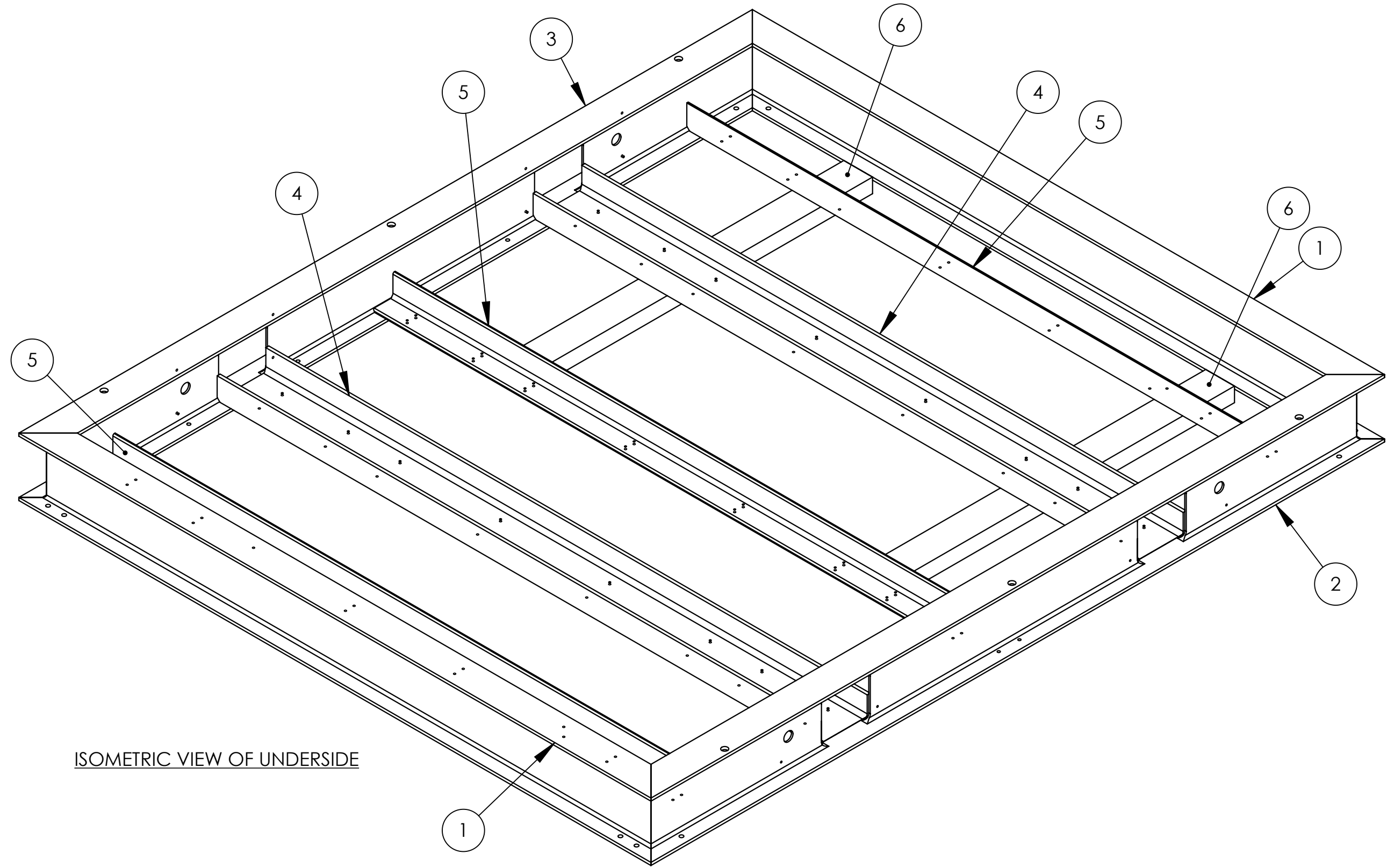
