

Production/Manufacturing Note

1. Please use 243 loctite at All Hex head screw
 2. Air test to be done for 1.5 bar

Refer Standard Sheet Reference No:S050 For Unspecified Tolerance

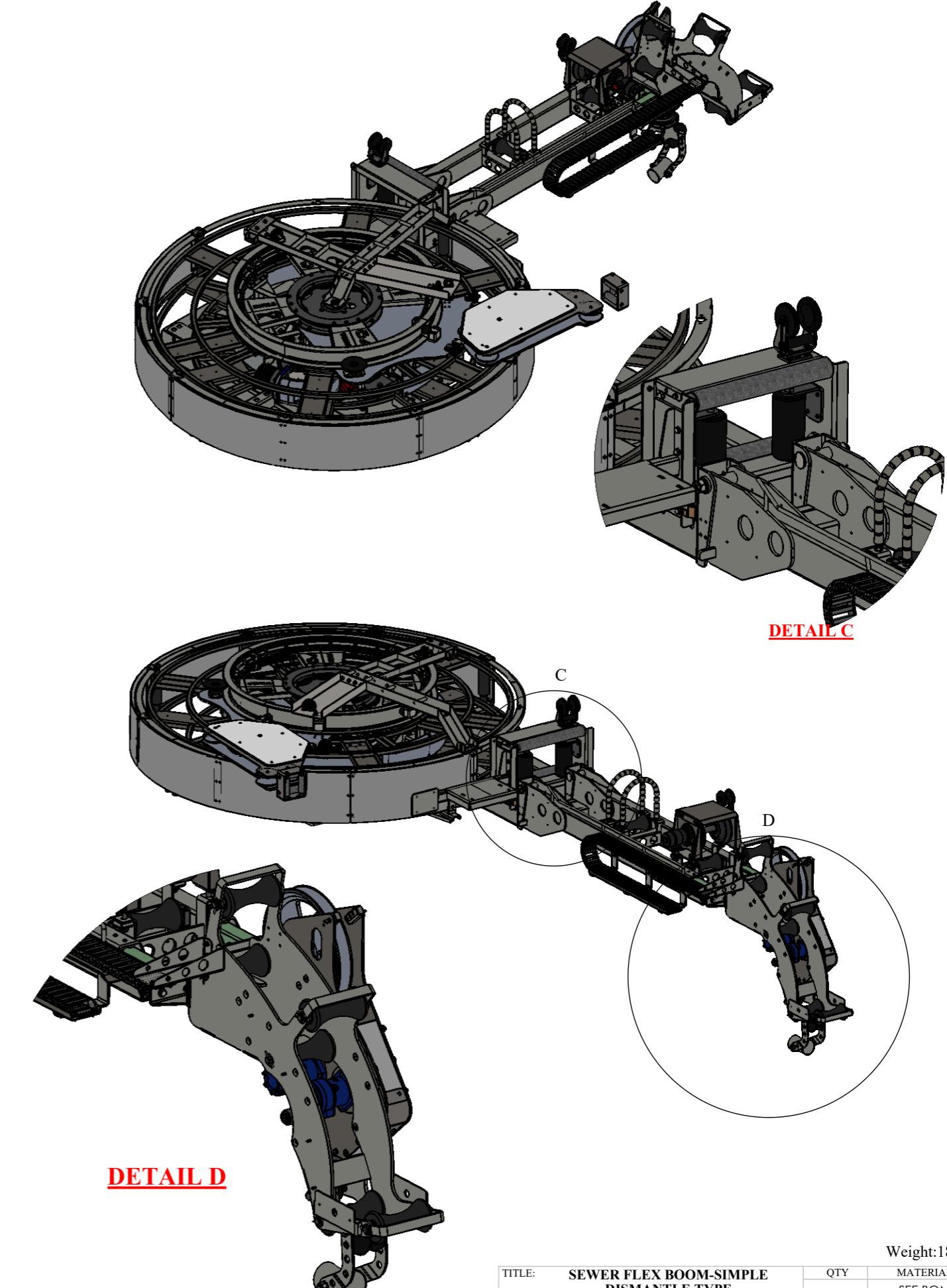
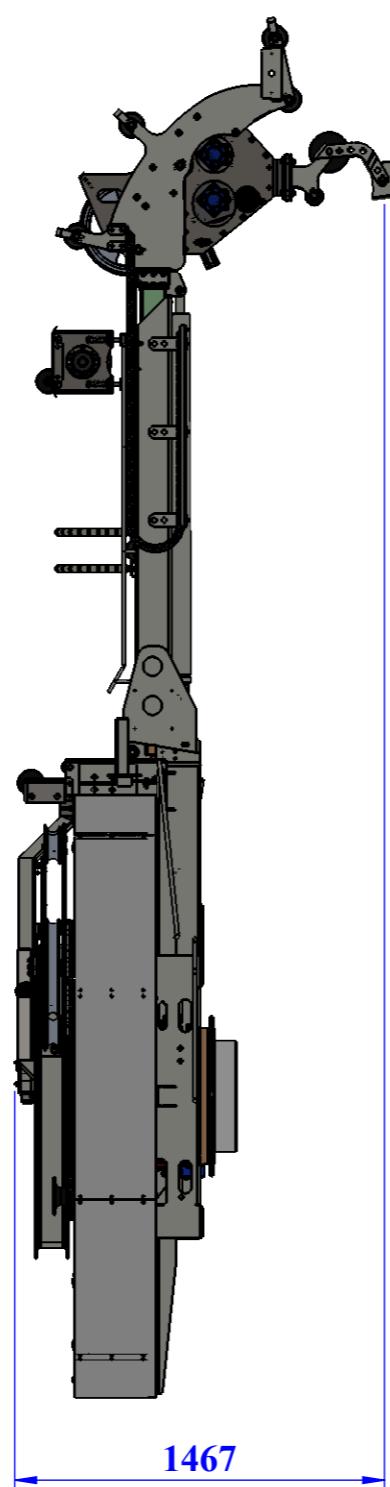
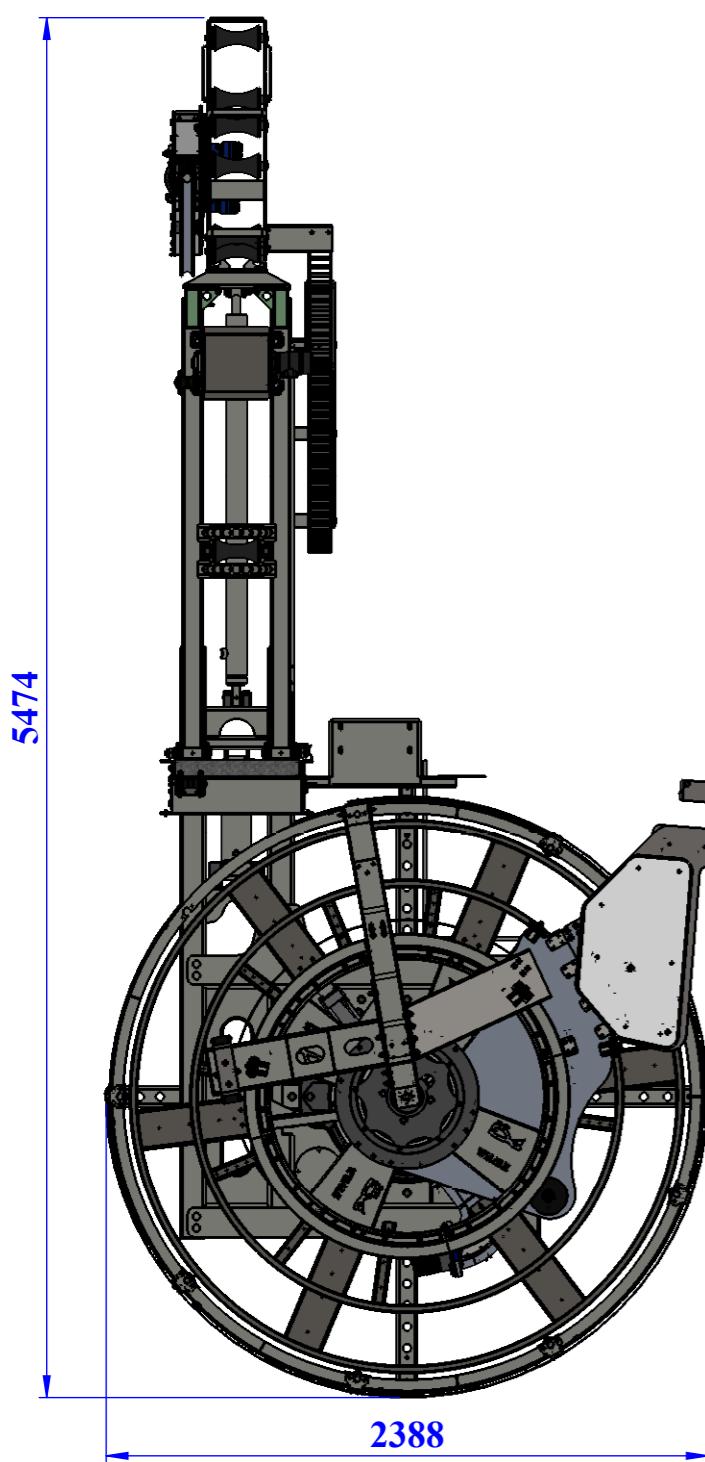
70	TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE			QTY	MATERIAL	REV.NO
				SEE BOM		A
PRODUCT:	SEWER FLEX BOOM		SUB.ASSY:			
	SCALE	PART NO	DATE	DRWN BY	CHKD BY	APPRVD BY
	NTS		11/01/2021	JPR		
72	WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM		DRG NO: A2600		
	SHEET NO	1 of 13				

