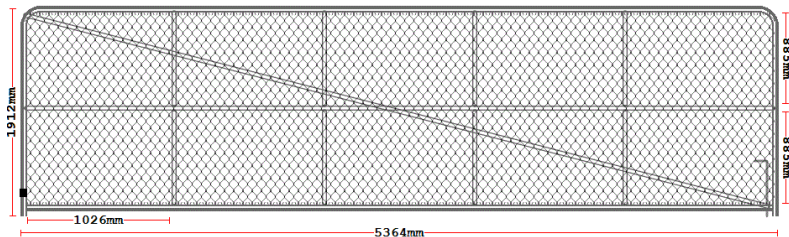


Shop Drawings

WORK ORDER WORKSHOP REPORT - 8/Jul/2024 02:51 PM

W/O Number:	WS02072024-1	Job Number:	22705
Date Issued:	8/Jul/2024 02:51 PM	Date Required:	28/Jun/2024 12:00 AM
W/O Raised By:	None	Client:	Test Company
Job Location:	113 Exhibition Street Melbourne VIC		113 Exhibition Street Melbourne VIC



NOMINAL WIDTH	5400
NOMINAL HEIGHT	1800
CHAIN LINK	50x3.15 KK Heavy Galvanized
SELECTED CHAIN LINK FABRIC HEIGHT	[22 LESS 0.5 DIAMOND] 1804
ACTUAL FRAME HEIGHT	1912
*GATE FRAME GALVANIZED FINISH	

Cut Crown Bar	DN32-XLG :: 1 X 4779 mm
Bend Crown Bar	
BOTTOM RAILS	[VOGEL CUT]DN32-XLG: 1 X 2898 MM
CENTRE RAILS	
VERTICAL BRACES	[VOGEL CUT]DN25-XLG: 2 X 931 MM
DRILL HOLE FOR SHOOT BOLT	828 MM

ITEM	PIPE	WORKSHOP CUTTING & BENDING (STAGE 1)	NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
	DN32-XLG	CUT CROWN BAR RAILS	1	1.5	1.5
	DN32-XLG	BEND CROWN BAR	2	5	10
	DN32-XLG	CUT BOTTOM RAILS	1	1.5	1.5
		CUT CENTRE RAILS	0	0	0

ITEM	PIPE	WORKSHOP CUTTING & BENDING (STAGE 1)	NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
	DN32-XLG	CUT VERTICAL BRACING	2	1.25	2.5
		VOGEL NOTCH BOTH ENDS OF BRACING RAILS	3	1	3
		DRILLING SHOOT BOLT HOLE	1	2	2
TOTAL CUT & PREP TIME FOR GATE FRAME					20.5

ITEM	PIPE	WORKSHOP WELDING GATE FRAMES (STAGE 2.A)	NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
		SETUP TIME ON WELDING BENCH (TACKING FRAME)	6	1	6
	DN32-XLG	WELD OUTER FRAME	2	5.5	11
		WELD INTERNAL RAIL	0	0	0
	DN32-XLG	WELD VERTICAL BRACING	4	4.5	18
TOTAL WELDING TIME FOR GATE FRAME ONLY					35

ITEM	CODE	IMAGE	WORKSHOP GATE FITTINGS (STAGE 2.B)	NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
	H8032D		TWO PART INTERLOCKING HINGES + ATTACHMENT - GALVANISED	2	1	2
	GEB12-SL		"SINGLE ("L" SHAPE) HAND HOLE (FOR TOP OF MID RAIL) (12MM ROD - 90MM X 186MM) FOR STANDARD SINGLE GATE SHOOT BOLT- GALVANISED"	1	1	1
	GDB370		SHORT DROP BOLTS - GALVANISED	1	1	1
	B8		SHOOT BOLT (WITH SLIDE PLATE) - GALVANISED	1	2	2
	HCR		HINGE COLLAR	1	3	3
TOTAL WELDING TIME FOR SELECTED WELD ON GATE FITTINGS ONLY						9

ITEM	WIRE UP GATE FRAMES (STAGE 3)		NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
STEP 1	DE-SCALE WELDS & PRIME PAINT ALL WELDS		6	1	6
STEP 2	FIT CHAIN LINK TO GATE FRAME BASED ON M2		3SQM	2	6
STEP 3	TRIM & KNUCKLE CHAIN LINK TO BOTTOM RAIL M		2.9	2.5	7.25
STEP 4	SHAPE IN HAND HOLES		1	1	1
STEP 5	LOAD UP GALV LACING WIRE TO NEEDLE KG		0.47 KG	4	1.88
STEP 6	LACE UP PERIMETER OF GATE FRAMES		8M	5	40

403 Forbidden

ITEM	WIRE UP GATE FRAMES (STAGE 3)	NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
TOTAL LACING TIME FOR GATE FRAME ONLY				62.13 MIN
SETUP TIME ALLOWANCE BETWEEN STAGES 1 TO 3				18
TOTAL O/ALL MINUTES ALLOWED FOR MANUFACTURER OF GATE (BASED ON CURRENT STANDARDS)				144.63