

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): 2000 kg	
PART SQUARE SIZE N/A x N/A	
DIRECTORY: Z:\1. MUTUAL PRODUCTION\1. PRODUCTS\11.DS DOORS\9. DS 250\3.DS250 2 IN 1\2. DS250-2IN1-RH-STD\REV-02\1. INVENTOR\1. ASSEMBLIES\DS250-2IN1-RH-A-00.iam	

SPECIAL NOTES:

MUTUAL

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MUTUAL SAFE & SECURITY (PTY) Ltd. GROUP

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TITLE

2 IN 1 VAULT DOOR

DS250 CAT5

VENDOR DRG. NO.

DS250C5-2IN1

DRAWING NUMBER

DS250-2IN1-RH-A-00

REV	DESCRIPTION	DATE	BY
02	A-01	2017/04/11	AV

PAGE No. :	1 /89	SCALE: N.T.S	A3
PROCESS:	ASSEMBLY		

DESIGNER:	AV	DATE:	2017/04/11
CHECKED BY:	AV	DATE:	2017/04/11
ENGINEER:	AV	DATE:	2017/04/11
MANAGER:	NDV		
PART No.:	DS250-2IN1-RH-A-00		
MATERIAL:	CATEGORY 5		
QTY PER UNIT:	AS PER ORDER		

