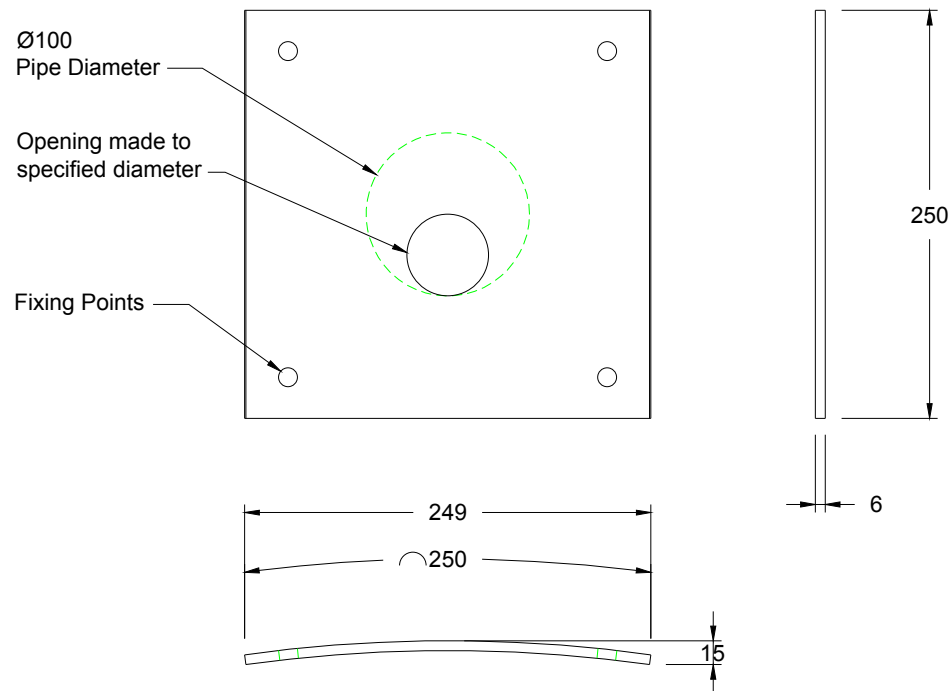
| SHEET NO: | WEIGHT: |
|-----------|---------|
| 01 OF 01 | kg |

PRODUCT NAME:

Galv. 100mm Curved Orifice Plate
for 2100mm dia Chamber

CODE:

GCOP1002100



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 ± 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 - 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.

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|---------|-------|--------------|
| REV NO: | DATE: | DESCRIPTION: |
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DRAWING TITLE:

Galv. 100mm Curved Orifice Plate
for 1800mm dia Chamber
250 x 250 x 6mm

FINISH:

