

NOTES:
 ALL THERMOPLASTIC WORK TO BE GENERALLY IN ACCORDANCE WITH FABRICATION AS LAID OUT IN BS EN 1778: 2000 AND BS EN 12573: 2000 PARTS 1 - 4.
 ALL THERMOPLASTIC WELDS TO BE FULL AND 10 MM MIN.
 ALL PIPE WORK TO BE UPVC CLASS E SOLVENT WELDED EXCEPT WHERE INDICATED.

GENERAL CONSTRUCTION
 PVC / GRP - USE 4.5 MM THK. MIN. PVC-U LINER C/W 450 GMS/M2 CHOPPED STRAND MAT AS SPECIFIED.

USE CRYSTIC 2.8500 PA RESIN FOR USE WITH CHOPPED STRAND MAT; MIN. HOT OF 67 DEG.C

VESSEL CONSTRUCTION:
 MAIN SHELL (ABOVE SUMP) 7 x 450 GMS/M2
 SUMP SHELL (CYLINDER) 12 x 450 GMS/M2

SUMP (FLAT) PANELS 12 x 450 GMS/M2
 C/W 50 x 50 x 5 'HYBOX' STIFFENERS OVERLAID WITH 4 x 450 GMS/M2 CSM

ROOF PANEL 10 x 450 GMS/M2
 C/W 50 x 50 x 5 'HYBOX' STIFFENERS OVERLAID WITH 4 x 450 GMS/M2 CSM

FLAT BASE SHOULD COMPRISE 18 MM THICK 'TIMBER' CORE OVERLAID WITH 5 x 450 GMS/M2 'SKINS' BOTH SIDES.

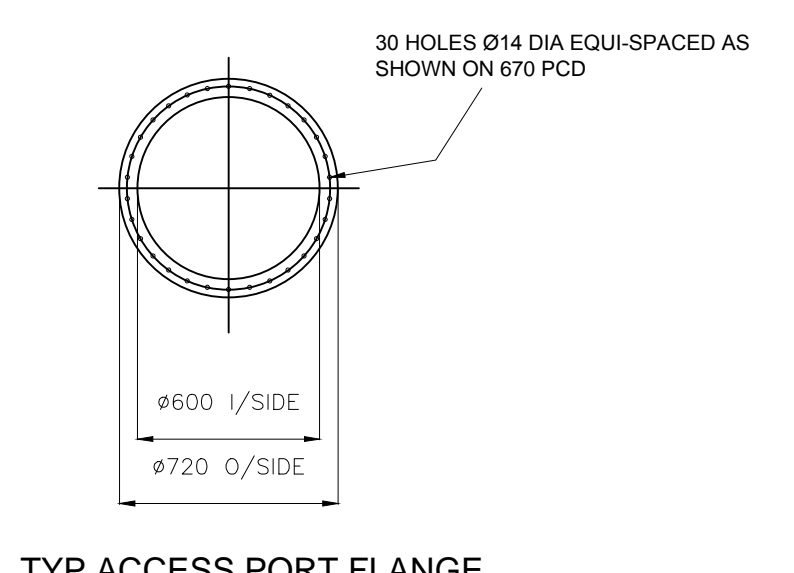
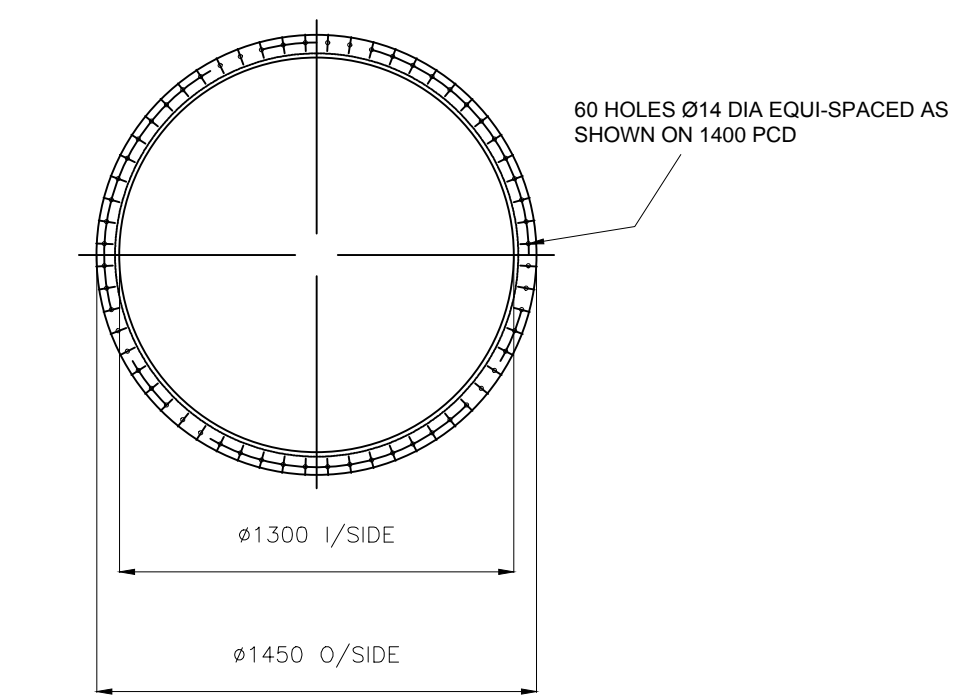
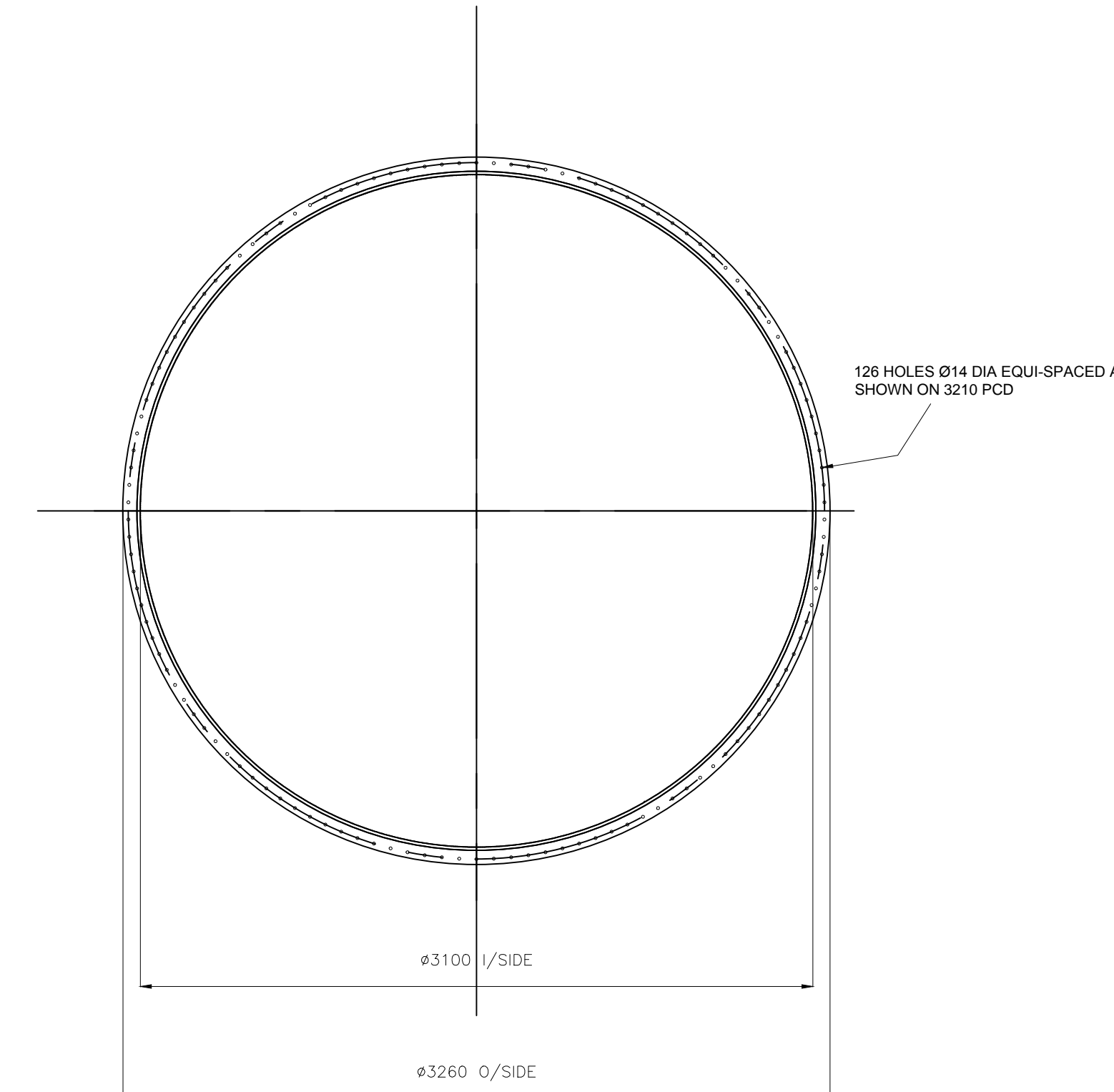
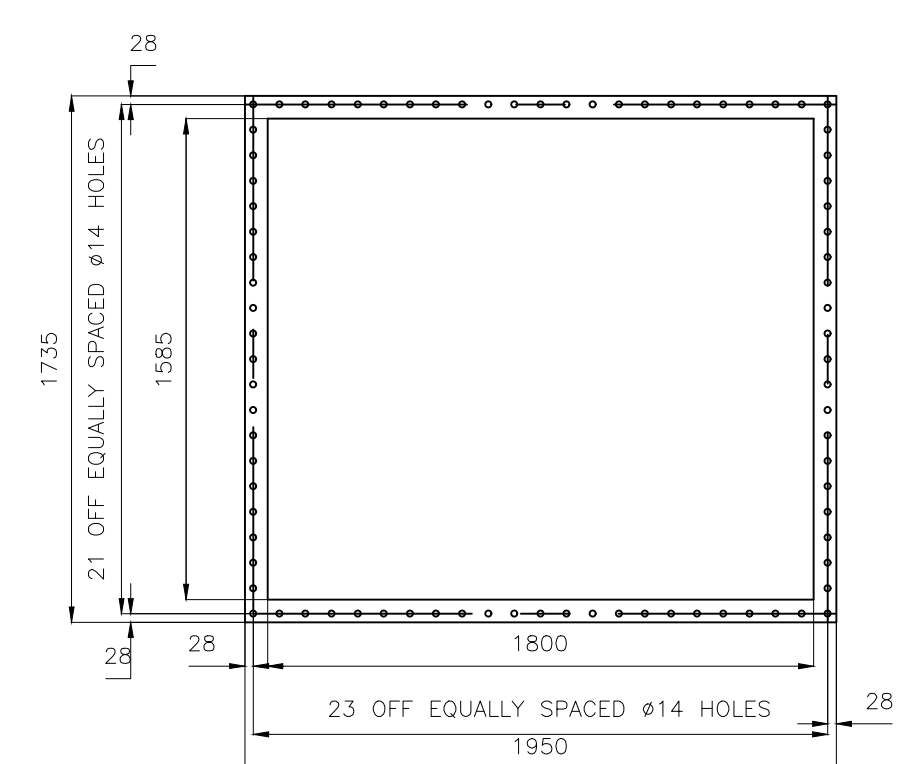
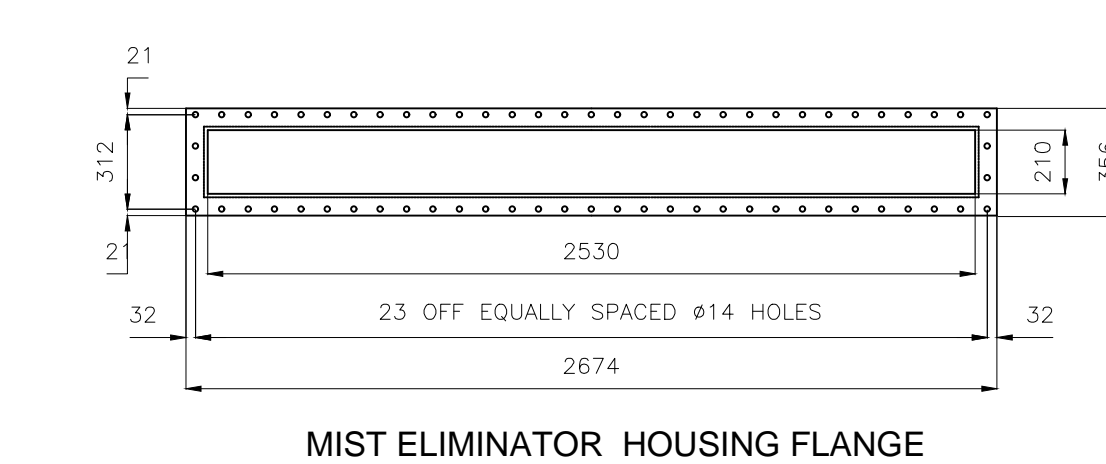
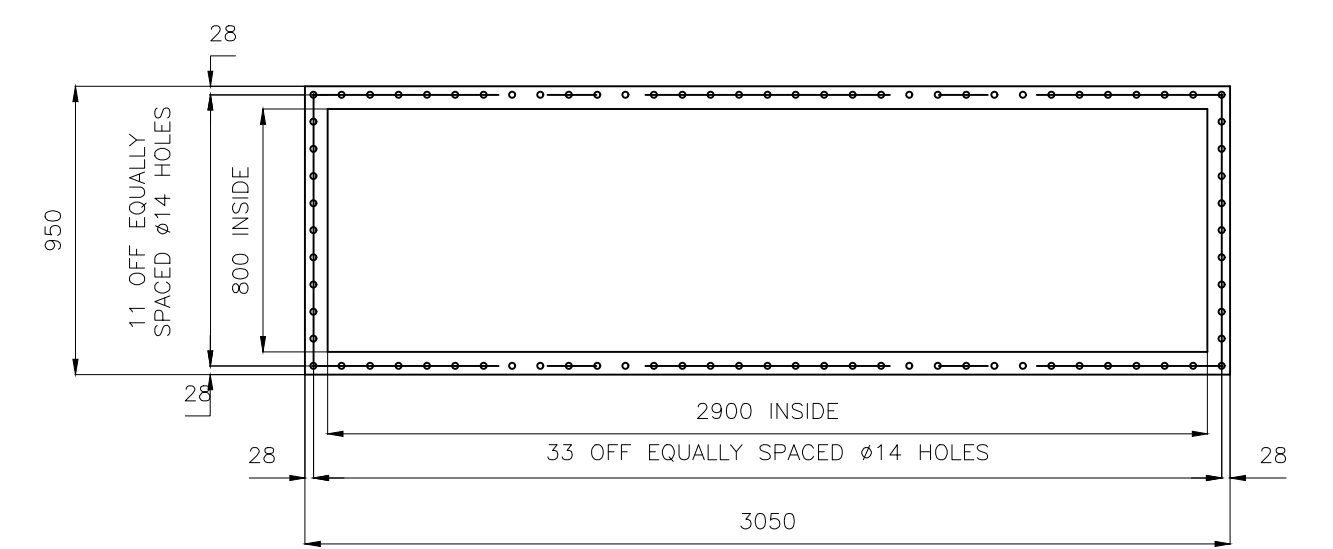