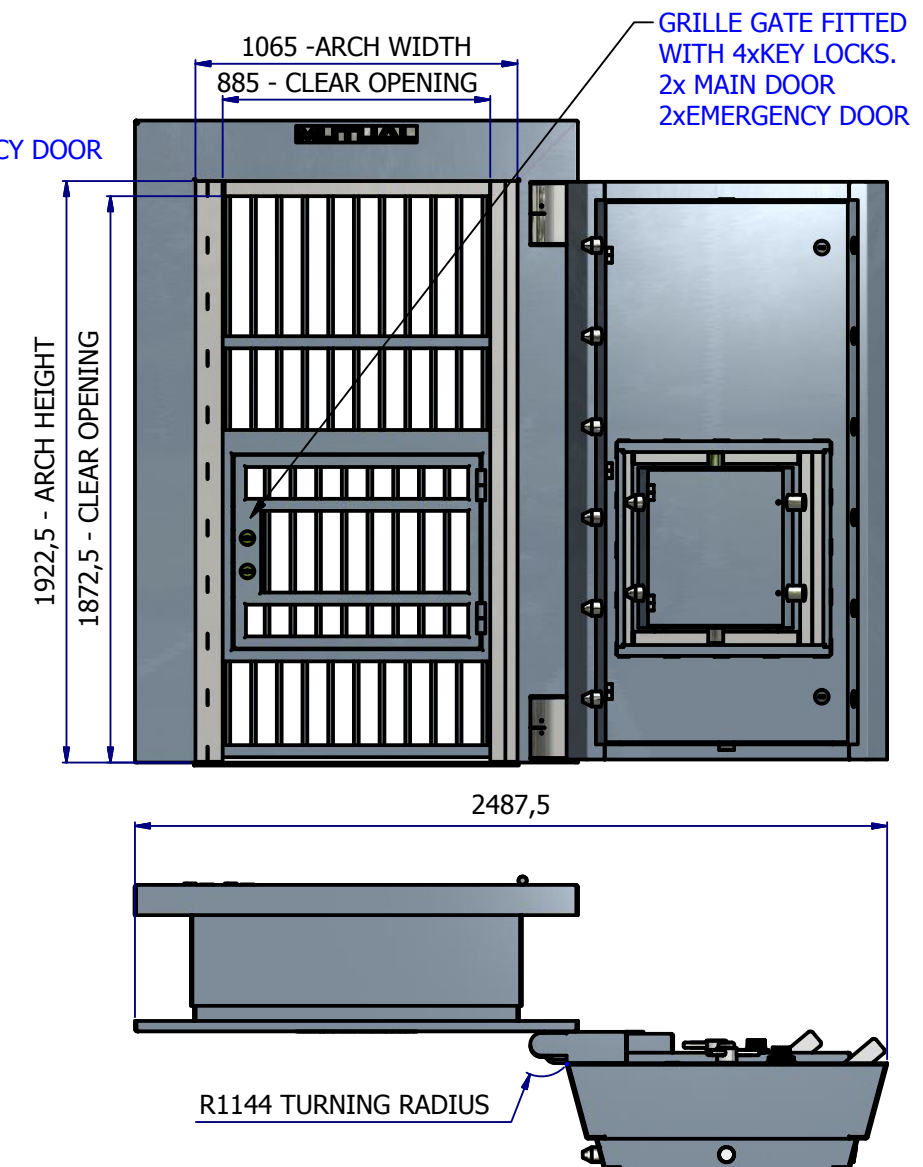
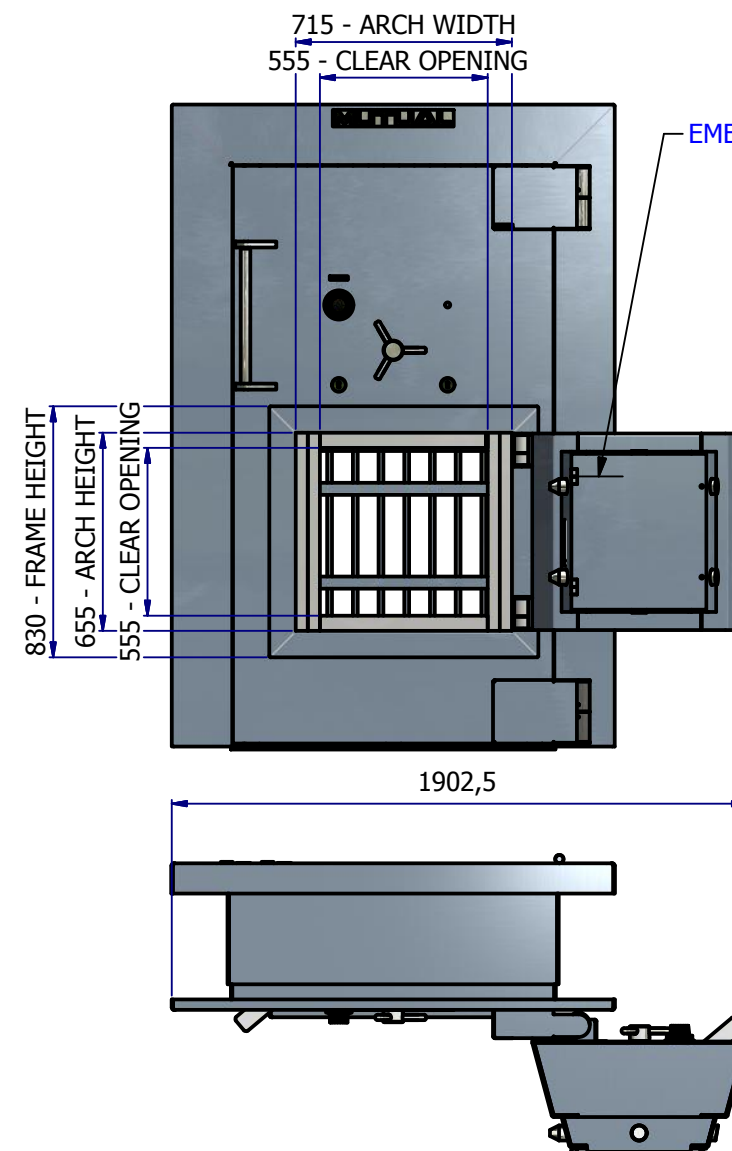
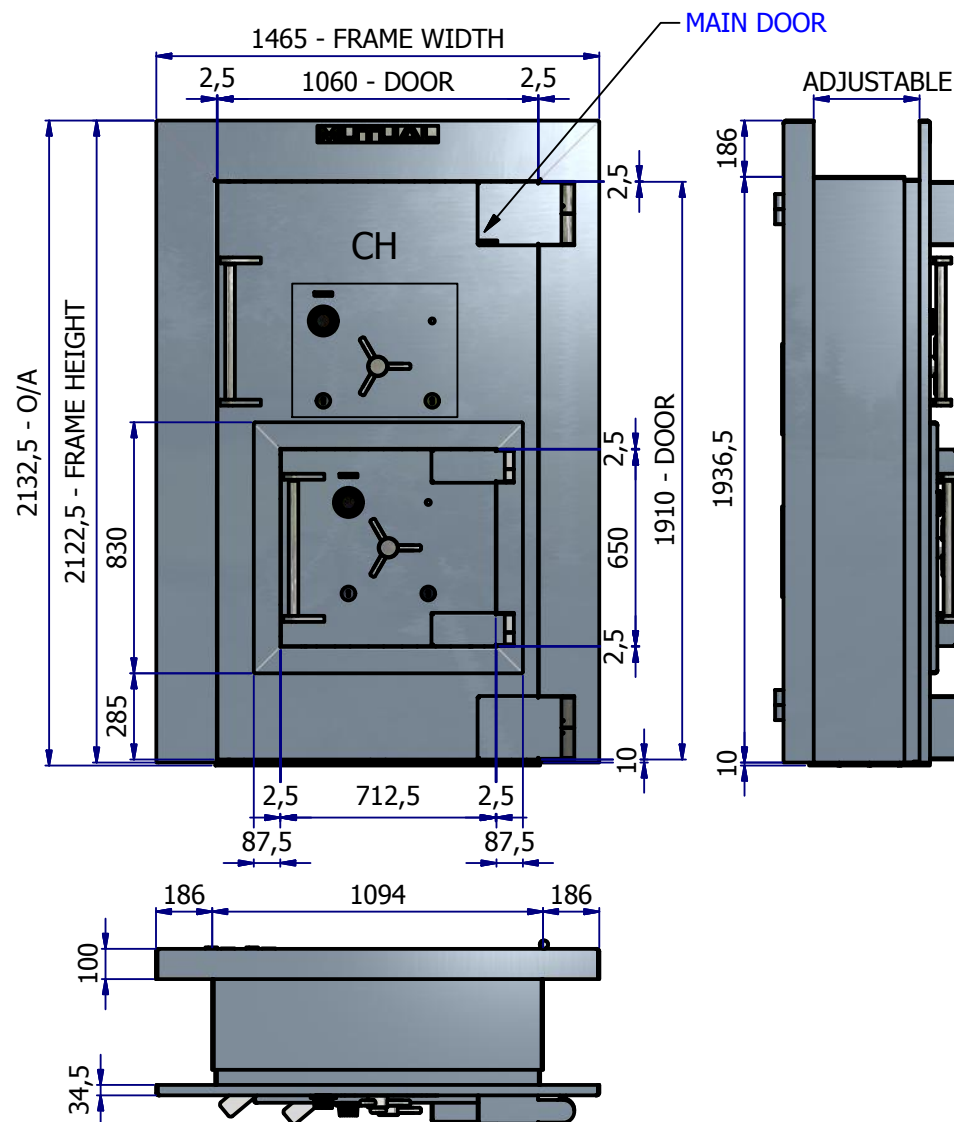