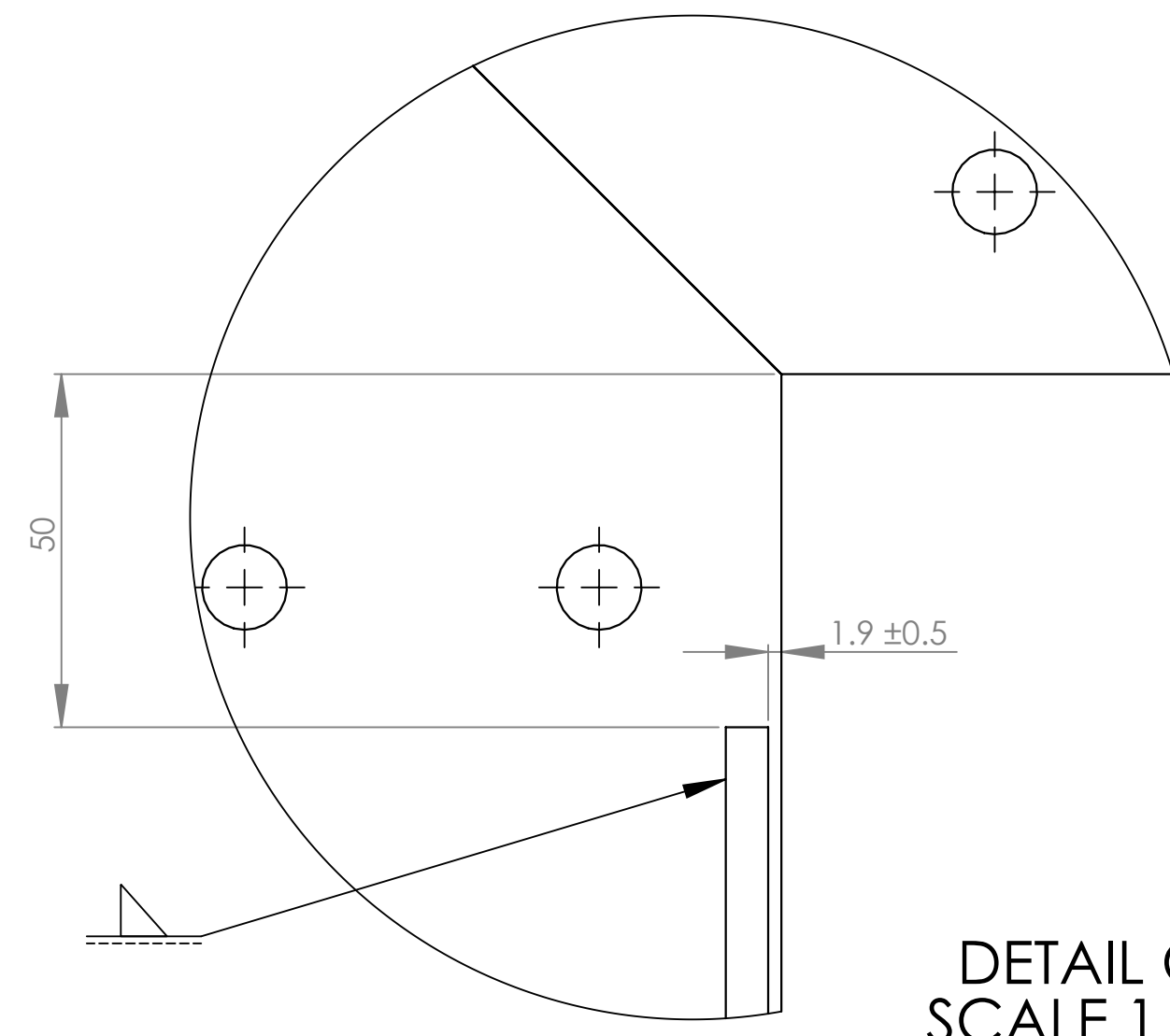
