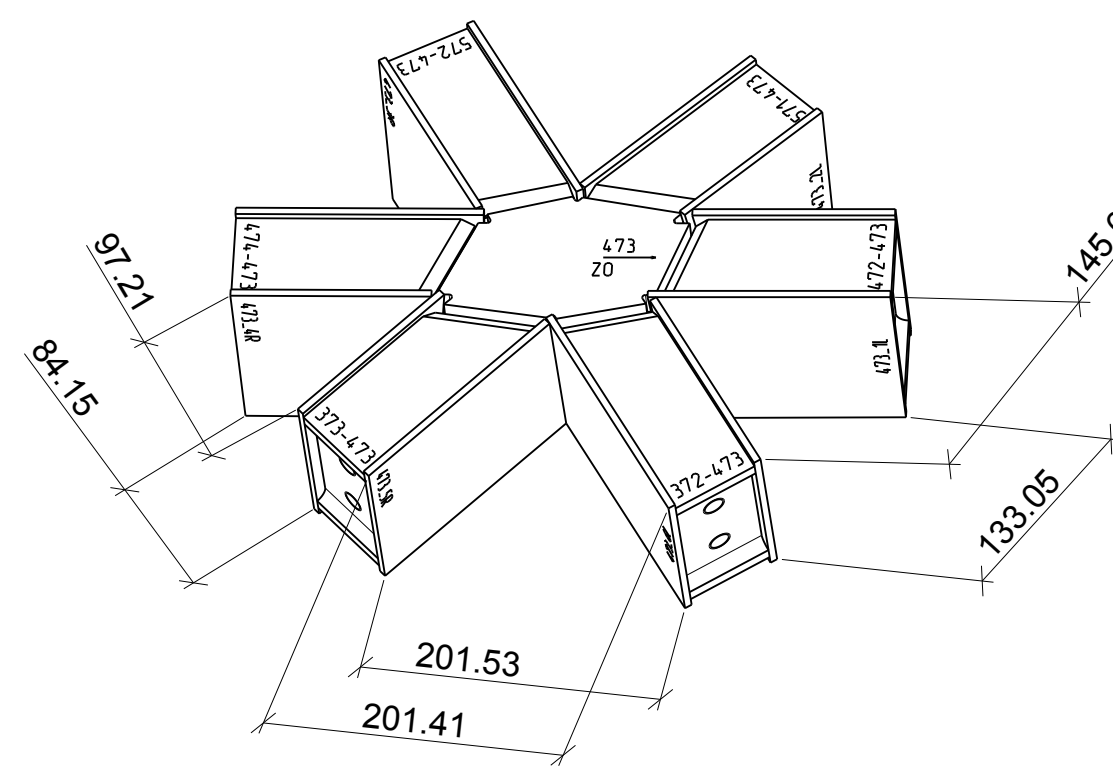
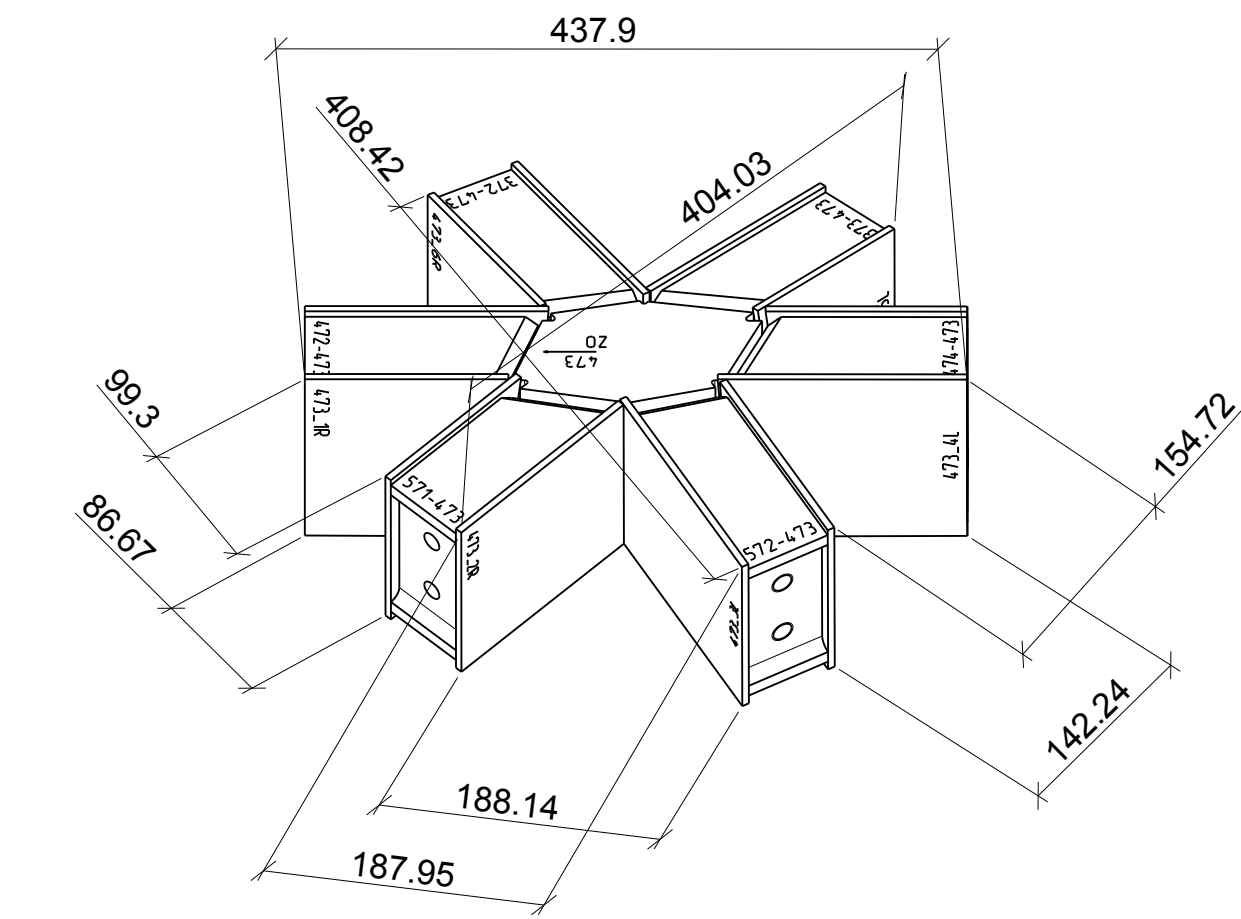


Position No.:	473	No. of Pieces:	
Material:	S355		
Surface:	coated RAL 7032 (0.458 m ²)		
	▽ = visible surface		
	▽▽ = Primer Coat between nodes and beams		
Tolerance:	according to schedule		
Weight/Piece:	36.31 kg		
Notes:	-		
All edges distorted. Show Position No. on finished item clearly & legible but not on visible surface.			