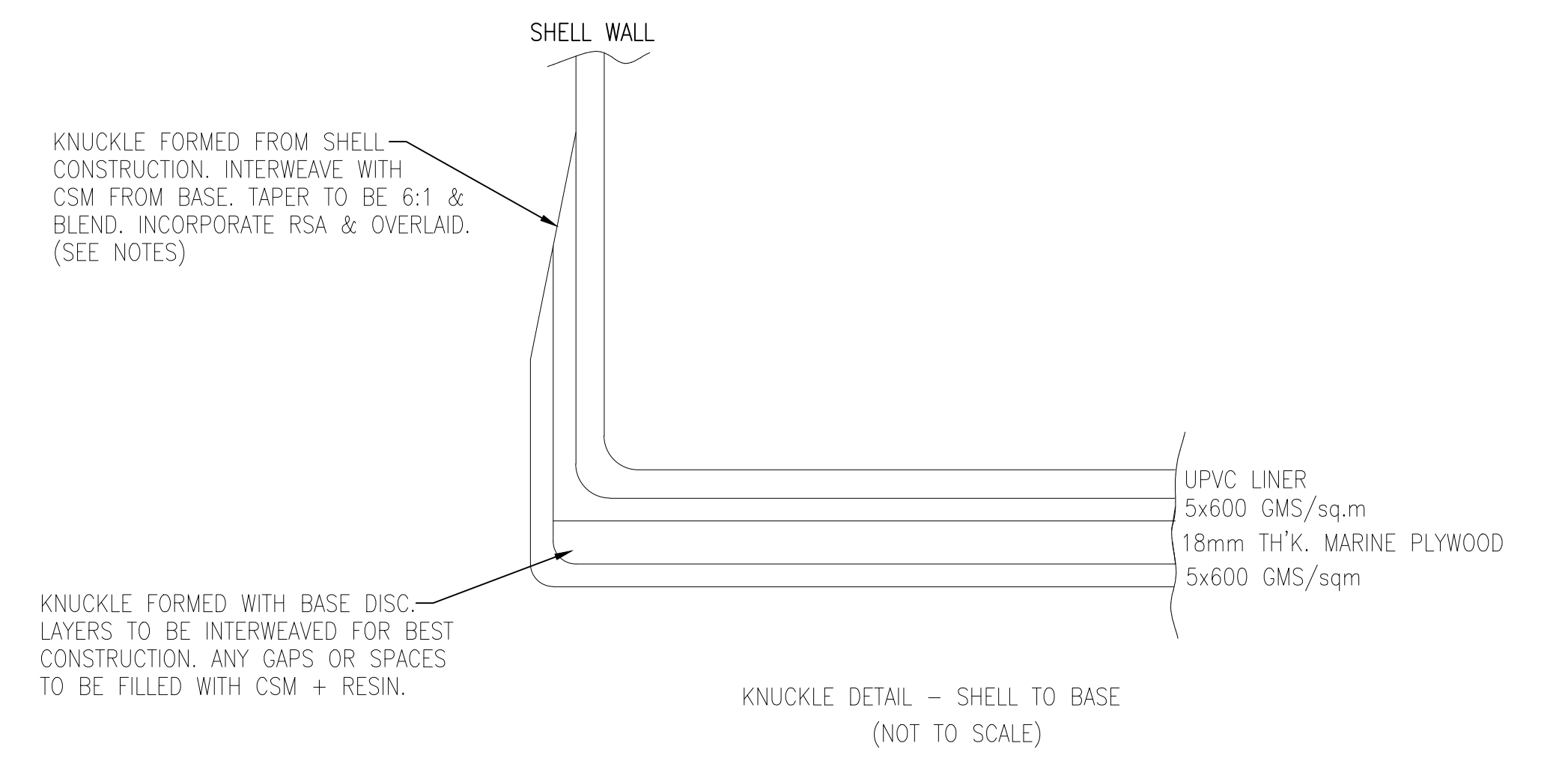
BASE KNUCKLES 6 x 450 GMS/M2 (18 x 450 GMS/M2 IN TOTAL)
 300 MIN. LONG ON SHELL; 450 MIN. ALONG BASE DISC BLENDED TO SUIT BASE CONSTRUCTION

ROOF SECTION
 CONICAL SECTION SHOULD COMPRISE 7 x 450 GMS/M2 C/W 4 OFF 50 x 50 FOAM STIFFENERS EQUISPACED.
 FLAT ROOF SECTION SHOULD COMPRISE 12 MM THICK 'CORE' OVERLAID WITH 4 x 450 GMS/M2 'SKINS' BOTH SIDES.

ROOF KNUCKLES 4 x 450 GMS/M2 (11 x 450 GMS/M2 IN TOTAL)
 TO RUN FOR A LENGTH OF 200 MM EITHER SIDE OF INTERSECTION.

ALL FLANGES / CONNECTIONS TO NBS PS15: 1969 EXCEPT WHERE STATED

WEIGHTS
 SUMP = 2500KG
 MIDDLE SECTION =
 SPRAY SECTION =
 TOP SECTION =
 TRANSFORMATION PIECE =



SHEET 1 OF 2