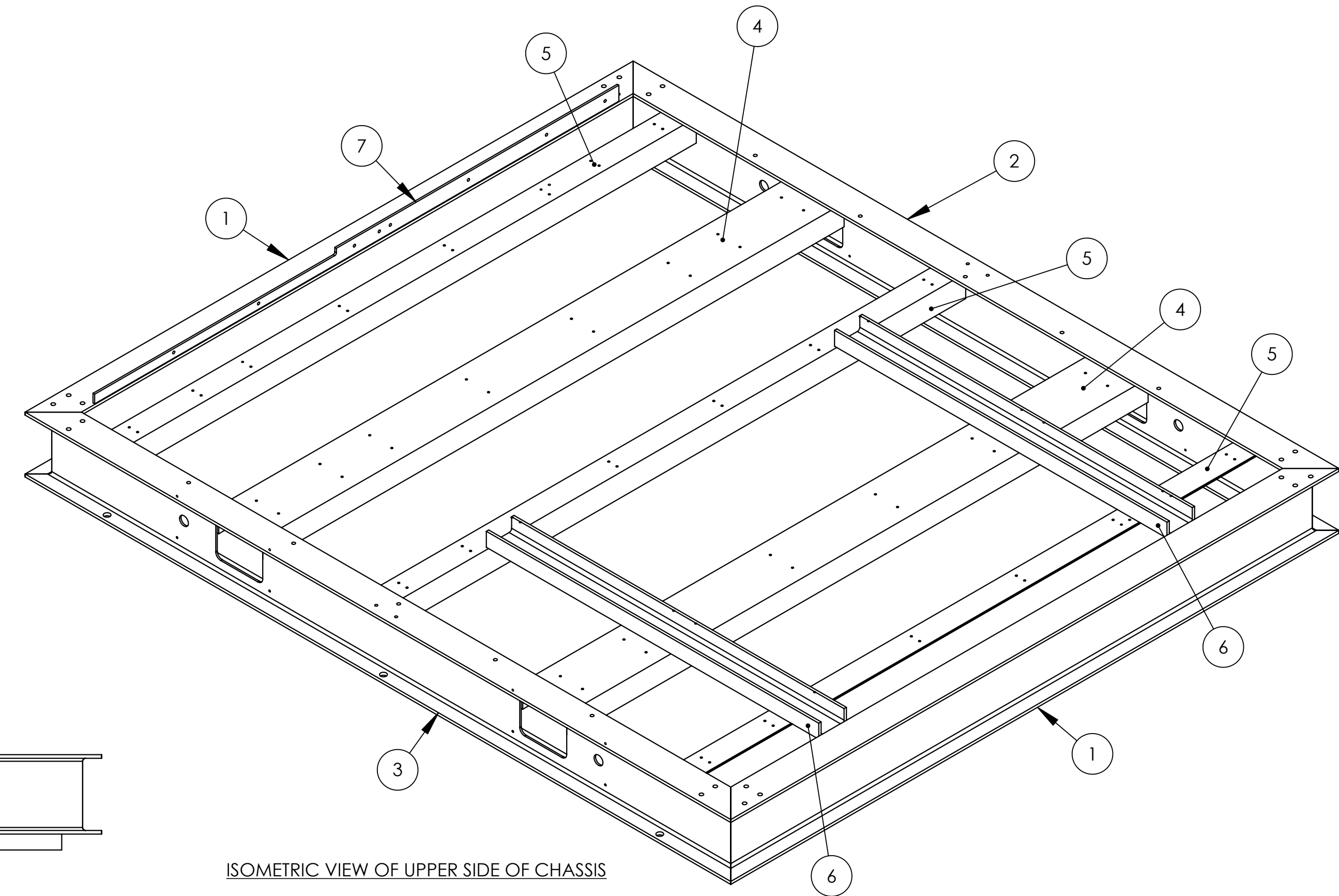




