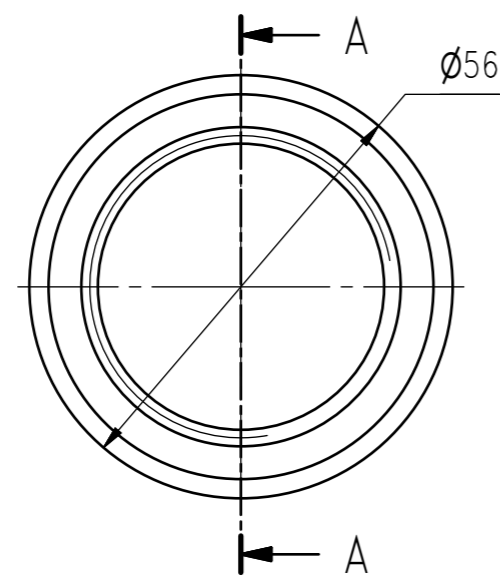


ITEM. 8 - CUSHION BUSH

BRASS

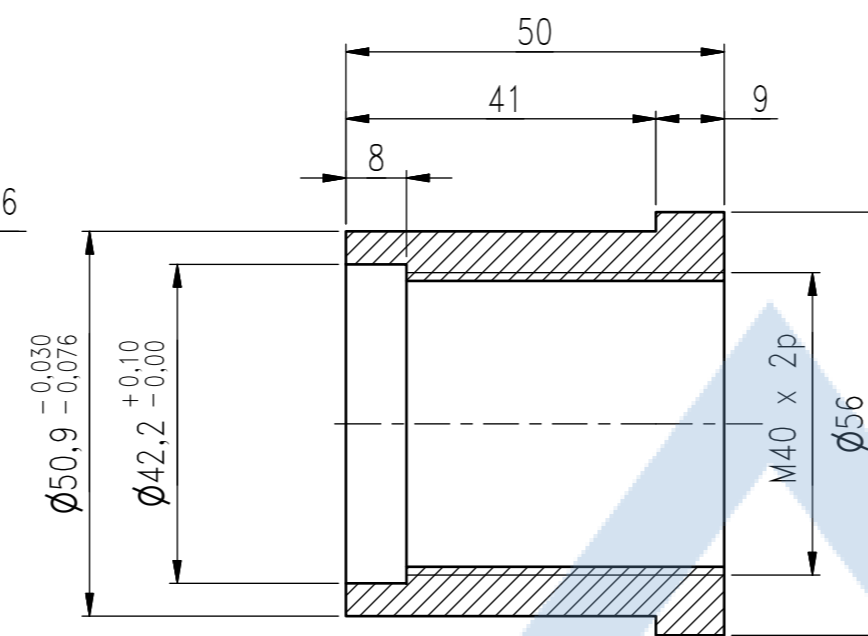
3.2/√ ALL OVER U.O.S



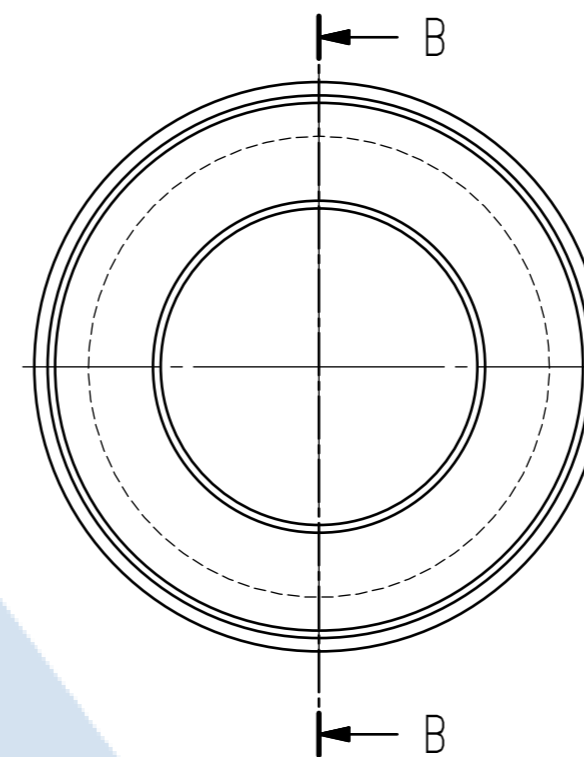
ITEM. 7 - PISTON NUT

STEEL TO SANS 1431 GR 300W

3.2/√ ALL OVER U.O.S



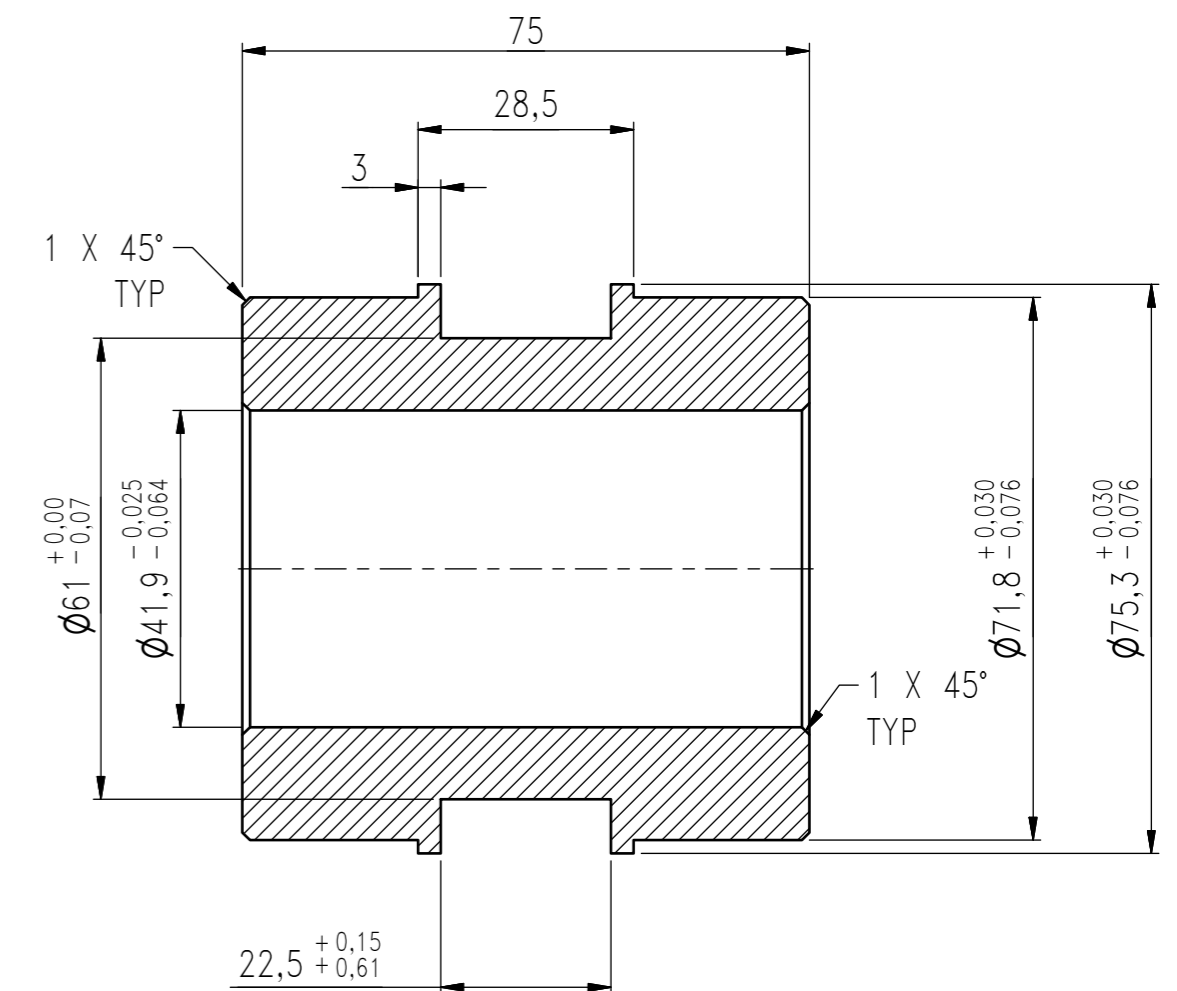
SECTION A-A



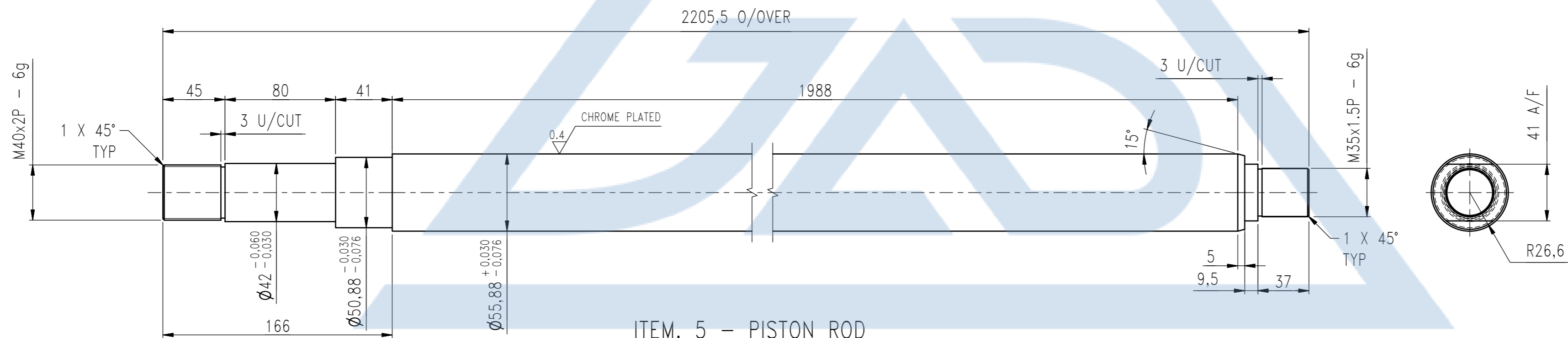
ITEM. 6 - PISTON

PHOSPOR BRONZE (PB1)

3.2/√ ALL OVER U.O.S



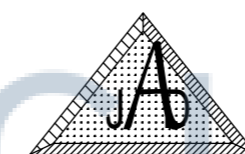
