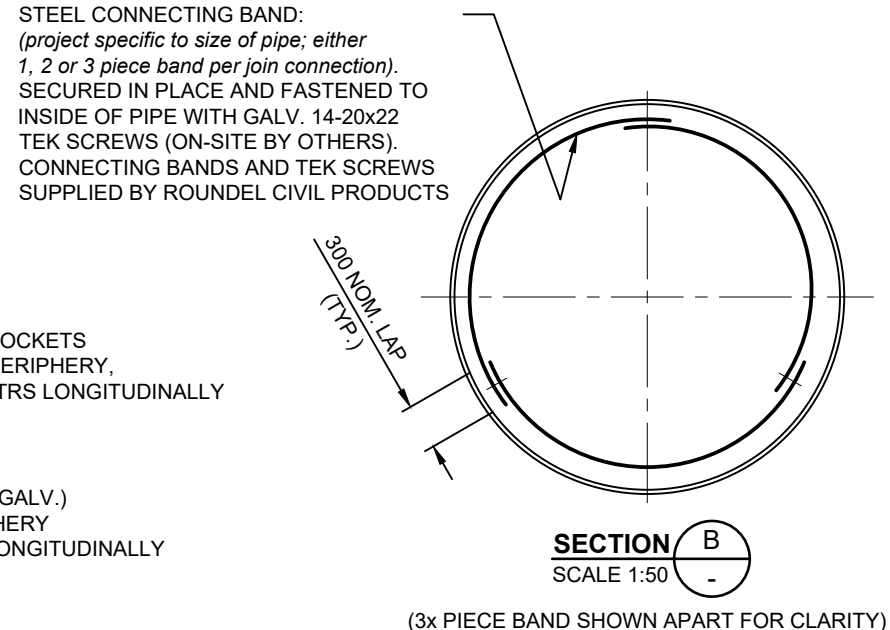
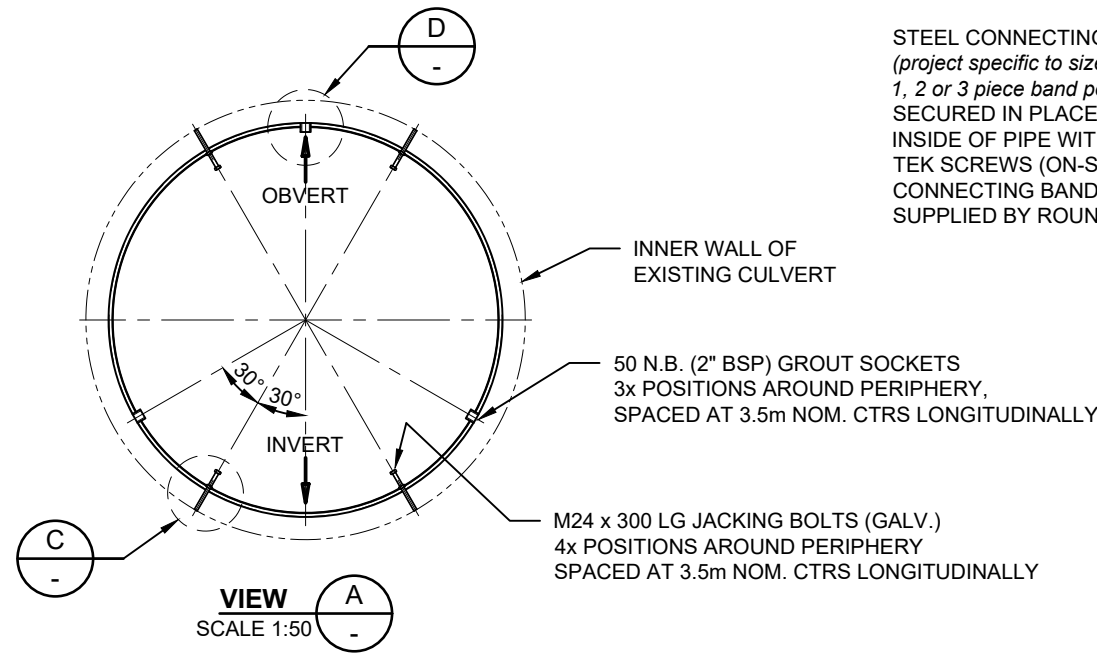
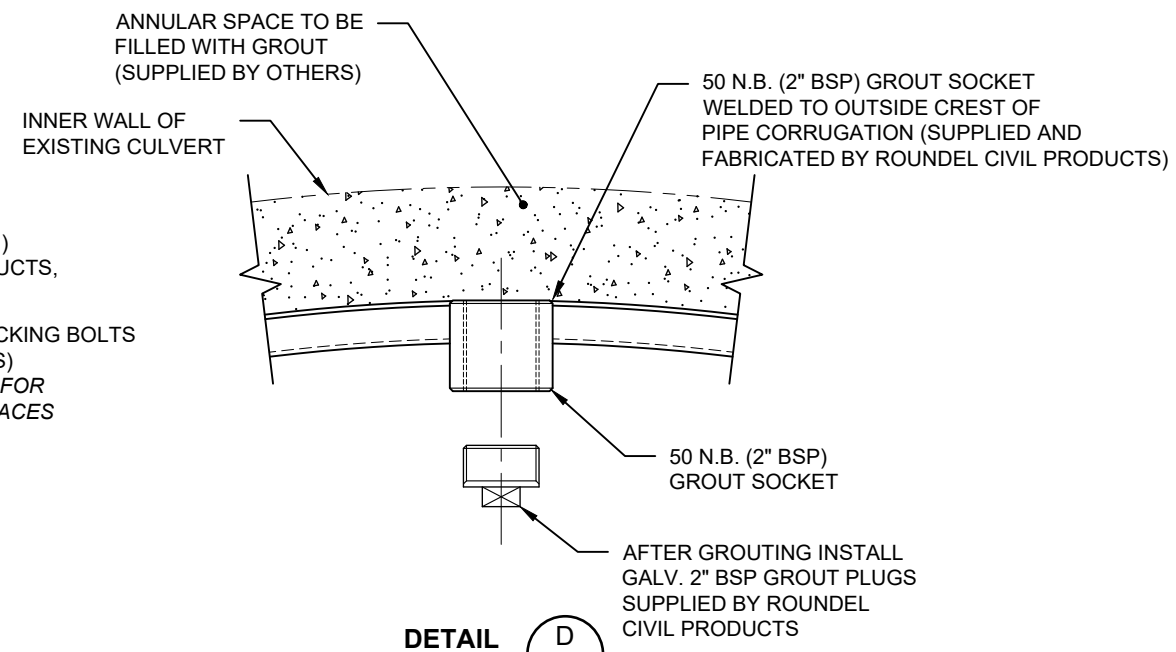
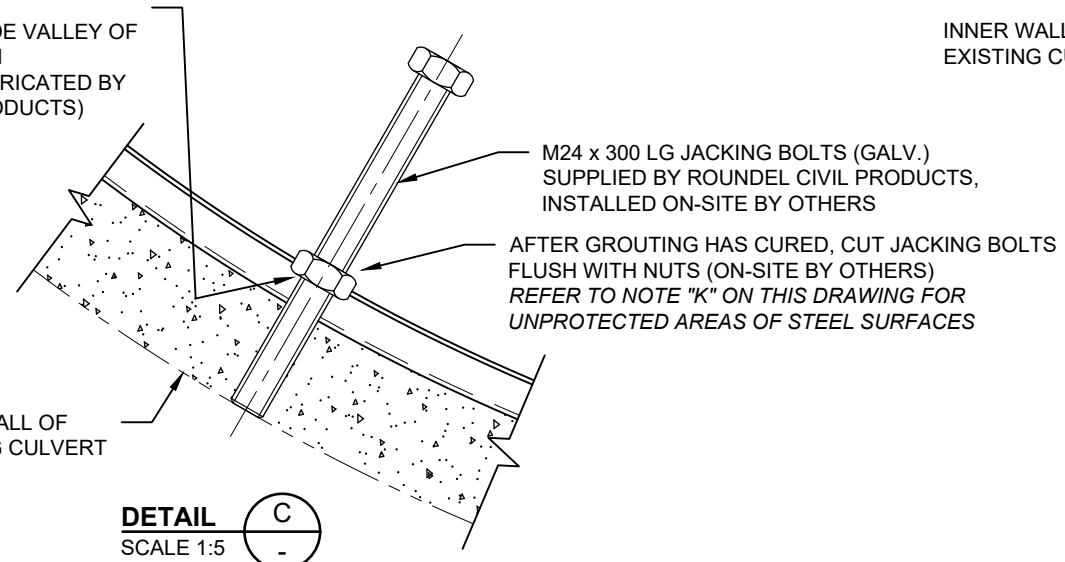