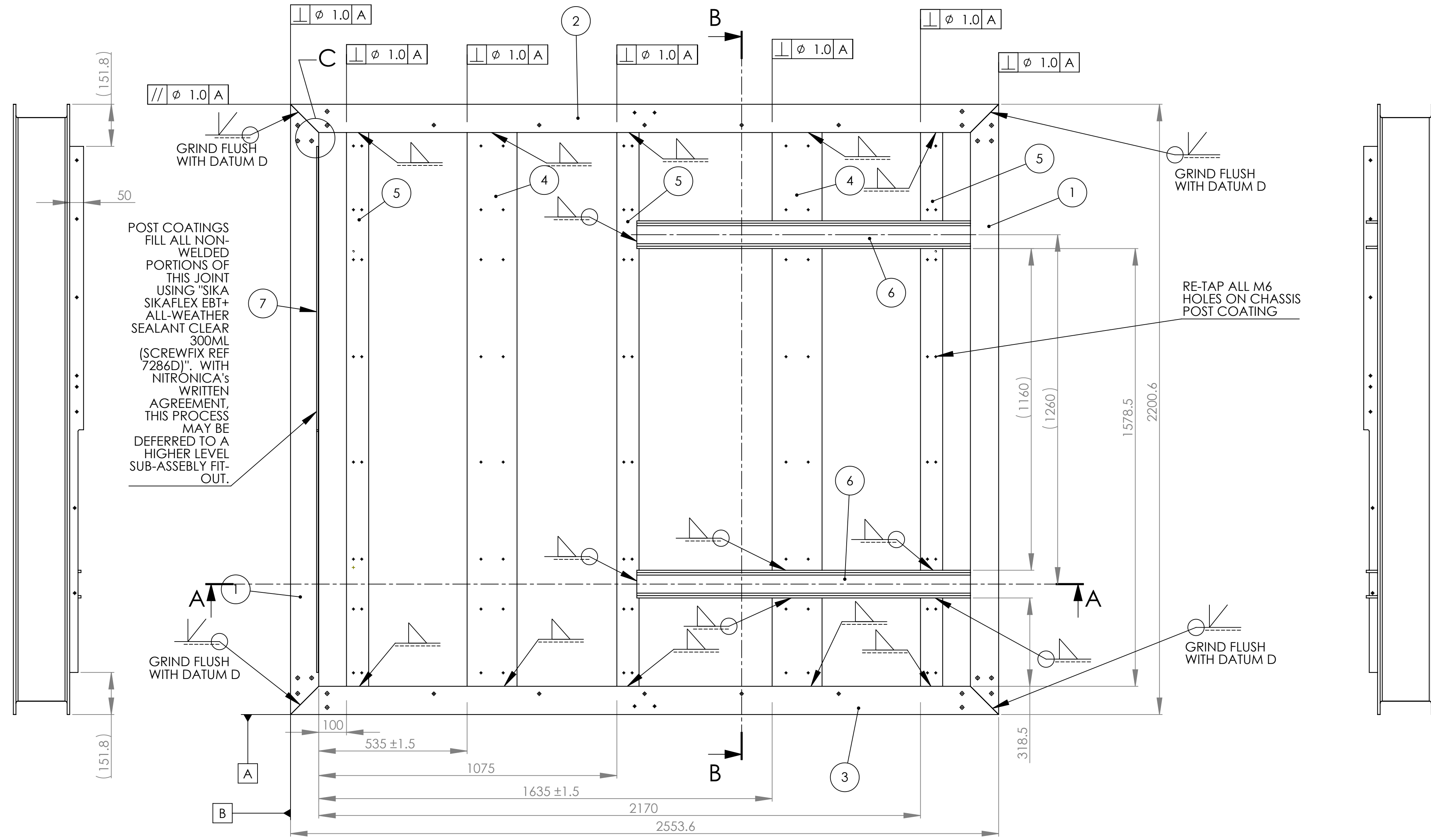