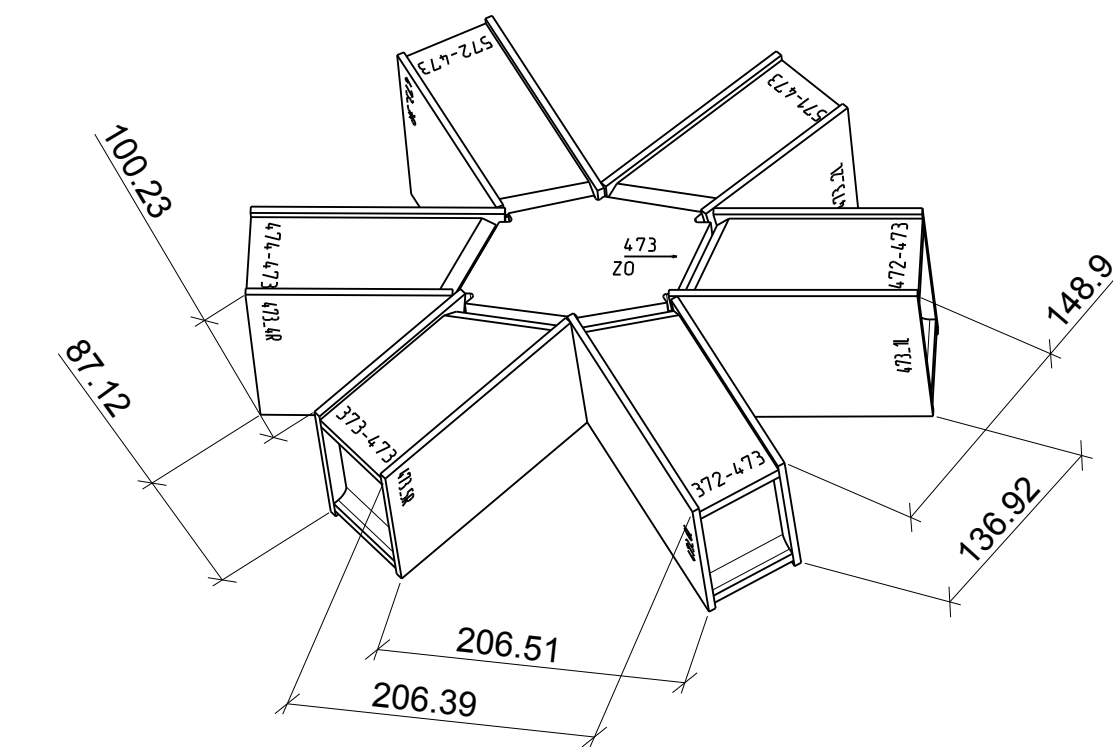
3d view fully machined



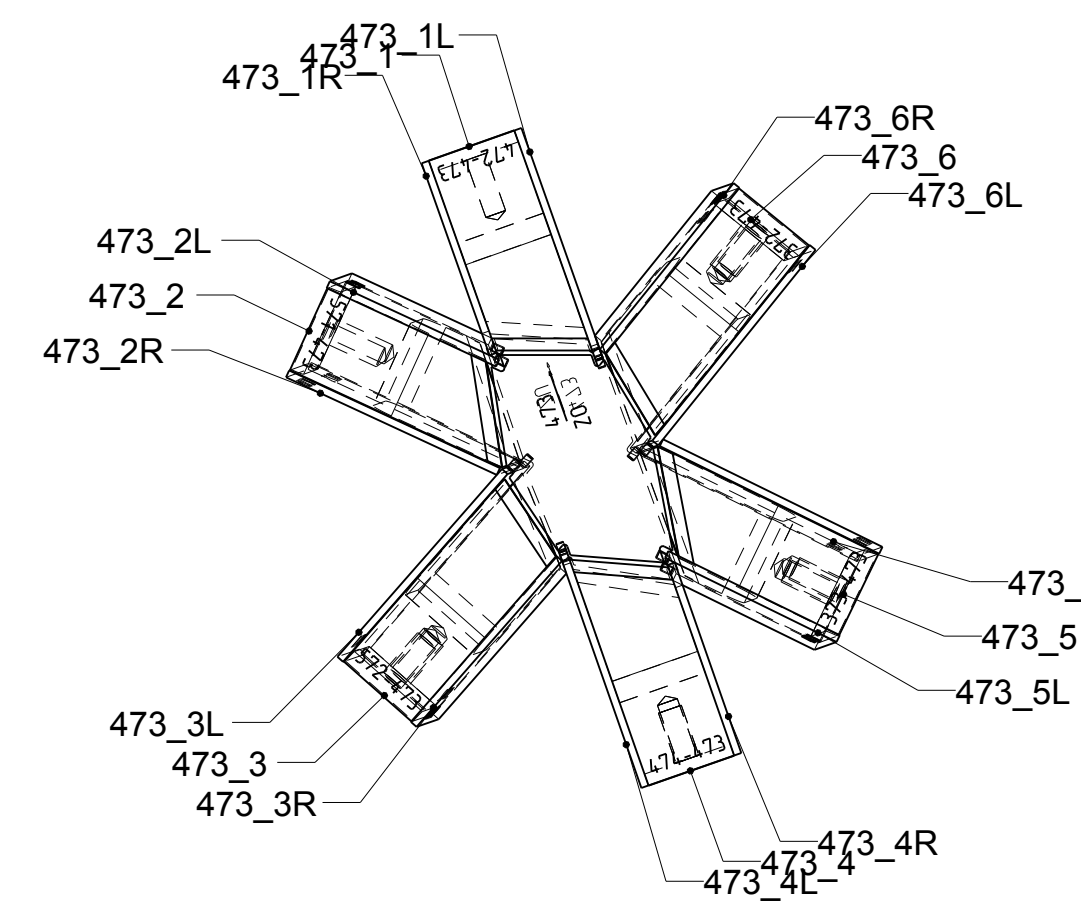
3d view fully machined



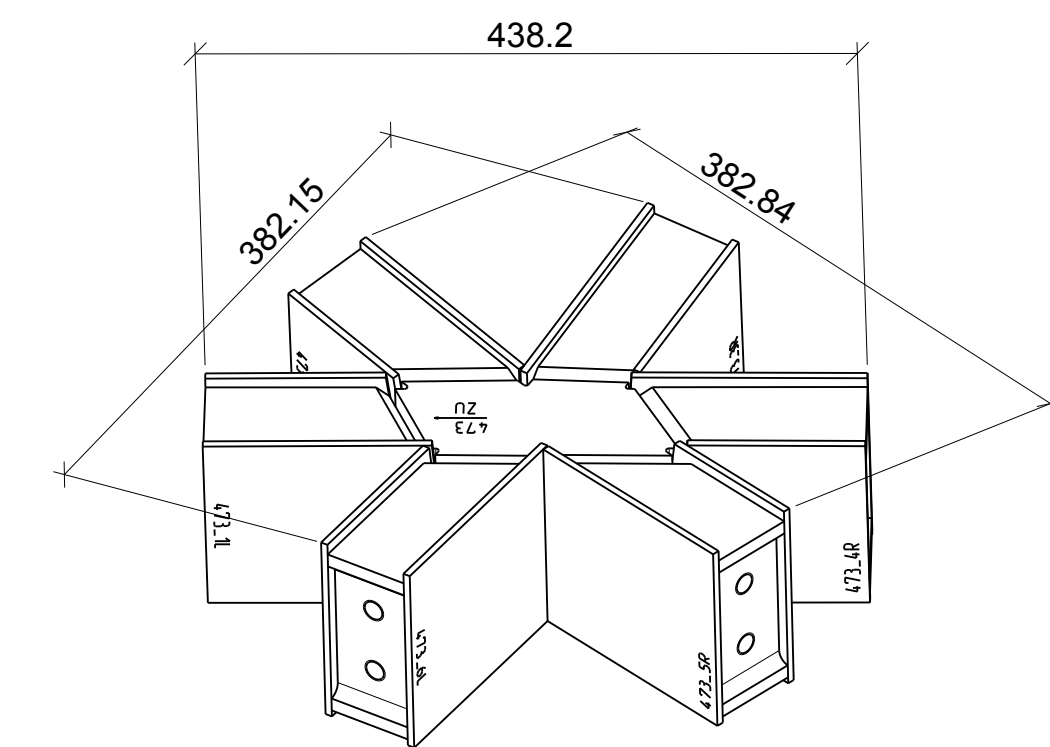
3d view raw part



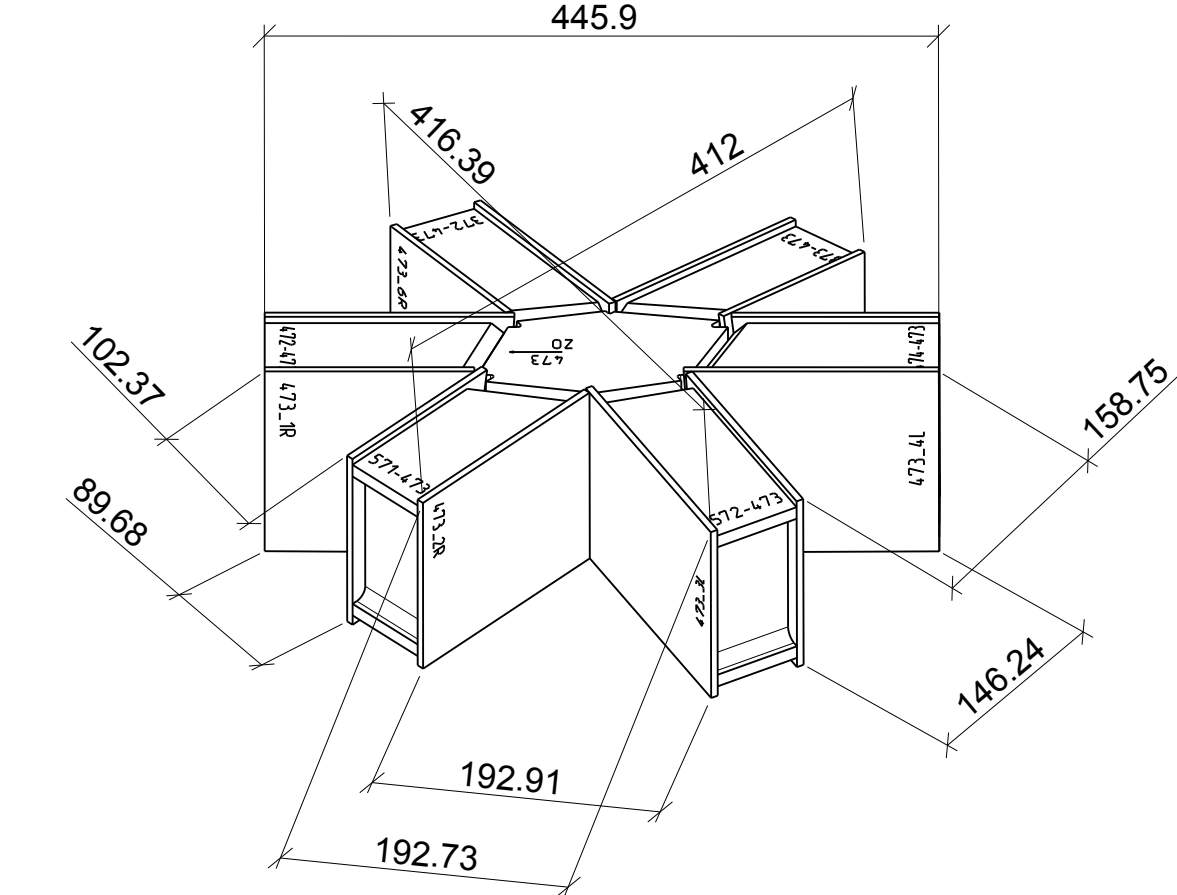
top view upper centralplate