SECTION B-B



ITEM. 5 - PISTON ROD

CHROME STOCK - (EN8)

3.2/√ ALL OVER U.O.S



JA DRAUGHTING

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EXAMPLE NOT FOR MANUFACTURE

GENERAL NOTES

- 1: ALL HOT ROLLED STEEL TO BE SANS 1431 GR 350 WA.
- 2: ALL PLATE WORK TO BE EN 10025 GR S355J U.O.N.
- 3: ALL WELDS TO 6 mm C.F.W U.O.N.
- 4: WELDING OF STRUCTURAL STEEL TO AWS D1.1.
- 5: ALL Ø22 HOLES FOR M20 HEX HEAD BOLTS U.O.N.
- 9: ALL PAINTING AS PER SISHEN SPECIFICATIONS.
- 10: ALL BURRS AND SHARP EDGES TO BE REMOVED.

MACHINING TOLERANCES (U.O.S) TO ISO 2768 & DIN 7168 - MEDIUM		
ABOVE	INCL.	TOL ±
0,5	6	0,1
6	30	0,2
30	120	0,3
120	315	0,5
315	1 000	0,8
1 000	2 000	1,2
2 000	4 000	2
4 000	8 000	3
8 000	12 000	4
12 000	16 000	5
16 000	20 000	6

DRN	PIERRE HATTINGH
DATE	2015/09/10
APPROVED	MAN/SUPT/ENG
PROJN	SCALE
AUTH.No	DO NOT SCALE

EXAMPLE
SHUTTLE
HYDRAULIC CYLINDER
80 BORE x 56ROD x 2400STROKE
DETAIL