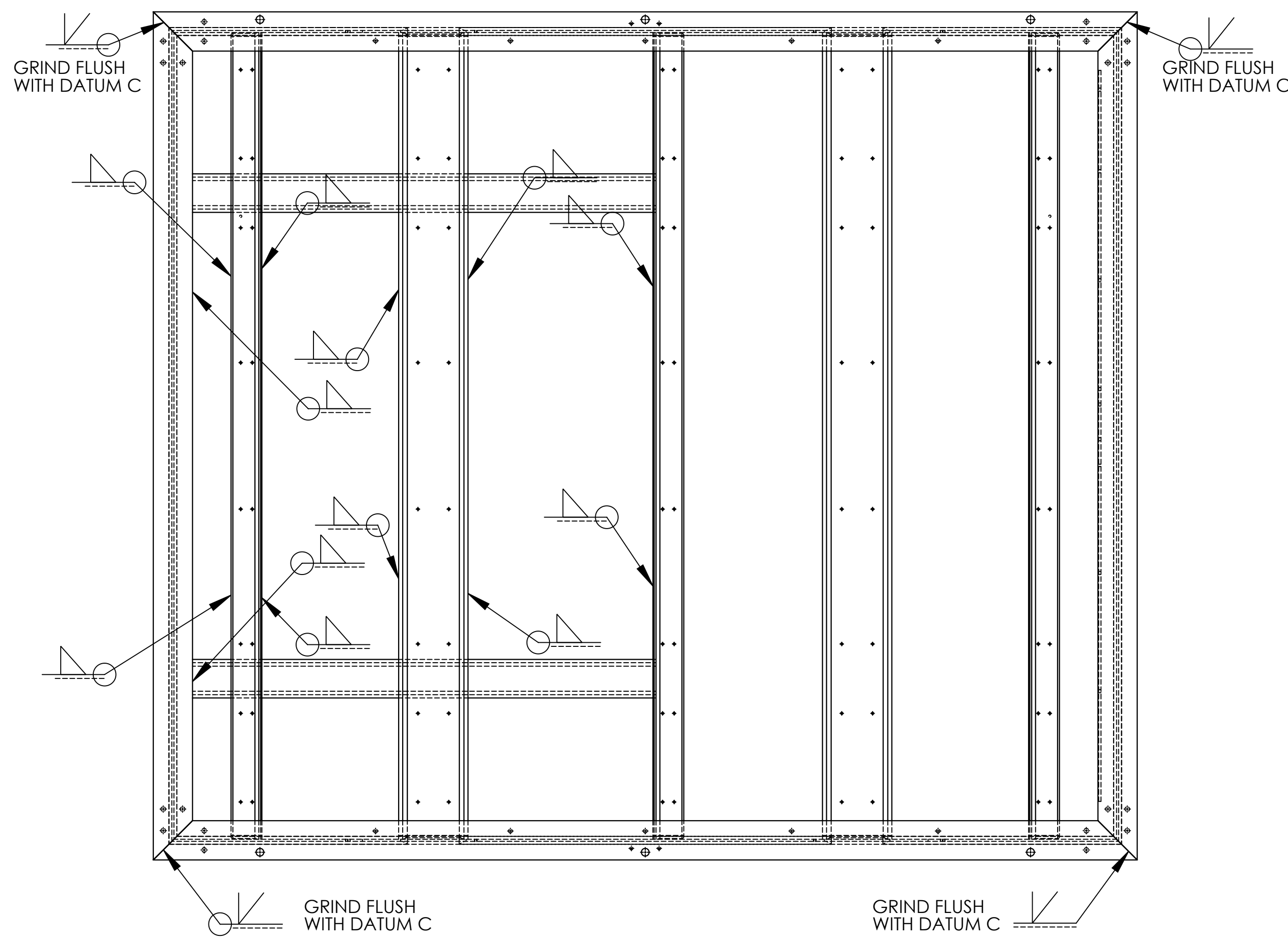
ISOMETRIC VIEW OF UNDERSIDE



