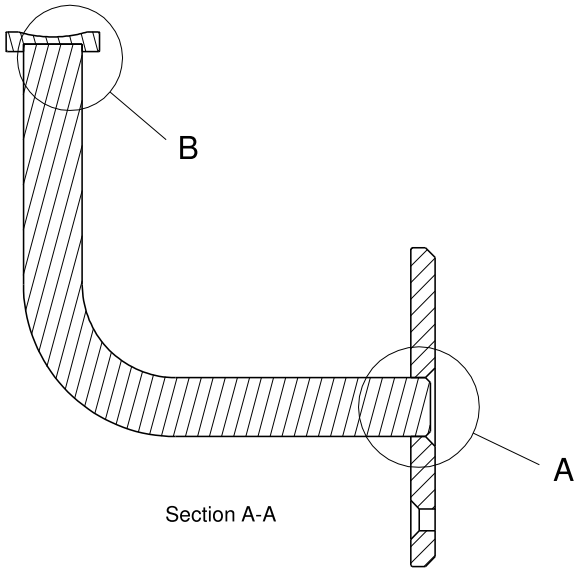
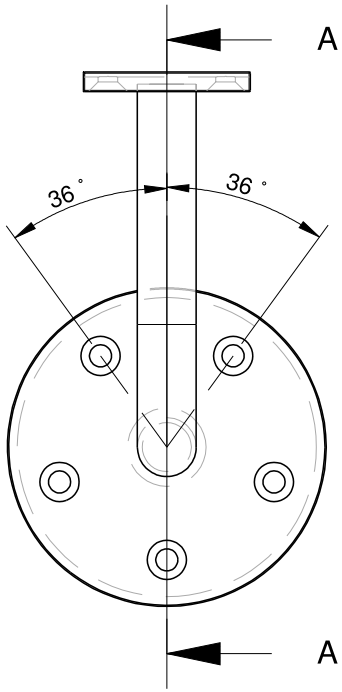
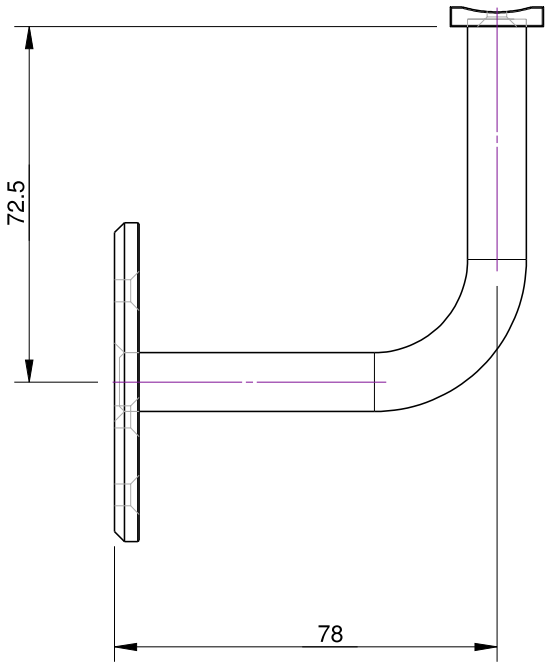
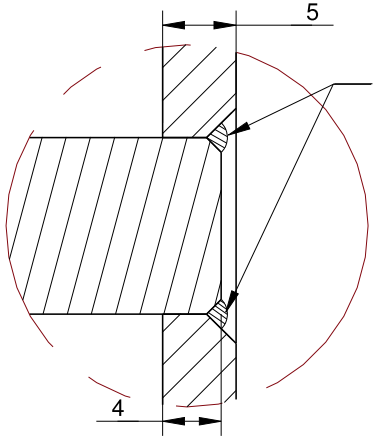
RevNo	Revision note	Date	Signature	Checked



Section A-A

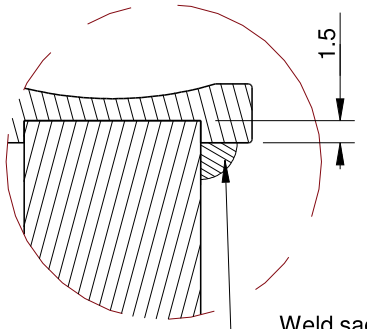






Full Penetration Stainless Weld
Note: Ensure height of weld
is below level of back face

Detail A



Weld saddle to spine full penetration
stainless weld 2 places for 30degree
arc.

Detail B

NOTE:
USE JIG TO POSITION BRACKET IN BASE.
ENSURE BRACKET IS EMBEDDED 4MM INTO BASE.
ENSURE BRACKET IS POSITIONED AT 36 DEGREES AS SHOWN.
WELD RIGHT ROUND.
USE JIG TO POSITION SADDLE TO SPINE.
ENSURE SPINE IS EMBEDDED 1.5MM INTO SADDLE.
ENSURE SIDE OF SADDLE IS PARALLEL WITH BASE.
WELD 2 PLACES FOR 30 DEGREE ARC OPPOSITE SIDES.

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CUSTOMER MILES NELSON MANUFACTURING		**Drawn By** P McKinney	**Date** 17/11/11
PROJECT 621 STAINLESS BANISTER BRACKET			
CA621 WELD ASSEMBLY		**Scale** 1 : 1	**Sheet** 1 of 1