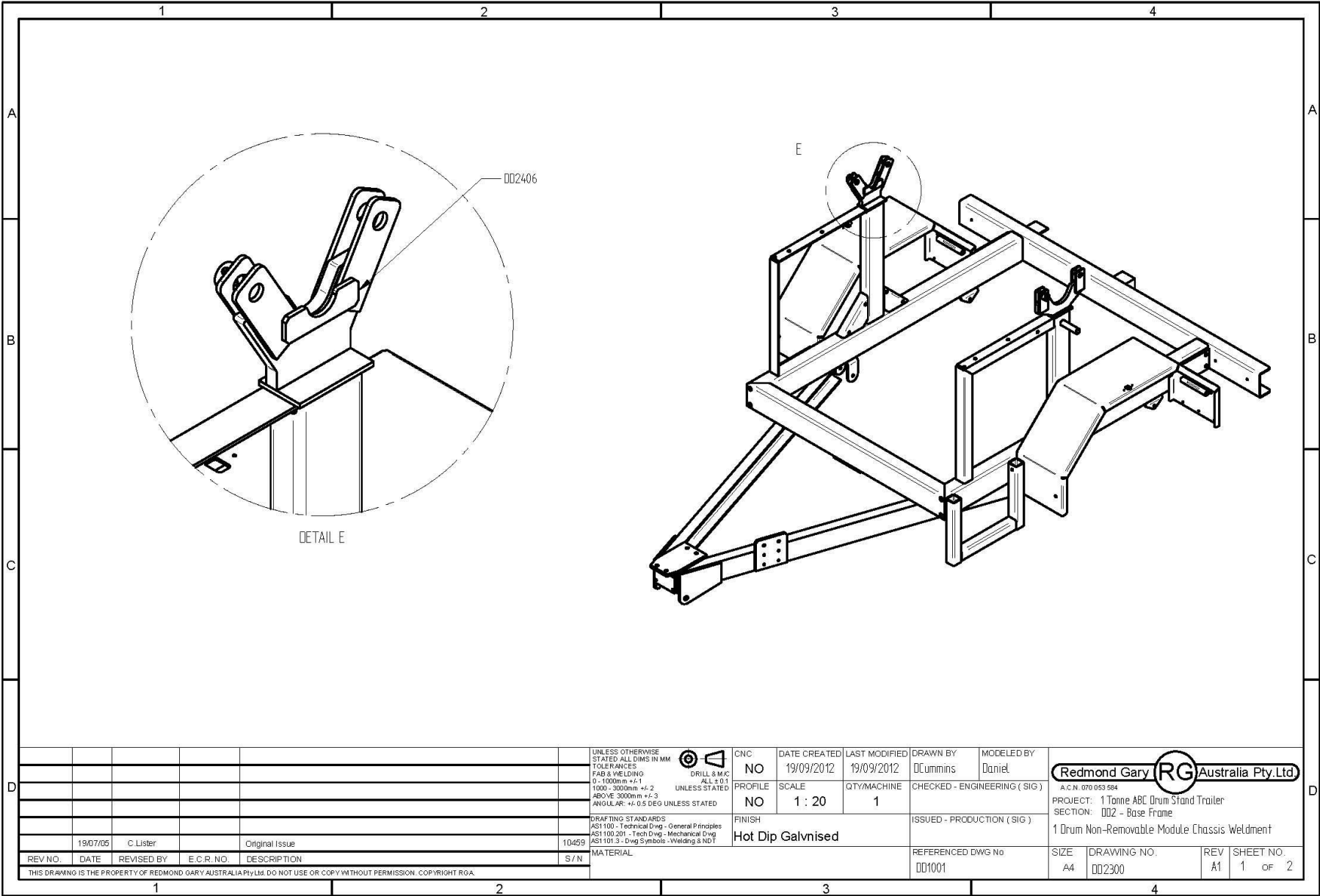


19th September, 2012

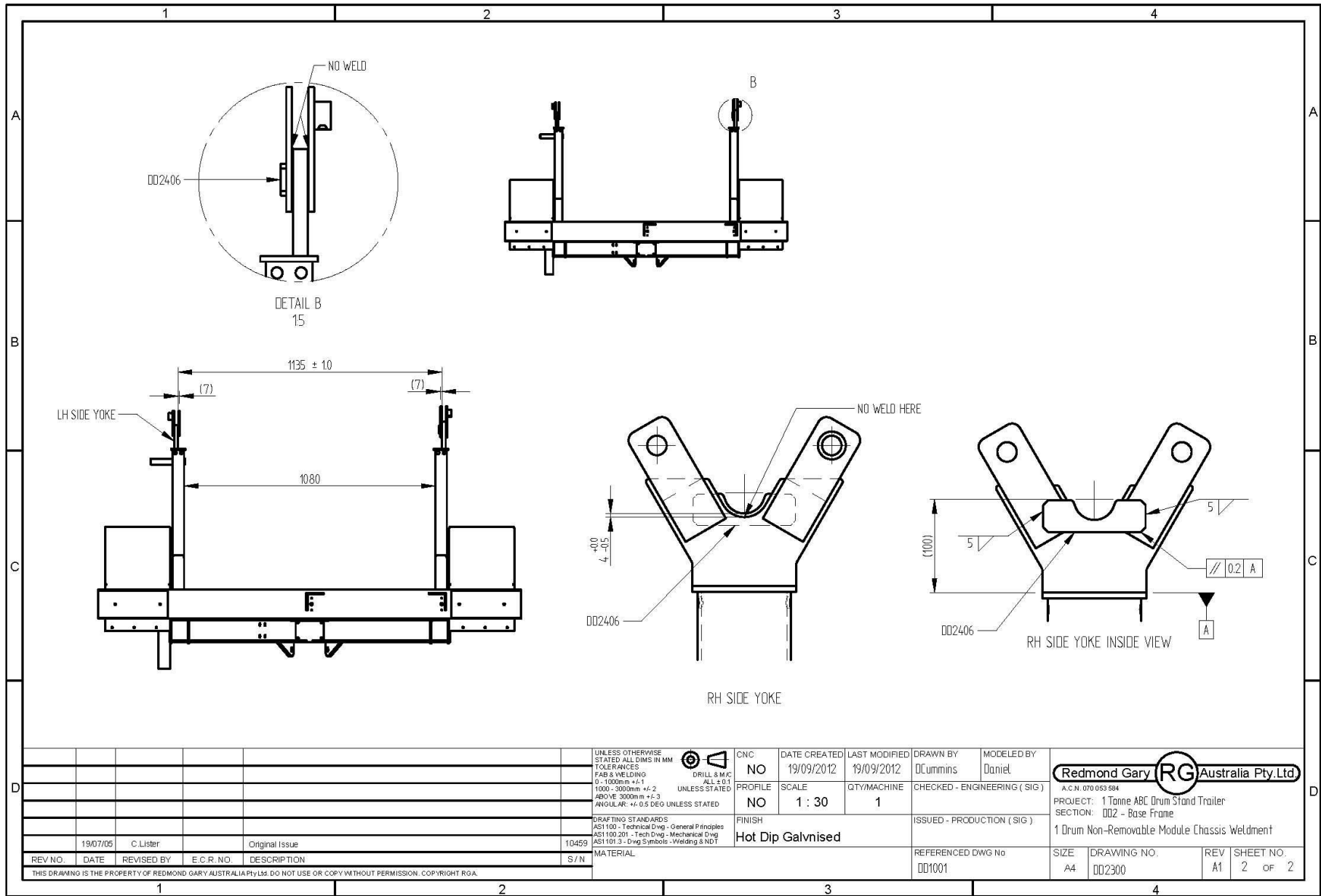
WORK INSTRUCTION TO ADD SPINDLE RETAINING PLATE TO SINGLE DRUM AND 3-DRUM ABC TRAILERS

Note: This work should be carried out by suitably trained personnel. Safety equipment such as safety glasses, leather gloves, hearing protection and shielding around the welding area must be used. A risk assessment must be carried out prior to commencement of this work.