Galvanised

| | | |
|--------|--------|--------------|
| SCALE: | PAPER: | DATE: |
| NTS | A4 | 27 - 09 - 19 |

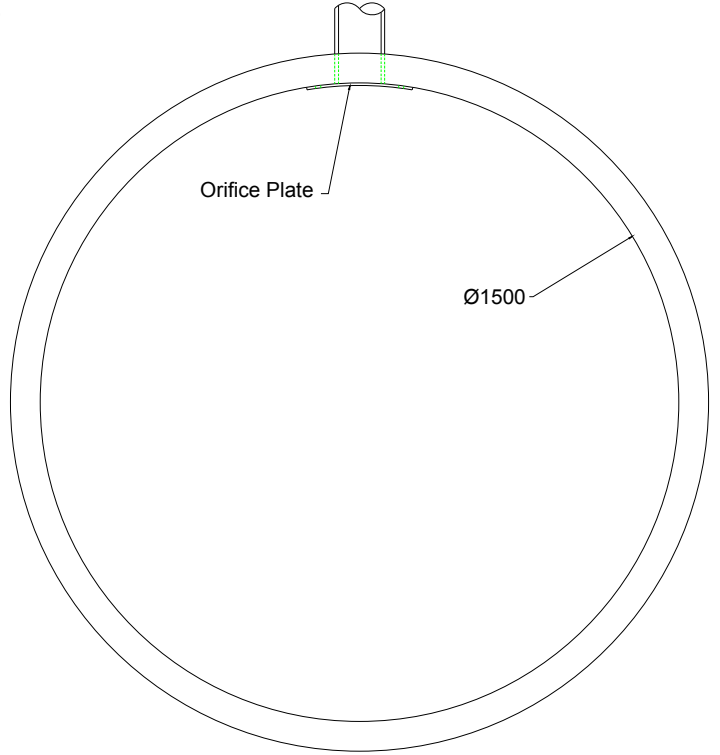
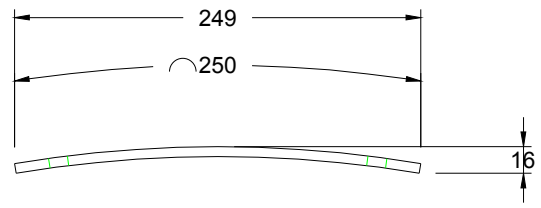
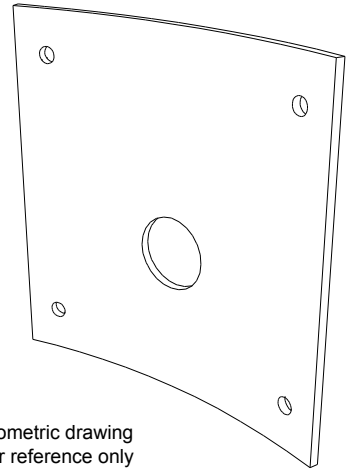
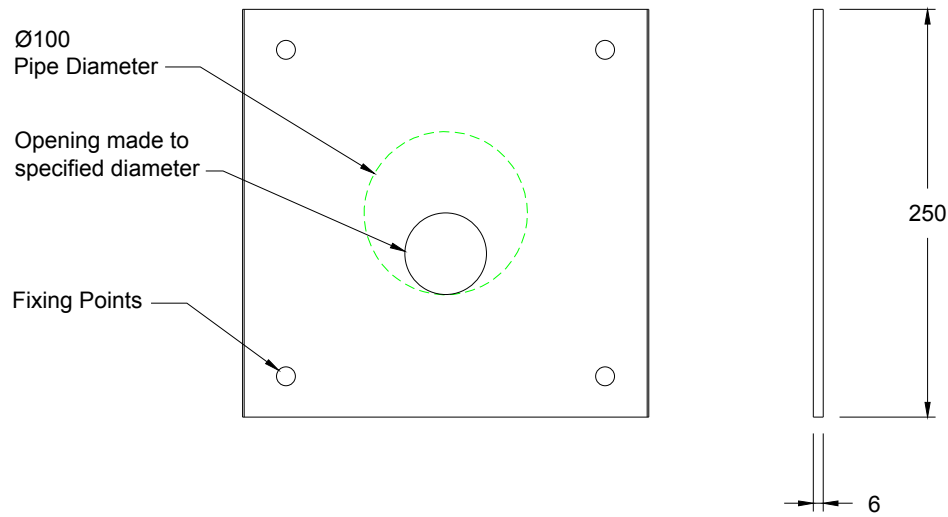
| | |
|-----------|---------|
| SHEET NO: | WEIGHT: |
| 01 OF 01 | kg |

PRODUCT NAME:

Galv. 100mm Curved Orifice Plate
for 1800mm dia Chamber

CODE:

GCOP1001800



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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DRAWING TITLE:

Galv. 100mm Curved Orifice Plate
for 1500mm dia Chamber
250 x 250 x 6mm

FINISH:

Galvanised

| SCALE: | PAPER: | DATE: |
|--------|--------|--------------|
| NTS | A4 | 27 - 09 - 19 |

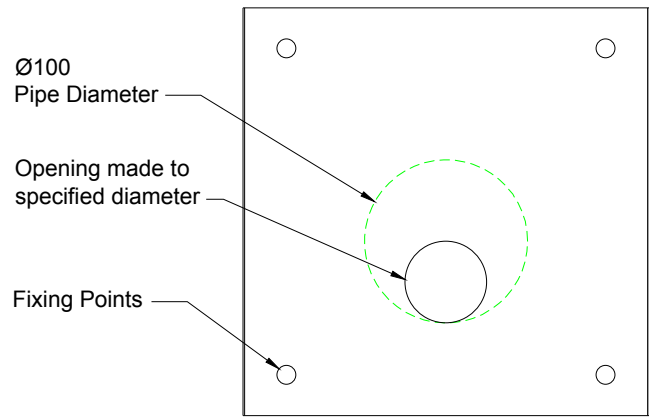
| SHEET NO: | WEIGHT: |
|-----------|---------|
| 01 OF 01 | kg |

