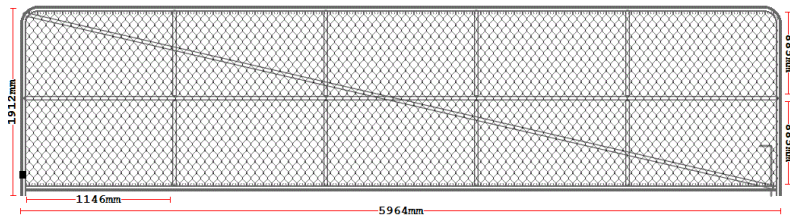


Shop Drawings

WORK ORDER WORKSHOP REPORT - 5/Jul/2024 07:36 PM shane@vinesit.com.au			
W/O Number:	WS04072024-2	Job Number:	22708
Date Issued:	5/Jul/2024 07:36 PM	Date Required:	
W/O Raised By:	Shane Cosgrove	Client:	Test Company
Job Location:	113 Exhibition Street Melbourne VIC	113 Exhibition Street Melbourne VIC	



NOMINAL WIDTH	6000
NOMINAL HEIGHT	1800
CHAIN LINK	50x3.15 KK Heavy Galvanized
SELECTED CHAIN LINK FABRIC HEIGHT	[22 LESS 0.5 DIAMOND] 1804
ACTUAL FRAME HEIGHT	1912
*GATE FRAME GALVANIZED FINISH	

Cut Crown Bar	DN32-XLG :: 1 X 4779 mm
Bend Crown Bar	851mm 3707mm 4779mm
BOTTOM RAILS	[VOGEL CUT]DN32-XLG: 1 X 2898 MM
CENTRE RAILS	
VERTICAL BRACES	[VOGEL CUT]DN25-XLG: 2 X 931 MM
DRILL HOLE FOR SHOOT BOLT	828 MM

ITEM	PIPE	WORKSHOP CUTTING & BENDING (STAGE 1)	NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
	DN32-XLG	CUT CROWN BAR RAILS	1	1.5	1.5
	DN32-XLG	BEND CROWN BAR	2	5	10
	DN32-XLG	CUT BOTTOM RAILS	1	1.5	1.5
		CUT CENTRE RAILS	0	0	0
	DN32-XLG	CUT VERTICAL BRACING	2	1.25	2.5

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ITEM	PIPE	WORKSHOP CUTTING & BENDING (STAGE 1)	NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
		VOGEL NOTCH BOTH ENDS OF BRACING RAILS	3	1	3
		DRILLING SHOOT BOLT HOLE	1	2	2
		TOTAL CUT & PREP TIME FOR GATE FRAME			20.5

ITEM	PIPE	WORKSHOP WELDING GATE FRAMES (STAGE 2.A)	NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
		SETUP TIME ON WELDING BENCH (TACKING FRAME)	6	1	6
	DN32-XLG	WELD OUTER FRAME	2	5.5	11
		WELD INTERNAL RAIL	0	0	0
	DN32-XLG	WELD VERTICAL BRACING	4	4.5	18
		TOTAL WELDING TIME FOR GATE FRAME ONLY			35

ITEM	CODE	IMAGE	WORKSHOP GATE FITTINGS (STAGE 2.B)	NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
	H8032D		TWO PART INTERLOCKING HINGES + ATTACHMENT - GALVANISED	2	1	2
	GEB12-SL		"SINGLE ("L" SHAPE) HAND HOLE (FOR TOP OF MID RAIL) (12MM ROD - 90MM X 186MM) FOR STANDARD SINGLE GATE SHOOT BOLT- GALVANISED"	1	1	1
	GDB370		SHORT DROP BOLTS - GALVANISED	1	1	1
	B8		SHOOT BOLT (WITH SLIDE PLATE) - GALVANISED	1	2	2
	HCR		HINGE COLLAR	1	3	3
			TOTAL WELDING TIME FOR SELECTED WELD ON GATE FITTINGS ONLY			9

ITEM	WIRE UP GATE FRAMES (STAGE 3)	NUMBER OF UNITS	MINUTES PER UNIT	TOTAL MINUTES
STEP 1	DE-SCALE WELDS & PRIME PAINT ALL WELDS	6	1	6
STEP 2	FIT CHAIN LINK TO GATE FRAME BASED ON M2	3SQM	2	6
STEP 3	TRIM & KNUCKLE CHAIN LINK TO BOTTOM RAIL M	2.9	2.5	7.25
STEP 4	SHAPE IN HAND HOLES	1	1	1
STEP 5	LOAD UP GALV LACING WIRE TO NEEDLE KG	0.47 KG	4	1.88
STEP 6	LACE UP PERIMETER OF GATE FRAMES	8M	5	40
	TOTAL LACING TIME FOR GATE FRAME ONLY			62.13 MIN

SETUP TIME ALLOWANCE BETWEEN STAGES 1 TO 3	18
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TOTAL O/ALL MINUTES ALLOWED FOR MANUFACTURER OF GATE (BASED ON CURRENT STANDARDS)

144.63

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