

## GENERAL FABRICATION PROCESS:

### 1. PLATE WORK:

1. ALL PLATE WORK TO BE COMMERCIAL MILD STEEL U.O.N.
2. ALL DIMENSIONS ARE OUTSIDE SIZES U.O.N.
3. DIMENSIONS BALLOONED & ALL BENDING ANGLES ARE TO BE NOTED AS CRITICAL SIZES WITHIN 1mm TOLERANCE.
4. LASER CUT PLATE WORK TO BE PRE-INSPECTED BEFORE FABRICATION MAY COMMENCE.
5. ALL HOLES SMALLER THAN PLATE THICKNESS TO BE MARKED AND DRILLED AFTERWARDS.
6. ALL PART NUMBERS TO BE ENGRAVED WHERE INDICATED ON SUPPLIED DXF FILES.
7. ALL PARTS TO BE DENT FREE AND ALL BURRS TO BE REMOVED.
8. SEE K-FACTOR ON DEVELOPMENT, IF K-FACTOR DIFFERS FROM SUPPLIER, THE SUPPLIER MUST RE-DEVELOP TO ENSURE CORRECT SIZES AFTER BENDING.

### 2. STEELWORK:

1. ALL STEELWORK TO BE IN ACCORDANCE WITH SANS 1431 STANDARD U.O.N.
2. WHERE NEEDED, STEELWORK SHOULD BE DETERMINED IN FABRICATION. (TO BE INSPECTED AND NOTED BY SUPERVISOR ON DUTY AND CONFIRMED BY DRAWING OFFICE)
3. ALL FABRICATION PARTS MUST BE MANUFACTURED IN ADVANCE AND MARKED.

### 3. ASSEMBLY PROCESS:

1. PARTS TO BE ASSEMBLED AS PER DRAWING & WITHIN DESIGN TOLERANCES.
2. NO ALTERATIONS MAY BE MADE TO DESIGN WITHOUT AUTHORISATION BY MANAGERS AND DRAWING OFFICE.
3. A STANDARD GAP OF 2,5mm BETWEEN DOOR AND BODY.

### 4. WELDING:

1. ALL WELDING SURFACES MUST BE APPLIED WITH ANTI-SPLATTER PRIOR TO WELDING.
2. ALL SPLATTER MUST BE REMOVED WHERE VISIBLE TO THE NAKED EYE.
3. ALL WELDING AND WELDING FINISHES TO BE AS INDICATED. (IF NOTED ON DRAWING)

### 5. CONCRETE:

1. DOOR CASES TO BE FILLED WITH MUTUAL BARRIER MATERIAL AND VIBRATED TO ENSURE AIR TIGHT.
2. BARRIER TO BE RE-ENFORCED WITH STEEL RODS (AS PER 2.1).
3. BARRIER FILLED PARTS MUST BE CLEAN BEFORE SENT BACK FOR WELDING.

### 6. MACHINE WORK:

1. ALL MACHINED PARTS TO BE AS PER DRAWING AND INSPECTED.
2. NO MACHINE PART MAY EXCEED TOLERANCES UNLESS AGREED UPON BY DRAWING OFFICE.

### 7. INSPECTION:

1. ALL PARTS TO BE INSPECTED BY SUPPLIER AND SIGNED FOR CORRECTNESS BEFORE DELIVERY.
2. ALL PARTS TO BE INSPECTED BY MUTUAL RECEIVING STORE AND SIGNED FOR CORRECTNESS BEFORE PARTS MAY BE ISSUED TO FACTORY.
3. ALL PRODUCTS TO BE INSPECTED BY FACTORY BEFORE PAINT JOB.

### 8. COSMETICS:

1. ITEM TO BE WASHED WITH ACID TO PREVENT OIL BUILD-UP, WIPED WITH THINNERS, BODY PUTTIED TO ENSURE FLAT SURFACE AND THEN WIPED WITH THINNERS AGAIN.
2. SPRAYED WITH 3 COTES OF GREY PRIMER
3. SPRAYED WITH REQUESTED COLOUR
4. PART TAGS WITH SERIAL NUMBERS TO BE FITTED TO FINNISH OFF.