REV

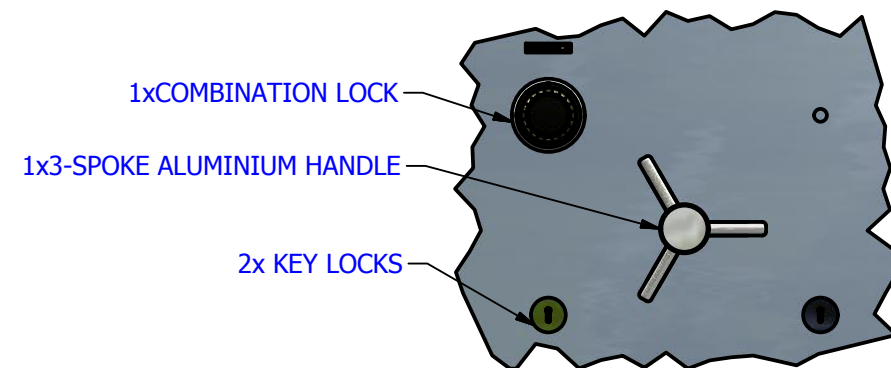
02

STATUS

A



DET CH
TYPICAL LOCK ORIENTATION DETAIL



CAT5

DS250 2IN1 RH

VAULT DOOR

PRODUCT SPECS:

CAT 5 MAIN DOOR:

- 250mm THICK
- 8x Ø50 CHROMED LOCK BOLTS
- 6x Ø50 FIXED DOG BOLTS
- 2x KEY LOCKS AND 1x 3WHEEL COMBINATION LOCK
- 2x LIVE RELOCKERS

CAT5 EMERGENCY DOOR:

- 250mm THICK
- 4x Ø50 CHROMED LOCK BOLTS
- 2x Ø50 FIXED DOG BOLTS
- 2x KEY LOCKS AND 1x 3WHEEL COMBINATION LOCK
- 2x LIVE RELOCKERS

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