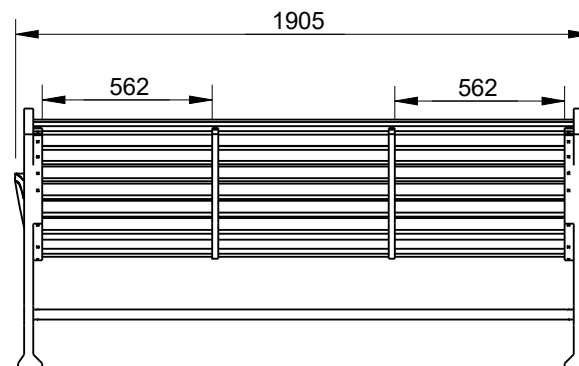
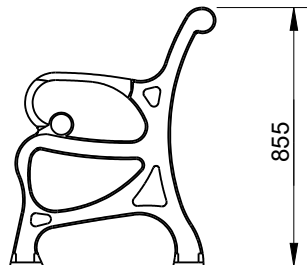
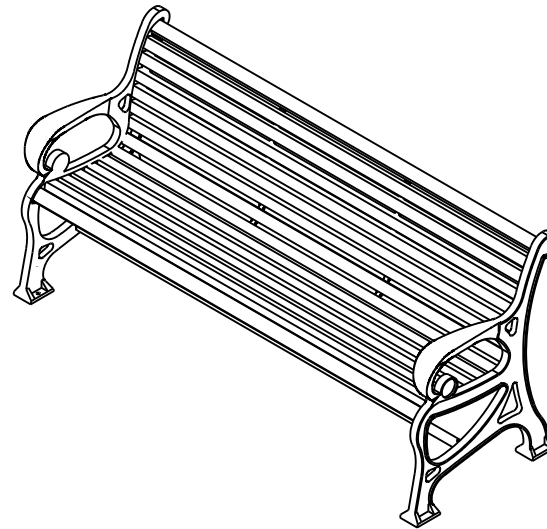
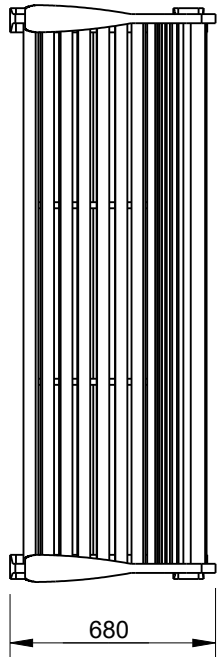




SPECIFICATION:

MATERIAL:

Seat ends - Cast aluminium
Straps - Mild steel
Slats - Hardwood timber

DIMENSIONS:

mm unless otherwise stated

FINISH:

Castings - Powder coated
Straps - Powder coated
Timber - Oil based

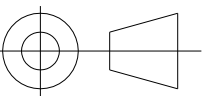


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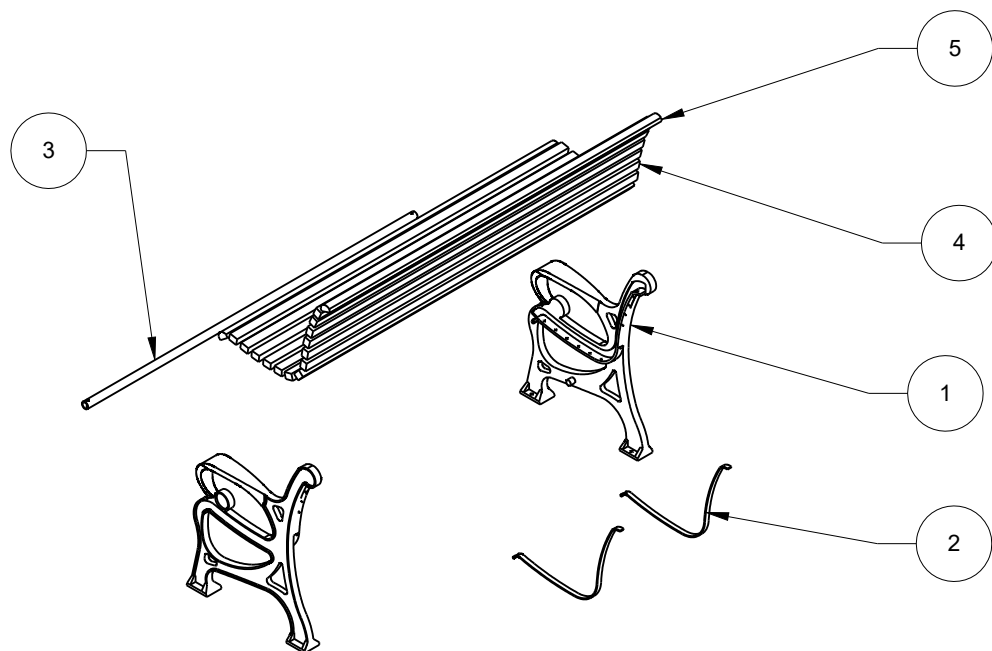
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REVISION	#	DESCRIPTION	BY	DATE	DRAWN	DRAWN DATE	CHECKED	CHECKED DATE	SCALE	A4
	1	ORIGINAL DRAWING	DN	24.11.10	R.CRIGTON	3.11.13			N/A	
	2	FULL PRODUCT REVIEW	RBC	3.11.13						
	3									
	4									
	5									
					 		ROTHERMAN SEAT SPEC.			
							FFSA002019	REV. 2	SHEET 1 OF 4	

ITEM	PART NUMBER	DESCRIPTION	QTY	COMMENT
1		ROTHERMAN SEAT CASTINGS	1	SET
2	RSFB20X5	STRAP ROTHERMAN	2	GALVANISED/PC
3	RSCHS25NBM	PIPE 25NB STD WEIGHT, 1788 LG	1	GALVANISED/PC
4	TIMCHA50X30X1800	TIMBER SLAT 50x30 1800 LG	13	
5	TIMBOWROTHERMANBN	BULLNOSE TIMBER SLAT 1800LG	2	
6	PFIX0900060	BUTTON SECURITY SCREW T25 S/S	60	
7	PFIX0900013	COACH BOLT, 1/4" x 1 3/4" LG c/w NUT	2	



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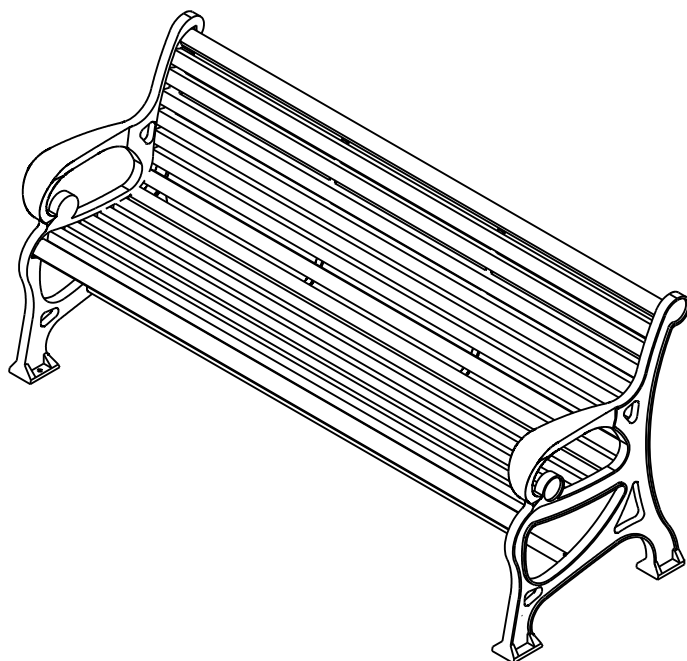
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	2	FULL PRODUCT REVIEW	RBC	3.11.13			ROTHERMAN SEAT BOM					
	3											
	4						FFSA002019		REV. 2	SHEET 2 OF 4		
	5											

PROCEDURE

CASTINGS & STRAPS

1. Inspect and repair any imperfections, then fettles castings.
2. Using correct jigs, mark timber mounting holes to casting, centre punch and drill to 7/32.
3. Drill holes in feet to 7/16.
4. Drill 5/16 holes in knob protruding from casting for pipe.
5. Drill 5/16 hole in each end of pipe for fixing to casting.
6. Drill straps to 7/32 using correct jig (before bending)
7. Using jig and correct dies, press centre straps.



ASSEMBLY

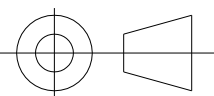
1. Inspect castings for any imperfections
2. Place 25NB gal pipe into position and fasten loosely
3. Slide centre timber into place and fasten loosely
4. Slide back timbers into place and fasten one end only at a time
5. Place all T25 screws into timbers and fasten loosely
6. Using a clamp, clamp top of seat to position to timber and fasten
7. Tighten remaining timbers
8. Place seat onto back and slide all timbers into place fastening one side only
9. Place all remaining T25 screws into timber and fasten loosely
10. Place clamp on end off casting to position last timber and fasten
11. Tighten all remaining timbers
12. Turn seat face down and place straps 600mm from cast ends and fasten, ensure they are square on seat
13. Tighten 25NB gal pipe
14. Place completed seat aside for Final Inspection and packaging.