3d view fully machined



3d view raw part

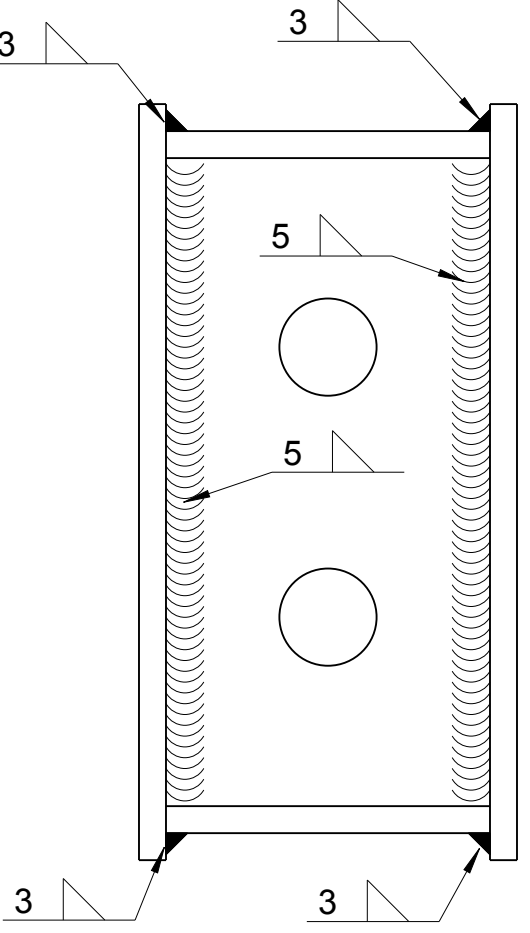


angle for template

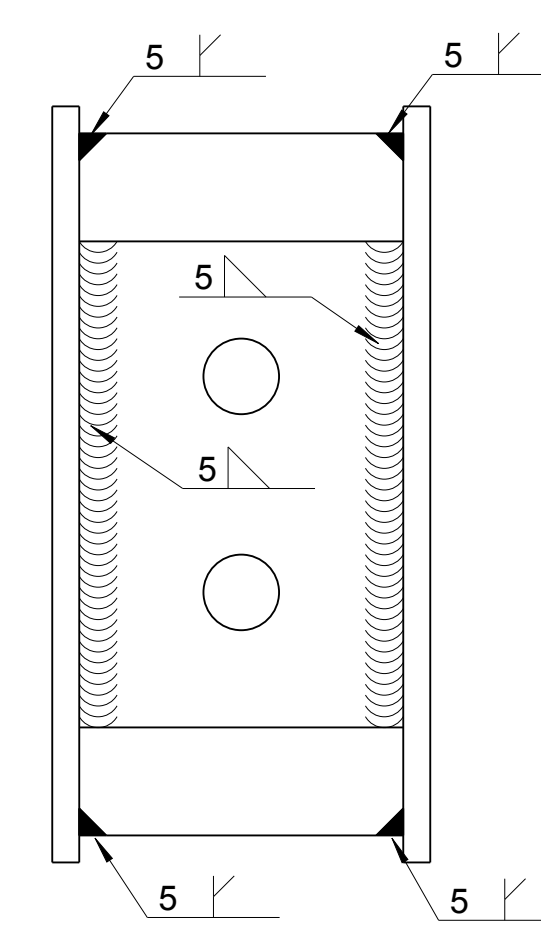
ANGLE 1-2	46.159
ANGLE 2-3	73.305
ANGLE 3-4	60.840
ANGLE 4-5	45.107
ANGLE 5-6	76.974
ANGLE 6-1	58.694

welding specification U-plate and longitudinal weld

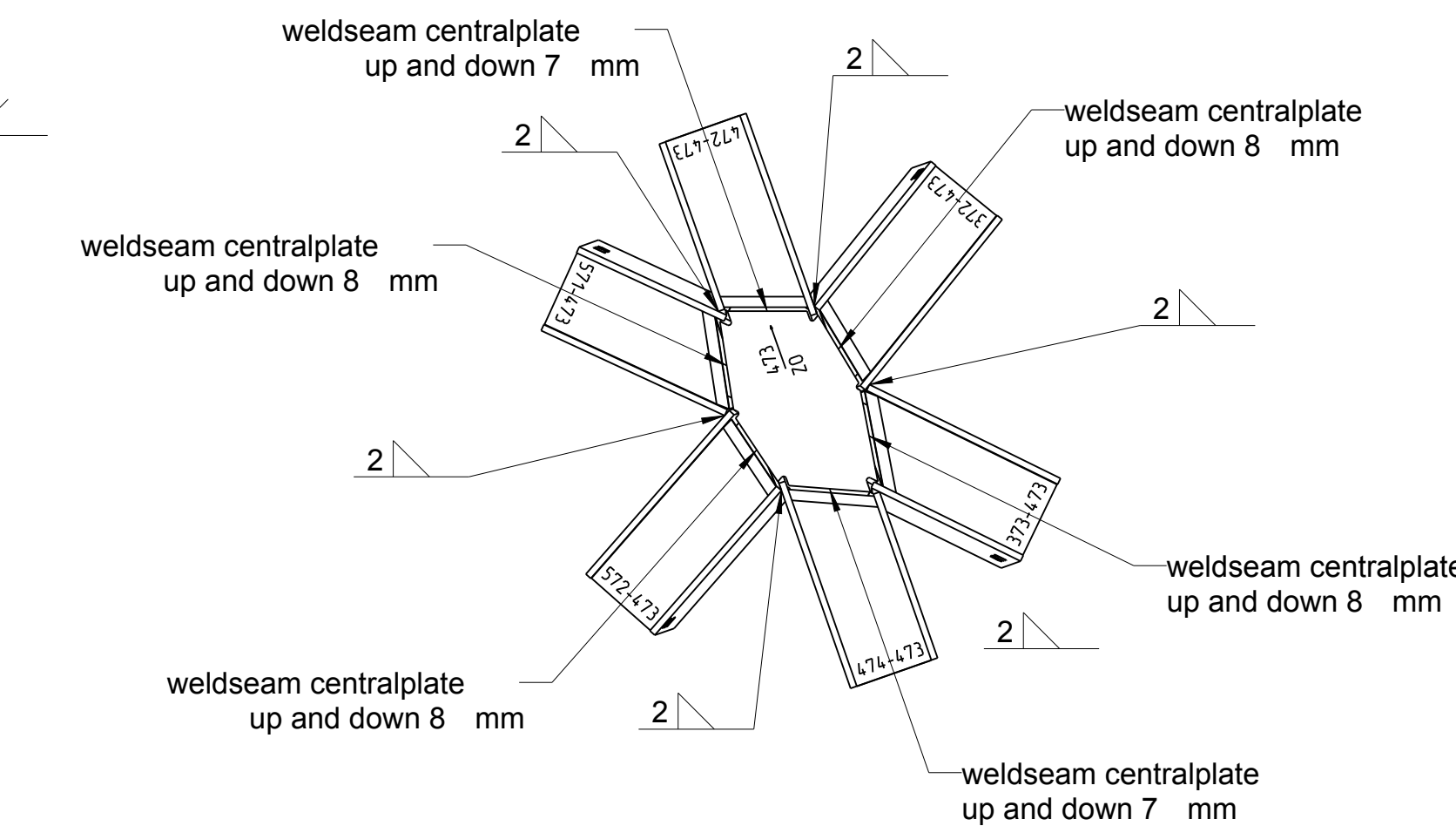
for 5mm and 10mm sheet metal flange



for 20mm and 25mm sheet metal flange



welding specification for central plate



pos.	description	qu. unit	semi-finished product	material	drawing number
1	centralplate down 193x71x20	1	sheet metal 193x71x20	S355	473_ZU
2	centralplate up 170x98x20	1	sheet metal 170x98x20	S355	473_ZO
3	left plate 132x143x5	1	sheet metal 132x143x5	S355	473_2L
4	left plate 134x143x5	1	sheet metal 134x143x5	S355	473_5L
5	left plate 171x143x5	1	sheet metal 171x143x5	S355	473_1L
6	left plate 175x143x5	1	sheet metal 175x143x5	S355	473_4L
7	left plate 178x143x5	1	sheet metal 178x143x5	S355	473_3L
8	left plate 179x143x5	1	sheet metal 179x143x5	S355	473_6L
9	right plate 137x143x5	1	sheet metal 137x143x5	S355	473_4R
10	right plate 139x143x5	1	sheet metal 139x143x5	S355	473_1R
11	right plate 146x143x5	1	sheet metal 146x143x5	S355	473_6R
12	right plate 151x143x5	1	sheet metal 151x143x5	S355	473_3R
13	right plate 158x143x5	1	sheet metal 158x143x5	S355	473_2R
14	right plate 166x143x5	1	sheet metal 166x143x5	S355	473_5R
15	U-plate 98x130x60	1	sheet metal 98x130x60	S355	473_1
16	U-plate 98x130x60	1	sheet metal 98x130x60	S355	473_2
17	U-plate 98x130x60	1	sheet metal 98x130x60	S355	473_3
18	U-plate 98x130x60	1	sheet metal 98x130x60	S355	473_4
19	U-plate 98x130x60	1	sheet metal 98x130x60	S355	473_5
20	U-plate 98x130x60	1	sheet metal 98x130x60	S355	473_6

General geometrical tolerances according EN 22768 (except otherwise noted)

Tolerance class	Tolerance (mm) for nominal size range (mm)							
	0.5 to 3	from 3 to 6	from 6 to 30	from 30 to 120	from 120 to 400	from 400 to 1000	from 1000 to 2000	from 2000 to 4000
m (middle)	± 0.1	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2

Tolerance class	Angular Dimensions				
	Tolerances in angular degree and minutes for nominal size range (mm) at shorter angle leg				
	to 10	from 10 to 50	from 50 to 120	from 120 to 400	over 400
m (middle)	± 1°	± 0° 30'	± 0° 20'	± 0° 10'	± 0° 5'

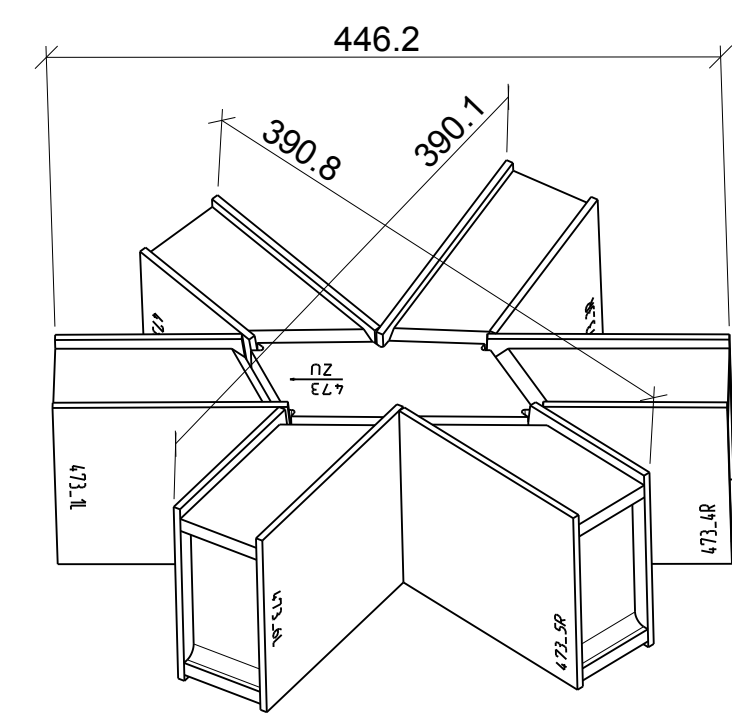
close all crevices with welds to prevent crevice corrosion if not noted close crevice without interfering with outside boundary lines of steel parts

product to be manufactured in accordance with ITP No.: ITP-0321-CA-1-1

Paint system for steel structures

Area	Interior steel structure Facades	
Surface	Steel S355 CORROSION PROTECTION OF MAINSTEEL: BLAST CLEAN TO SA 2½ (EN ISO 12944-4)	
Surface preparation	Application of the sealer coating should be carried out within 4h. In every case, the surface must be clean & dry before the application.	
Coatings in the shop / Application by airless spraying		
Primer Coat	GEHOPON-E24-Primer, E24-102, SAND YELLOW, approx. RAL 1002 binder 2-component epoxy	NDFT 80µm
Primer Coat at surface between nodes and beams	GEHOPON-E35-R Zinc, electrically conducting colour to achieve electrical continuity and allow the pretension forces for the screws	NDFT 40µm
Top (Finish) Coat (▽)	WIEREGEN-M20, M20-F7032, PEBBLE GREY, RAL 7032, GLOSS GRADE 20% binder 2-component polyurethane	NDFT 80µm
Total NDFT		160µm
System fulfils the requirements of the corrosivity category C3, expected durability "High" (more than 15 years) according to EN ISO 12944-5:2007		
Please refer to report 0321-P570-Rep-010 Specification for Steelwork protection system		
Primer Coat at surface between nodes and beams GEHOPON-E35-R Zinc		

3d view raw part



INDEX	REVISION	ISSUE DATE	NAME
-	-	-	-

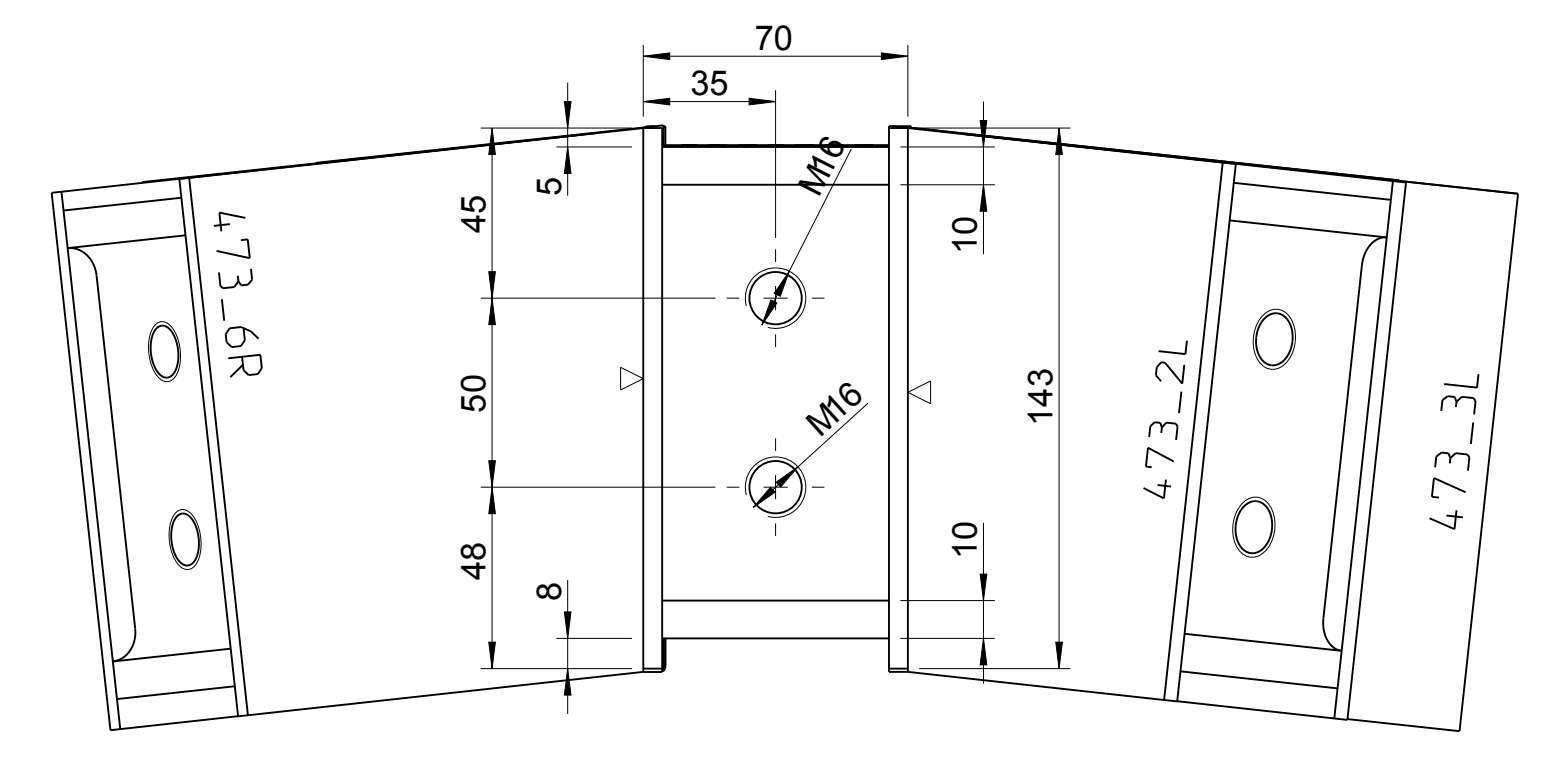
seele austria GmbH & Co. KG | +43 7662 22000-0 | E-Mail: office@seele-austria.com
 Gewerbestraße 2 | Fax: +43 7662 22000-400 | www.seele.com
 A-4861 Schörfling