DETAIL C
SCALE 1 : 1



ISOMETRIC VIEW OF UPPER SIDE OF CHASSIS

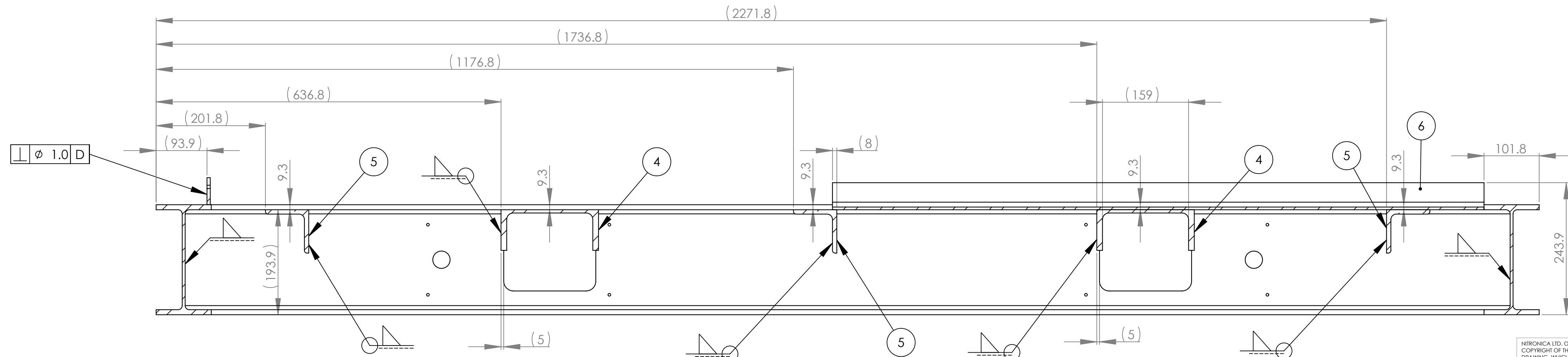
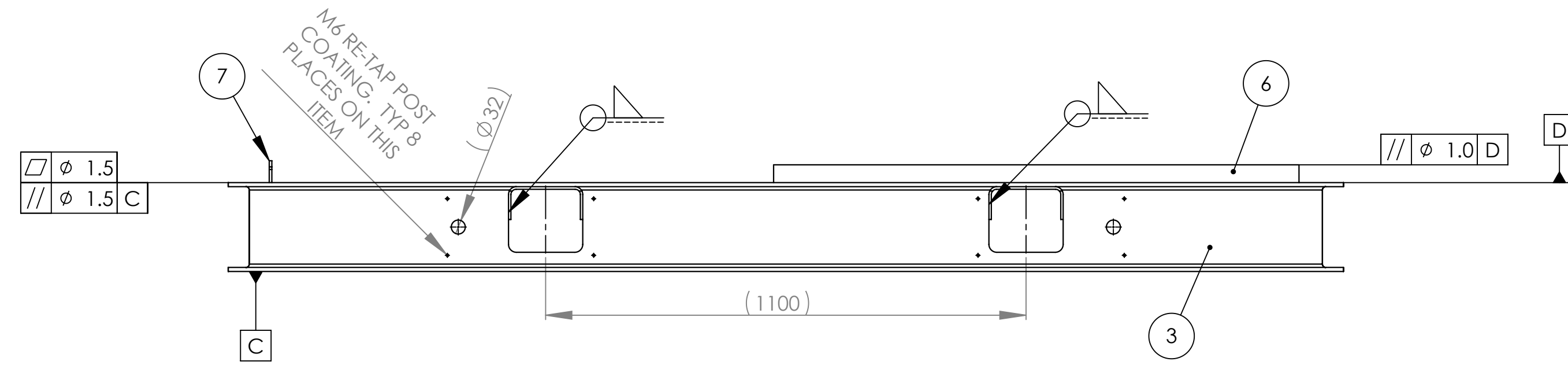


POST COATINGS
FILL ALL NON-
WELDED
PORTIONS OF
THIS JOINT
USING SIKAFLEX EBT+
ALL-WEATHER
SEALANT CLEAR
300ML
(SCREWFIX REF
7286DY) WITH
NITRONICA'S
WRITTEN
AGREEMENT,
THIS PROCESS
MAY BE
DEFERRED TO A
HIGHER LEVEL
SUB-ASSEMBLY FIT-
OUT.