**IF IN DOUBT ASK!!!**

STATUS	DESCRIPTION
A	PRODUCT APPROVED AND READY FOR MASS PRODUCTION
B	PRODUCT STILL IN DESIGN PHASE, NO MASS PRODUCTION.
C	PRODUCT CANCELLED AND MUST BE ARCHIVED
TOTAL WEIGHT (INCL. CONCRETE): 300 kg	
PART SQUARE SIZE N/A x N/A	
DIRECTORY: Z:\1. MUTUAL PRODUCTION\1. PRODUCTS\11.DS DOORS\7. DS 100\2. DS100E\2. DS100E-RH-STD\REV-01\1. INVENTOR\1. ASSEMBLIES\DS100E-RH-A-00.iam	

## SPECIAL NOTES:

# MUTUAL

Safe & Security (Pty) Ltd



POSTAL ADDRESS: P.O BOX 35641, MENLO PARK 0102 PRETORIA SOUTH AFRICA  
TEL: +27-12-803 6051  
FAX: +27-12-803 6094  
E-MAIL: mutualsafes@global.co.za  
INTERNET: www.mutual.co.za

MUTUAL SAFE & SECURITY (PTY) Ltd. GROUP

THE INFORMATION CONTAINED IN THIS DRAWING AND ALL THE INFORMATION THEREON IS THE SOLE PROPERTY OF MUTUAL SAFE & SECURITY (PTY) Ltd. GROUP. ANY PRODUCTION IN PART OR AS A WHOLE, WITHOUT THE THE WRITTEN PERMISSION OF MUTUAL SAFE & SECURITY (PTY) Ltd. GROUP, IS PROHIBITED.

TITLE

**EMERGENCY VAULT DOOR**

**DS100 CAT3**

VENDOR DRG. NO.