Project: Cutty Sark Conservation Project | Project-No. 0321
 Main Contractor: Gardiner & Theobald LLP
 Client: Cutty Sark Trust
 Architect: Grimshaw Architects LLP
 Address: Greenwich, London
 Drawing Title: 0321_473
 Scale: 1:5
 Drawn By: brm | Approved: hw | Date: 2011-03-03
 Drawing-No.: 0321-2080-207 | Revision: -

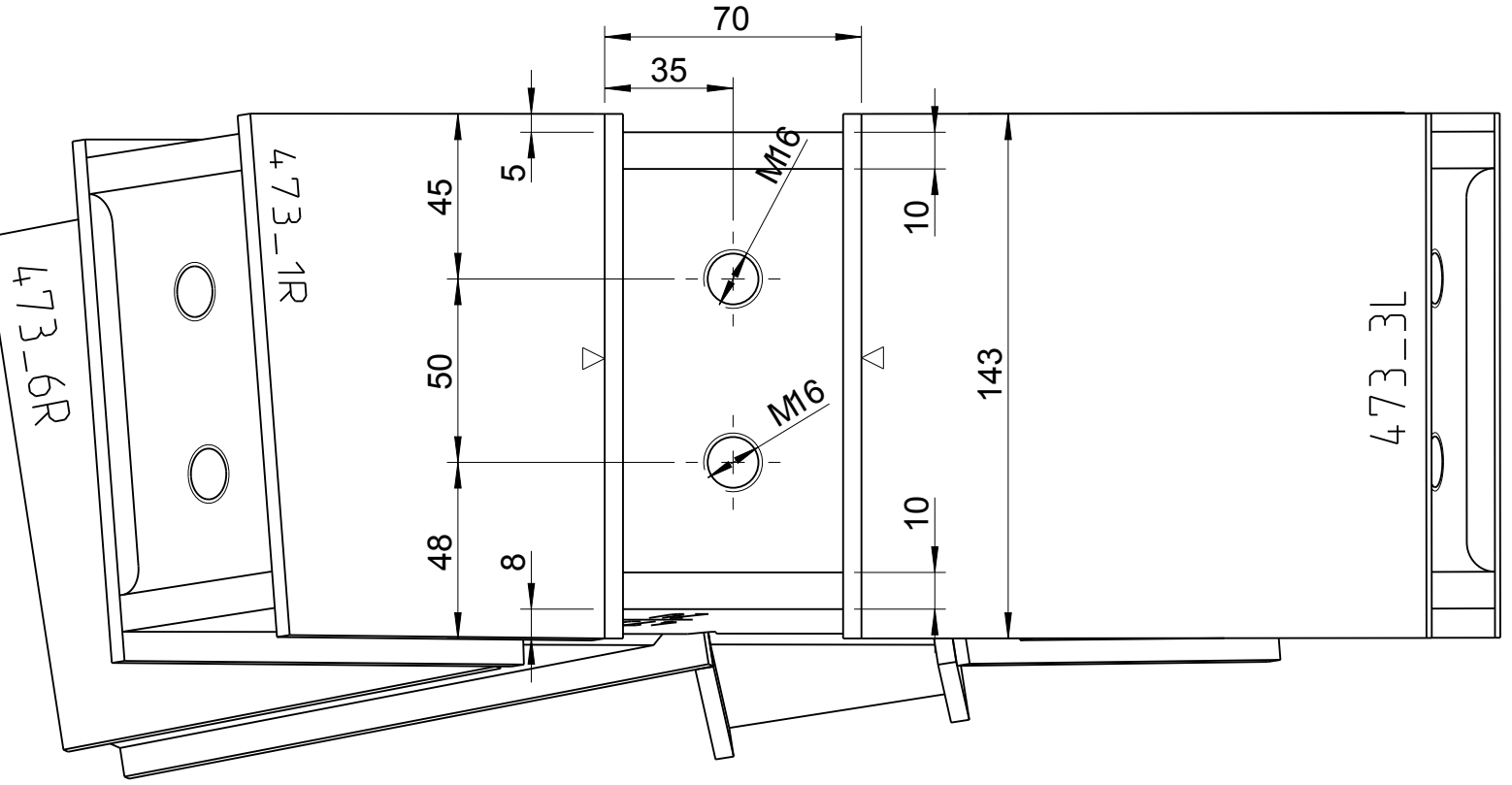
Position No.:	473	No. of Pieces:	
Material:	S355		
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Notes:	-		

All edges deburred.
Show Position No. on finished item clearly & legible but not on visible surface.