RE-TAP ALL M6
HOLES ON CHASSIS
POST COATING

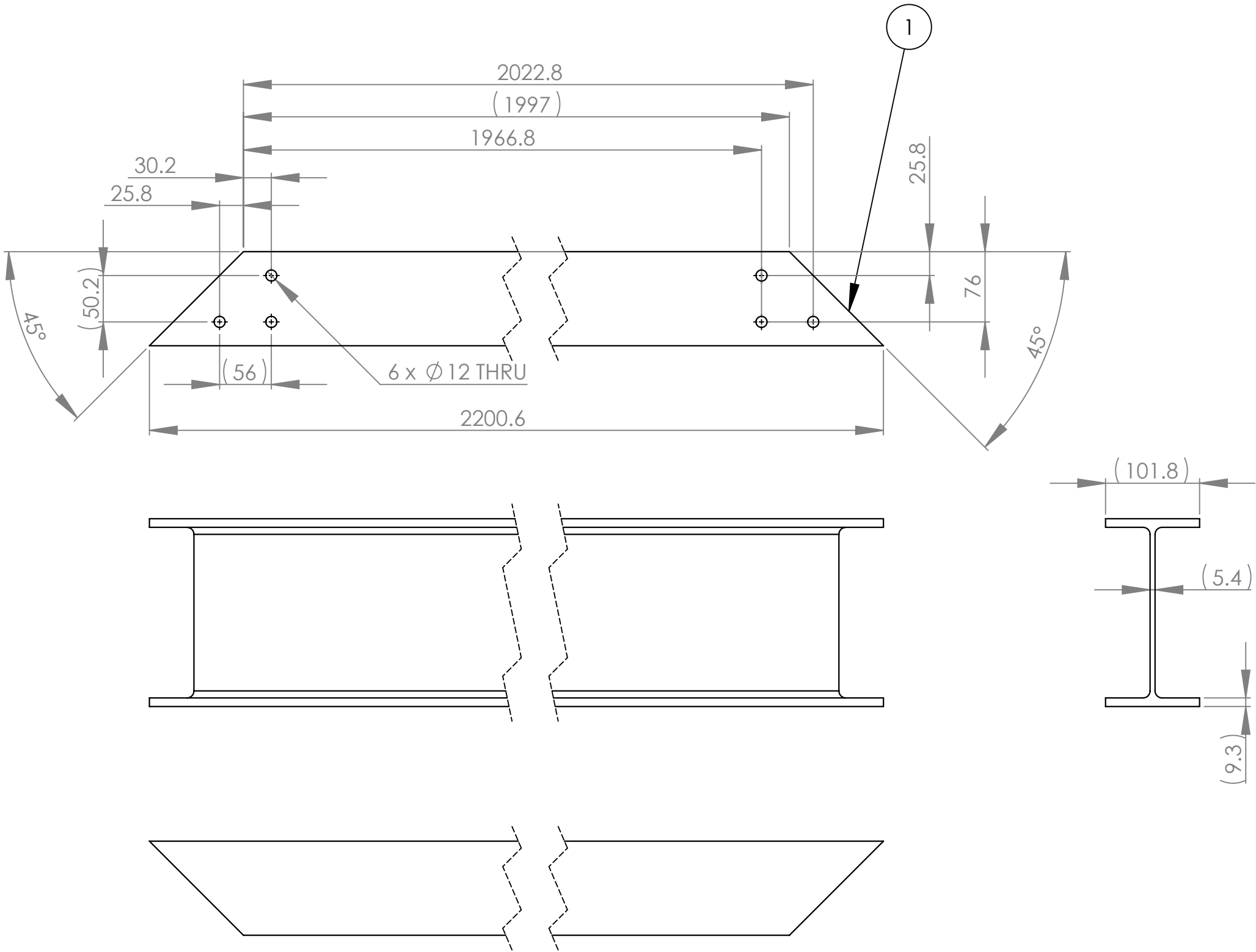
NOTES

- REFER TO SUBSEQUENT DRAWING SHEETS FOR INDIVIDUAL ITEM MACHINING DETAILS.
- CHECK FORKLIFT SLOTS (WIDTH AVAILABLE & PITCH) ARE ADEQUATELY SIZED PRIOR TO MANUFACTURE.
- ALL JOINTS ARE TO BE SEAM WELDED WITH EXEPTION OF ITEM 7 WHICH IS STITCHED AS PER ANNOTATION.
- MIG WELDING IS ACCEPTABLE.
- COVER WORKPIECE TO AVOID SPATTER.
- ENSURE THERE IS NO POROSITY IN WELDING. IF IN DOUBT DYE-PEN TEST JOINTS PRIOR TO GALVANISING. THIS IS AN IMPORTANT CONSIDERATION FOR CORROSION PREVENTION.
- UNSPECIFIED WELDS TO SAME AS EXAMPLE SIMILAR JOINTS ON ASSEMBLY, OTHERWISE FULL PENETRATION FILLET WELDS.
- MINIMISE DEFORMATION AS FAR AS PRACTICABLE.
- IF ENCLOSED HOLLOW SECTIONS ARE USED, FABRICATOR TO DRILL 6mm HOLES AS REQUIRED TO PREVENT PRESSURE BUILD UP DURING GALVANISING. SIMILARLY, ENCLOSED HOLLOW SECTIONS SHOULD HAVE SUITABLE HOLES DRILLED TO PREVENT EXCESS GALVANISING BUILD-UP, THUS MINIMISING WEIGHT & GALV COSTS.
- NOTE USE OF SINGLE-BEVEL BUTT WELDS... ENSURE THESE ARE BEVELLED AS DESCRIBED. BEVELS IN THIS CASE ARE NOT SHOWN ON ITEM MACHINING DETAILS. THESE ARE TO BE FORMED USING GRINDER AS REQUIRED, PRE-JIGGING.
- IT IS FABRICATOR'S RESPONSIBILITY TO ENSURE THAT ALL WELDING IS SUITABLE FIT FOR PURPOSE WITH ADEQUATE PENETRATION. IF REQUIRED, SEEK ADVICE FROM NITRONICA REGARDING FINAL ASSEMBLY'S END USE INCLUDING LOADING CONDITIONS FOR BOTH NORMAL USE & MATERIALS HANDLING.
- NOTE THAT STRUCTURAL LOADING OF THIS CHASSIS & COMPONENTS TO BE ASSEMBLED HAS NOT BEEN ANALYSED FOR STRENGTH AT TIME OF DRAWING ISSUE. THIS GREAT CARE IS REQUIRED DURING INITIAL PROTOTYPE TRIALS TO ENSURE THAT IN TERMS OF STRENGTH OF MATERIALS & DEFORMATION. IT IS RECOMMENDED TO CONDUCT SUITABLE OVERLOAD TESTS FOR VARIOUS USE CASES, INCLUDING ALL EXTREMES OF MATERIALS HANDLING (CHASSIS & TOP-LEVEL ASSEMBLY STAGES) INCLUDING REASONABLE MISUSE.
- ITEM 7 PROFILE TOLS WITHIN 0.4mm OF TRUE POSITION OF DXF FILE PROVIDED.
- WHERE NO MACHINING DETAIL IS PROVIDED, SIMPLY CUT SECTION TO LENGTH AS PER TABLE +/- 0.5mm.



SECTION A-A
SCALE 1 : 5

		Weldment Cut List		
ITEM NO.	Description	Material	LENGTH	QTY.
1	Universal Beam (I Section), 203 x 102 x 23	BS 4: Part 1: 1993	2200.6	2
2	Universal Beam (I Section), 203 x 102 x 23	BS 4: Part 1: 1993	2553.6	1
3	Universal Beam (I Section), 203 x 102 x 23	BS 4: Part 1: 1993	2553.6	1
4	Parallel Flange Channel, 180 x 75 x 20	BS EN 10279 : 2000, EN 10279:2000	2093.4	2
5	Equal Angle 80 x 80 x 8	BS4848 Part 4 1972 (1986	2093.4	3
6	Parallel Flange Channel, 100 x 50 x 10	BS EN 10279 : 2000, EN 10279:2000	1203	2
7	573-P001-ITEM7 6mmMS-QTY1-Rev1.DXF	EN 10025 1993 S275JR		1



NOTES

1. FOR MATERIAL SPECS REFER TO SHT1 TABLE.

NITRONICA LTD. OWNS THE COPYRIGHT OF THIS DRAWING, WHICH IS SUPPLIED IN CONFIDENCE. IT MUST NOT BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT IS SUPPLIED. THIS DRAWING INCLUDING EXTRACTS OF ITS CONTENT MUST NOT BE REPRODUCED, DISTRIBUTED OR ITS CONTENTS DISCLOSED TO ANY THIRD PARTIES WITHOUT WRITTEN CONSENT. EXCEPTIONS TO ABOVE STATEMENT ARE PERMISSIBLE ONLY WITH WRITTEN AGREEMENT OF NITRONICA LTD.

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS
SURFACE FINISH:
TOLERANCES U.O.S:
LINEAR: ±0.5mm
ANGULAR: ±0.5°

THIRD ANGLE PROJECTION
DO NOT SCALE - WORK TO FIGURED DIMS
IF IN DOUBT ASK
DEBUR AND REMOVE SHARP EDGES
PART NUMBER SHOWN PICTORIALY IS
PREFIXED DRG No. & SUFFIXED VARIANT

TITLE: Chassis
(MACHINING DETAILS)

REV	PROJECT	DRAWN	CHK'D	DATE RELEASED	STATUS	PRELIMINARY
2	0573	JP	JP	1/12/2020	THIS COPY DATE:	01/12/2020
					FINISH:	
					MATERIAL:	Plain Carbon Steel
					APPROX WEIGHT (g):	378983.46



nitronica

CLIENT:
MEDPOINT

NITRONICA Ltd.
4 Antrim Rd,
Ballynahinch
BT24 8AN
+44 (0) 28 9756 6200
www.nitronica.com

DRG NO.	VARIANT	REVISION
573-P001	001	2
COPYRIGHT 2020 NITRONICA LTD.		A3

SCALE:1:5

SHEET 3 OF 3