DS100C3-E

DRAWING NUMBER

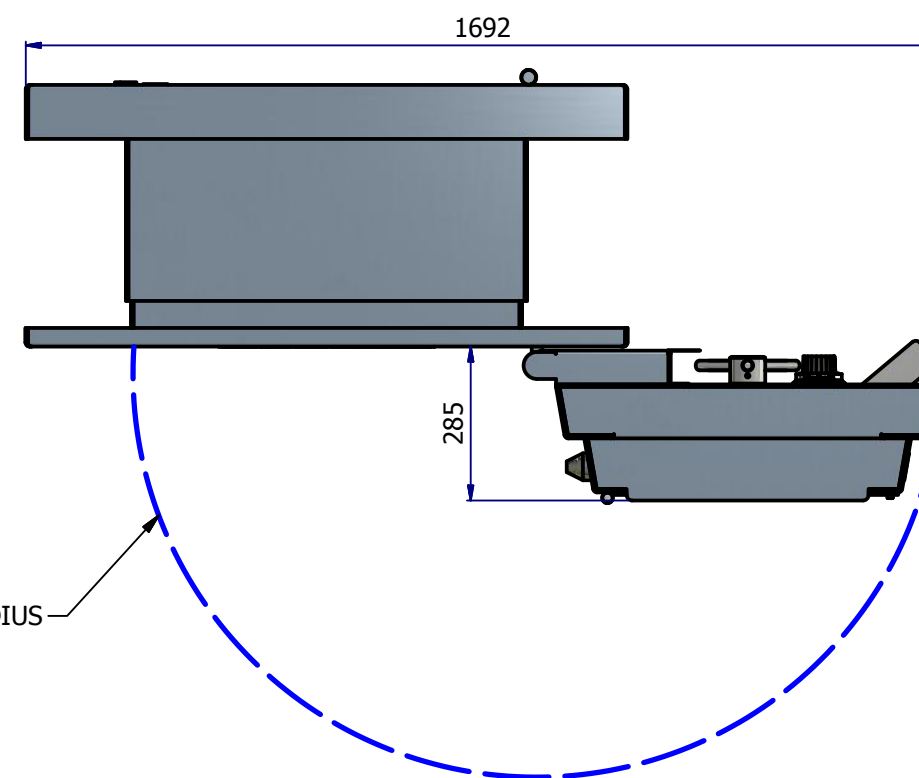
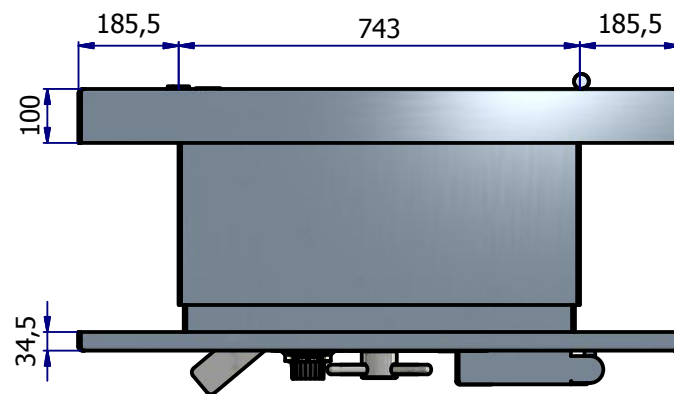
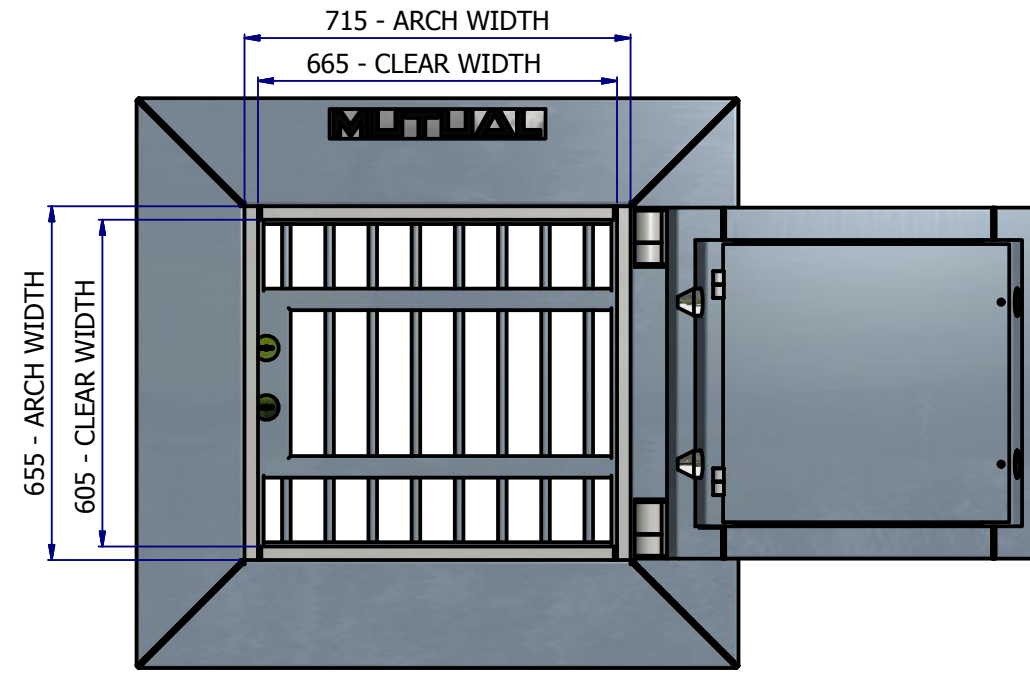
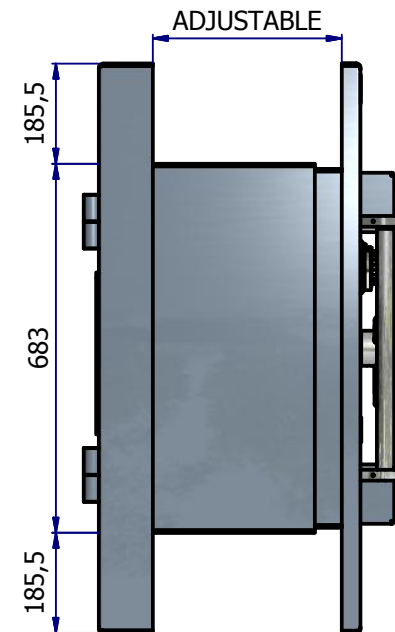
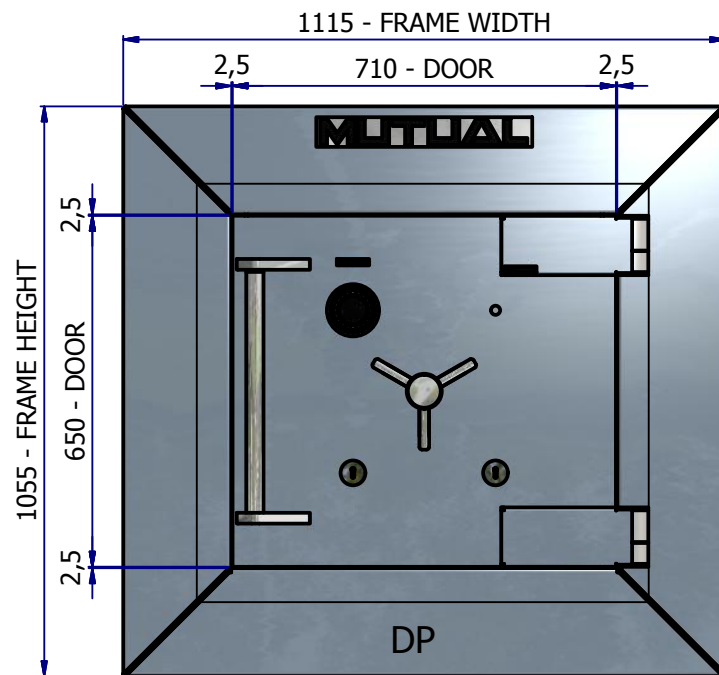
DS100E-RH-A-00

REV	DESCRIPTION	DATE	BY
01	A-01	2016/03/24	AV

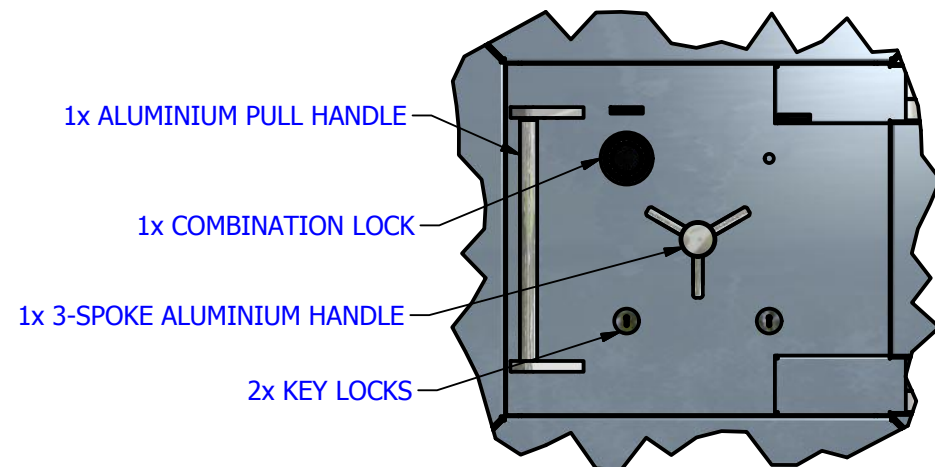
PAGE No. :	1 / 33	SCALE: N.T.S	<b>A3</b>
PROCESS:	ASSEMBLY		

DESIGNER:	AV	DATE:	2016/03/24
CHECKED BY:	AV	DATE:	2016/03/24
ENGINEER:	AV	DATE:	2016/03/24
MANAGER:	NDV		
PART No.:	DS100E-RH-A-00		
MATERIAL:	CATEGORY 3		
QTY PER UNIT:	AS PER ORDER		

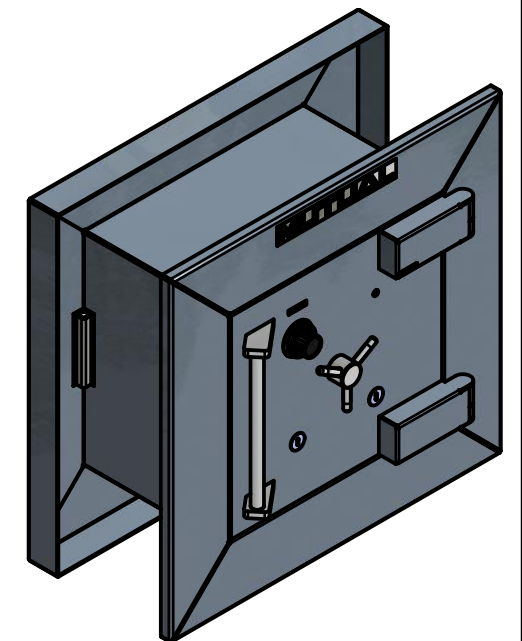
	REV	01	STATUS	<b>A</b>
--	-----	----	--------	----------



**DET DP**  
TYPICAL LOCK ORIENTATION DETAIL



R747 TURNING RADIUS



# CAT3

## DS 100 RH

### EMERGENCY VAULT DOOR

#### PRODUCT SPECS:

- CAT5 EMERGENCY DOOR:**  
 -100mm THICK  
 -4x Ø50 CHROMED LOCK BOLTS  
 -2x Ø50 FIXED DOG BOLTS  
 -2x KEY LOCKS AND 1x 3WHEEL COMBINATION LOCK  
 -2x LIVE RELOCKERS

**MUTUAL**  
 Safe & Security (Pty) Ltd