PRODUCT NAME:

Galv. 100mm Curved Orifice Plate
for 1500mm dia Chamber

CODE:

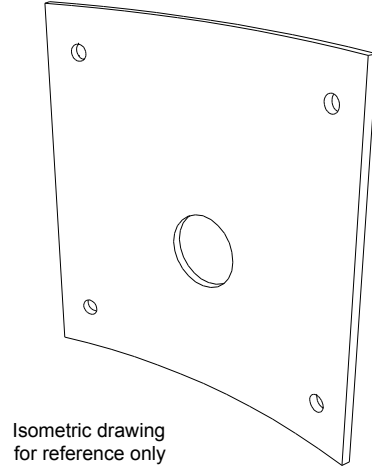
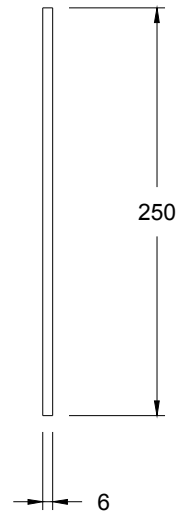
GCOP1001500



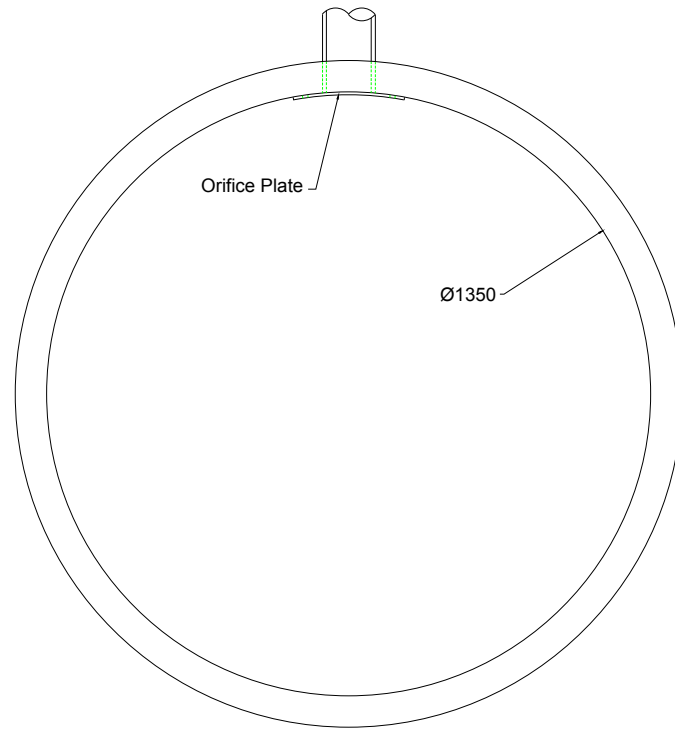
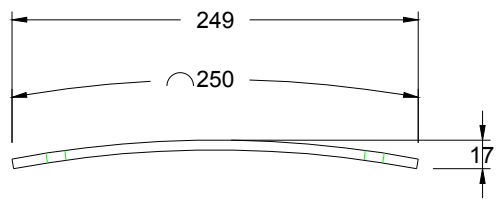
Ø100
Pipe Diameter

Opening made to
specified diameter

Fixing Points



Isometric drawing
for reference only



Orifice Plate

Ø1350

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 ± 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.

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DRAWING TITLE:

Galv. 100mm Curved Orifice Plate
for 1350mm dia Chamber
250 x 250 x 6mm

FINISH:

Galvanised

| SCALE: | PAPER: | DATE: |
|--------|--------|--------------|
| NTS | A4 | 27 - 09 - 19 |

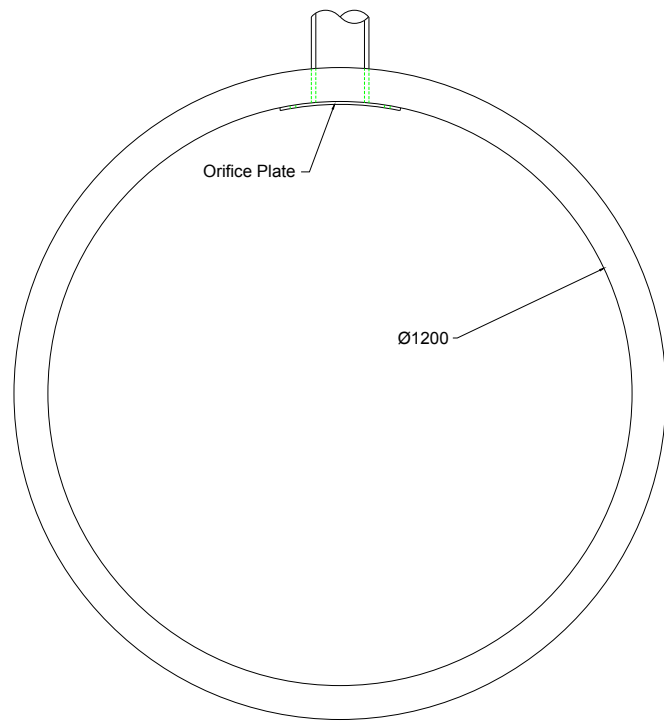
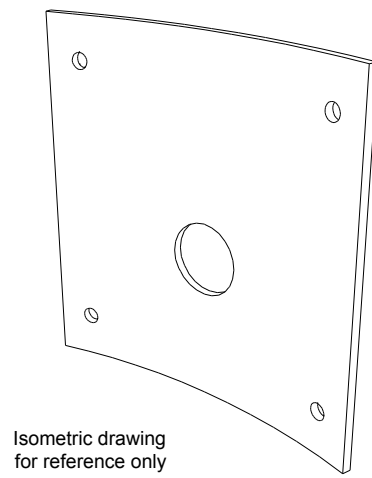
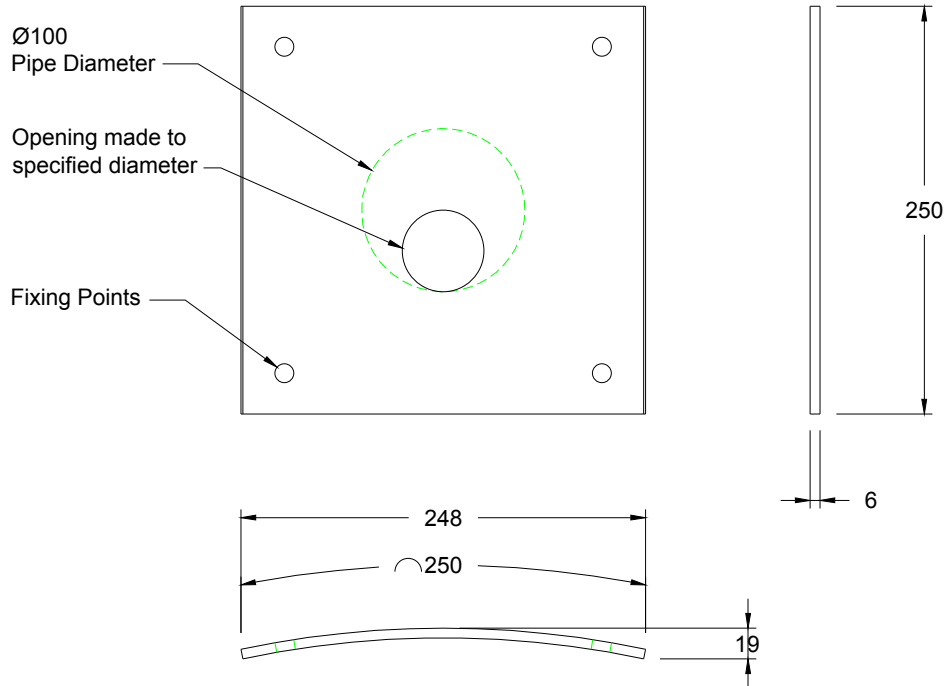
| SHEET NO: | WEIGHT: |
|-----------|---------|
| 01 OF 01 | kg |

PRODUCT NAME:

Galv. 100mm Curved Orifice Plate
for 1350mm dia Chamber

CODE:

GCOP1001350



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
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PROPRIETARY & CONFIDENTIAL

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DRAWING TITLE:

Galv. 100mm Curved Orifice Plate
for 1200mm dia Chamber
250 x 250 x 6mm

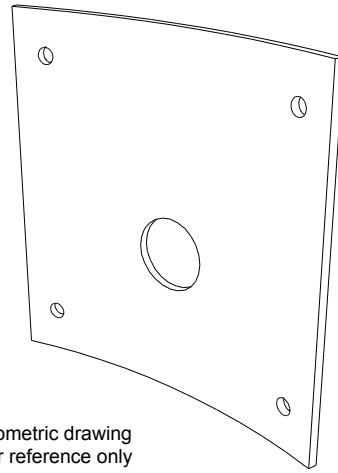
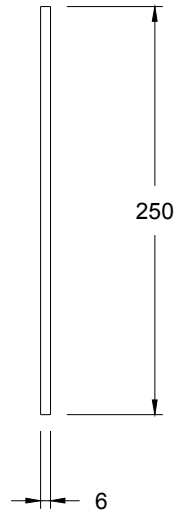
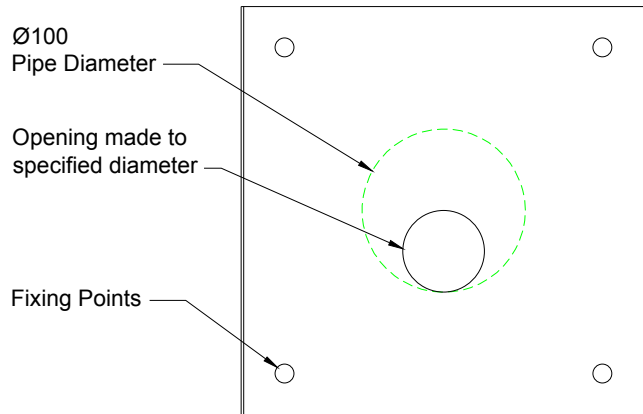
FINISH: Galvanised

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| NTS | A4 | 27 - 09 - 19 |

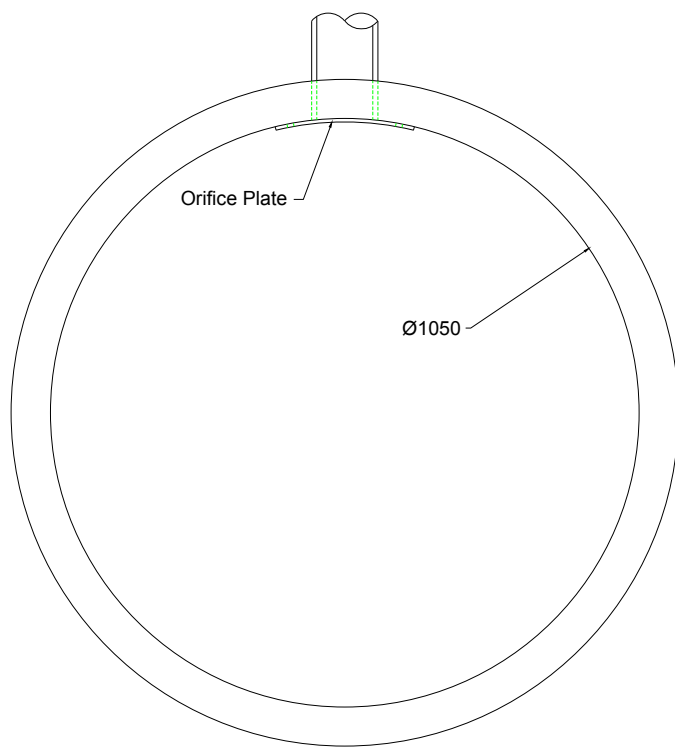
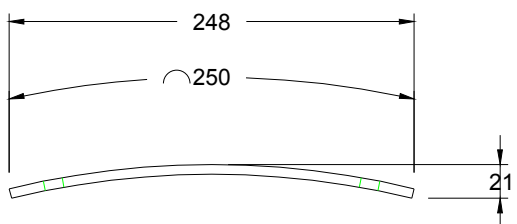
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| SHEET NO: | WEIGHT: |
| 01 OF 01 | kg |

PRODUCT NAME:
Galv. 100mm Curved Orifice Plate
for 1200mm dia Chamber

CODE: GCOP1001200



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 ± 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.

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DRAWING TITLE:

Galv. 100mm Curved Orifice Plate
for 1050mm dia Chamber
250 x 250 x 6mm

FINISH:

Galvanised

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| NTS | A4 | 27 - 09 - 19 |

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| SHEET NO: | WEIGHT: |
| 01 OF 01 | kg |

PRODUCT NAME:

Galv. 100mm Curved Orifice Plate
for 1050mm dia Chamber

CODE:

GCOP1001050