	1	2	3	4	5	6				
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	
A	1	A2610	Main rotator assembly - O ring design with Simple Dismantle Type	SEE BOM	1	56	O132016	PLAIN WASHER SS M24 A2 (SS 304)	STD	3
	2	A2601	Boom chassis assembly - Simple Dismantle Type	SEE BOM	1	57	O116010	HEX NYLOCK NUT SS M24	STD	3
	3	9101836	Gravity Roller 63dia x 500mm ZP - RS243-1490	STD	3	58	62334	Spacer profile primary swivel - Span roller assembly - Twin boom Mk2 Flexi-boom	1.0577 (S355J2G4)	4
	4	62043	Top Roller box cover profile - Twin boom Mk2 - Flexi-boom	1.0145 (S275J2G4)	1	59	O204014	IGUS FLANGE BEARING GFM2526-25-0.5	STD	4
	5	52895	Spool assembly complete	SEE BOM	1	60	62344	Front fixing pin - Extension ram - Twin Boom Mk2 Modular Flexi-boom	EN8	1
	6	64508	Mid boom section weld assembly - KW & UK spec	Reference B.O.M	1	61	O132014	PLAIN WASHER SS M16	STD	1
	7	62042	Short roller support profile - Twin boom Mk2 Modular Flexi-boom	Carbon Steel-B5 EN 10025 S275 J2	8	62	O117011	HEX NYLOCK NUT ZnPi M16x2	STD	15
	8	62041	Peripheral roller - vacuum hose guide - Twin boom Mk2 Flexi-boom	Polypropylene Rod	8	63	62345	Rear fixing pin - Lift ram - Twin Boom Mk2 Modular Flexi-boom	EN8	1
	9	62033	Vac hose front drive unit assembly - Twin boom Mk2 Modular Flexi-boom	Reference B.O.M	1	64	62346	Front fixing pin - Lift ram - Twin Boom Mk2 Modular Flexi-boom	EN8	1
	10	62076	Large vacuum hose cover panel profile - Twin boom Mk2 modular flexi-boom	3.3547 (EN-AW 5083)	3	65	62353	Special bolt M16 x 335mm - Twin Boom Mk2 Modular Flexi boom	EN8	8
	11	62077	Small cacuum hose cover panel profile - Twin boom Mk2 modular Flexi-boom	3.3547 (EN-AW 5083)	1	66	A0457	primary hose guid assembly	SEE BOM	1
	12	62075	Inner finisher profile - vacuum hose cover - Twin boom Mk2 modular flexi-boom	3.3547 (EN-AW 5083)	1	67	A0439	JETTING HOSE ALIGNING ROLLER	SEE BOM	1
	13	62074	Outer finisher profile - vacuum hose cover - Twin boom Mk2 modular flexi-boom	3.3547 (EN-AW 5083)	1	68	58975	Primary hose guide hoop assembly - spiral boom	As Detailed	2
	14	55179	Top ring assembly - outer roller support	Reference B.O.M	1	69	A1423	Turret adapter ring -O ring design	1.0143(S275J0)	1
	15	64512	NS front slide arm assembly - Long stroke	As Detailed	1	70	O322138	O RING ID 532.26X6.99 mm (Material: NBR)	STD	1
	16	62031	Boom head assembly - Twin Boom Mk2 modular Flexi-boom	As Detailed	1	71	A0332	SEWER FLEX BOOM-HYDRAULIC SUPPORT BOX	SEE BOM	1
	17	52979	Boom End Roller Shaft	20 Dia BDMS Bar -	6	72	O120046	HEX SOCKET HEAD CAP SCREW GRADE(10.9) ZnPi M16X65	STD	12
	18	52980	Boom End Roller Spacer	Polypropylene	16	73	O119034	HEX SOCKET HEAD CAP SCREW GRADE(10.9) ZnPi M16X120	STD	4
	19	O136028	R PIN DIA 4 - 64mm LENGTH	STD	6	74	O119033	HEX SOCKET HEAD CAP SCREW GRADE(10.9) ZnPi M10X70	STD	4
	20	62037	Base roller assembly - Twin boom Mk2 Modular Flexi-boom	Reference B.O.M	8	75	O119030	HEX SOCKET HEAD CAP SCREW GRADE(10.9) ZnPi M8 X 60	STD	8
	21	51792	Spacer	En8	6	76	O105091	HEX HEAD BOLT GRADE (10.9) ZnPi M16x70mm	STD	16
	22	57458	Front Drive Unit	Reference B.O.M	1	77	O131016	PLAIN WASHER ZnPi M16	STD	51
	23	A2670	Carrousel drive assembly -O Ring design with Simple Dismantle Type	SEE BOM	1	78	O101048	HEX HEAD SCREW GRADE (10.9) ZnPi M16x50	STD	31
	24	A1595	Alternate Boom valve Assy-O ring design	SEE BOM	1	79	O131014	PLAIN WASHER ZnPi M12	STD	82
	25	A2380	Inlet hose spigot assembly -Round Flange	SEE BOM	1	80	O117006	HEX NYLOCK NUT ZnPi M12	STD	28
	26	62339	Spoke assembly type 2 - Twin Boom Mk2 Modular Flexi-boom	Reference B.O.M	1	81	O105050	HEX HEAD BOLT GRADE (10.9) ZnPi M12x60	STD	12
	27	62342	Ram mount assembly - Twin boom Mk2 Flexi-boom	Reference B.O.M	1	82	O131012	PLAIN WASHER ZnPi M8	STD	94
	28	62338	Spoke assembly type 1 - Twin Boom Mk2 Modular Flexi-boom	Reference B.O.M	3	83	O117004	HEX NYLOCK NUT ZnPi M8	STD	82
	29	A2378	Intake chamber With Wear Plate Assy-o ring Design	SEE BOM	1	84	O105004	HEX HEAD SCREW GRADE (10.9) ZnPi M8x30	STD	70
	30	52939	Extension Arm Bearing	Brass	8	85	O101012	HEX HEAD SCREW GRADE (10.9) ZnPi M8X20	STD	12
	31	68250	Cable chain support Tray profile - twin boom MK2 modular - Flexi-boom	SS304	1	86	O101027	HEX HEAD SCREW GRADE (10.9) ZnPi M10x55	STD	7
	32	1103144&1103145	Front Cable Chain Dynamic Assembly	SEE BOM	1	87	O105087	HEX HEAD BOLT GRADE (10.9) ZnPi M12x25mm	STD	8
	33	62032	Front cable chain securing bracket - Twin boom Mk2 Modular Flexi-boom	1.0145 (S275J2G4)	1	88	O132002	PLAIN WASHER SS M5	STD	48
	34	A1601	Span roller assembly for Side reel compatibility	SEE BOM	1	89	O127003	HEX SOCKET BUTTON HEAD SCREW GRADE(10.9) M5x10 SS	STD	48
	35	62048	Primary vertical vac hose guide roller - Twin boom Mk2 Modular Flexi-boom	AL6082-T6	2	90	O131013	PLAIN WASHER ZnPi M10	STD	31
	36	O202013	DEEP GROOVE BALL BEARING 6203-ZZ	STD	4	91	O101020	HEX HEAD SCREW GRADE (10.9) ZnPi M10X20	STD	16
	37	O110008	HEX NUT GRADE (10.9)ZnPi M16	STD	2	92	O125020	HEX SOCKET BUTTON HEAD SCREW GRADE(10.9) ZnPi M6X12	STD	2
	38	62050	Interal bearing spacer tube Primary roller - Twin boom Mk2 Modular Flexi-boom	1.0145 (S275J2G4)	2	93	O101021	HEX HEAD SCREW GRADE (10.9) ZnPi M10x25	STD	2
	39	62049	External spacer primary roller - Twin boom MK2 Modular Flexi-boom	1.0145 (S275J2G4)	4	94	O117005	HEX NYLOCK NUT ZnPi M10 x THK 10mm	STD	6
	40	62044	Roller box side panel profile type I - Twin boom Mk2 Modular Flexi-boom	1.0145 (S275J2G4)	1	95	O110004	HEX NUT GRADE (10.9)ZnPi M8	STD	4
	41	A2374	Roller box side panel profile type 2 and saddle clip assy	SEE BOM	1	96	O101032	HEX HEAD SCREW GRADE (10.9) ZnPi M12X20	STD	10
	42	62046	Top bracket profile type 1 - roller mounting - Twin boom Mk2 Modular Flexi-boom	1.0145 (S275J2G4)	1	97	O105008	HEX HEAD BOLT GRADE (10.9) ZnPi M10x30	STD	4
	43	62047	Top Bracket profile type 2 - roller mounting - Twin boom Mk2 Modular Flexi-boom	1.0145 (S275J2G4)	1	98	O119036	HEX SOCKET HEAD CSK SCREW GRADE(10.9) ZnPi M10X45mm	STD	7
	44	64511	OS front slide arm assembly - Long stroke	As Detailed	1	99	0157001	HEX GRUB SCREW M8 X 15	STD	4
	45	62035	Axle block - lower mid boom roller - Twin boom Mk2 Modular Flexi-boom	1.0143 (S275J0)	4	100	O101007	HEX HEAD SCREW GRADE (10.9) ZnPi M6X16	STD	16
	46	62036	Roller axle bar - lower mid boom roller - Twin boom Mk2 Modular Flexi-boom	1.0145 (S275J2G4)	2	101	O101034	HEX HEAD SCREW GRADE (10.9) ZnPi M12x35	STD	16
	47	52986	Lift Hydraulic Cylinder 100 Dia x 150mm Stroke - Twin Boom Mk2 Modular Flexi-boom	SEE BOM	1	102	O109043	HEX HEAD BOLT GRADE (8.8) ZnPi M6X25	STD	4
	48	62040	Rear lift ram pivot block - Twin boom Mk2 Modular Flexi-boom	1.0145 (S275J2G4)	2	103	O131011	PLAIN WASHER ZnPi M6	STD	14
	49	62023	Front boom neck assembly - Twin boom Mk2 Modular Flexi-boom	Reference B.O.M	1	104	O117003	HEX NYLOCK NUT ZnPi M6	STD	8
	50	62039	Rear mounting block - push ram - Twin boom Mk2 Modular Flexi-boom	1.0145 (S275J2G4)	2	105	O128002	HEX SOCKET HEAD CSK SCREW GRADE(8.8) ZnPi M6x20	STD	4
	51	33877	Pushing Cylinder,50x1350	SEE BOM	1	106	O129014	Hexagon socket countersunk head screw ISO 10642 - M8 x 35	STD	2
	52	A2371	Front upper cable track support Plate Assy	SEE BOM	1	107	O310004	M8 Grease Nipple	STD	2
	53	62038	Rear pivot pin - push ram - Twin boom Mk2 Modular Flexi-boom	EN8	1	108	9101743	PRV SPRING (WT CODE:101704)	SS316	4
	54	62051	Axle bolt Primary Roller - Twin boom Mk2 Modular Flexi-boom	EN8	2	109	O105093	HEX HEAD BOLT GRADE (10.9) ZnPi M12x160mm	STD	4
	55	62321	Main boom pivot pin - Lift arm to Boom chassis - Twin boom MK2 Flexi-boom	EN8	2	110	O125020	HEX SOCKET BUTTON HEAD SCREW GRADE(10.9) ZnPi M6X20	STD	6

Weight:1813.68 KG

TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM	A	
SUB.ASSY:				
 NTS		DATE	DRWN BY	CHKD BY/APPRVD BY
		11/01/2021	JPR	
		SHEET NO	2 of 13	
		DRG NO:	A2600	
		WHALE	WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	

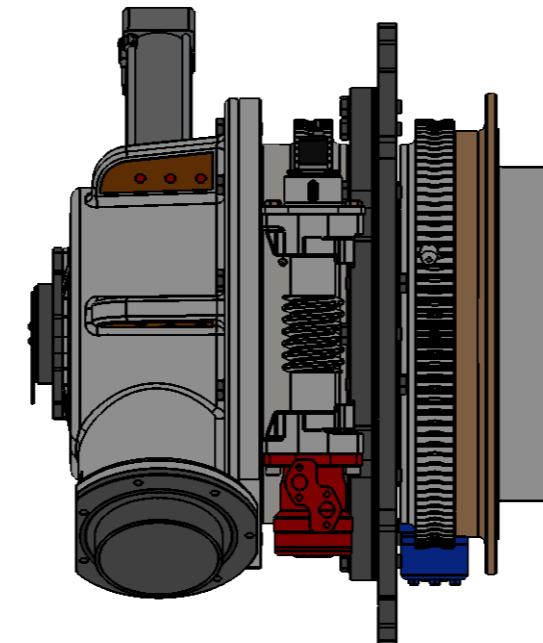
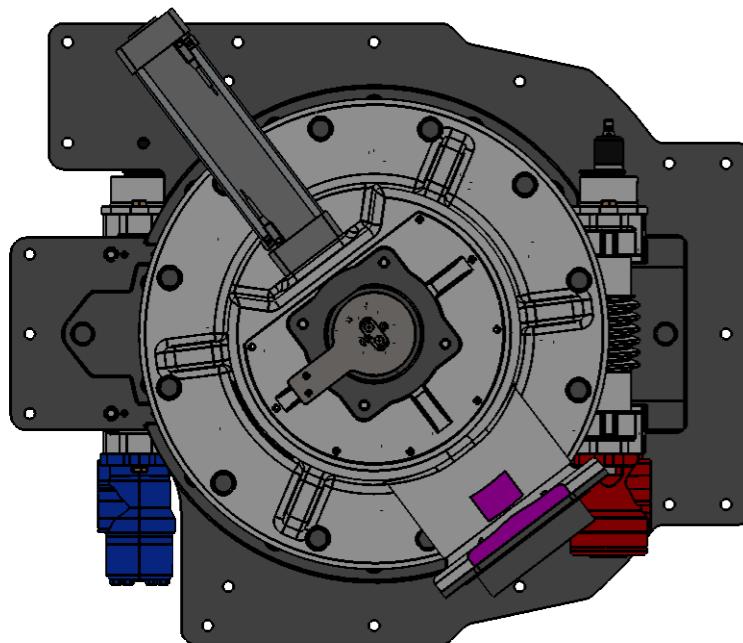
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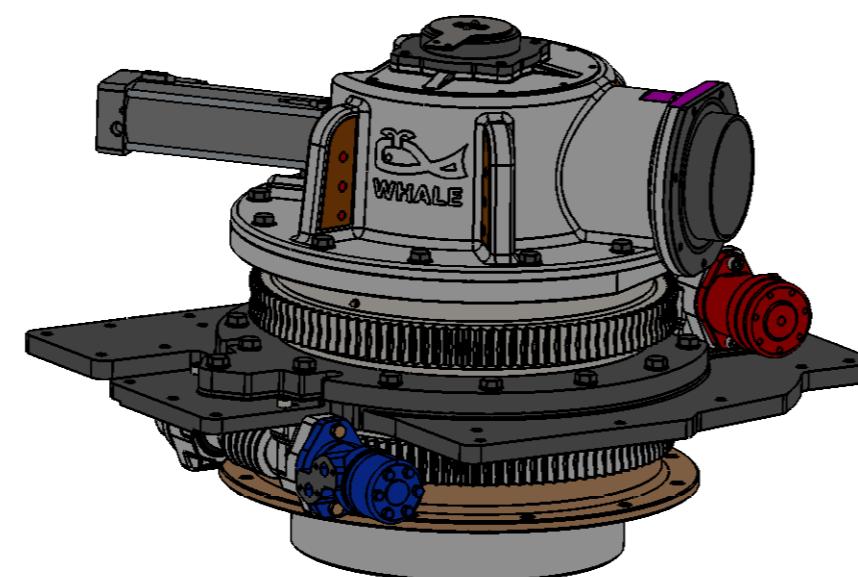
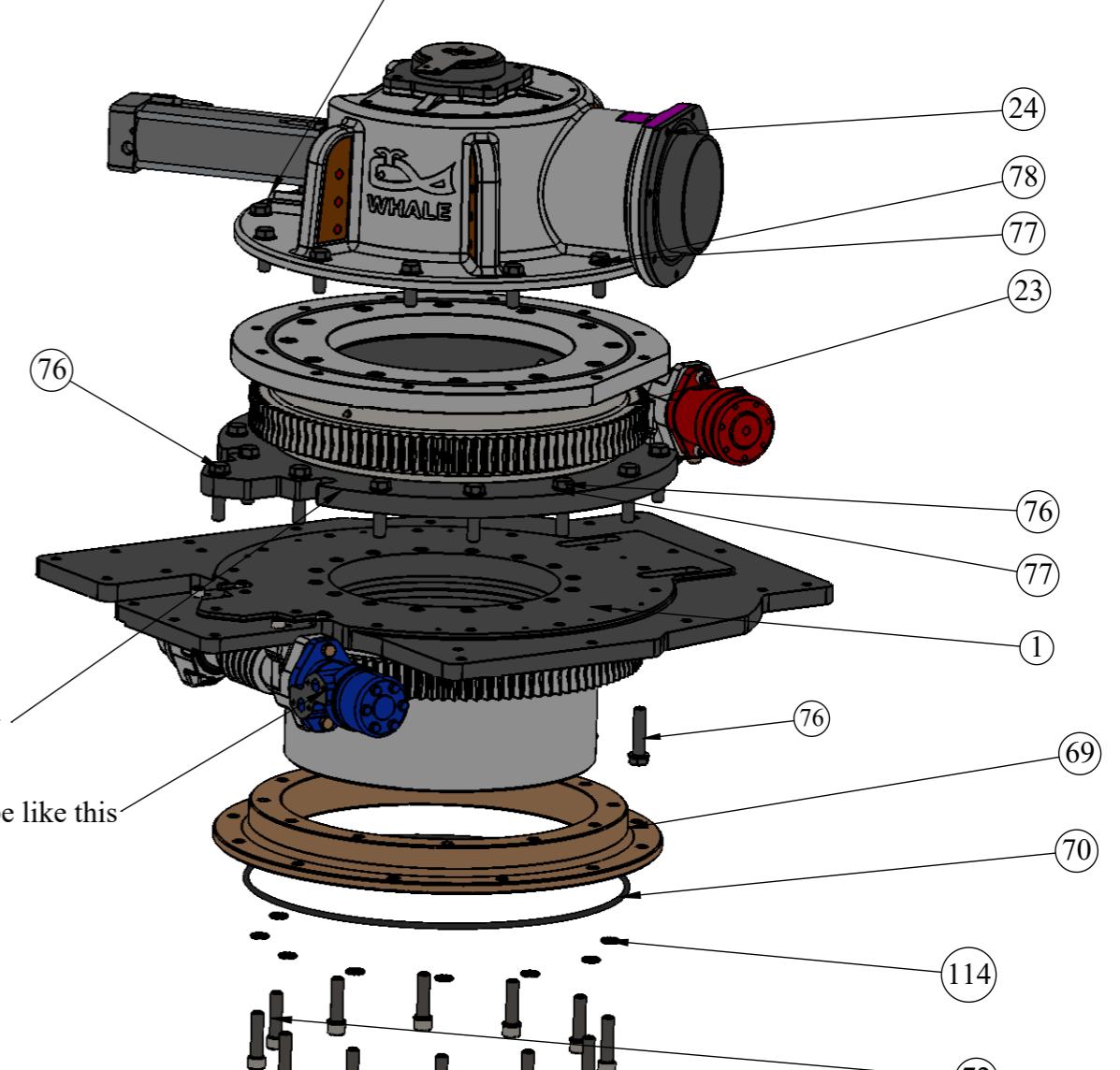
Weight: 1813.68 KG

TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM		A
SUB.ASSY:		DATE	DRWN BY	CHKD BY/APPRVD BY
	SCALE	PART NO		
NTS			11/01/2021	JPR
	WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM		
	SHEET NO	3 of 13	DRG NO:	A2600

7 8 9 10 11 12



Please use 243 loctite at Hex head screw



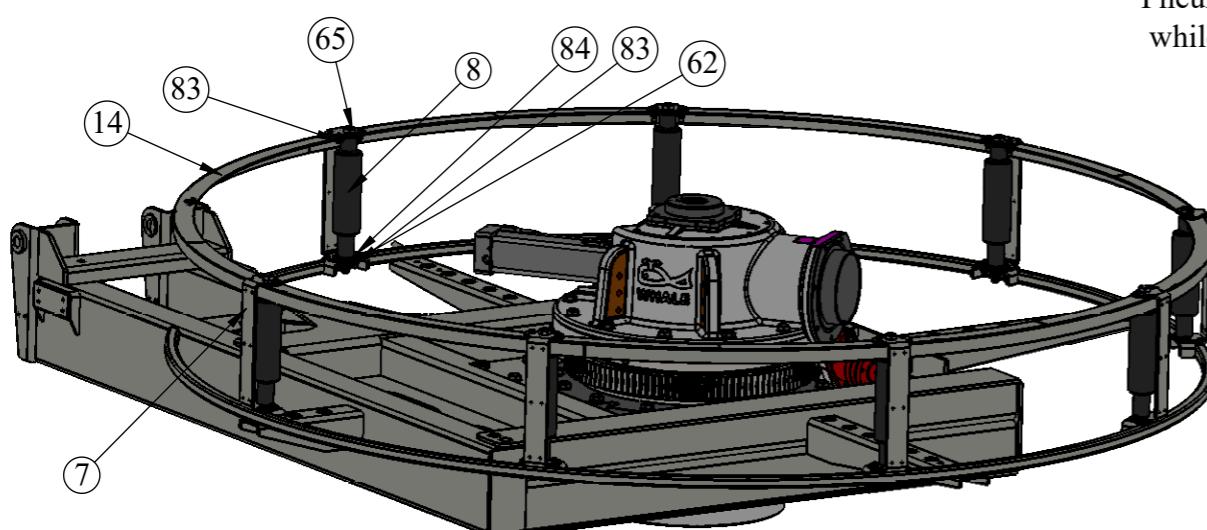
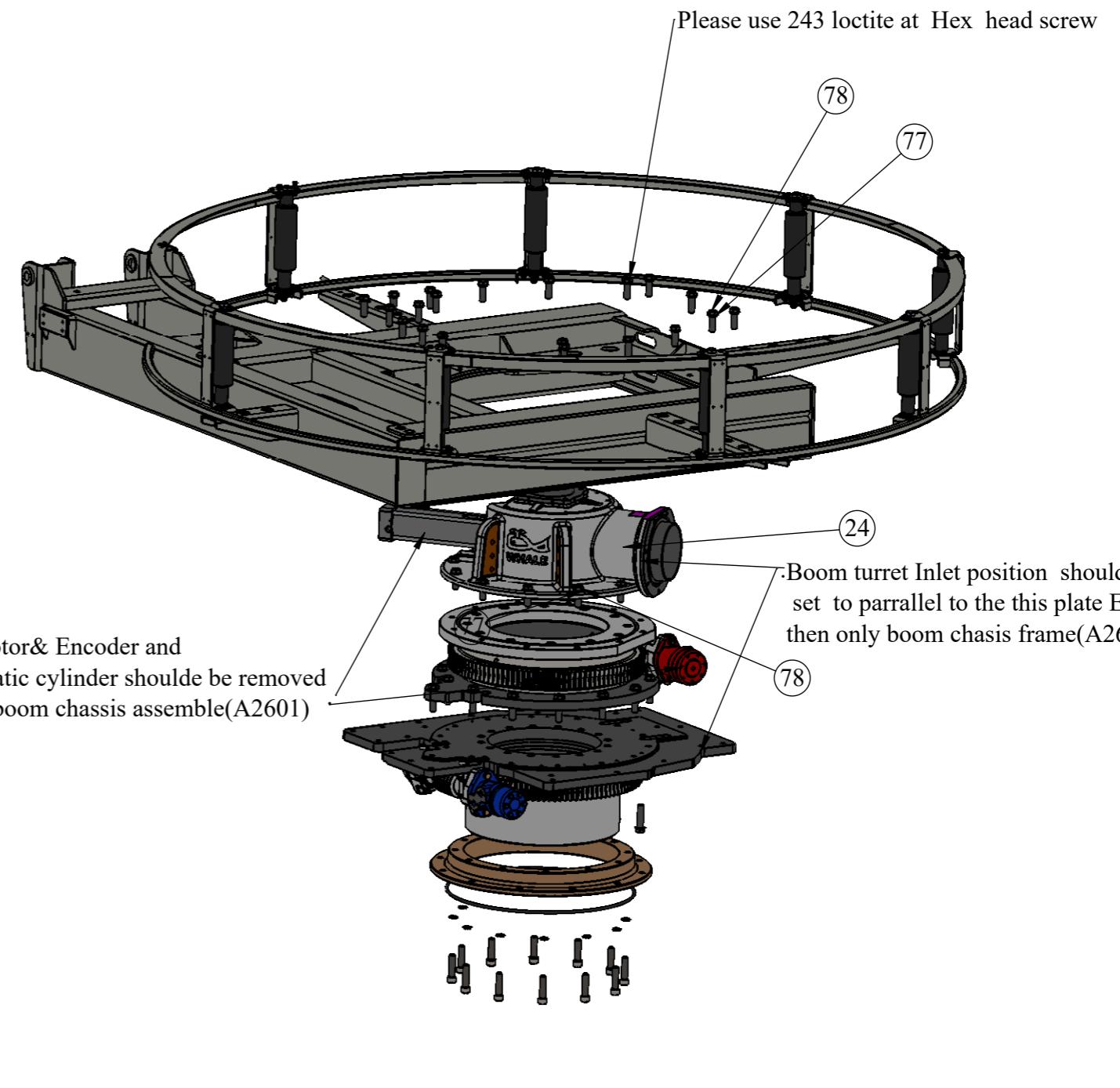
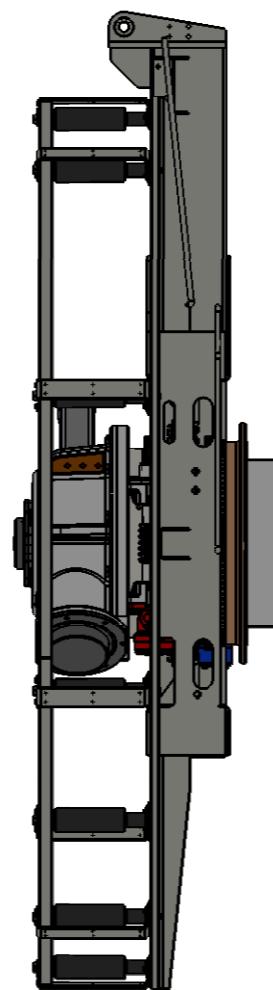
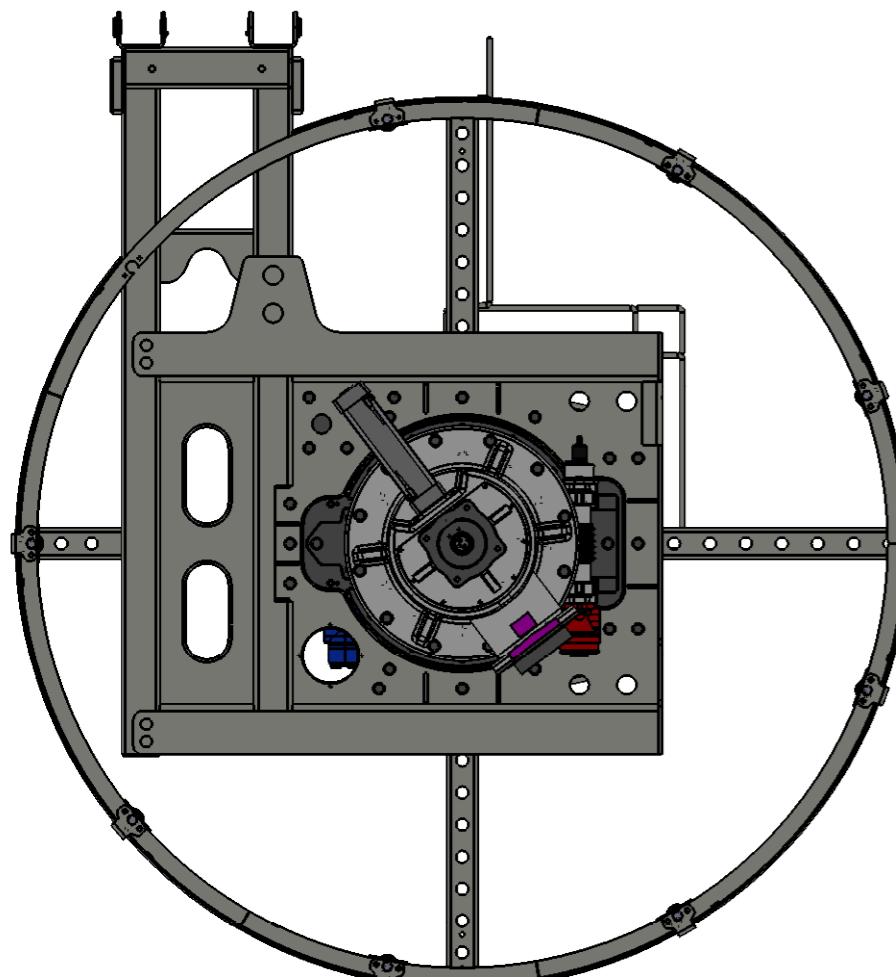
[Production/Manufacturing Note](#)

STAGE 1

Refer Standard Sheet Reference No:S050 For Unspecified Tolerance

Weight:1813.68 KG

TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM		A
SUB.ASSY:		SCALE	PART NO	
	NTS			
		DATE 11/01/2021	DRWN BY JPR	CHKD BY APPRVD BY
WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM	SHEET NO 4 of 13	DRG NO: A2600	



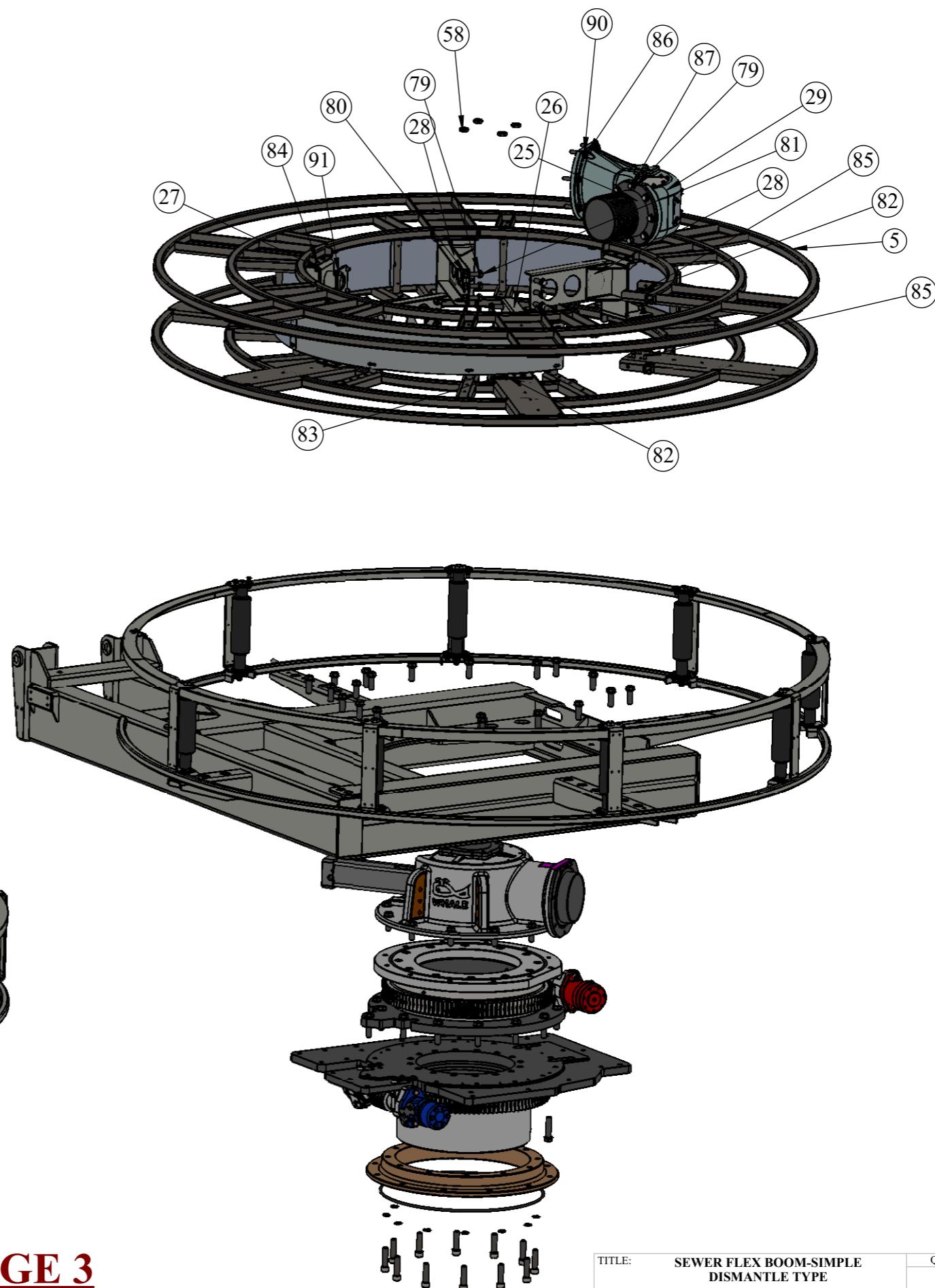
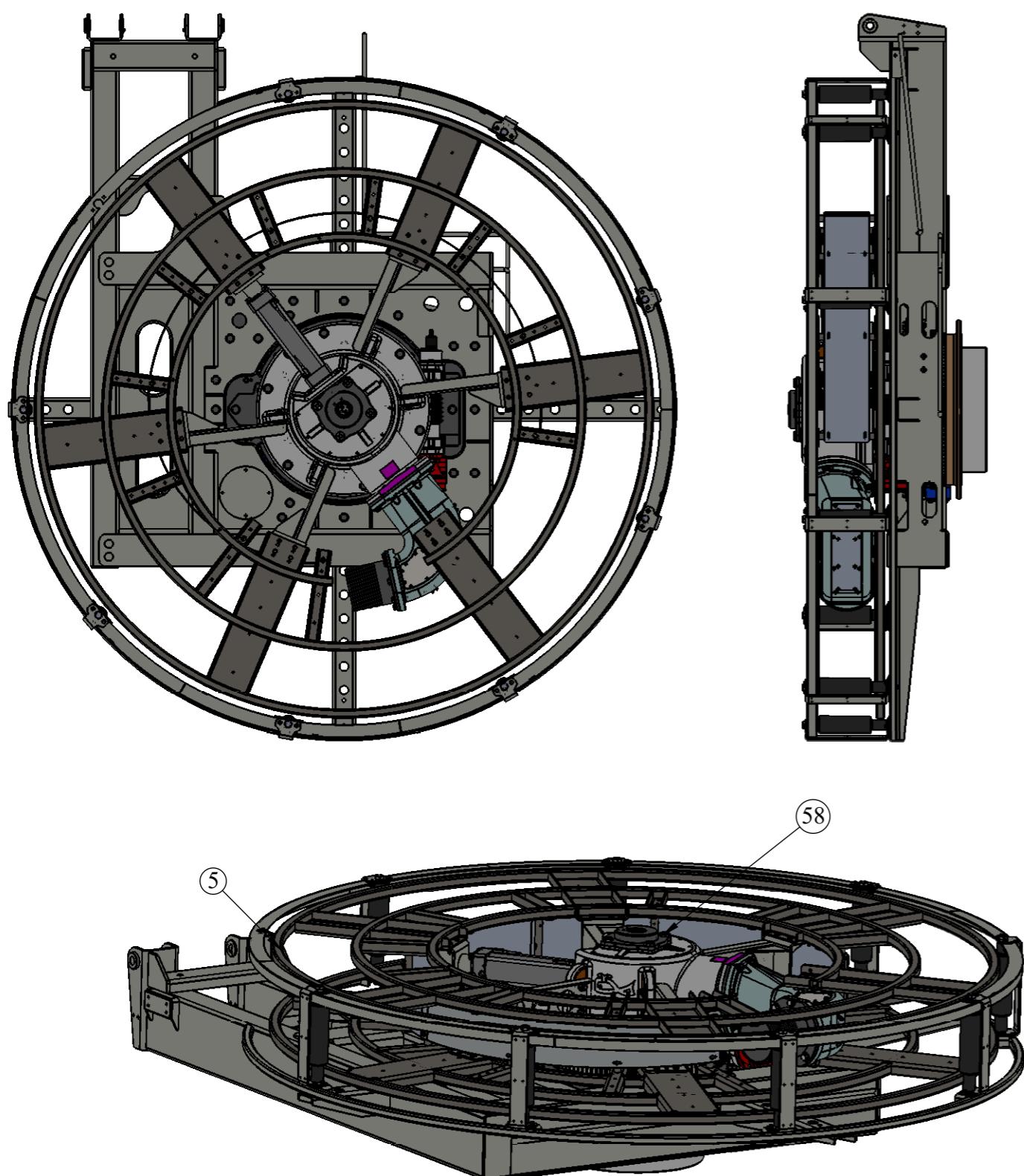
STAGE 2

[Production/Manufacturing Note](#)

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Weight:1813.68 KG

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PRODUCT: SEWER FLEX BOOM		SEE BOM		A
SUB.ASSY:		SCALE	PART NO	DATE DRWN BY CHKD BY APPRVD BY
	NTS			
		11/01/2021	JPR	
	WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM	SHEET NO	5 of 13
			DRG NO:	A2600



STAGE 3

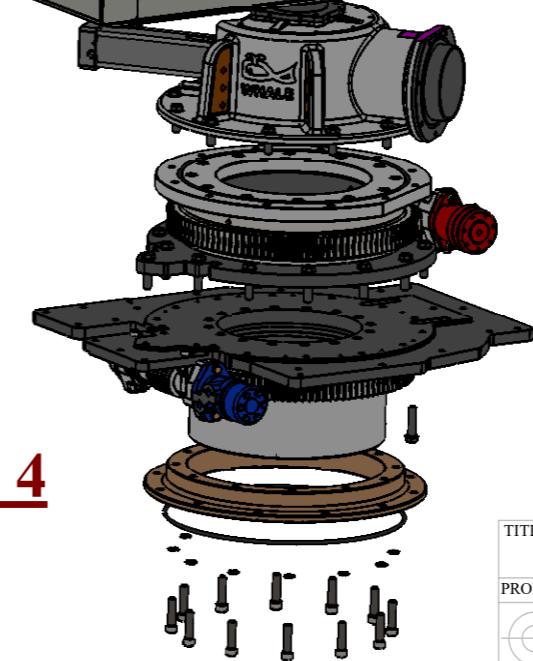
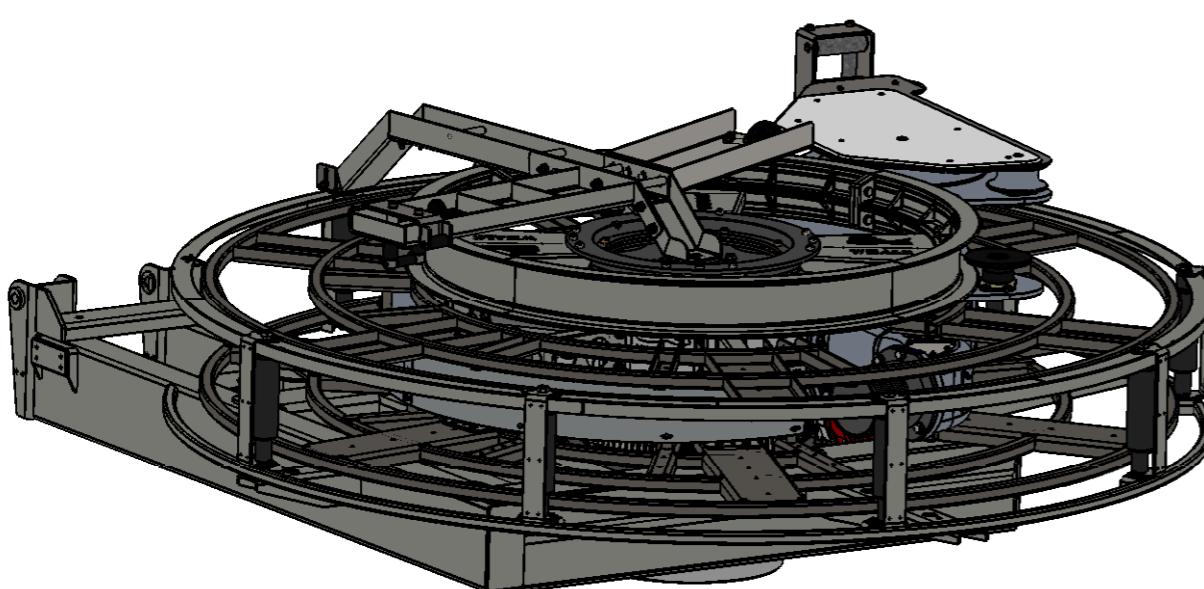
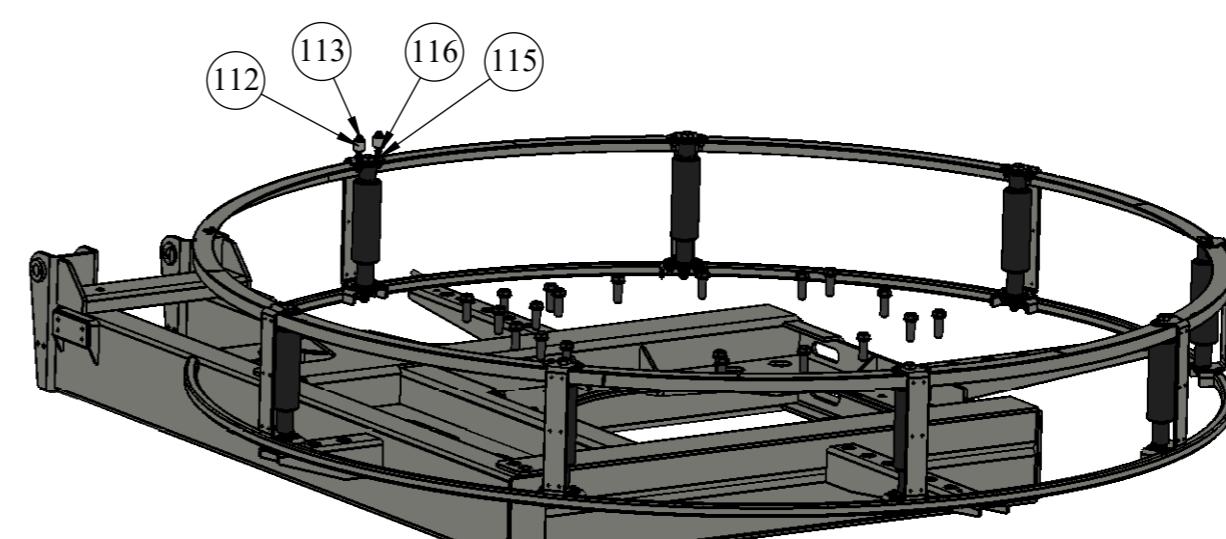
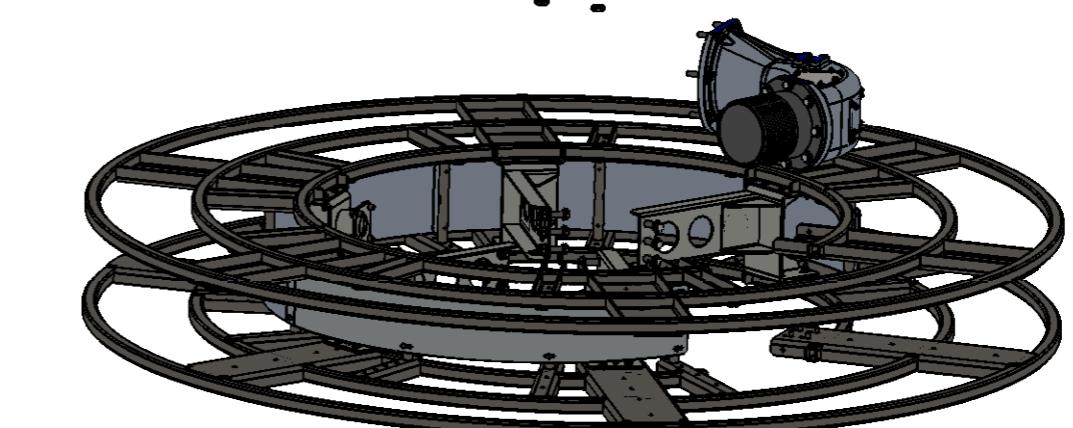
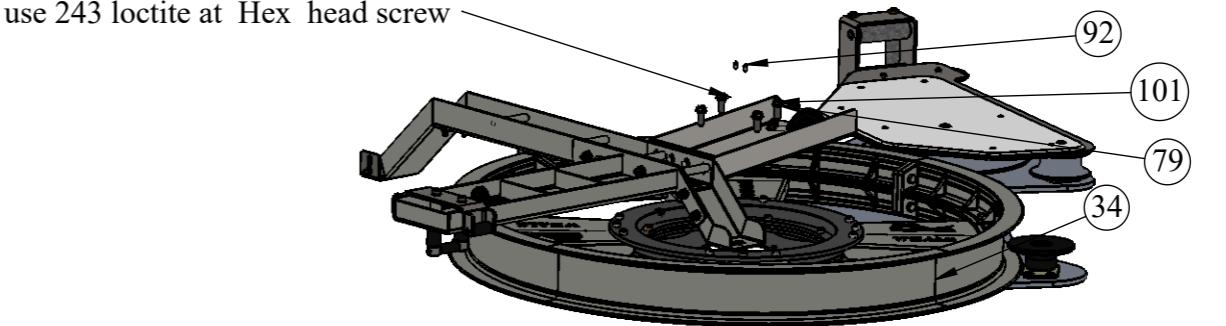
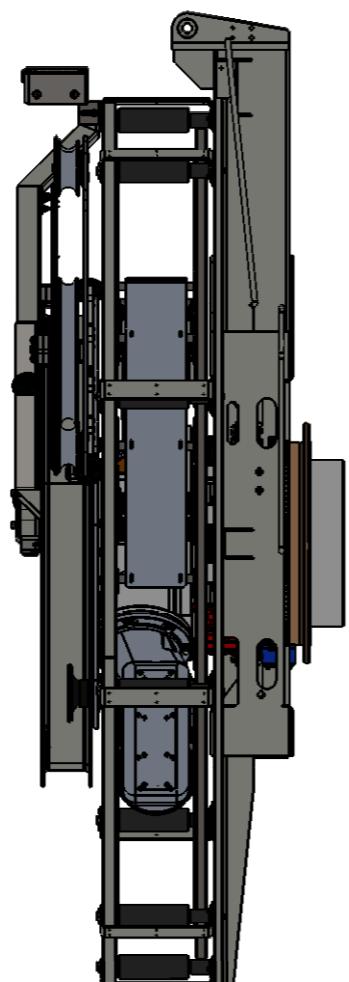
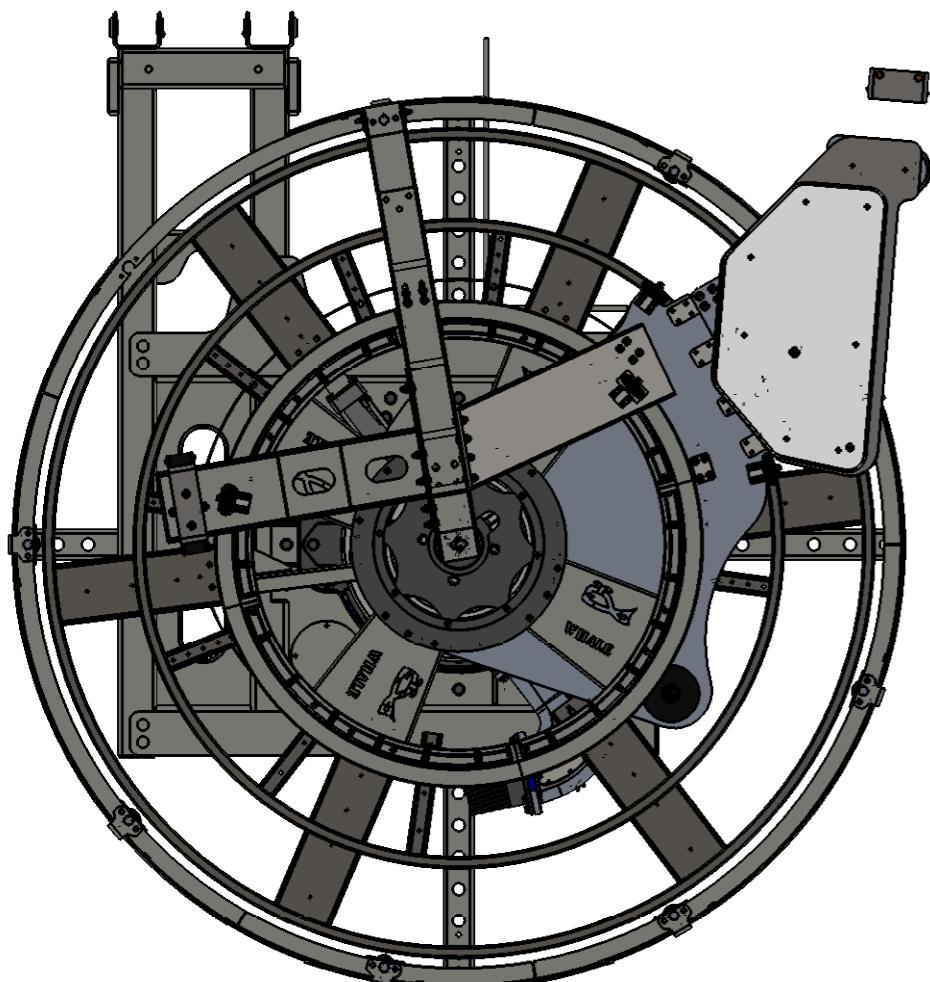
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TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM		A
SUB.ASSY:		SCALE	PART NO	DATE DRWN BY CHKD BY APPRVD BY
	NTS			11/01/2021 JPR
WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM	SHEET NO	6 of 13	DRG NO: A2600

Please use 243 loctite at Hex head screw



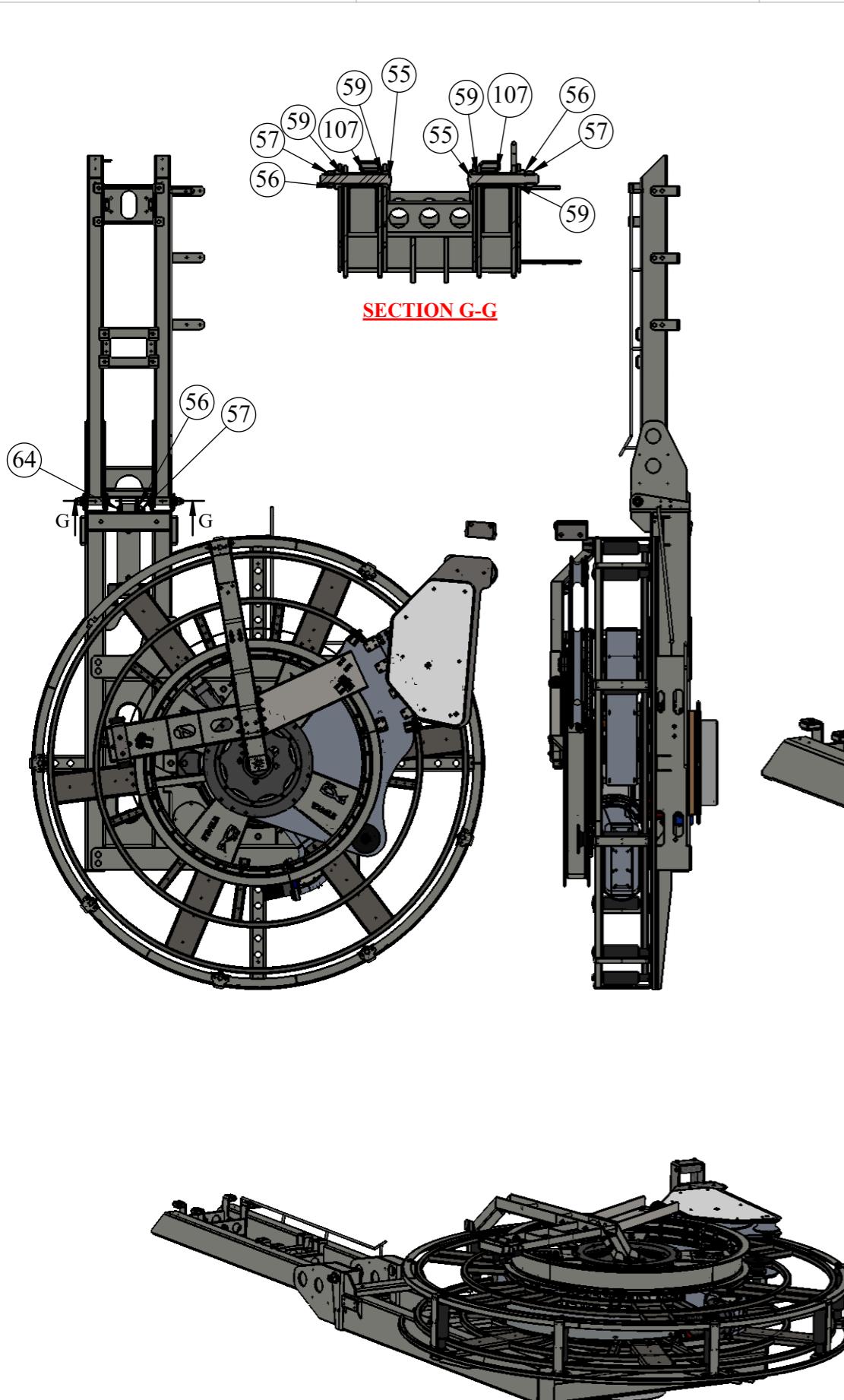
STAGE 4

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Weight:1813.68 KG

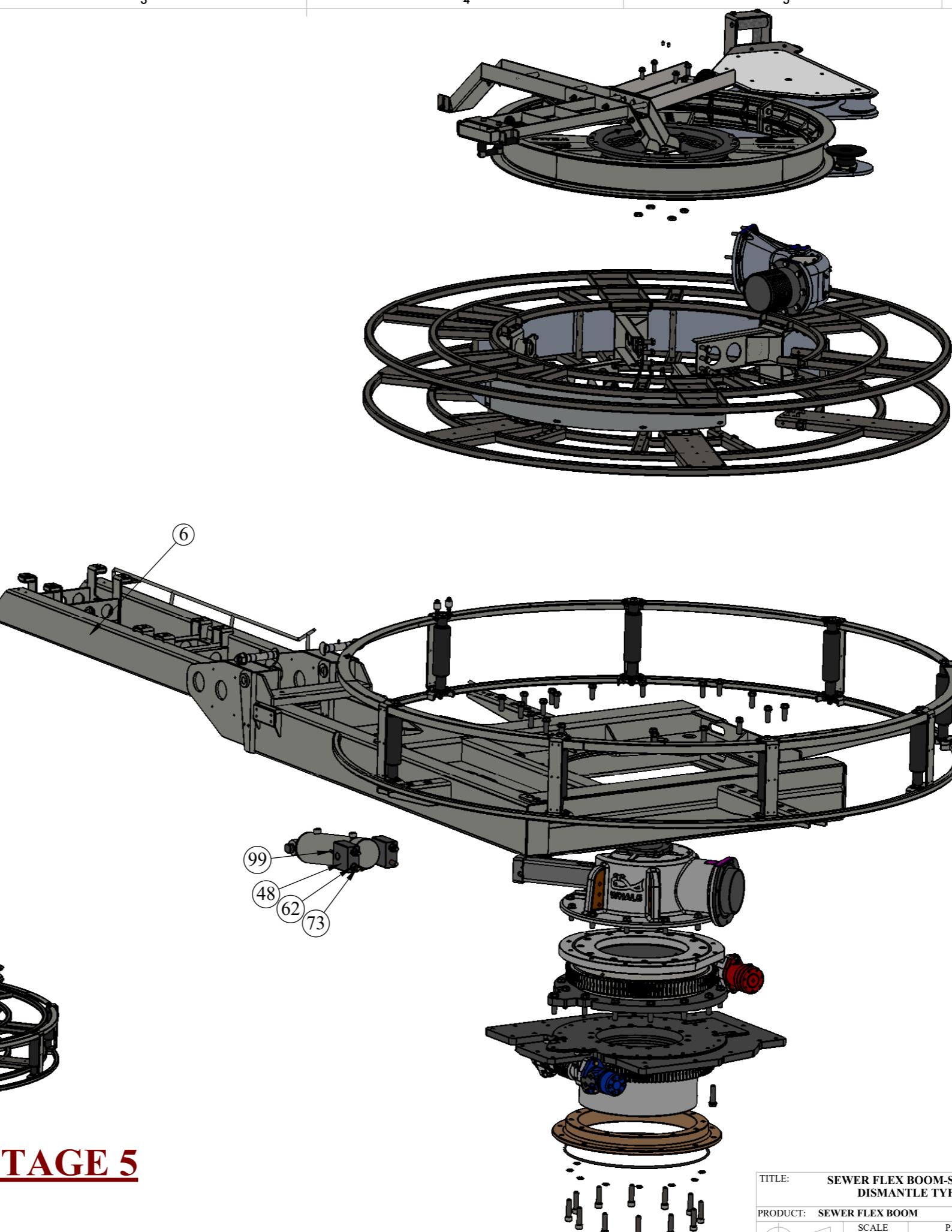
TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM		A
SUB.ASSY:		SCALE	PART NO	DATE DRWN BY CHKD BY APPRVD BY
	NTS			
		11/01/2021	JPR	
WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM	SHEET NO	7 of 13	DRG NO: A2600



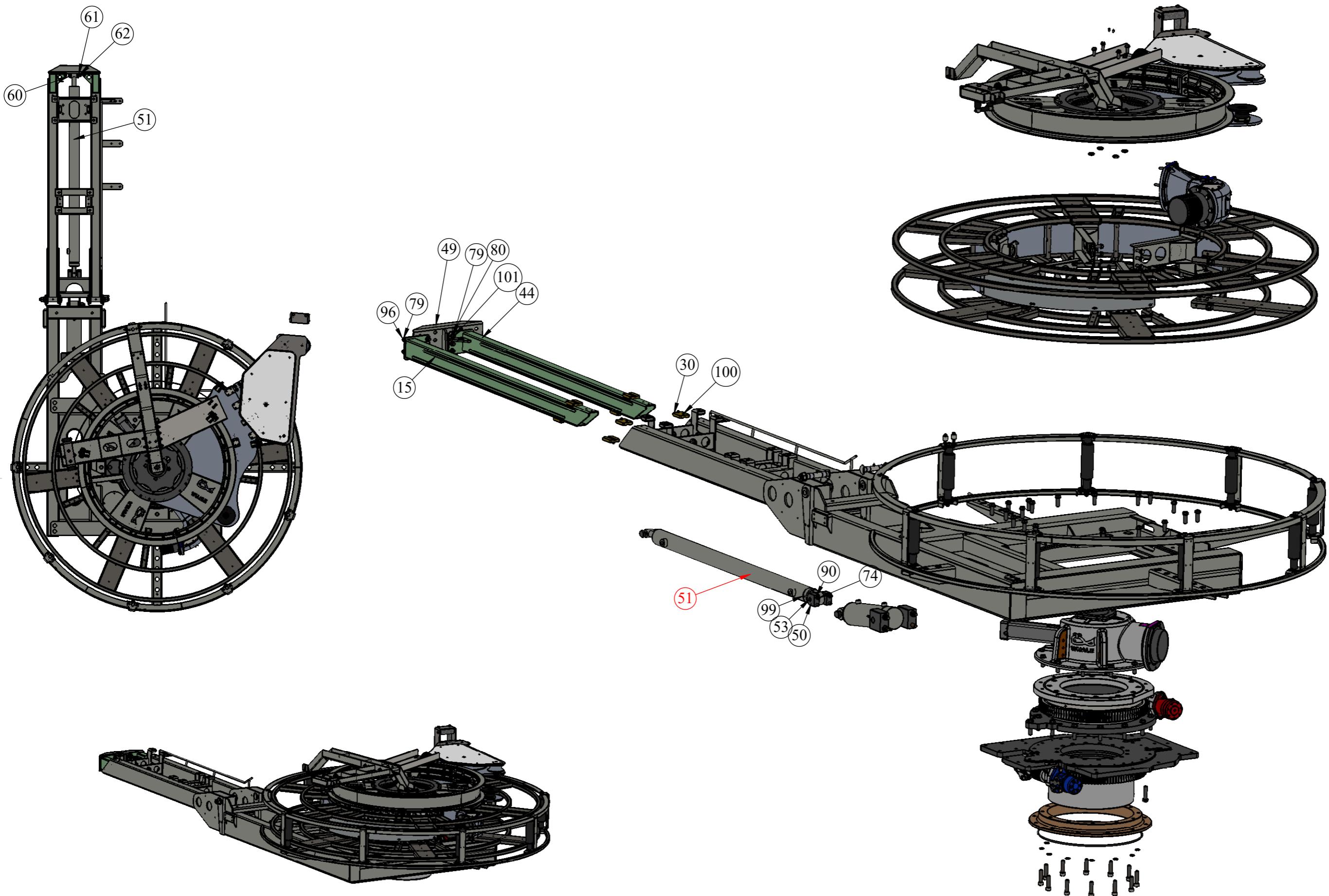
STAGE 5

[Production/Manufacturing Note](#)

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TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM		A
SUB.ASSY:		SCALE	PART NO	DATE DRWN BY CHKD BY APPRVD BY
	NTS			11/01/2021 JPR
	WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM	SHEET NO 8 of 13	DRG NO: A2600



STAGE 6

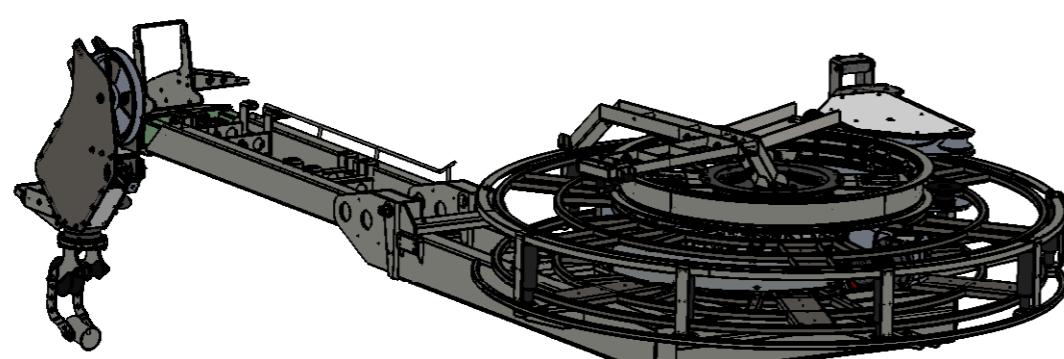
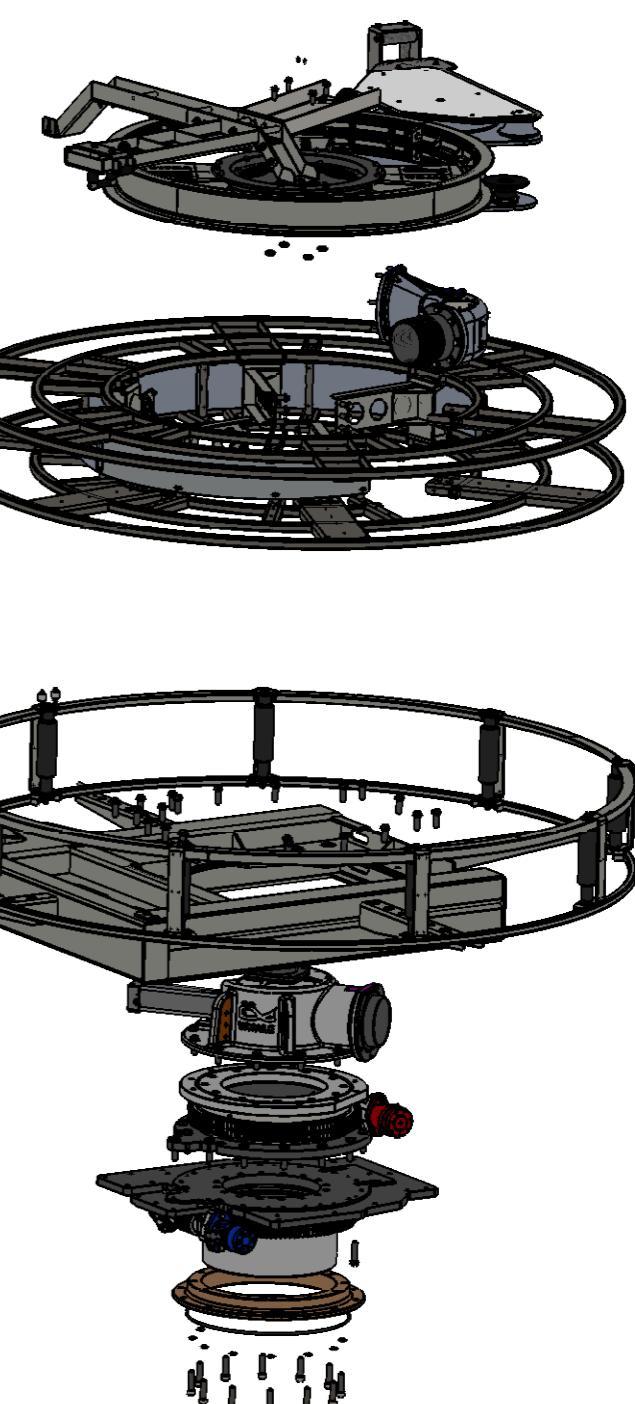
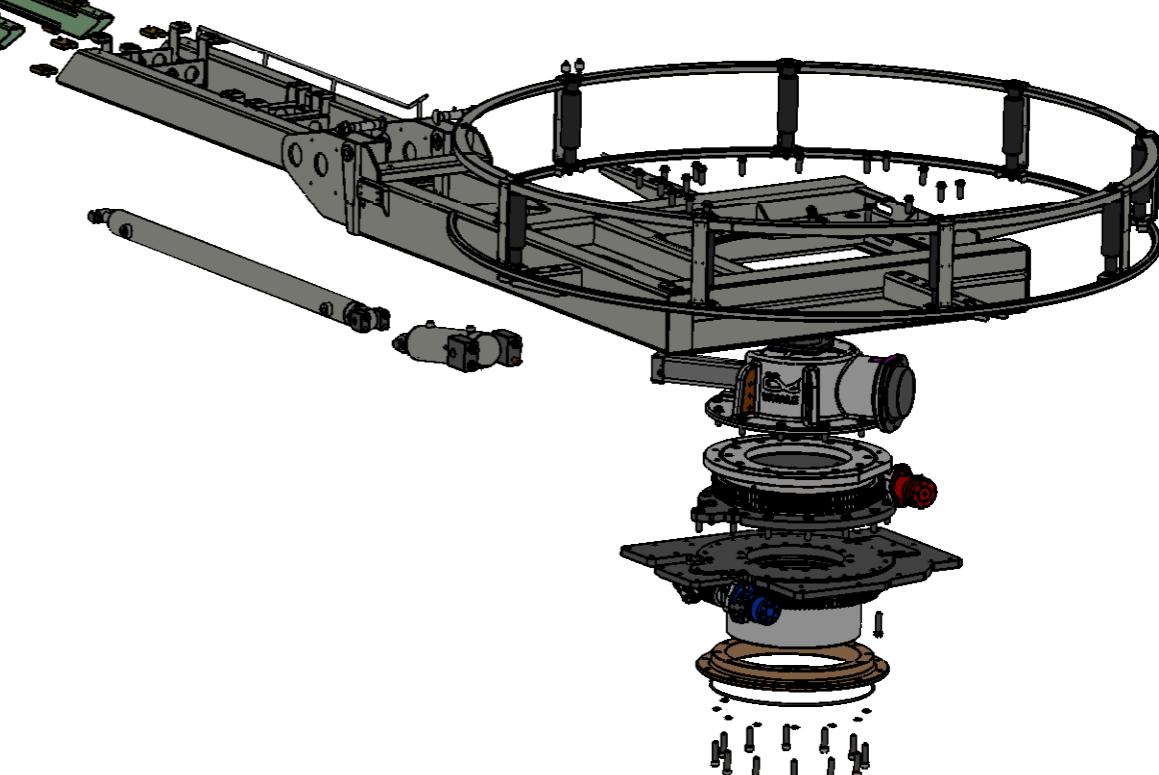
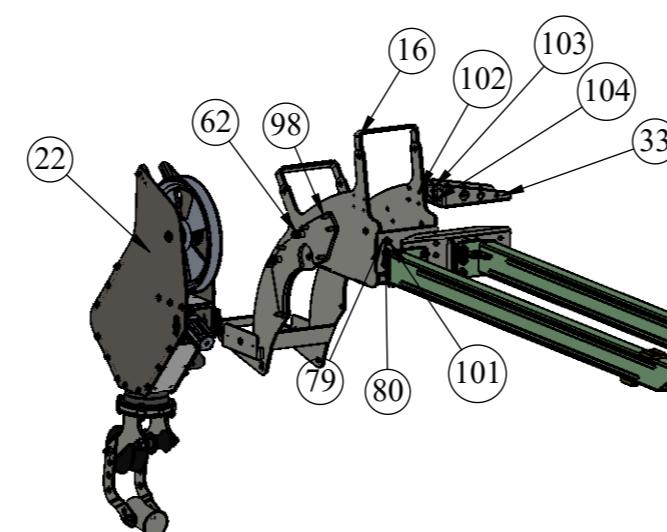
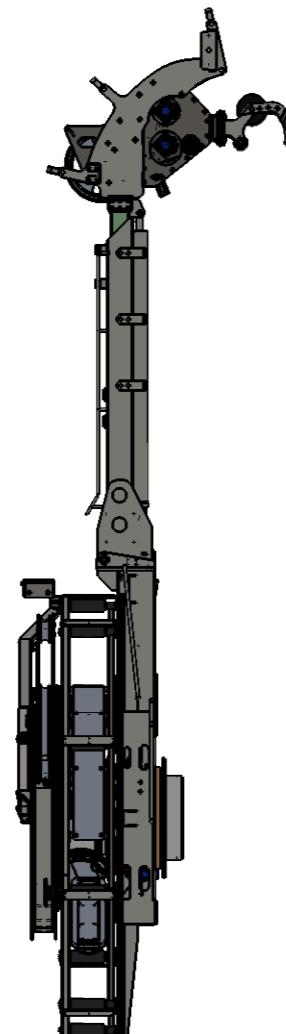
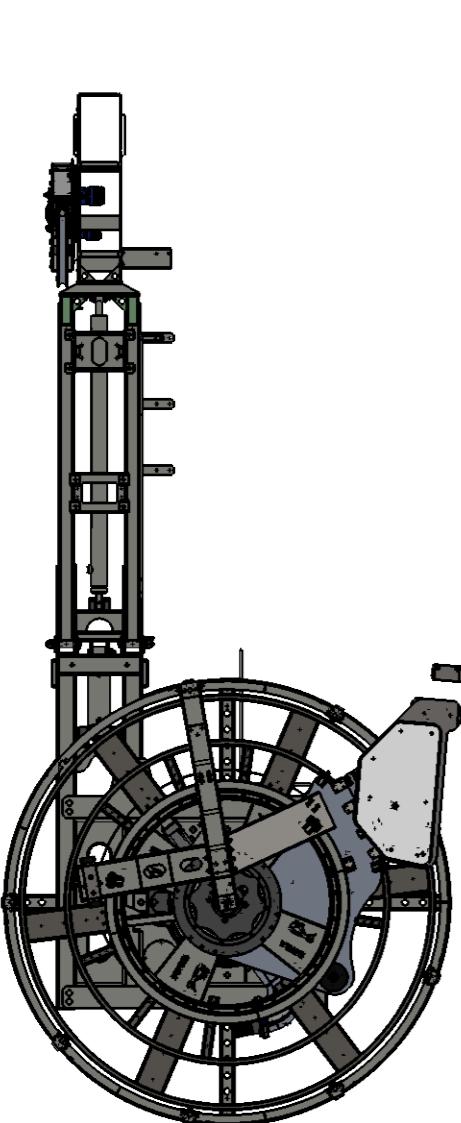
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TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM		A
SUB.ASSY:		SCALE	PART NO	DATE DRWN BY CHKD BY APPRVD BY
	NTS			11/01/2021 JPR
	WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM		DRG NO: A2600
		SHEET NO	9 of 13	

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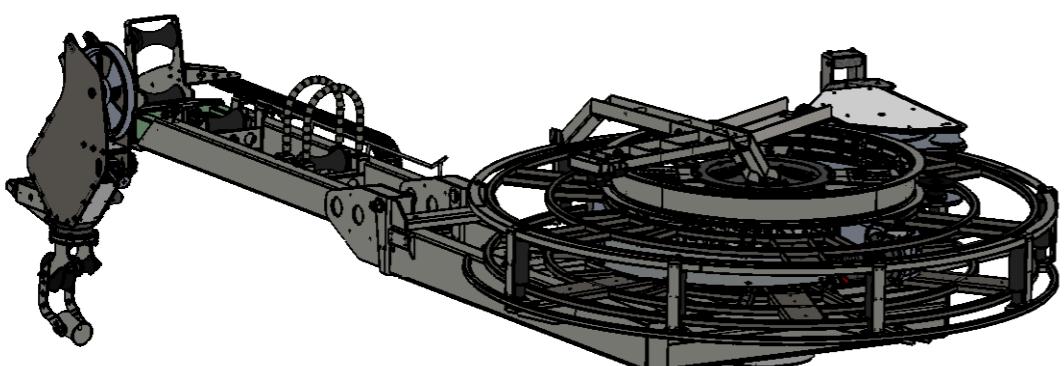
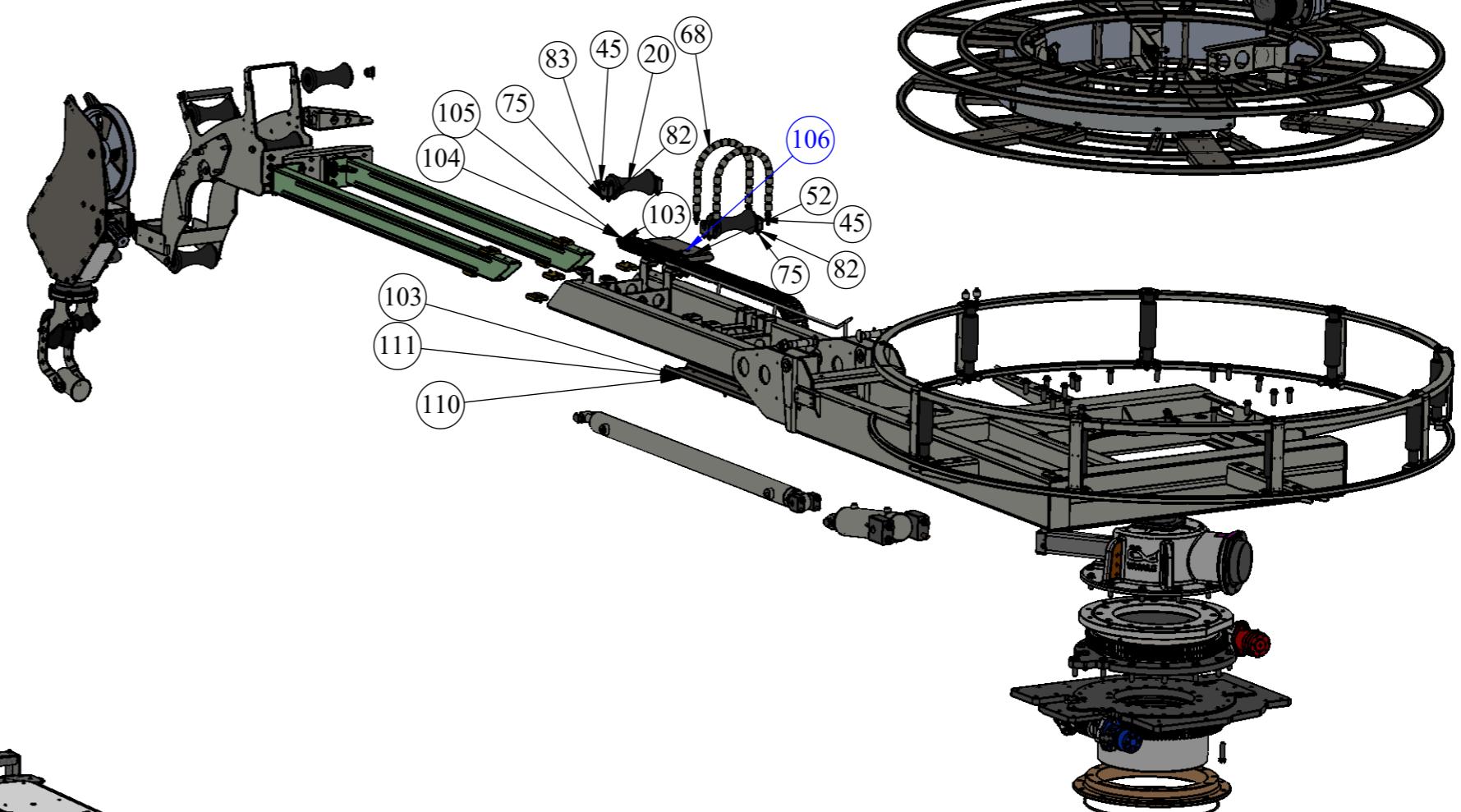
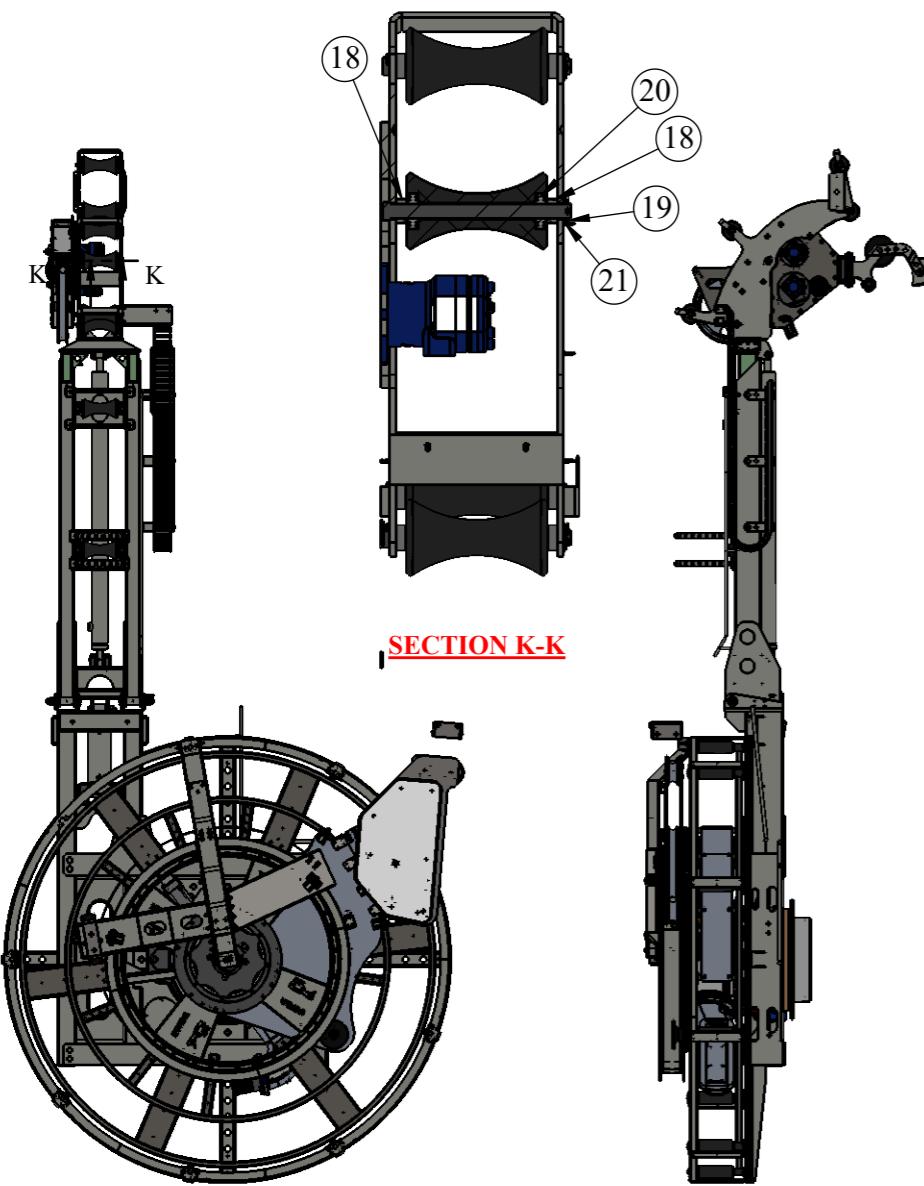
[Production/Manufacturing Note](#)

STAGE 7

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Weight:1813.68 KG

TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM		A
SUB.ASSY:		SCALE	PART NO	DATE DRWN BY CHKD BY APPRVD BY
	NTS			11/01/2021 JPR
	WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM	SHEET NO 1 of 13	DRG NO: A2600



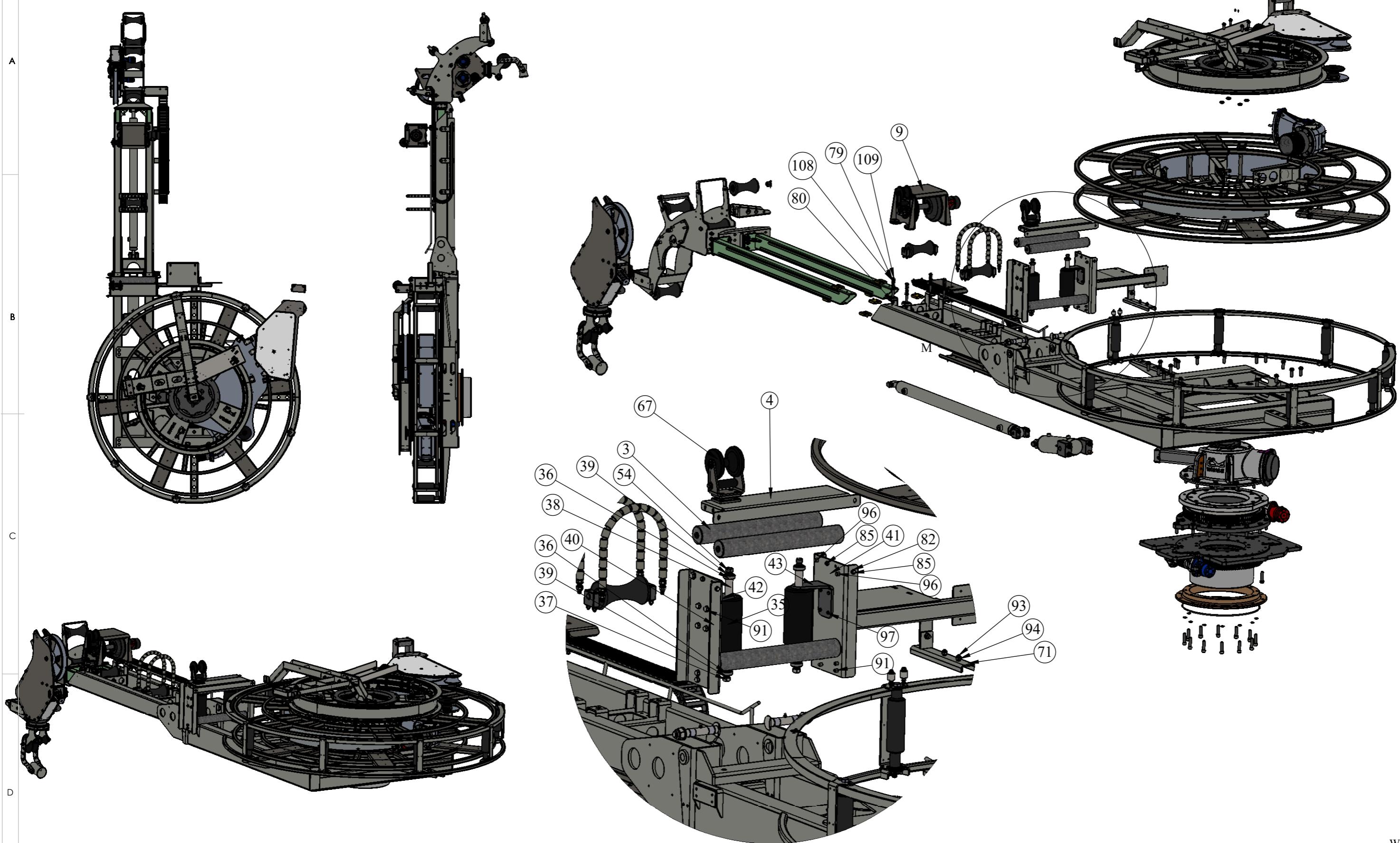
[Production/Manufacturing Note](#)

STAGE 8

Refer Standard Sheet Reference No:S050 For Unspecified Tolerance

Weight:1813.68 KG

TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM	A	
SUB.ASSY:		SCALE	PART NO	DATE DRWN BY CHKD BY APPRVD BY
	NTS			11/01/2021 JPR
WHALE ENTERPRISE(P) LTD, KALPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM	SHEET NO	1 of 13	DRG NO: A2600



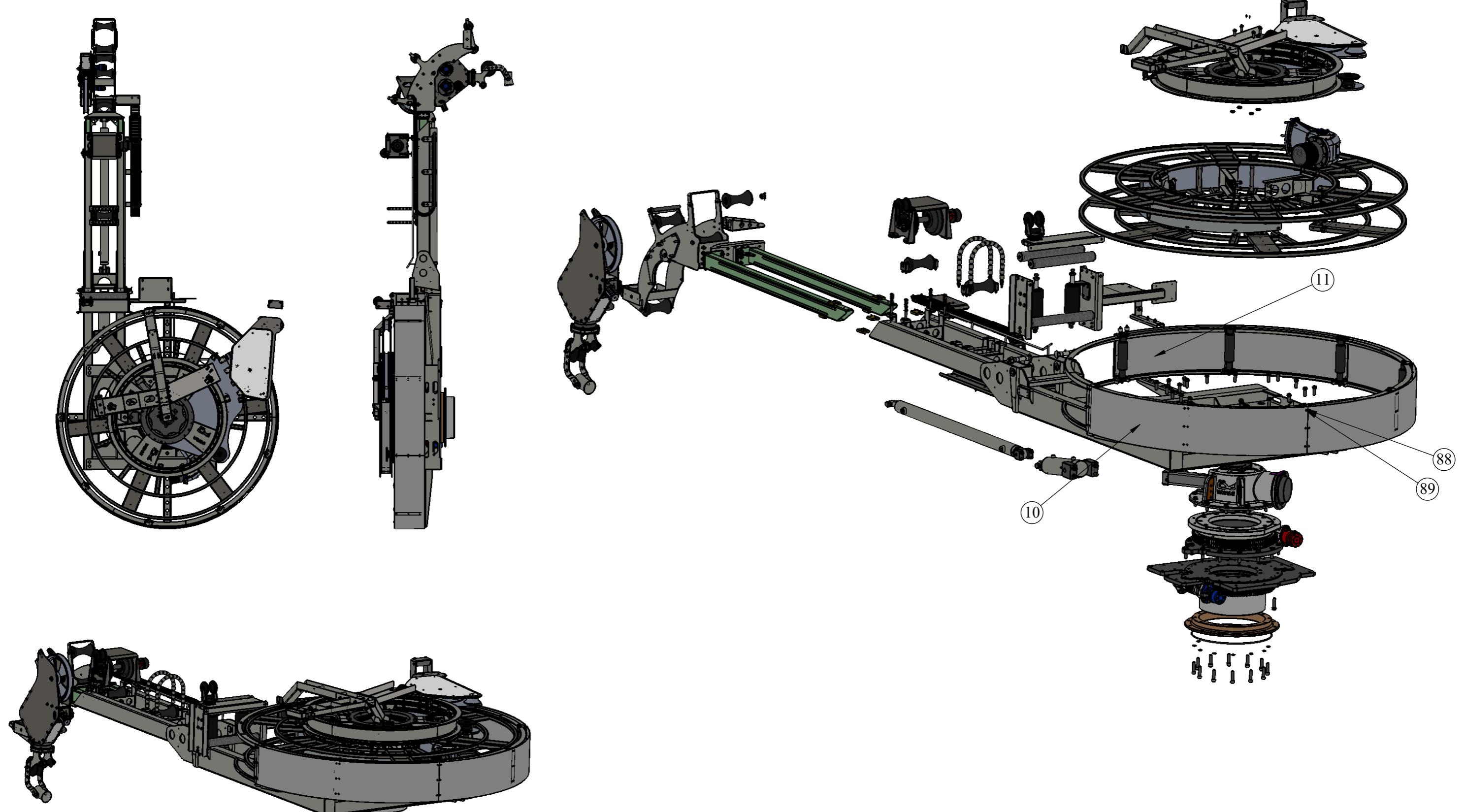
[Production/Manufacturing Note](#)

STAGE 9

Refer Standard Sheet Reference No:S050 For Unspecified Tolerance

Weight:1813.68 KG

TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM		A
SUB.ASSY:		SCALE	PART NO	
	NTS			
		DATE	DRWN BY	CHKD BY/APPRVD BY
		11/01/2021	JPR	
WHALE ENTERPRISE(P) LTD, ALL DIMENSIONS ARE IN MM KALAPATTY, COIMBATORE-641048.		DRG NO:	A2600	
		SHEET NO	1 of 13	
			2	



Weight: 1813.68 KG

Production/Manufacturing Note**STAGE 10**

Refer Standard Sheet Reference No:S050 For Unspecified Tolerance

TITLE: SEWER FLEX BOOM-SIMPLE DISMANTLE TYPE		QTY	MATERIAL	REV.NO
PRODUCT: SEWER FLEX BOOM		SEE BOM		A
SUB.ASSY:		DATE	DRWN BY	CHKD BY/APPRVD BY
	SCALE	PART NO		
NTS			11/01/2021	JPR
WHALE ENTERPRISE(P) LTD, KALAPATTY, COIMBATORE-641048.	ALL DIMENSIONS ARE IN MM	SHEET NO	1 of 13	3
				DRG NO: A2600