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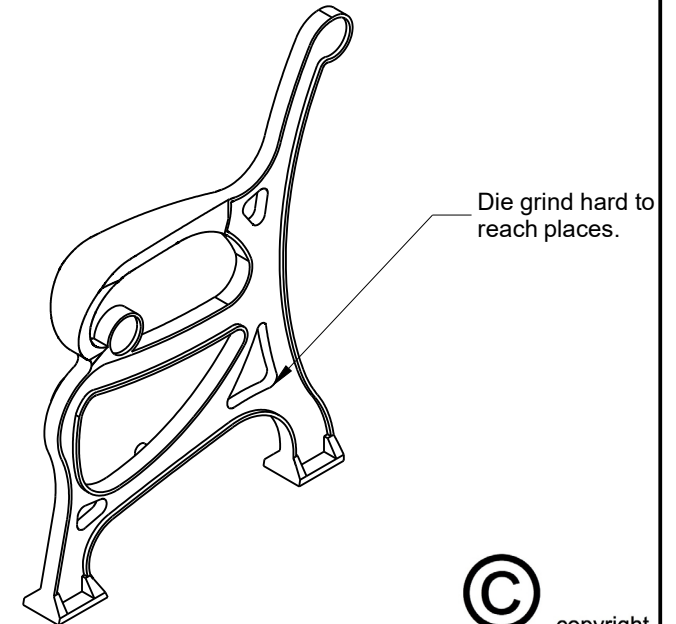
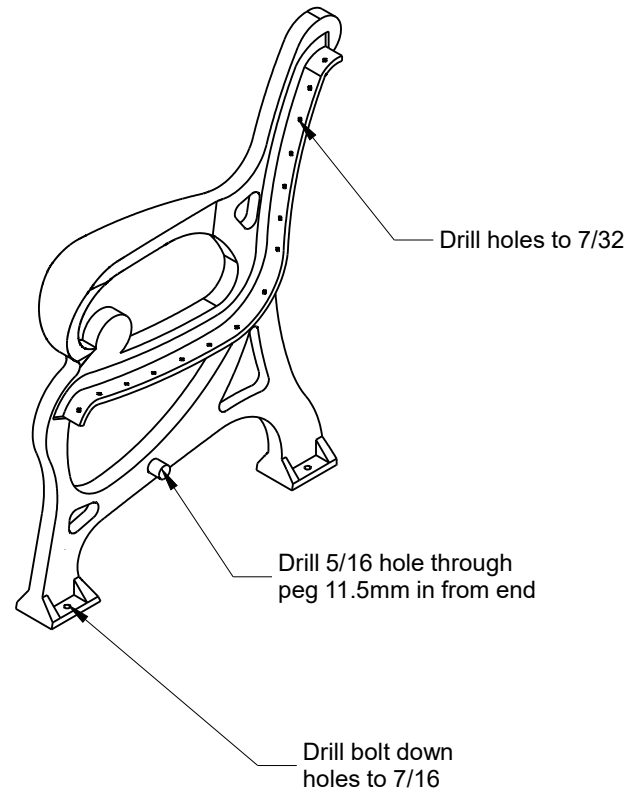
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	2	FULL PRODUCT REVIEW	RBC	3.11.13			ROTHERMAN SEAT ASSEMBLY & PROCEDURE					
	3											
	4						FFSA002019				REV. 2	SHEET 3 OF 4
	5											

Finish: Powder coated (painted)

NOTE: For fettling/grinding/finishing refer to - Fettling Procedure (Grinding steps) sheet.



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SIGNIFICANT CHARACTERISTICS TO BE INSPECTED

Surface finishes/
imperfections

Hole sizes &
positioning

To be mill or
powder coat
product

**Tick if
correct:
Notes or
faults:**

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REVISION	#	DESCRIPTION	BY	DATE	DRAWN	DRAWN DATE	CHECKED	CHECKED DATE	SCALE	A4			
	1	ORIGINAL DRAWING	DN	24.11.10	R.CRIGTON	3.11.13			N/A				
	2	FULL PRODUCT REVIEW	RBC	3.11.13			ROTHERMAN SEAT FETTLING PROCEDURE						
	3												
	4						FFSA002019				REV. 2	SHEET 4 OF 4	
	5												