1. Inspect spindle assembly for straightness. If bent, replace the spindle.
2. Check the upright arms - distance apart should be 1080mm between the two RHS Members. Check that they are square to the rear cross-member. If they are splayed out or out of alignment, straighten them using a clamp. It may also be necessary to apply some heat to the welded connection. (Refer to Drawing No. DD 2300 – Sheet 2 of 2).
3. Install plate No. DD2406. Refer to Drawing No. DD2300 – Sheet 1 of 2, which shows the location of the plate reference Detail E.
4. Before welding the plate into position, using a 4” grinder, grind the galvanising coating away from the areas where it is to be welded. Make sure that safety equipment is used including eye protection and gloves.
5. Tack weld plate into position in accordance with the dimensions given on Drawing No. DD2300-Sheet 2 of 2
6. Using the spindle, fit into position checking that the plate is correctly aligned and the spindle uprights are vertical.
7. Weld using mig welder or low hydrogen rods. Ensure welding is only on the inside face as indicated on the drawing. It is important that the plate is positioned accurately in accordance with the drawing, otherwise the spindle will not fit.
8. Using the spindle as a gauge, check that it fits correctly.
9. Treat all unprotected surfaces, including welds, with cold gal paint.



					UNLESS OTHERWISE STATED ALL DIMS IN MM		CNC	DATE CREATED	LAST MODIFIED	DRAWN BY	MODELED BY	 A.C.N. 070 053 584
					TOLERANCES	DRILL & M/C	NO	19/09/2012	19/09/2012	DCummins	Daniel	
					FAB & WELDING	ALL ±0.1	PROFILE	SCALE	QTY/MACHINE	CHECKED - ENGINEERING (SIG)		PROJECT: 1 Tonne ABC Drum Stand Trailer
					0 - 1000mm ±0.1	UNLESS STATED	NO	1 : 20	1	ISSUED - PRODUCTION (SIG)		SECTION: 002 - Base Frame
					1000 - 3000mm ±0.2		FINISH				1 Drum Non-Removable Module Chassis Weldment	
					ABOVE 3000mm ±0.3		Hot Dip Galvanised					
					ANGULAR: ±0.5 DEG UNLESS STATED						REFERENCED DWG No	SIZE
											001001	A4
												DRAWING NO.
												002300
												REV
												A1
												SHEET NO.
												1 OF 2
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REV NO.	DATE	REVISED BY	E.C.R. NO.	DESCRIPTION	S/N
19/07/05		C.Lister		Original Issue	10459

UNLESS OTHERWISE STATED ALL DIMS IN MM
 TOLERANCES
 FAB & WELDING
 0 - 100mm ± 0.1
 1000 - 3000mm ± 0.2
 ABOVE 3000mm ± 0.3
 ANGULAR: ± 0.5 DEG UNLESS STATED

DRIFTING STANDARDS
 ASI 100 - Technical Dwg - General Principles
 ASI 100 201 - Tech Dwg - Mechanical Dwg
 ASI 101 3 - Dwg Symbols - Welding & NDT

CNC	NO	DATE CREATED	19/09/2012	LAST MODIFIED	19/09/2012
PROFILE	NO	SCALE	1:30	QTY/MACHINE	1
FINISH	Hot Dip Galvanised				

DRAWN BY	DCummins	MODELED BY	Daniel
CHECKED - ENGINEERING (SIG)		ISSUED - PRODUCTION (SIG)	

Redmond Gary (RG) Australia Pty.Ltd
 A.C.N. 070 053 584

PROJECT: 1 Tonne ABC Drum Stand Trailer
 SECTION: 002 - Base Frame
 1 Drum Non-Removable Module Chassis Weldment

REFERENCED DWG No	SIZE	DRAWING NO.	REV	SHEET NO.
001001	A4	002300	A1	2 OF 2

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