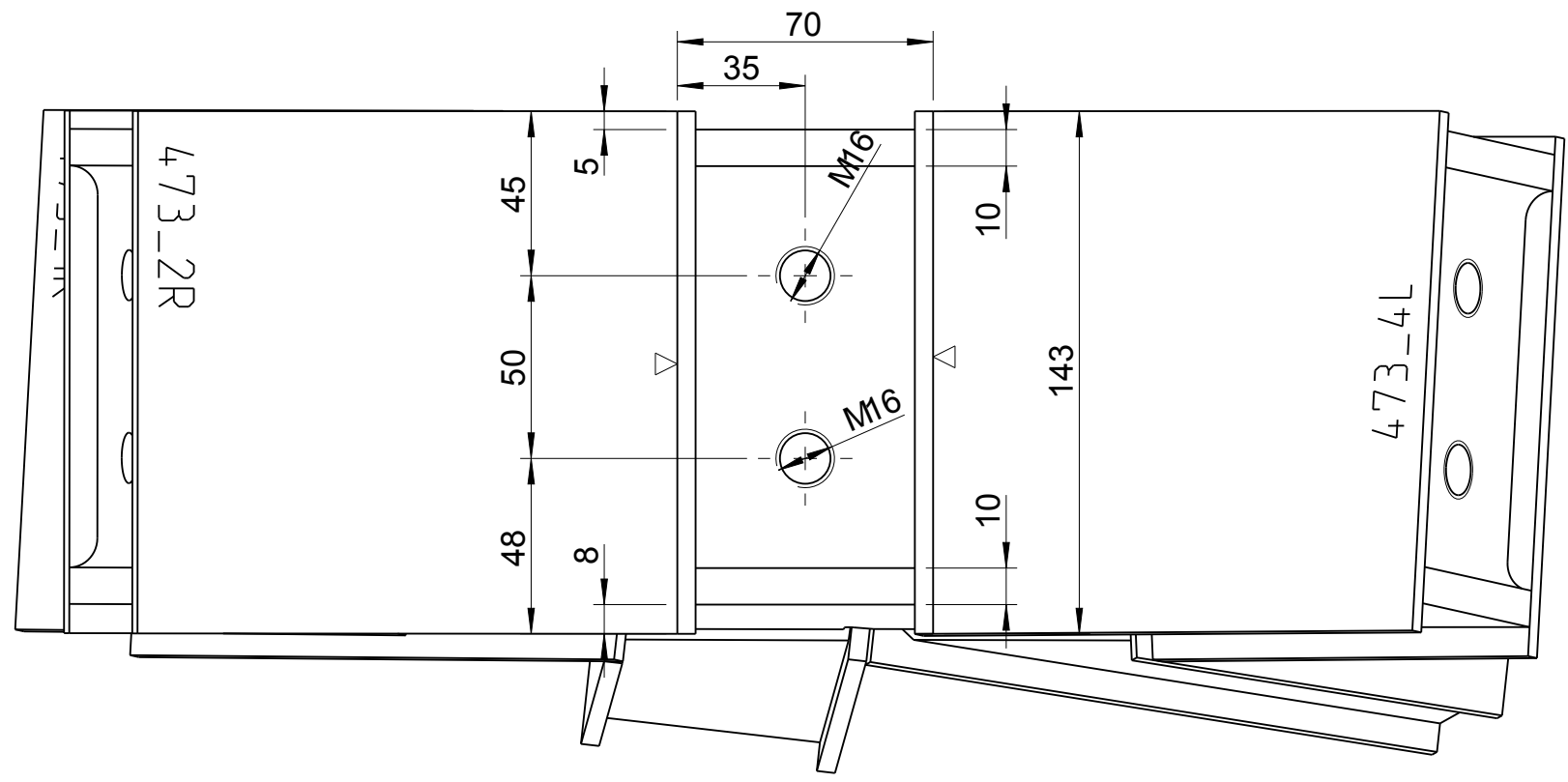
Nodearm 1



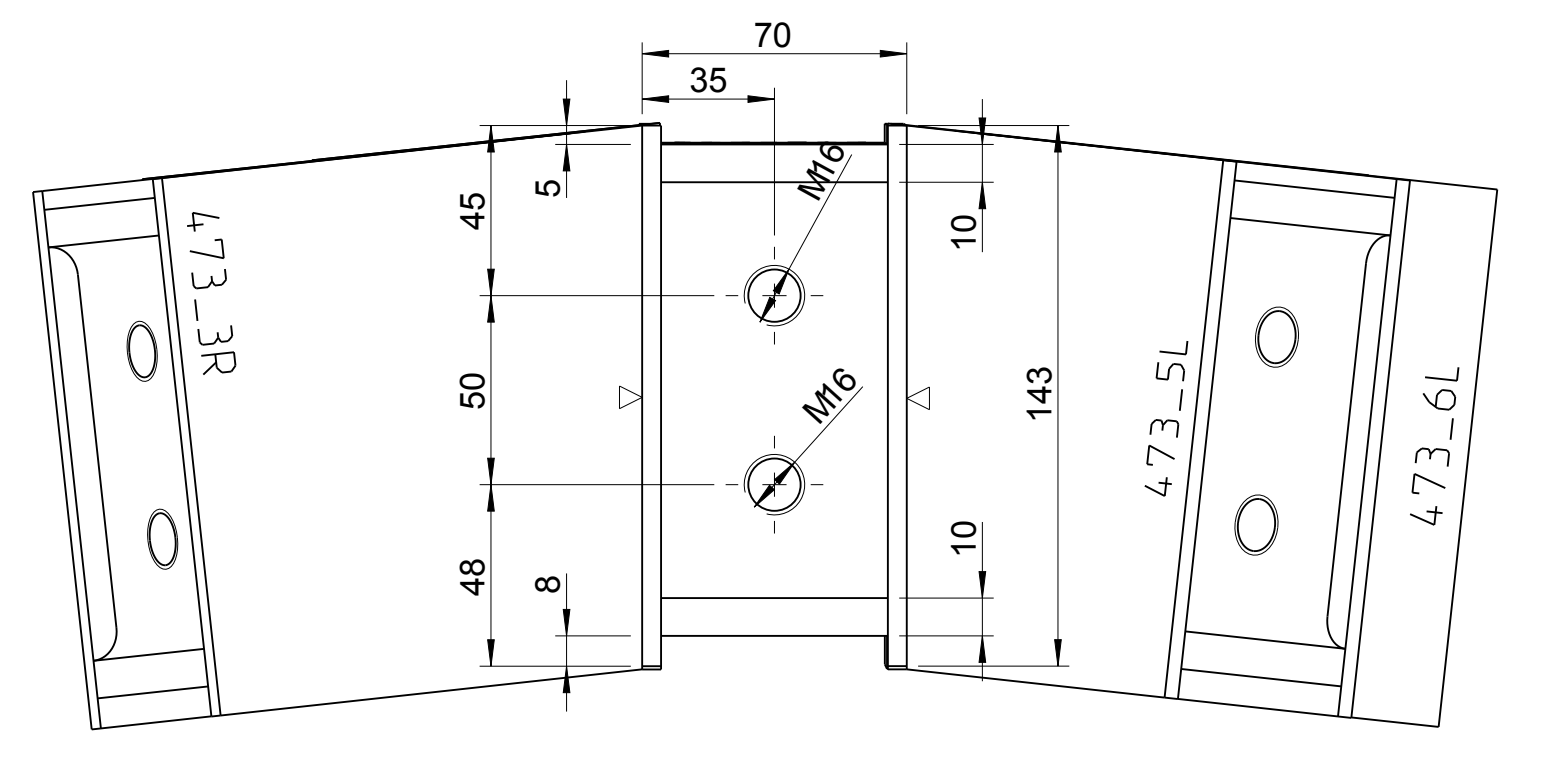
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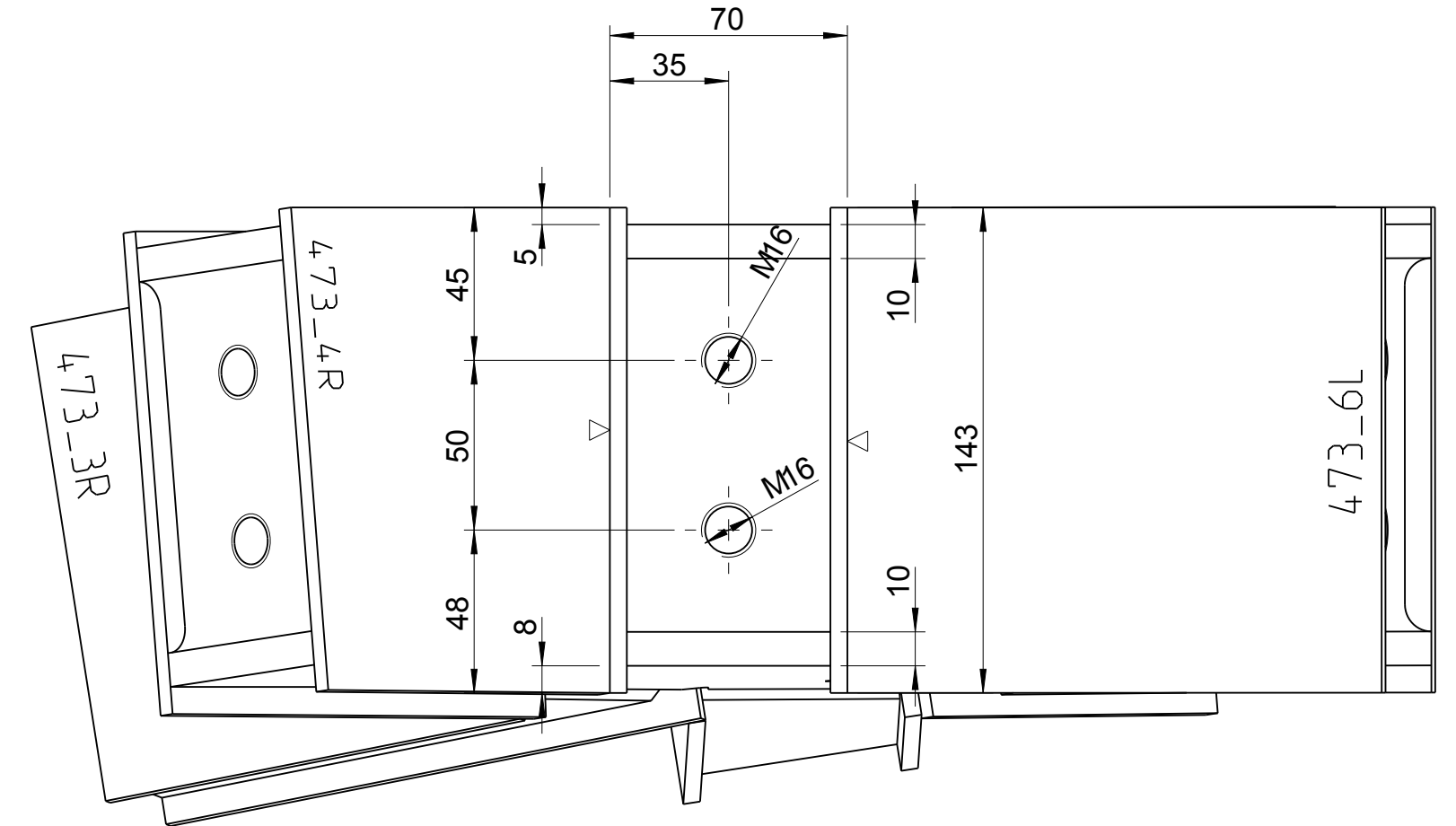
Nodearm 3



