



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. ALL SAFES (WHERE NEEDED) TO BE FILLED WITH 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 WEIGHT241.096 kg	
PART SQUARE SIZEN/A x N/A	
DIRECTORY:Z:\1. MUTUAL PRODUCTION\1. PRODUCTS\15. ANTI BANDID DOORS\1. WITH VIEW PORT\1. G1 DOOR\2. G1-RH DOOR\REV-00\1. INVENTOR\1. ASSEMBLIES\G1-ABD-RH-VP-A-00.iam	

SPECIAL NOTES:

MUTUAL

Safe & Security (Pty) Ltd



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MUTUAL SAFE & SECURITY (PTY) Ltd. GROUP

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TITLE

ANTI BANDID DOOR-RH

G1

VENDOR DRG. NO.

G1-ABD-RH-VP

DRAWING NUMBER

G1-ABD-RH-VP-A-00

REV	DESCRIPTION	DATE	BY
00	MODEL	2017/05/25	AV

PAGE No. :	1 / 2	SCALE: N.T.S	A3
PROCESS:	ASSEMBLY		

DESIGNER:	AV	DATE:	2017/05/25
CHECKED BY:	AV	DATE:	2017/05/25
ENGINEER:	AV	DATE:	2017/05/25
MANAGER:	NDV		
PART No.:	G1-ABD-RH-VP-A-00		
MATERIAL:			
QTY PER UNIT:	AS PER ORDER		

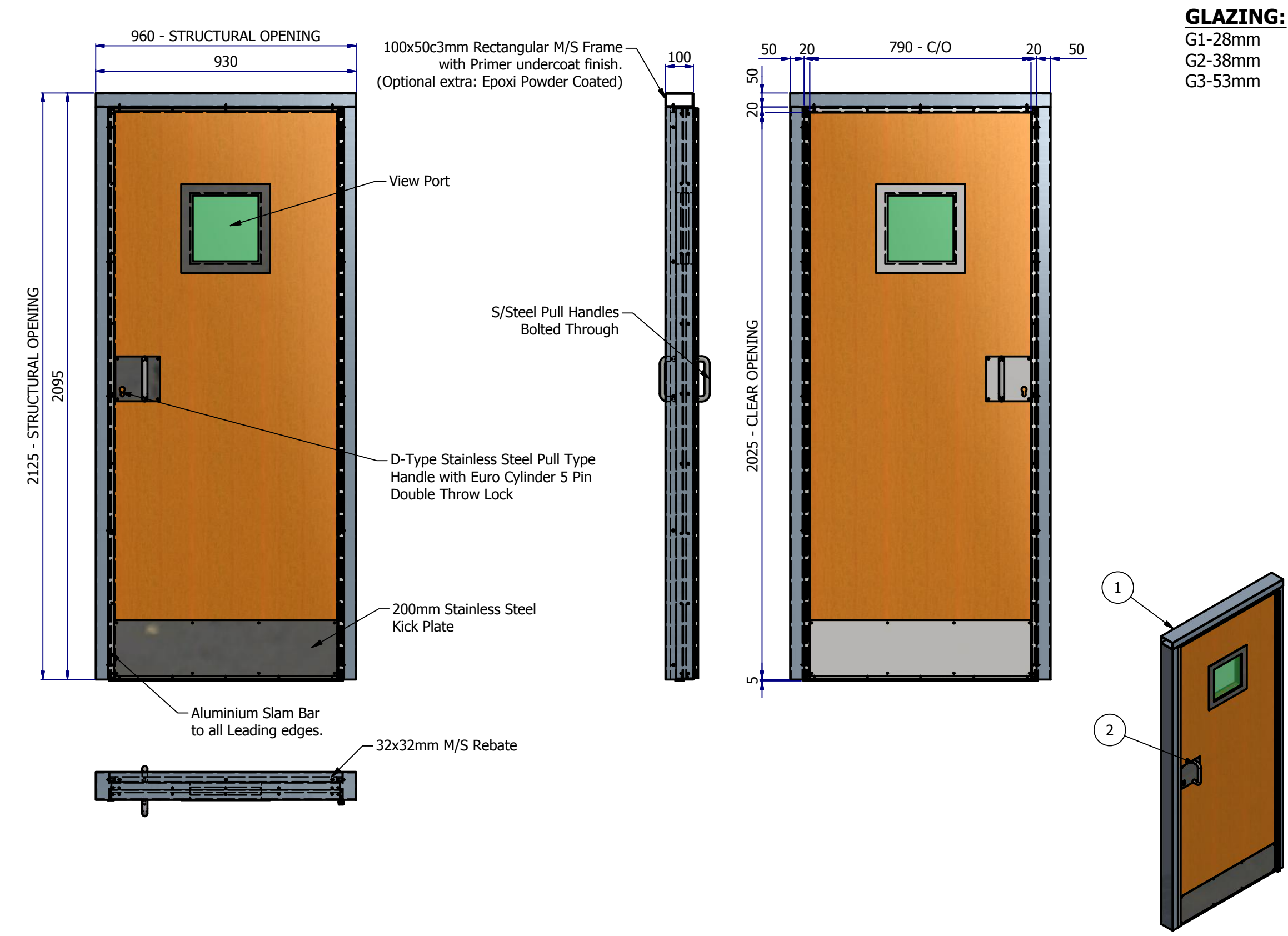


REV

00

STATUS

A



GLAZING:
G1-28mm
G2-38mm
G3-53mm

MUTUAL

Safe & Security (Pty) Ltd

SABS

SABS ISO 9001

UL

VdS getest

AGIC

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00	MODEL	2017/05/25	AV

PAGE No. : 2 / 2

SCALE: N.T.S

A3

PROCESS: ASSEMBLY

DESIGNER: AV

DATE: 2017/05/25

CHECKED BY: AV

DATE: 2017/05/25

ENGINEER: AV

DATE: 2017/05/25

MANAGER: NDV

PART No.: G1-ABD-RH-VP-A-00

MATERIAL:

QTY PER UNIT: AS PER ORDER

REV 00

STATUS A

STATUS	DESCRIPTION
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PART SQUARE SIZE N/A x N/A	
DIRECTORY: Z:\1. MUTUAL PRODUCTION\1. PRODUCTS\15. ANTI BANDID DOORS\1. WITH VIEW PORT\1. G1 DOOR\2. G1-RH DOOR\REV-00\1. INVENTOR\1. ASSEMBLIES\G1-ABD-RH-VP-A-00.iam	

BILL OF MATERIALS				
ITEM	QTY	PART NUMBER	DRAWING NUMBER	PROCESS
1	1	G1-ABD-RH-VP-A-01-FRAME	G1-ABD-RH-VP-A-01	SUB-ASSEMBLY
2	1	G1-ABD-RH-VP-A-02-DOOR	G1-ABD-RH-VP-A-02	SUB-ASSEMBLY
3	1	G1-ABD-RH-VP-A-03-HINGE	G1-ABD-RH-VP-A-03	SUB-ASSEMBLY

SPECIAL NOTES: