

ITEM No.	DESCRIPTION	QTY	WT.	Part No.
W83485-(1)	650 x 465 x 32 HR PL.	1	76	WPL1.25
" (2)	210 x 200 x 32 HR PL.	1	11	WPL1.25
" (3)	370 x 130 x 32 HR PL.	1	12	WPL1.25
" (4)	365 x 130 x 30 HR PL.	1	11	WPL1.125
(5)				
W83485-(6)	268 x 200 x 32 HR PL.	1	13	WPL1.25
" (7)	130 x 80 x 20 HR PL.	3	5	WPL75
" (8)	411 x 100 x 20 HR PL.	2	12	WPL75
" (9)	100 X 100 X 12 ANGLE 1200 LG.	2	46	WAG40x40x50x240
W83485-(10)	100 x 96 x 20 HR PL.	2	3	WPL75
(11)	M24 8.8 THREADED ROD 450 LG.	1	1	M24Z9-450V
(12)	M24 HEX NUT	3	-	M24H5-V
(13)	M24 FLAT WASHER	2	-	M24-11-Z
(14)	M24 BOLT-90LG. w/NUT & LOCK WASHER	2	-	M24H1-90VJ


190 Kg RAW MATERIAL WT.
140 Kg EST. FINAL BEAM WT.

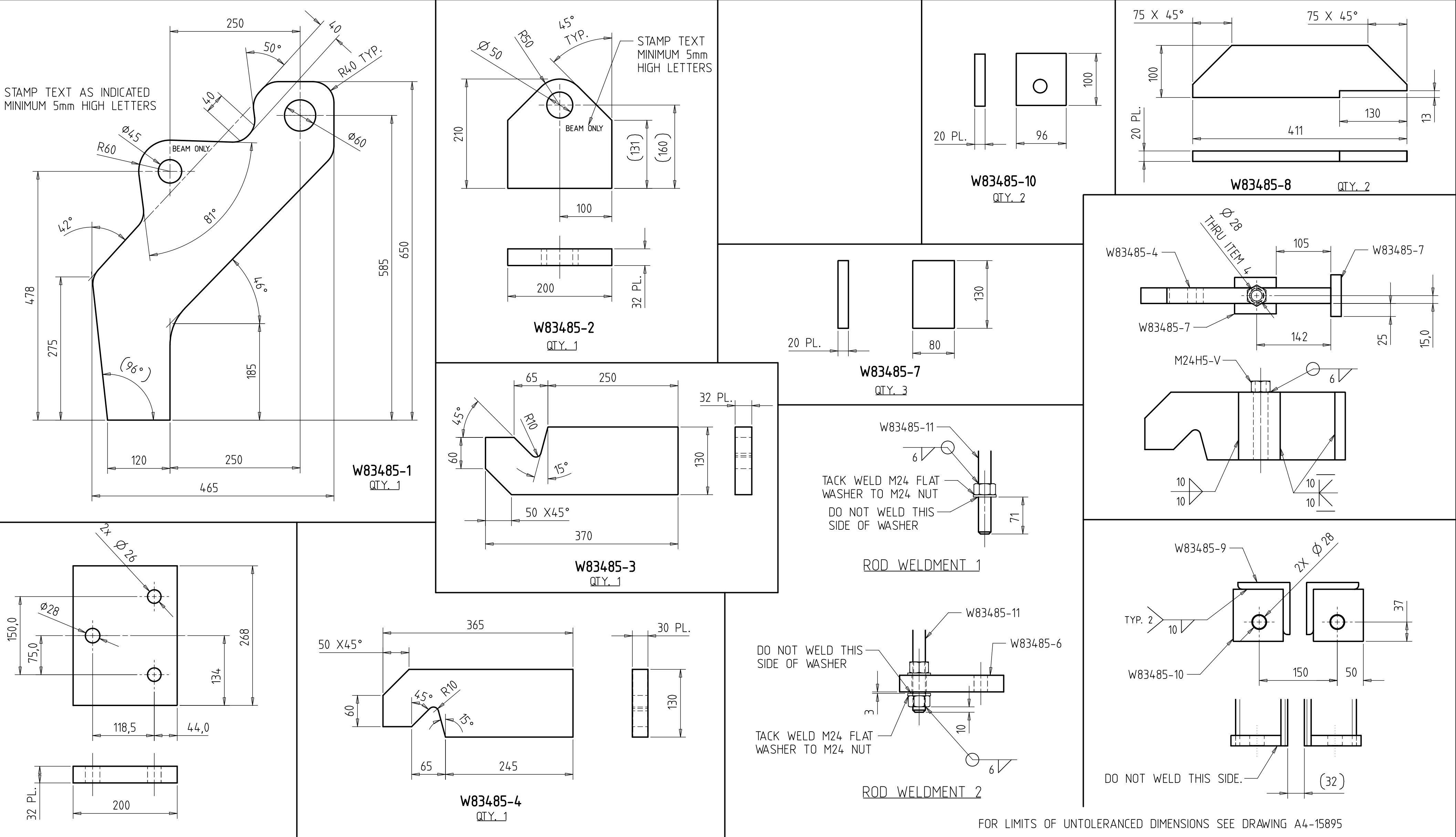
- 1.) STEEL TO BE ASTM-A-36 OR EQUAL.
- 2.) WELDING MUST CONFORM TO CYCLICALLY (DYNAMICALLY) LOADED STRUCTURES OF THE A.W.S.-D-1.1 CODE EXCEPT THAT UNDERCUT IS NOT PERMITTED.
- 3.) ALL WELDS TO BE 10mm CONTINUOUS FILLET UNLESS OTHERWISE SPECIFIED.
- 4.) ONLY QUALIFIED OR PREQUALIFIED WELDING PROCEDURE SPECIFICATIONS (WPS) MAY BE USED IN WELDING.
- 5.) WELDERS MUST BE CERTIFIED FOR THE PROCESS AND POSITION BEING USED.
- 6.) ALL WELDMENTS ARE SUBJECT TO VISUAL & MAGNETIC PARTICLE INSPECTION BY A C.W.I.
- 7.) REMOVE ALL BURRS AND SHARP EDGES.
- 8.) SURFACE PREPARATION AND PAINTING PROCEDURE SHOULD BE IN ACCORDANCE WITH APPLICABLE SECTIONS OF THE STRUCTURAL STEEL PAINT COUNCIL SPECIFICATIONS.

FOR LIMITS OF UNTOLERANCED DIMENSIONS SEE DRAWING A4-15895.
FOR 5 VANE IMPELLERS USE TOOL GAMMC30313E02.

IMPELLER LIFTING BEAM
LIFTING BEAM PART NO: GAM35313EL2E02
LIFTS ITEMS: GAM35145EL2
USED WITH 350 MCU/MCR
LIFTING BEAM WT (TARE): 140 Kg
TOTAL LIFT (SWL): 1363 Kg

NAMEPLATE DETAIL

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	4						APP.	R.BOURGEOIS				
	3						CHECK	M.VIKEN				
	2						DRN.	J.VIAN				
	1	ADDED MISSING DIMENSION. DR101613	JCV	JUN.14,2006	MLV	DATE	MAY.17,2006			WEIR MINERALS NORTH AMERICA DESIGN CENTRE OF ORIGIN : MADISON	DRAWING No. A2- 111 -3-383485 SHEET 1 OF 2 SHEETS	REV. 1
	No.	DESCRIPTION	BY	DATE	CHK	SCALE						
	REVISIONS					1 : 8						



W83485-6
QTY. 1

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No.	1	ADDED MISSING DIMENSION TO SHEET 1. DR101613	JCV	JUN.14,2006	MLV
No.	2				
No.	3				
No.	4				
No.	5				
REVISIONS					

APP.	R.BOURGEOIS
CHECK	M.VIKEN
DRN.	J.VIAN
DATE	MAY.17,2006
SCALE	1 : 5

PRODUCT :	WARMAN PUMP 350 MCU/MCR
WEIR MINERALS	WEIR MINERALS NORTH AMERICA

TITLE :	IMPELLER LIFTING BEAM "GAM35313EL2E02" FOR 4 VANE IMPELLERS FABRICATION DETAIL
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SHEET 2 OF 2 SHEETS	