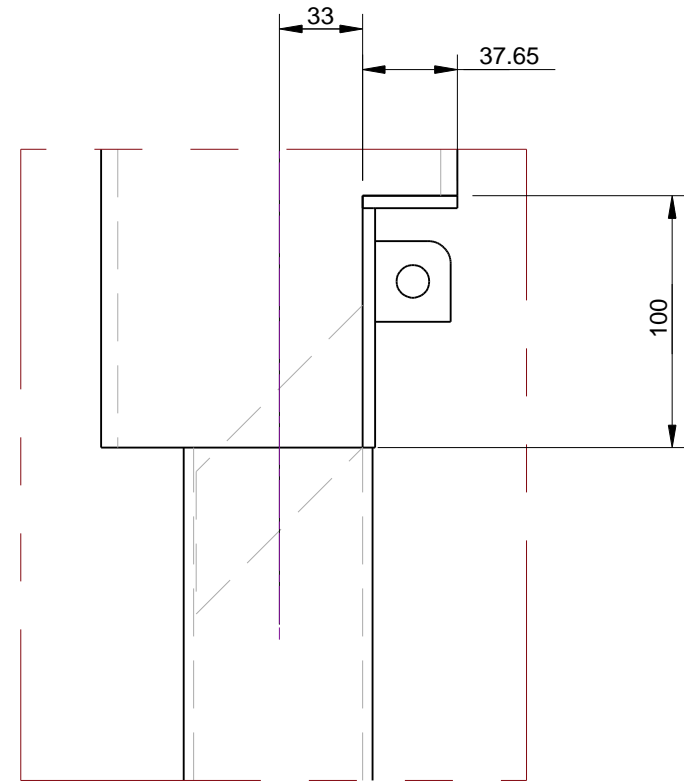
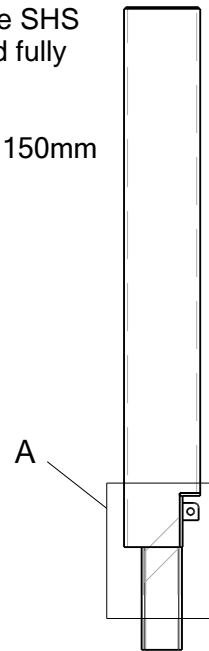


# PROCEDURE

1. Cut pipe to length - 997mm
2. Clean and square top end of pipe.
3. Place cap on top of pipe having an even gap around the top edge. Tack in place and fully weld dress flush.
4. Using an angle grinder with cutting disk, remove section of pipe 100mm longitudinally, and 33mm from pipe centre. See detail. This corresponds to a 153mm distance around the pipe (if 141.3 O.D.).
5. Tack in arc plate. Ensure square and check dimensions. Fully weld and dress flush with pipe.
6. Tack together SHS, 120x5x95 plate, back gusset, and cleat. Refer to detail A. Ensure square and fully weld.
7. Tack together the lower assembly to the pipe assembly. Ensure the SHS is colinear with the pipe and is square, this is essential. Check and fully weld, dress flush with outside of pipe.
8. Drill 5/16 holes in top as per Spec for galvanising
9. After galvanising and painting, install a 30mm wide reflective tape 150mm down from top.
10. Final inspection.



Detail A



Quality  
ISO 9001  
SAI GLOBAL



CONFIDENTIAL

REVISION	#	DESCRIPTION	BY	DATE	DRAWN	DRAWN DATE	CHECKED	CHECKED DATE	SCALE	A4
	1	1	ORIGINAL DRAWING	RBC	19.12.13	R.CRIGTON	19.12.13			
2	2									
3	3									
4	4									
5	5									

**BARRIER BOLLARD (140mm) - REMOVABLE  
PROCEDURE & DETAIL**

FFSB008021

REV. 1

SHEET 3 OF 3