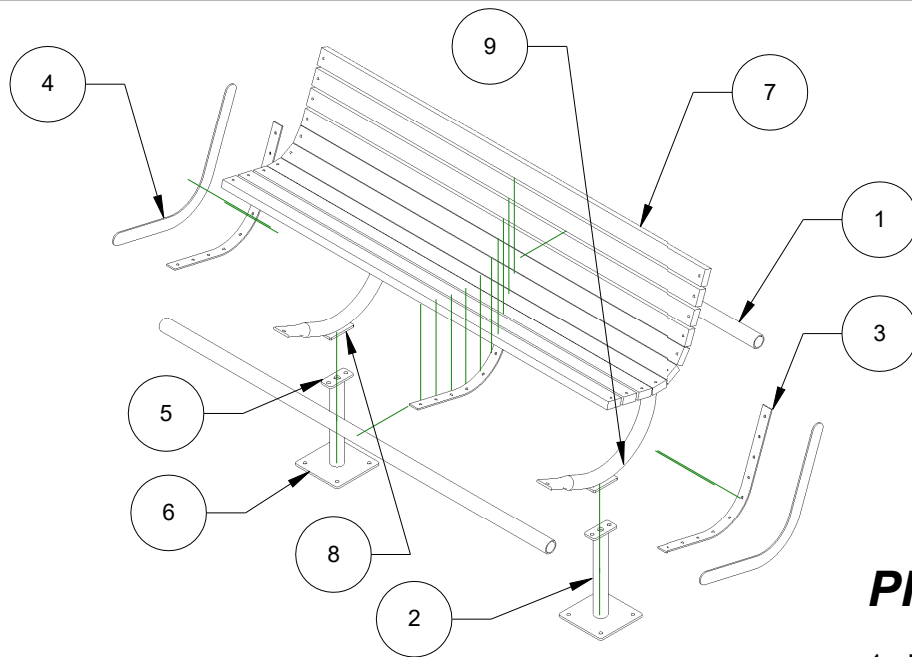




ITEM	PART NUMBER	DESCRIPTION	QTY
1	RSCHS40NBM	PIPE, 40 NB, 1804 LG	2
2	RSCHS40NBM	PIPE 40NB STD WEIGHT, 335 LG	2
3	RSFB40X5	SLAT 40x5 744LG	3
4	PCOM0900212	SEAT END PROFILE	2
5	PCOM0900210	THREE HOLE CLEAT	2
6	PCOM0900256	STANDARD BASE PLATE	2
7	TIMCHA63X30X1800	TIMBER SLAT 63x30 1800 LG	10
8	PCOM0900211	2 HOLE CLEAT	2
9	RSCHS40NBM	PIPE 40NB STD WEIGHT 845 LG	2
10	PFIX0900029	TIMBER TEKS	10
11	PFIX0900002	HEX BOLT, 3/8" x 3/4" LG	4
12	PFIX090013	COACH BOLT, 1/4" x 1 3/4" LG c/w NUT	20



PROCEDURE:

1. Ensure you the correct materials, deburr and clean laser cut edges.
2. Take 40x5 slat support straps place in correct jig and drill to 5/16". Using correct dies and jigs press support straps (see sample).
3. Take back support 40NB pipe @ 845 and drill 3/8" hole either end 10mm in using seam as locator. Use pipe bender to bend back supports. Use correct jigs in press to squash each end of back support 50mm in and kink ends so it sits nicely in jig welding. There is a sample back support jig to G3 your work against
4. Drill 3/8" gal holes in main pipe 10mm in and using seam as locator.
5. Position main pipes in jig with gal holes facing up the right direction, place slat supports, back rest and seat end profiles in jig.
6. Tack all components together and weld where accessible.
7. Take 2 hole cleats and tap to 3/8" use correct jig and position cleats, tack and weld.
8. Remove from jig complete welding, clean and prep for galvanizing
9. For bolt down legs place all components in correct jig and tack together, remover from jig check plumb and square and weld off.



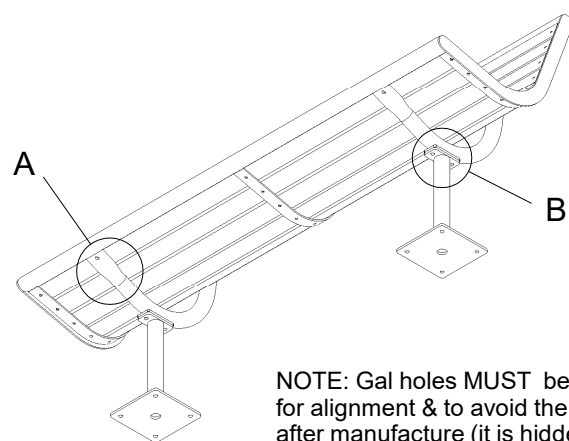
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REVISION	#	DESCRIPTION	BY	DATE	DRAWN	DRAWN DATE	CHECKED	CHECKED DATE	SCALE	A4	
	1	ORIGINAL DRAWING	DN	3.9.10	R.CRIGTON	14.11.13			N/A		
	2	FULL PRODUCT REVIEW	RBC	14.11.13			WOODGROVE SEAT - BOLT DOWN BOM, PROCEDURE				
	3										
	4						FFSB002004				
	5										REV. 2

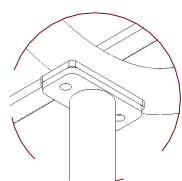
SIGNIFICANT CHARACTERISTICS & DETAIL:

DETAIL A: This shows the back support pipe gal hole and squashed detail.

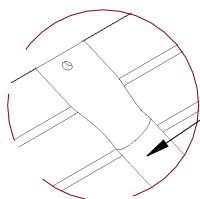
DETAIL B: This shows cleat detail and positioning.



NOTE: Gal holes MUST be drilled on pipe seam for alignment & to avoid the seam being visible after manufacture (it is hidden underneath)



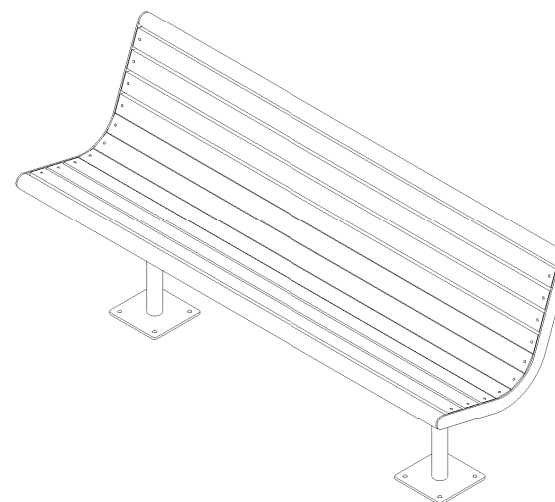
Detail B



Detail A

ASSEMBLY

1. Inspect seat profiles
2. Fix all timbers to seat profiles and fasten loosely
3. Tighten all timbers
4. Place seat face down and fix centre strap to timbers using tek screws
5. Place completed seat to the side for Final Inspection and packaging.



Quality
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	1	ORIGINAL DRAWING	DN	3.9.10	R.CRIGTON	14.11.13			N/A	
	2	FULL PRODUCT REVIEW	RBC	14.11.13						
	3									
	4									
	5									
						WOODGROVE SEAT - BOLT DOWN ASSEMBLY				
						FFSB002004		REV. 2	SHEET 3 OF 3	