M24 NUTS (GALV.)
WELDED TO OUTSIDE VALLEY OF
PIPE CORRUGATION
(SUPPLIED AND FABRICATED BY
ROUNDEL CIVIL PRODUCTS)



GENERAL:

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- All dimensions are in millimetres, unless noted otherwise.
- All dimensions are subject to manufacturing and installation tolerances in accordance with the following specifications.

MATERIALS, TOLERANCES AND MANUFACTURE:
(in accordance with AS/NZS2041.4:2010 Section 2)

- STILCOR (CSP) manufactured with using galvanized steel strip complying with the requirements of AS 1397 for steel base grade G250 and galvanized to Z600 or;
- Galvanized steel strip of grade G230 minimum and galvanized to Z600 with a polymer coating in accordance with ASTM A742.
- Steel connecting bands shall be manufactured from materials having the same composition and coated to the same thickness of protective coating as the pipes which they are to join.
- STILCOR (CSP) pipe tolerances comply with the following;
 - Length = $\pm 1\%$,
 - Average internal diameter, measured as the mean of a pair of internal measurements taken mutually at right angles to internal crests = $\pm 6\text{mm}$ or $\pm 1\%$ whichever is greater of the specified diameter.
 - A pipe shall be round such that the major axis diameter does not exceed the minor axis diameter by more than 2%.
- Galvanized Jacking bolts and nuts in accordance with AS 1111 and AS 1112 respectively.
- Galvanized Grout Sockets and Square Head Plugs manufactured in accordance with the BS EN 10241:2000 standard.
- Component welding in accordance with AS/NZS 1554.1:2004, Grade GP U.N.O

INSTALLATION:

- Unprotected areas (i.e. after component welding, coating damaged) shall be treated with zinc rich paint for galvanized pipes and or Watty Killrust epoxy gloss enamel paint (Black) for polymer coating pipes.
- Nominal Grout compressive strength for annular space = 5MPa
- Typical Grout mix by volume ratio;
 - Sand to Cement = 2-2.5 : 1
 - Water to Cement = 0.4-0.45 : 1
 - Fluidifier to Cement = 1 : 100

F						
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A	06 JUN 18	INITIAL ISSUE	BF	BF		
Rev	Date	Revision Description	Drawn	Draft Chk	Des Eng	Lead Eng

A3 Scale:
AS SHOWN

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CORRUGATED STEEL PIPES (CSP)
CULVERT INSTALLATION
CULVERT RELINE DETAILS

Drq No. RCP-STD-CSP-06