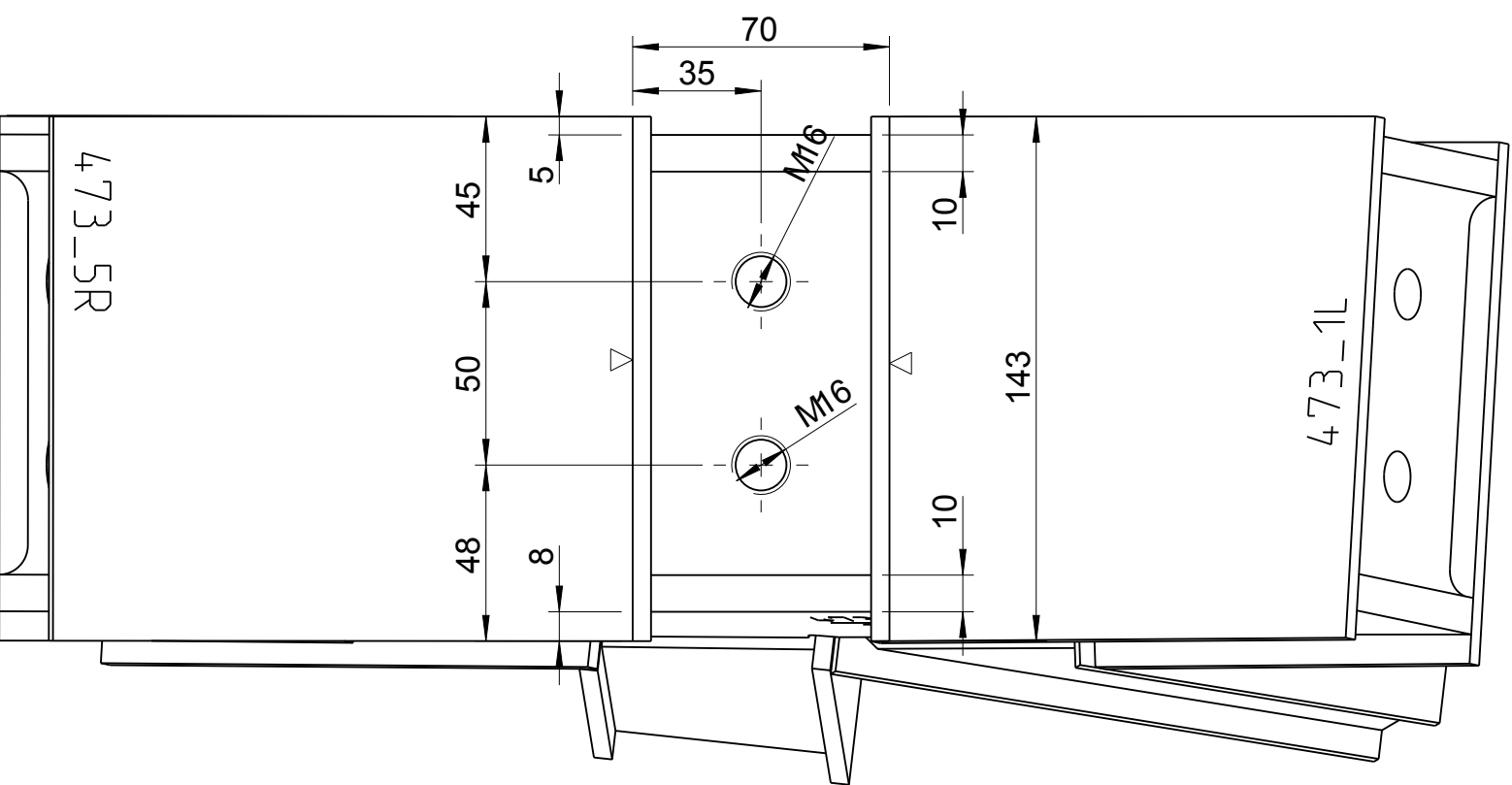
Nodearm 4



Nodearm 5



Nodearm 6



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Total NDFT		160µm

System fulfils the requirements of the corrosivity category C3, expected durability "High" (more than 15 years) according to EN ISO 12944-5:2007

Please refer to report 0321-P570-Rep-010 Specification for Steelwork protection system

Primer Coat at surface between nodes and beams GEHOPON-E35-R Zinc

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seele austria GmbH & Co. KG +43 7662 22000-0 E-Mail: office@seele-austria.com Gewerbepark 2 Fax: +43 7662 22000-400 www.seele.com A-4861 Schörfling			
Project	Cutty Sark Conservation Project	Project-No.	0321
Main Contractor	Gardiner & Theobald LLP		
Client	Cutty Sark Trust		
Architect	Grimshaw Architects LLP		
Address	Greenwich, London		
Drawing Title	0321_473		
		Scale	1:2
Drawn By	brm	Approved	hw
		Date	2011-03-03
Drawing-No.	0321-2080-207	Revision	-