

# Hi-SPAN

## PRODUCTION DRAWINGS 2017



CONTROL ISSUE:

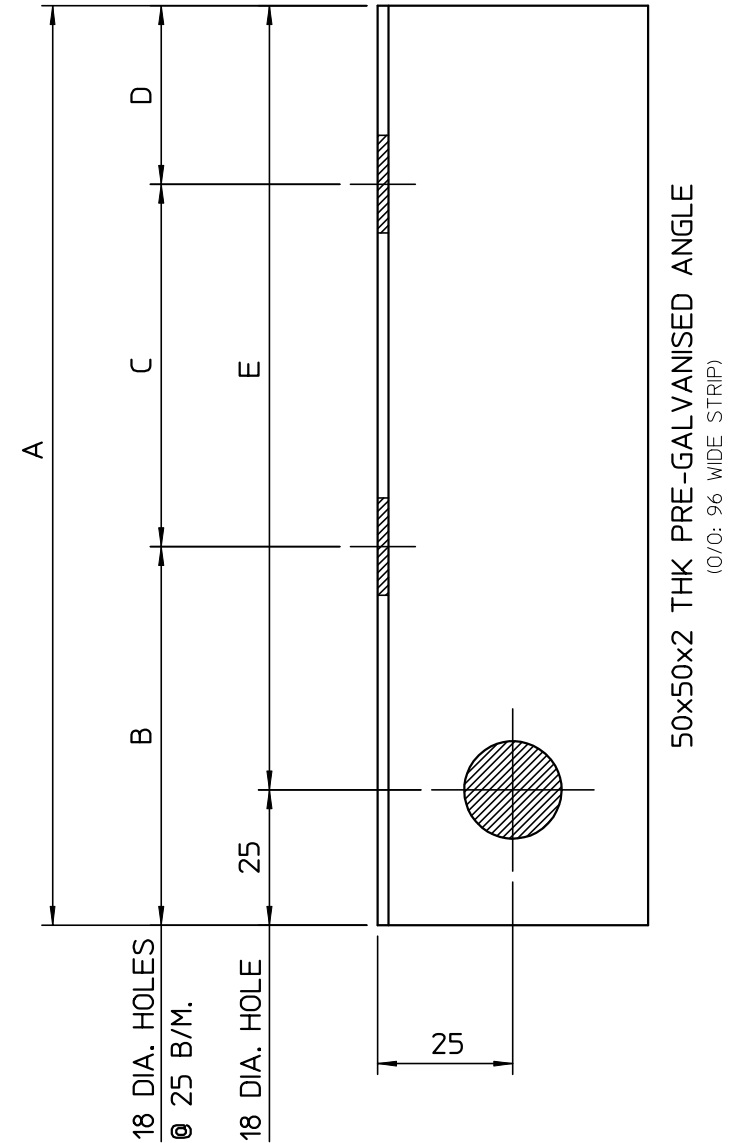
# Hi-Span Production Drawings Register 2017

6<sup>TH</sup> ISSUE

<u>DRG. No.</u>	<u>REV.</u>	<u>DESCRIPTION</u>	<u>DRG. No.</u>	<u>REV.</u>	<u>DESCRIPTION</u>
HSP-001		Angle Cleats-A15,A17,A20,A23,A25,A30 & A35	HSP-027		Bolt On Cleat 30
HSP-002		Apex Tie Cleat	HSP-028		Bolt On Cleat 35
HSP-003		Ball Type Washer	HSP-029		Wel On Cleat
HSP-004		Bracket Type A for Diagonal Bracing	HSP-030		Rafter/Column Stays
HSP-005		Bracket Type A Thickened	HSP-031		Rigid Apex Strut
HSP-006		Channel & Mezzanine Floor Beam - Cleats	HSP-032		Rigid-Fix Strut End Cleats
HSP-007		Clamp Plate Dimensions	HSP-033		Rigid-Fix Strut
HSP-008		Cleader Rail	HSP-034		Rigid-Fix Strut Assembly
HSP-009		Cleader Rail Jointing Sleeve	HSP-035		Rigid-Fix Strut Assembly Cont.
HSP-010		Cold Rolled Section - C-Channels	HSP-036		Screwed End Sag Bar
HSP-011		Cold Rolled Section - Eaves Beams	HSP-037		Screwed Sag Bar End 20mm
HSP-012		Cold Rolled Section - Mezzanine Floor Beams	HSP-038		Screwed Sag Bar End 32mm
HSP-013		Cold Rolled Section - z Purlins	HSP-039		Screwed Sag Bar End 100mm
HSP-014		Cold Rolled Section Tolerances	HSP-040		Sleeves C Section
HSP-015		Counter Formed Plate Dimensions	HSP-041		Sleeves C Section > 1.8mm
HSP-016		Diagonal Wire Brace Detail	HSP-042		Sleeves Z Section
HSP-017		Eaves Beam Cleat	HSP-043		Strut to Eaves Beam Cleat Assembly
HSP-018		Eaves Beam Double Stiffener Cleat	HSP-044		Strut to Eaves Beam Cleat Assembly 309 / 359
HSP-019		Eaves Beam Single Stiffener Cleat	HSP-045		Strut to Eaves Beam Cleat Details
HSP-020		FB Bracket	HSP-046		Top Hat Assembly Drawing
HSP-021		Fire Boundary Wall Conditions	HSP-047		Top Hat Sections & Sleeves
HSP-022		Bolt On Cleat 15	HSP-048		Vertical Cladding Rail Assembly
HSP-023		Bolt On Cleat 17	HSP-049		Vertical Cladding Rail Cleats
HSP-024		Bolt On Cleat 20	HSP-050		Vertical Cladding Rail Cleats to Underside of Eaves Beam
HSP-025		Bolt On Cleat 23	HSP-051		Vertical Cladding Rail Dimensions
HSP-026		Bolt On Cleat 25	HSP-052		WCP Assembly Drawing
HSP-SET		Hi-SPAN Production Drawings - Complete Set			

PURLIN TYPE	A	B	C	D	E	MARK
156	200	100	67	33	175	A15
176	220	100	87	33	195	A17
206	250	103	116	31	225	A20
238	280	100	146	34	255	A23
258	290	112	146	32	265	A25
309	340	112	196	32	315	A30
359	385	112	241	32	360	A35

ANGLE CLEATS - A15, A17, A20, A23, A25, A30 & A35  
(FOR PURLIN TYPES 156, 176, 206, 238, 258, 309 & 359)



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
ANGLE CLEATS - A15, A17, A20, A23, A25, A30 & A35

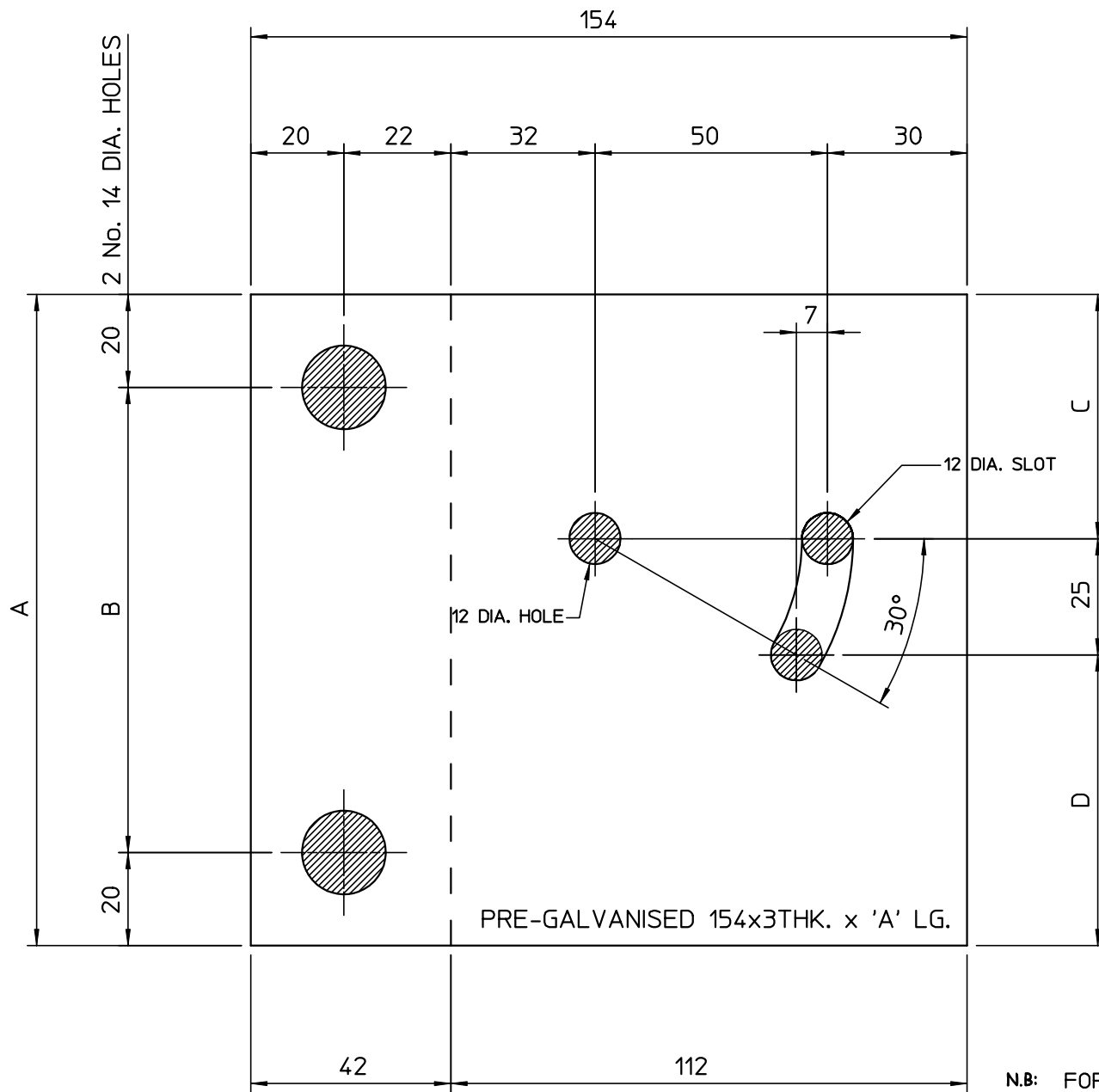
DRWN BY: DATE:

DRG No: HSP-001 Rev: ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN ACCORDANCE WITH BS EN ISO9001

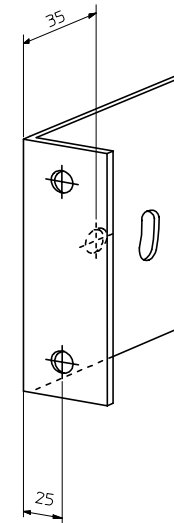
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N.B: FOR ANGLES ABOVE 30°  
ADDITIONAL SLOTS WILL  
BE REQUIRED AND CLEATS  
MAY BE NON-STANDARD

MARK	A	B	C	D
AC15	107	67	41	41
AC17	127	87	51	51
AC20	156	116	65	66
AC23	186	146	80	81
AC25	186	146	80	81
AC30	236	196	105	106
AC35	281	241	128	128



N.B: FOR EVERY AS DRN CLT AN OPP HAND CLT WILL BE REQUIRED  
POST FIXED 'X' i.e, AC15X, AC17X, AC20X, AC23X, AC25X, AC30X & AC35X.



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
APEX TIE CLEAT

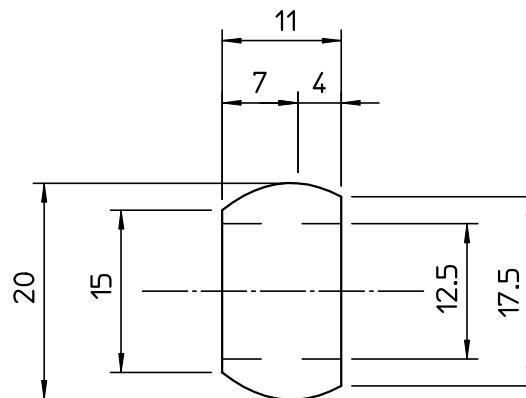
DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_

DRG No: HSP-002 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN  
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BALL TYPE WASHER



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 BALL TYPE WASHER

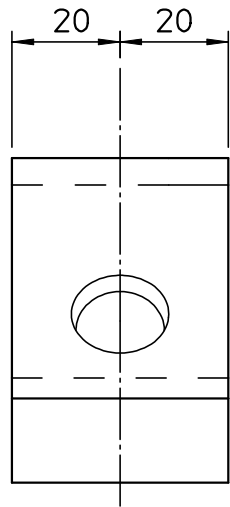
DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_

DRG No: HSP-003 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

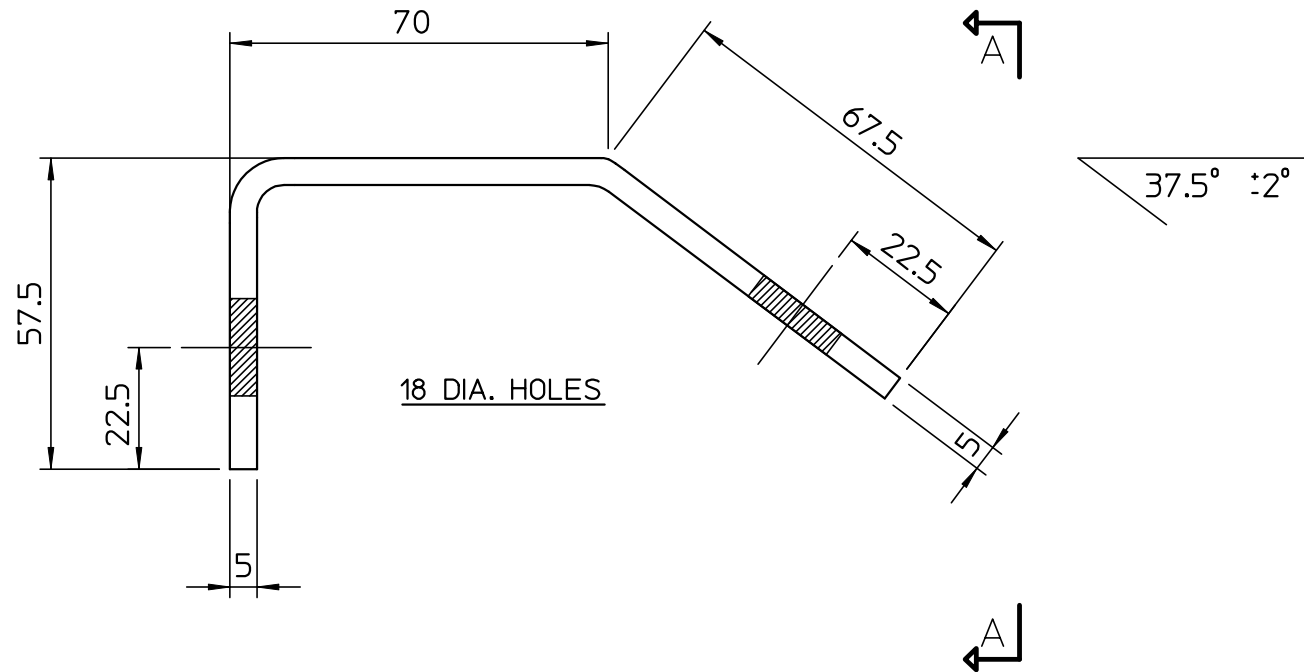
MATERIAL: MANUFACTURED FROM EN1A (230M07) LOW  
 CARBON-MANGANESE STEEL

NOTES: 1: Tolerance + / - 0.5mm  
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VIEW 'A-A'



**BRACKET TYPE A**

GRADE S275 (o/o 180 x 5 PLT x 40 LNG)



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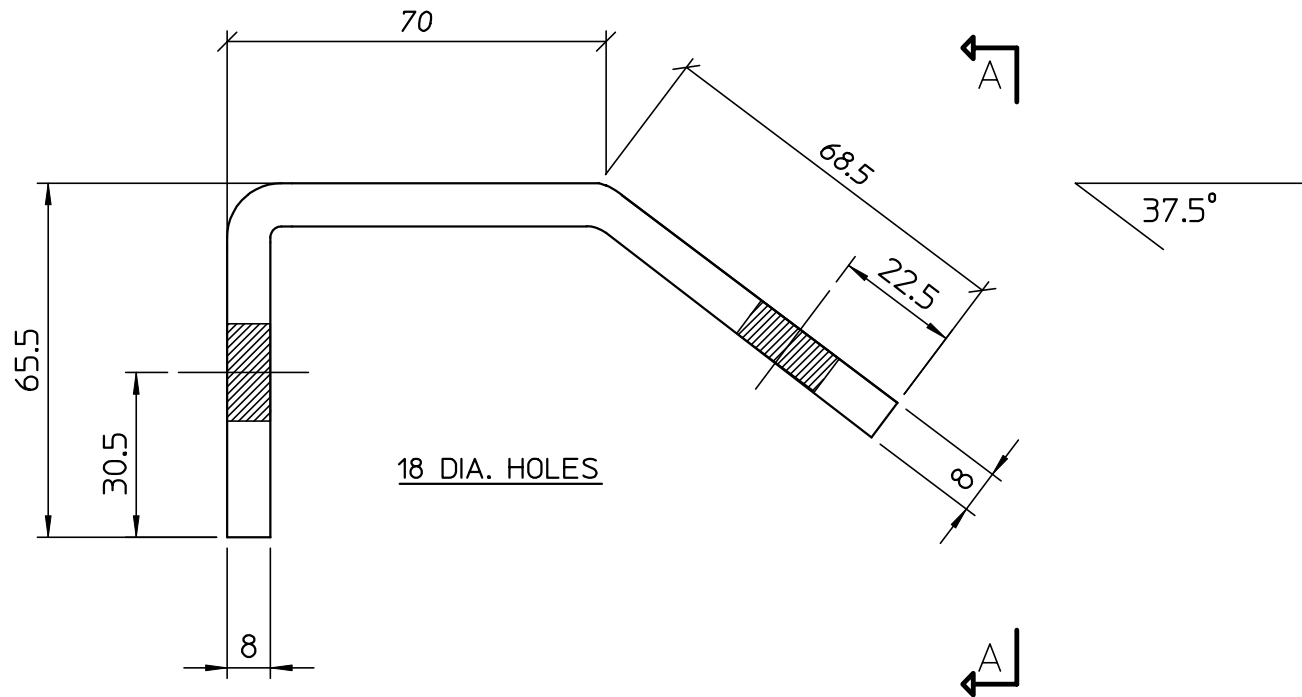
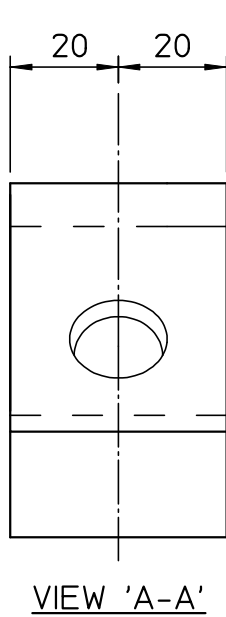
DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 BRACKET TYPE A FOR DIAGONAL BRACING

DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
 DRG No: HSP-004 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
 SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN  
 ACCORDANCE WITH BS EN ISO9001

NOTES: 1: Tolerance - 1mm Edge Distance  
 Tolerance - 1mm Hole Centres  
 Tolerance - 1mm Plate Dimensions  
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## BRACKET HEAVY DUTY TYPE A

GRADE S275 (o/o 180 x 8 FLT x 40 LNG)

GALVANISED AFTER MANUFACTURE



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 BRACKET TYPE A THICKENED

DRWN BY:

DATE:

DRG No: HSP-005

Rev:

ISSUE:

6th ISSUE

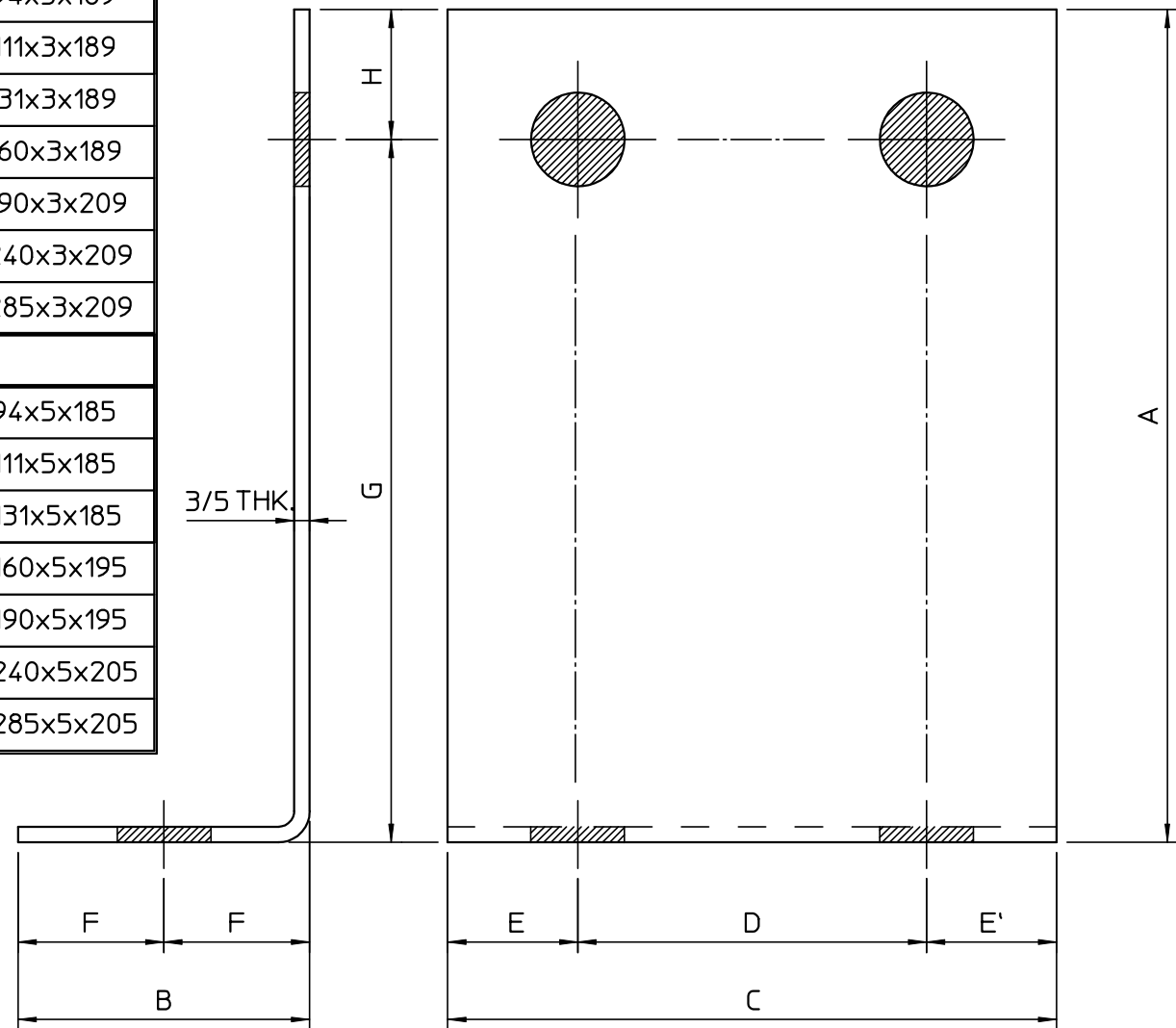
MATERIAL: MANUFACTURED FROM PLT TO BS EN 10025 S275  
 SPIN GALVANISED TO BS ISO 1461

NOTES: 1: Tolerance - 1mm Edge Distance  
 Tolerance - 1mm Hole Centres  
 Tolerance - 1mm Plate Dimensions  
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CLEAT REF	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	E' (mm)	F (mm)	G (mm)	H (mm)	CUT FROM:
TC50	135	60	94	50	22	22	30	110	25	94x3x189
TC67	135	60	111	67	22	22	30	110	25	111x3x189
TC87	135	60	131	87	22	22	30	110	25	131x3x189
TC116	135	60	160	116	22	22	30	110	25	160x3x189
TC146	155	60	190	146	22	22	30	130	25	190x3x209
TC196	155	60	240	196	22	22	30	130	25	240x3x209
TC241	155	60	285	241	22	22	30	130	25	285x3x209
MFB50	135	60	94	50	22	22	30	110	25	94x5x185
MFB67	135	60	111	67	22	22	30	110	25	111x5x185
MFB87	135	60	131	87	22	22	30	110	25	131x5x185
MFB116	145	60	160	116	22	22	30	120	25	160x5x195
MFB146	145	60	190	146	22	22	30	120	25	190x5x195
MFB196	155	60	240	196	22	22	30	130	25	240x5x205
MFB241	155	60	285	241	22	22	30	130	25	285x5x205

ALL HOLES 18 DIA.



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 CHANNEL & MEZZANINE FLOOR BEAM CLEATS

DRWN BY: DATE:

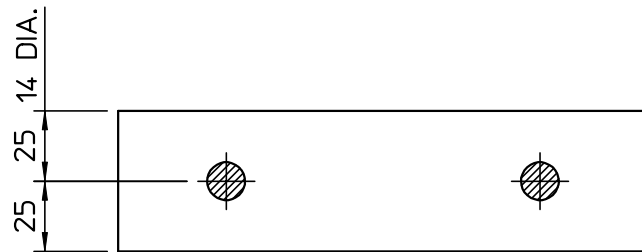
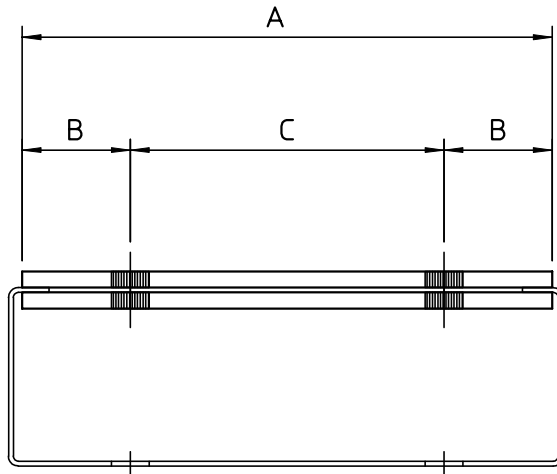
DRG No: HSP-006 Rev: ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
 SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN  
 ACCORDANCE WITH BS EN ISO9001

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PRIMED FINISH

TYPE	A	B	C	O/O:
CP127	115	24	67	50x6PLTx115 LG
CP156	139	36	67	50x6PLTx139 LG
CP176	159	36	87	50x6PLTx159 LG
CP206	196	40	116	50x6PLTx196 LG
CP220	210	47	116	50x6PLTx210 LG
CP238	214	34	146	50x6PLTx214 LG
CP258	240	47	146	50x6PLTx240 LG
CP270	260	72	146	50x6PLTx260 LG
CP290	280	42	196	50x6PLTx280 LG
CP309	284	44	196	50x6PLTx284 LG
CP359	329	44	241	50x6PLTx329 LG



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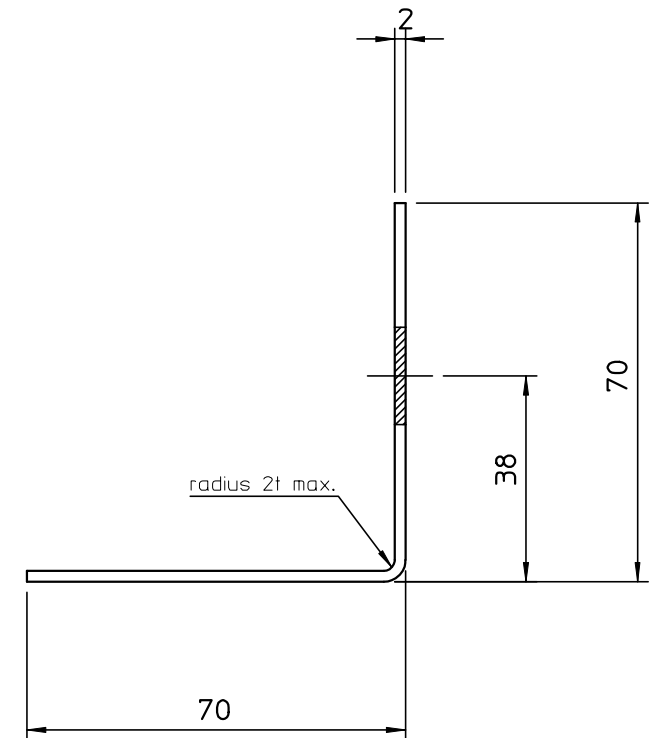
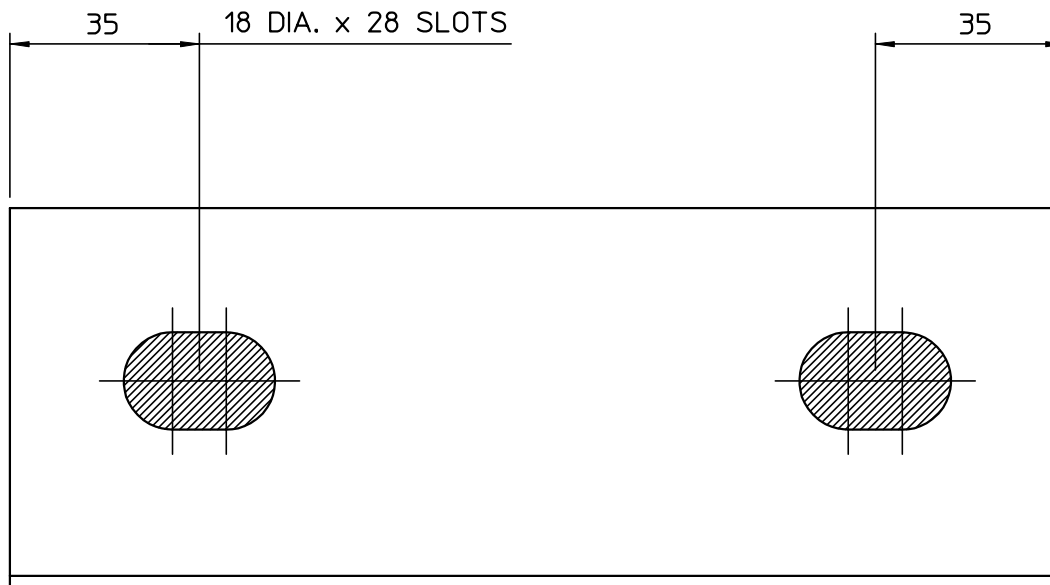
DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 CLAMP PLATE DIMENSIONS

DRWN BY:  DATE:   
 DRG No: HSP-007 Rev:  ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM PLT TO BE EN 10025 S275

NOTES: 1: Tolerance - 1mm Edge Distance  
 Tolerance - 1mm Hole Centres  
 Tolerance - 1mm Dimensions  
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**CLEADER RAIL**  
**PRE-GALVANISED**  
 (0/0 136mm WIDE STRIP)



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 CLEADER RAIL

DRWN BY:

DATE:

DRG No: HSP-008

Rev:

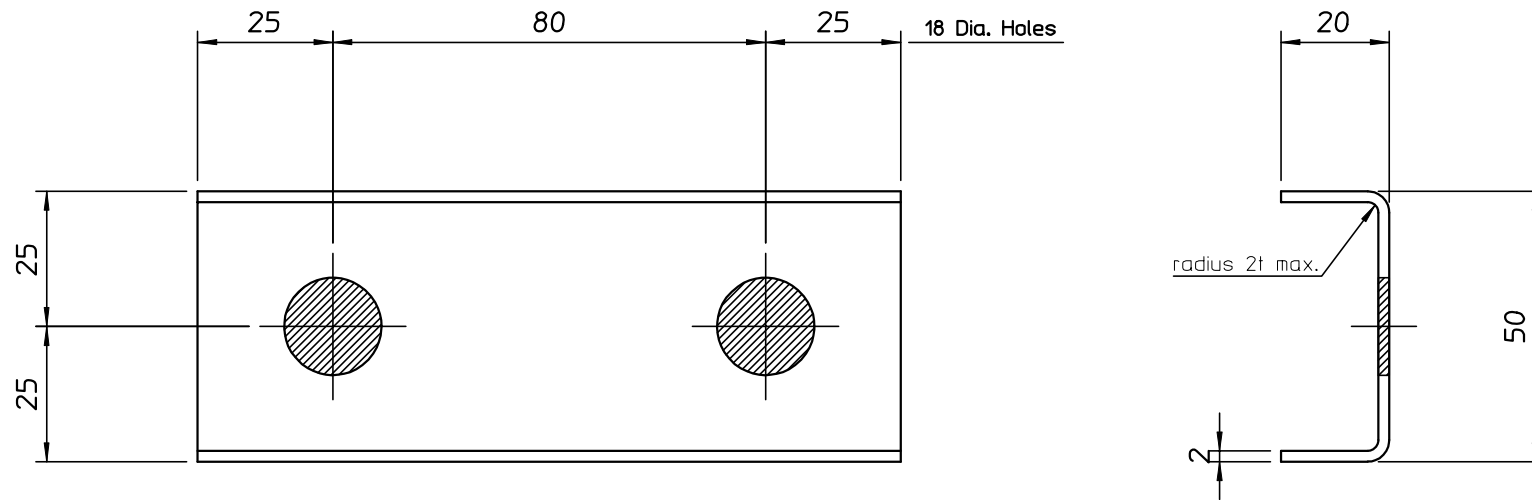
ISSUE:

6th ISSUE

**MATERIAL:** MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
 SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN  
 ACCORDANCE WITH BS EN ISO9001

**NOTES:** 1: For tolerances please see HSP-014  
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**CLEADER RAIL JOINTING SLEEVE**  
**PRE-GALVANISED**  
(O/O 82mm WIDE STRIP)



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
CLEADER RAIL JOINTING SLEEVE

DRWN BY:

DATE:

DRG No: HSP-009

Rev:

ISSUE:

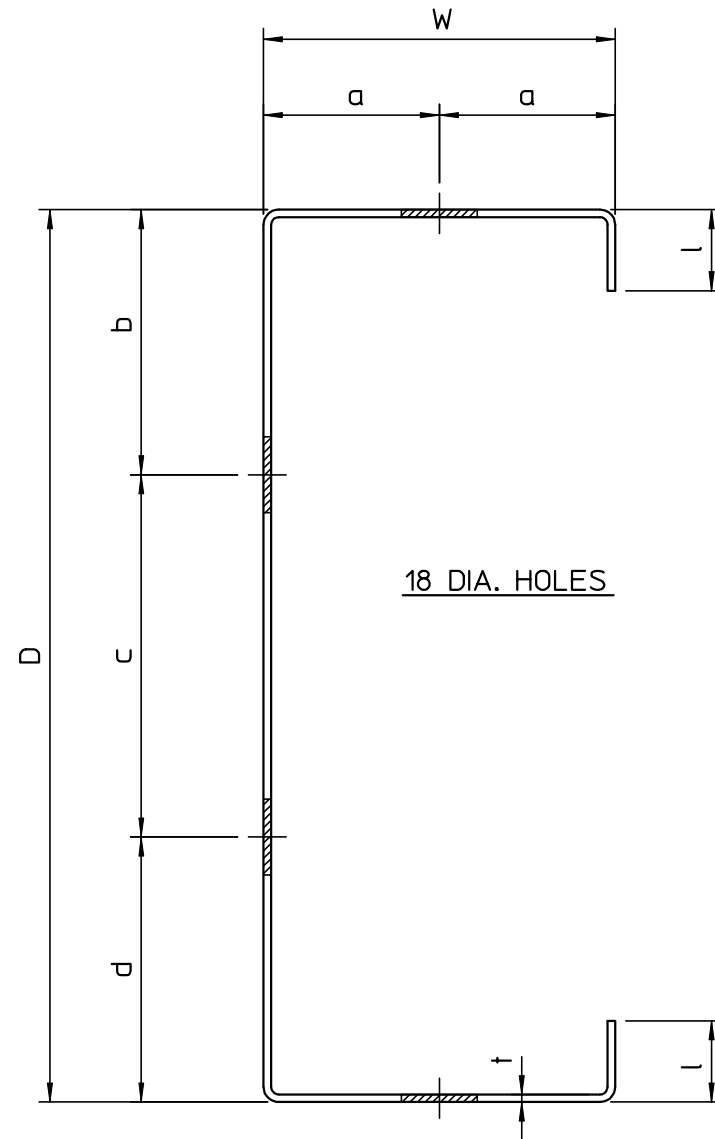
6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN  
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SECTION REF	DEPTH	WIDTH	THICKNESS	LIPS	STANDARD PUNCHING LINES			
	D (mm)	W (mm)	t (mm)	l (mm)	a (mm)	b (mm)	c (mm)	d (mm)
<b>60 SERIES</b>								
C15613	150	66	1.3	15	33	42	67	41
C15614	150	66	1.4	15	33	42	67	41
C15615	150	66	1.5	15	33	42	67	41
C15616	150	66	1.6	15	33	42	67	41
C15618	150	66	1.8	15	33	42	67	41
C15620	150	66	2.0	15	33	42	67	41
C17613	170	66	1.3	15	33	42	87	41
C17614	170	66	1.4	15	33	42	87	41
C17615	170	66	1.5	15	33	42	87	41
C17616	170	66	1.6	15	33	42	87	41
C17618	170	66	1.8	15	33	42	87	41
C17620	170	66	2.0	15	33	42	87	41
C17624	170	66	2.4	15	33	42	87	41
C20613	205	66	1.3	15	33	45	116	44
C20614	205	66	1.4	15	33	45	116	44
C20615	205	66	1.5	15	33	45	116	44
C20616	205	66	1.6	15	33	45	116	44
C20618	205	66	1.8	15	33	45	116	44
C20620	205	66	2.0	15	33	45	116	44
C20624	205	66	2.4	15	33	45	116	44
C20629	205	66	2.9	15	33	45	116	44
<b>80 SERIES</b>								
C23815	230	80	1.5	18	40	42	146	42
C23816	230	80	1.6	18	40	42	146	42
C23818	230	80	1.8	18	40	42	146	42
C23820	230	80	2.0	18	40	42	146	42
C23824	230	80	2.4	18	40	42	146	42
C23830	230	80	3.0	18	40	42	146	42
C25816	255	80	1.6	18	40	55	146	54
C25818	255	80	1.8	18	40	55	146	54
C25820	255	80	2.0	18	40	55	146	54
C25824	255	80	2.4	18	40	55	146	54
C25830	255	80	3.0	18	40	55	146	54
<b>90 SERIES</b>								
C30920	305	90	2.0	21	45	55	196	54
C30925	305	90	2.5	21	45	55	196	54
C30929	305	90	2.9	21	45	55	196	54
C35925	350	90	2.5	21	45	55	241	54
C35929	350	90	2.9	21	45	55	241	54



**C-CHANNELS**



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 COLD ROLLED SECTION - C-CHANNELS

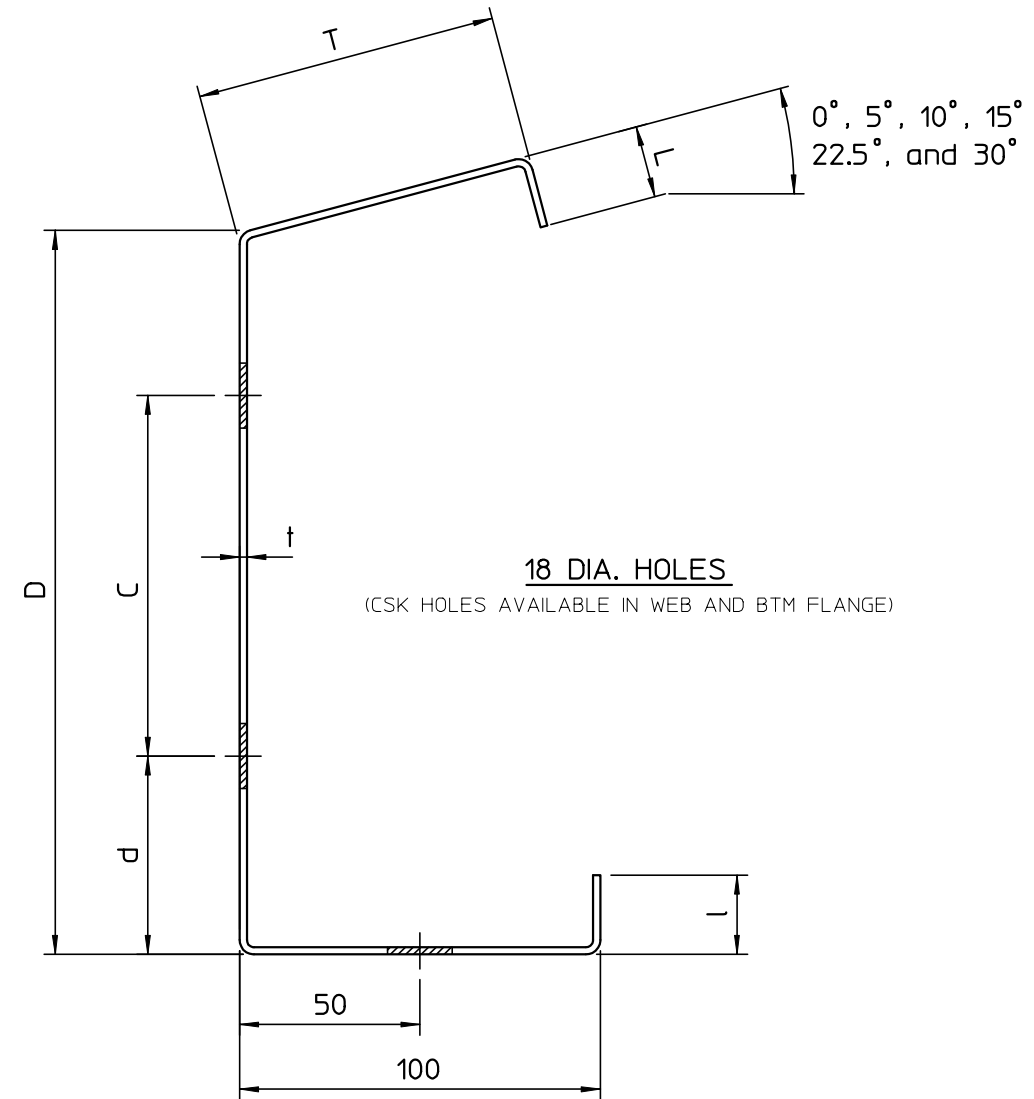
DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_

DRG No: HSP-010 Rev: \_\_\_\_\_ ISSUE: \_\_\_\_\_ 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
 SHEET TO BS EN 10346 S450GD+Z275 N-A-C SUPPLIED IN  
 ACCORDANCE WITH BS EN ISO9001

NOTES: 1: For tolerances please see HSP-014  
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SECTION REF.	DEPTH	THKNESS	HOLE GAUGE	HOLE CENTRES	TOP (T) FLANGE	TOP (L) LIP	BOTTOM LIP (I)
	D mm	t mm	d mm	C mm	T mm	L mm	l mm
E17020	170	2.0	44	84	75	16	20
E20020	200	2.0	55	100	83	20	22
E20024	200	2.4	55	100	83	20	22
E24020	240	2.0	55	116	83	20	22
E24025	240	2.5	55	116	83	20	22
E28020	280	2.0	55	146	100	20	22
E28025	280	2.5	55	146	100	20	22
E28029	280	2.9	55	146	100	20	22



## EAVES BEAMS



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
COLD ROLLED SECTION - EAVES BEAMS

DRWN BY:

DATE:

DRG No: HSP-011

Rev:

ISSUE:

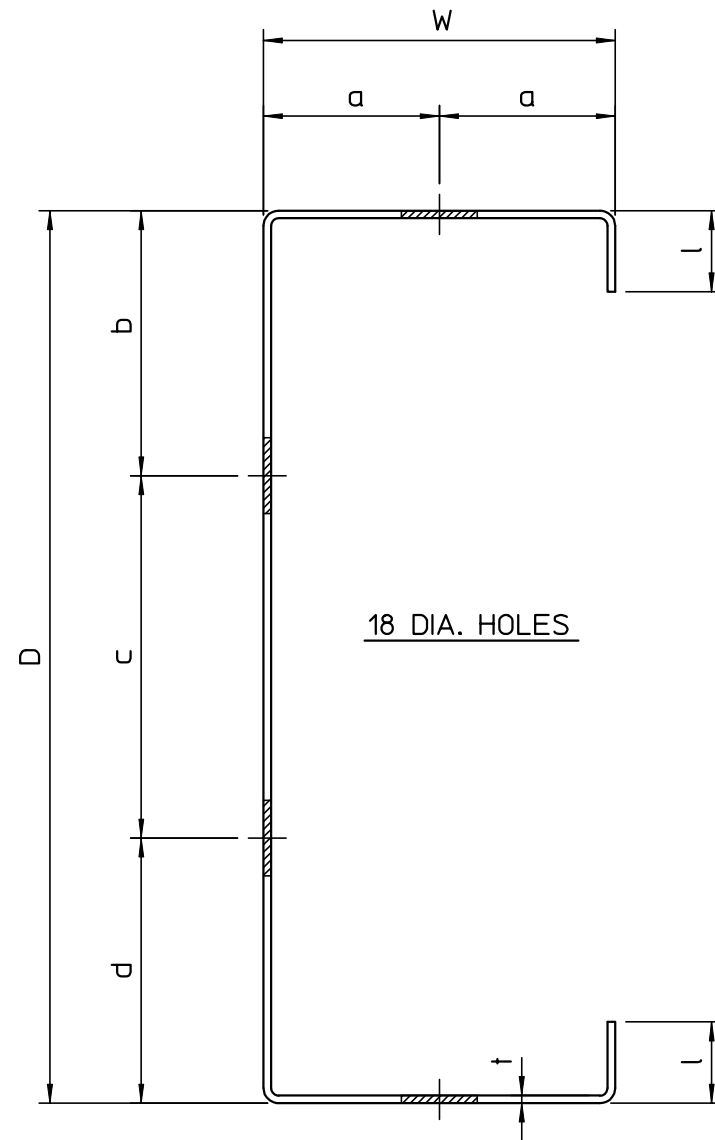
6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
SHEET TO BS EN 10346 S450GD+Z275 N-A-C SUPPLIED IN  
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SECTION REF	DEPTH	WIDTH	THICKNESS	LIPS	STANDARD PUNCHING LINES			
	D (mm)	W (mm)	t (mm)	l (mm)	a (mm)	b (mm)	c (mm)	d (mm)
C12715	127	66	1.5	15	33	30	67	30
C12716	127	66	1.6	15	33	30	67	30
C12718	127	66	1.8	15	33	30	67	30
C12720	127	66	2.0	15	33	30	67	30
C15613	150	66	1.3	15	33	42	67	41
C15614	150	66	1.4	15	33	42	67	41
C15615	150	66	1.5	15	33	42	67	41
C15616	150	66	1.6	15	33	42	67	41
C15618	150	66	1.8	15	33	42	67	41
C15620	150	66	2.0	15	33	42	67	41
C17613	170	66	1.3	15	33	42	87	41
C17614	170	66	1.4	15	33	42	87	41
C17615	170	66	1.5	15	33	42	87	41
C17616	170	66	1.6	15	33	42	87	41
C17618	170	66	1.8	15	33	42	87	41
C17620	170	66	2.0	15	33	42	87	41
C17624	170	66	2.4	15	33	42	87	41
C20613	205	66	1.3	15	33	45	116	44
C20614	205	66	1.4	15	33	45	116	44
C20615	205	66	1.5	15	33	45	116	44
C20616	205	66	1.6	15	33	45	116	44
C20618	205	66	1.8	15	33	45	116	44
C20620	205	66	2.0	15	33	45	116	44
C20624	205	66	2.4	15	33	45	116	44
C20629	205	66	2.9	15	33	45	116	44
C22016	220	66	1.6	15	33	52	116	52
C22018	220	66	1.8	15	33	52	116	52
C22020	220	66	2.0	15	33	52	116	52
C22024	220	66	2.4	15	33	52	116	52
C23815	230	80	1.5	18	40	42	146	42
C23816	230	80	1.6	18	40	42	146	42
C23818	230	80	1.8	18	40	42	146	42
C23820	230	80	2.0	18	40	42	146	42
C23824	230	80	2.4	18	40	42	146	42
C23830	230	80	3.0	18	40	42	146	42
C27020	270	66	2.0	15	33	62	146	62
C27024	270	66	2.4	15	33	62	146	62
C27030	270	66	3.0	15	33	62	146	62
C29030	290	75	3.0	15	37.5	47	196	47



**MFB-CHANNELS**



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 COLD ROLLED SECTION - MEZZANINE FLOOR BEAMS

DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_

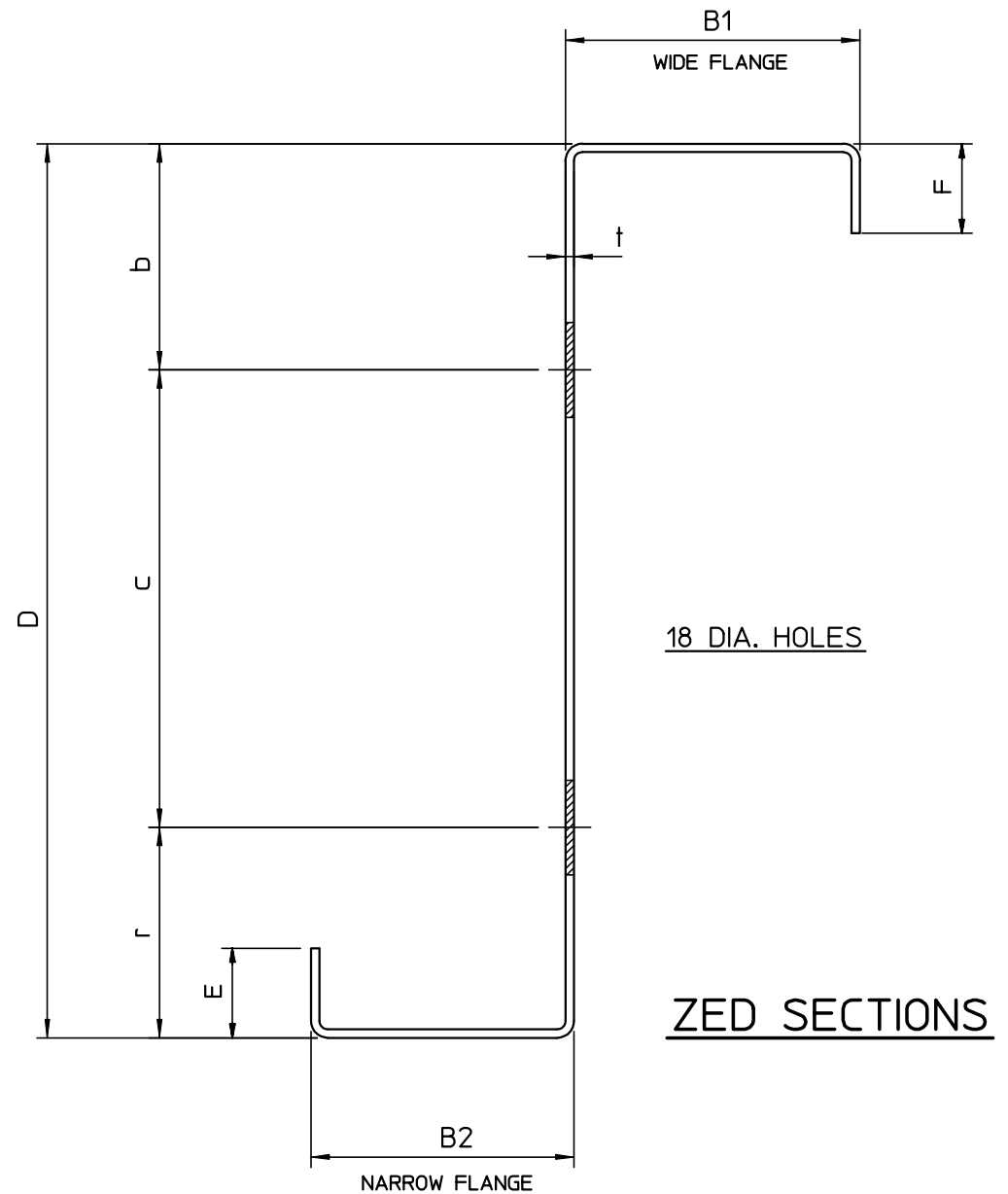
DRG No: HSP-012 Rev: \_\_\_\_\_ ISSUE: \_\_\_\_\_ 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
 SHEET TO BS EN 10346 S450GD+Z275 N-A-C SUPPLIED IN  
 ACCORDANCE WITH BS EN ISO9001

NOTES: 1: For tolerances please see HSP-014  
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SECTION REF	DEPTH	WIDE FLANGE	NARROW FLANGE	TOP LIP	BTM LIP	THICKNESS	GAUGE LINES		
	D mm	B1 mm	B2 mm	E mm	F mm		t mm	b mm	c mm
<b>60 SERIES</b>									
Z15613	150	66	60	19	17	1.3	43	67	40
Z15614	150	66	60	19	17	1.4	43	67	40
Z15615	150	66	60	19	17	1.5	43	67	40
Z15616	150	66	60	19	17	1.6	43	67	40
Z15618	150	66	60	19	17	1.8	43	67	40
Z15620	150	66	60	19	17	2.0	43	67	40
Z17613	170	66	60	19	17	1.3	43	87	40
Z17614	170	66	60	19	17	1.4	43	87	40
Z17615	170	66	60	19	17	1.5	43	87	40
Z17616	170	66	60	19	17	1.6	43	87	40
Z17618	170	66	60	19	17	1.8	43	87	40
Z17620	170	66	60	19	17	2.0	43	87	40
Z17624	170	66	60	19	17	2.4	43	87	40
Z20613	205	66	60	19	17	1.3	46	116	43
Z20614	205	66	60	19	17	1.4	46	116	43
Z20615	205	66	60	19	17	1.5	46	116	43
Z20616	205	66	60	19	17	1.6	46	116	43
Z20618	205	66	60	19	17	1.8	46	116	43
Z20620	205	66	60	19	17	2.0	46	116	43
Z20624	205	66	60	19	17	2.4	46	116	43
Z20629	205	66	60	19	17	2.9	46	116	43
<b>80 SERIES</b>									
Z23815	230	83	75	19	17	1.5	44	146	40
Z23816	230	83	75	19	17	1.6	44	146	40
Z23818	230	83	75	19	17	1.8	44	146	40
Z23820	230	83	75	19	17	2.0	44	146	40
Z23824	230	83	75	19	17	2.4	44	146	40
Z23830	230	83	75	19	17	3.0	44	146	40
Z25816	255	83	75	19	17	1.6	57	146	52
Z25818	255	83	75	19	17	1.8	57	146	52
Z25820	255	83	75	19	17	2.0	57	146	52
Z25824	255	83	75	19	17	2.4	57	146	52
Z25830	255	83	75	19	17	3.0	57	146	52
<b>90 SERIES</b>									
Z30920	305	94	86	22	20	2.0	57	196	52
Z30925	305	94	86	22	20	2.5	57	196	52
Z30929	305	94	86	22	20	2.9	57	196	52
Z35925	350	94	86	22	20	2.5	57	241	52
Z35929	350	94	86	22	20	2.9	57	241	52



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 Web: www.hi-span.com



DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 COLD ROLLED SECTIONS - Z-PURLINS

DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_

DRG No: HSP-013 Rev: \_\_\_\_\_ ISSUE: \_\_\_\_\_ 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
 SHEET TO BS EN 10346 S450GD+Z275 N-A-C SUPPLIED IN  
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# COLD FORMED SECTIONS AND ACCESSORIES - TOLERANCES

## 1. THICKNESS

Nominal thickness (mm)	Normal tolerance (mm)
>1.20 to ≤1.60	± 0.15
>1.60 to ≤2.00	± 0.18
>2.00 to ≤2.50	± 0.21
>2.50 to ≤3.00	± 0.24
>3.00 to ≤5.00	± 0.26

NB. The thickness of the section should not be checked in the radiused areas as slight changes in the wall thickness may occur in the bending zone of the cold rolled sections. These changes are too small to affect the structural values.

## 2. CROSS-SECTION

The permitted tolerance for external dimensions are 2mm. Dimensional checks shall be carried out at a distance of at least 250mm from the ends of the sections.

## 3. BEND ANGLE

The permitted angular tolerance is 2 degrees from the specified nominal angle.

## 4. LENGTH

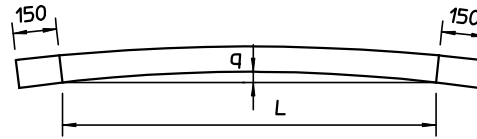
The permitted length tolerance is as follows:

Specified length (mm)	Tolerance (mm)
≤2000	± 1
>2000 to ≤6000	± 2
>6000 to ≤10000	± 3
>10000 to ≤15000	± 4

The length should be measured along the centreline of the largest surface

## 5. STRAIGHTNESS - on both axes

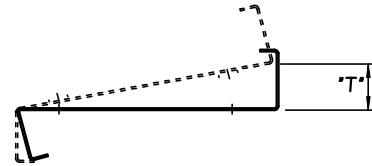
The permitted deviation q from the straight line must not exceed  $0.002 L (L/500)$



The straightness of a section should be checked over the entire length (less a minimum distance of 150mm from the ends) of the section resting on a flat base.

## 6. THE TWISTING

The angle of twist must not exceed 1 degree per metre and should be checked over the entire length (less a minimum distance of 250mm from the ends) of the section resting on a flat base, and measured against the web.



Maximum allowable twist, 'T', in millimetres

## 7. HOLE POSITIONS

The deviation from the intended position of an isolated hole, also a group of holes relative to each other shall not exceed 1mm.

The deviation of the backmark to a hole position shall not exceed 2mm

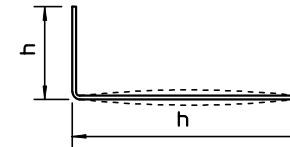
## 8. HOLE SIZES

The permitted tolerance in diameter for non-dished, punched or drilled holes =  $\pm 0.50\text{mm}$ .  
The permitted tolerance in diameter for dished, punched or drilled holes =  $\leq 3\text{mm}$ .

## 9. SURFACES

- The surface of cold formed products shall be visually inspected without the use of optical magnifiers.
- The surface of the finished product shall meet the same standards as the base product.
- Slight defects resulting from machining, such as rolling marks or stripes are no cause for rejection as long as the tolerances permitted for the base product are not exceeded.
- Burrs on section ends or holes typical of the cutting/punching method employed, as well as a slight deformation at the cut are permitted, unless specified otherwise on drawings.
- Excessive amounts of lubricant used during cold forming should be wiped from the surface.
- Any white rust on the surface of cold formed sections or base product should be reported to MANAGEMENT.

## 10. CONCAVITY / CONVEXITY



The tolerances for Concavity or Convexity shall not exceed 0.8 % of h

## 11. INCREASED TOLERANCES

Higher tolerance values can be achieved upon specific request from the client.

## 12. PROTECTION OF SURFACES, STORAGE & TRANSPORT

With galvanised cold rolled sections the special storage and transport requirements applicable to zinc coated products shall be observed (see EN 10142 and EN 10147).



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
COLD ROLLED SECTION TOLERANCES

DRWN BY: DATE:

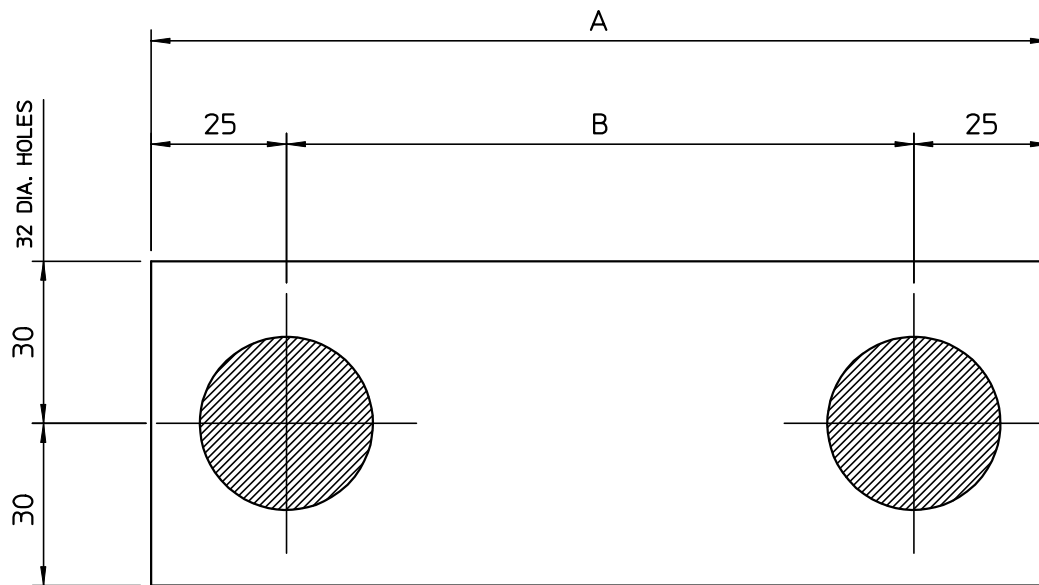
DRG No: HSP-014 Rev: ISSUE: 6th ISSUE

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PRIMED FINISH

MARK	A	B	O/O:
CFP 50	100	50	60x10PLT x100 LG
CFP 67	117	67	60x10PLT x117 LG
CFP 87	137	87	60x10PLT x137 LG
CFP 116	166	116	60x10PLT x166 LG
CFP 146	196	146	60x10PLT x196 LG
CFP 196	246	196	60x10PLT x246 LG
CFP 241	291	241	60x10PLT x291 LG



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 COUNTER FORMED PLATE DIMENSIONS

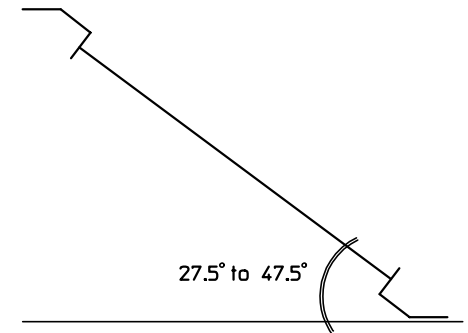
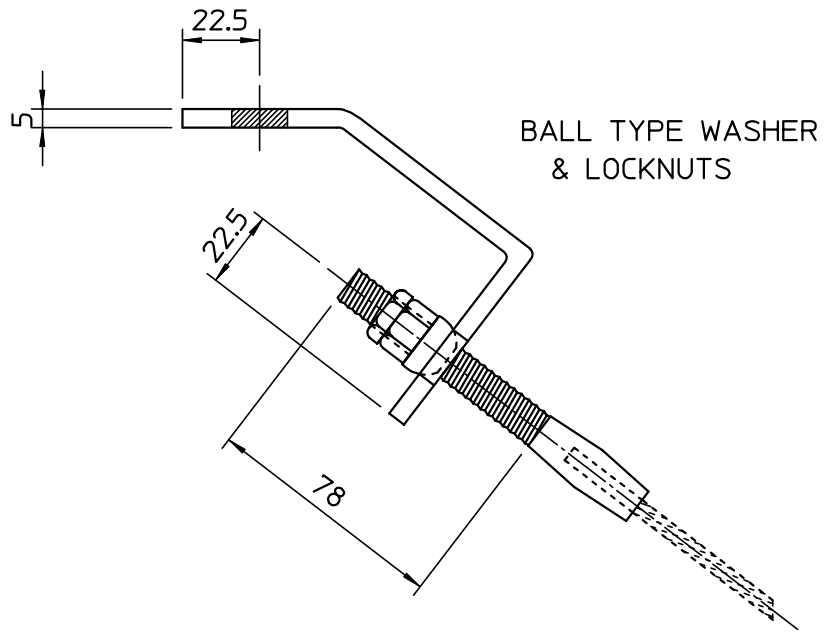
DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_

DRG No: HSP-015 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM PLT TO BSEN 10025 S275

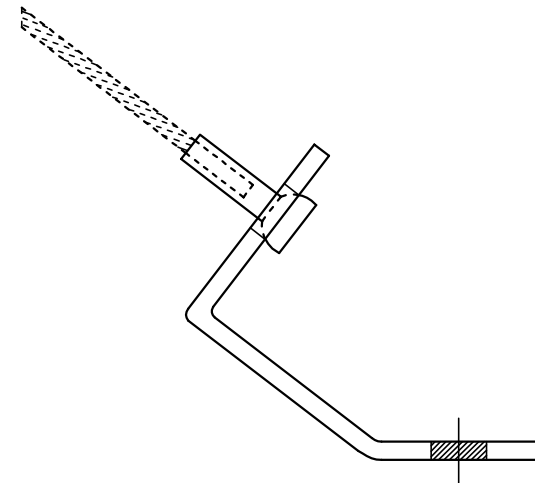
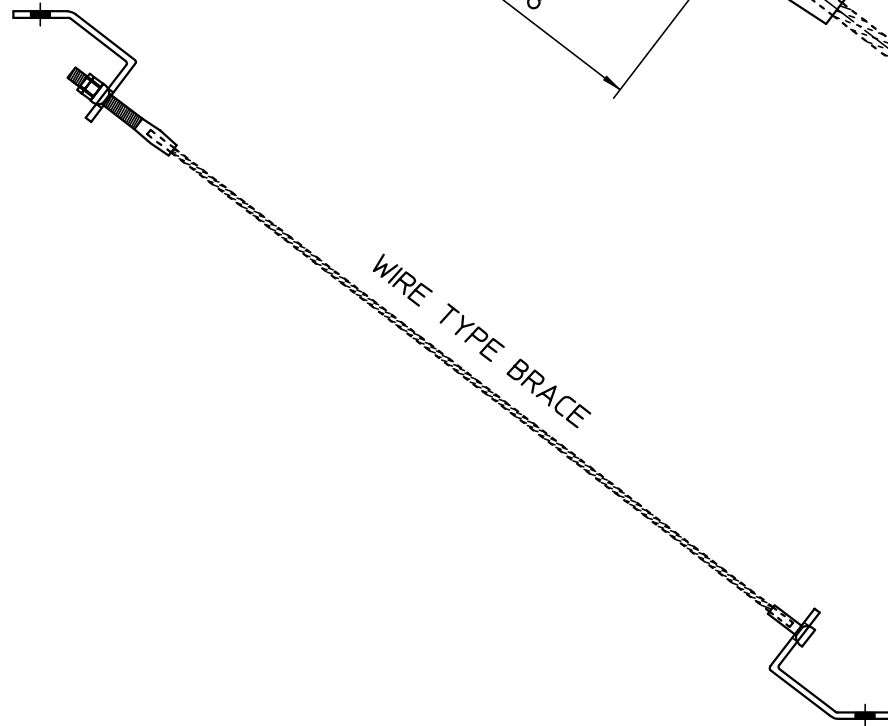
NOTES: 1: Tolerance - 1mm Edge Distance  
 Tolerance - 1mm Hole Centres  
 Tolerance - 1mm Plate Dimensions  
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USE TYPE A BRACKET

FOR ANGLES LESS THAN 27.5°  
AND CLADDING DEEMED HEAVY  
USE THICKENED TYPE A BRACKET



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
DIAGONAL WIRE BRACE DETAIL

DRWN BY:

DATE:

DRG No: HSP-016

Rev: A

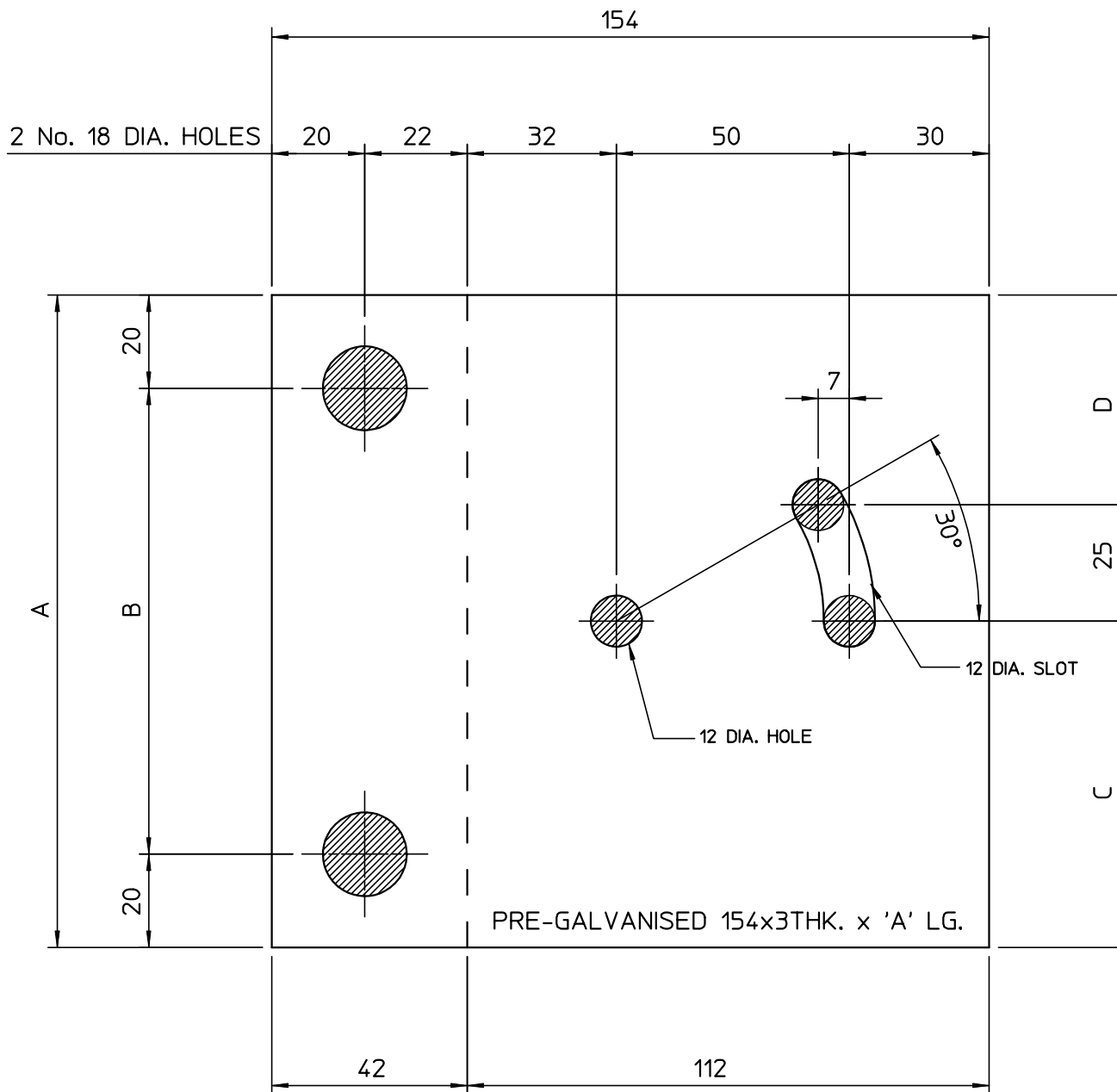
ISSUE:

6th ISSUE

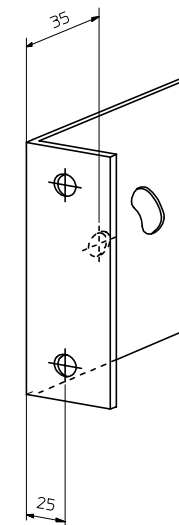
MATERIAL: MANUFACTURED FROM 5mm Dia x 19 STRAND GALVANISED  
WIRE TO BS EN 302

NOTES: 1: For tolerances please see HSP-014  
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MARK	A	B	C	D
EB17	124	84	62	37
EB20	140	100	70	45
EB24	156	116	78	53
EB28	186	146	93	68



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 EAVES BEAM CLEAT

DRWN BY:

DATE:

DRG No: HSP-017

Rev:

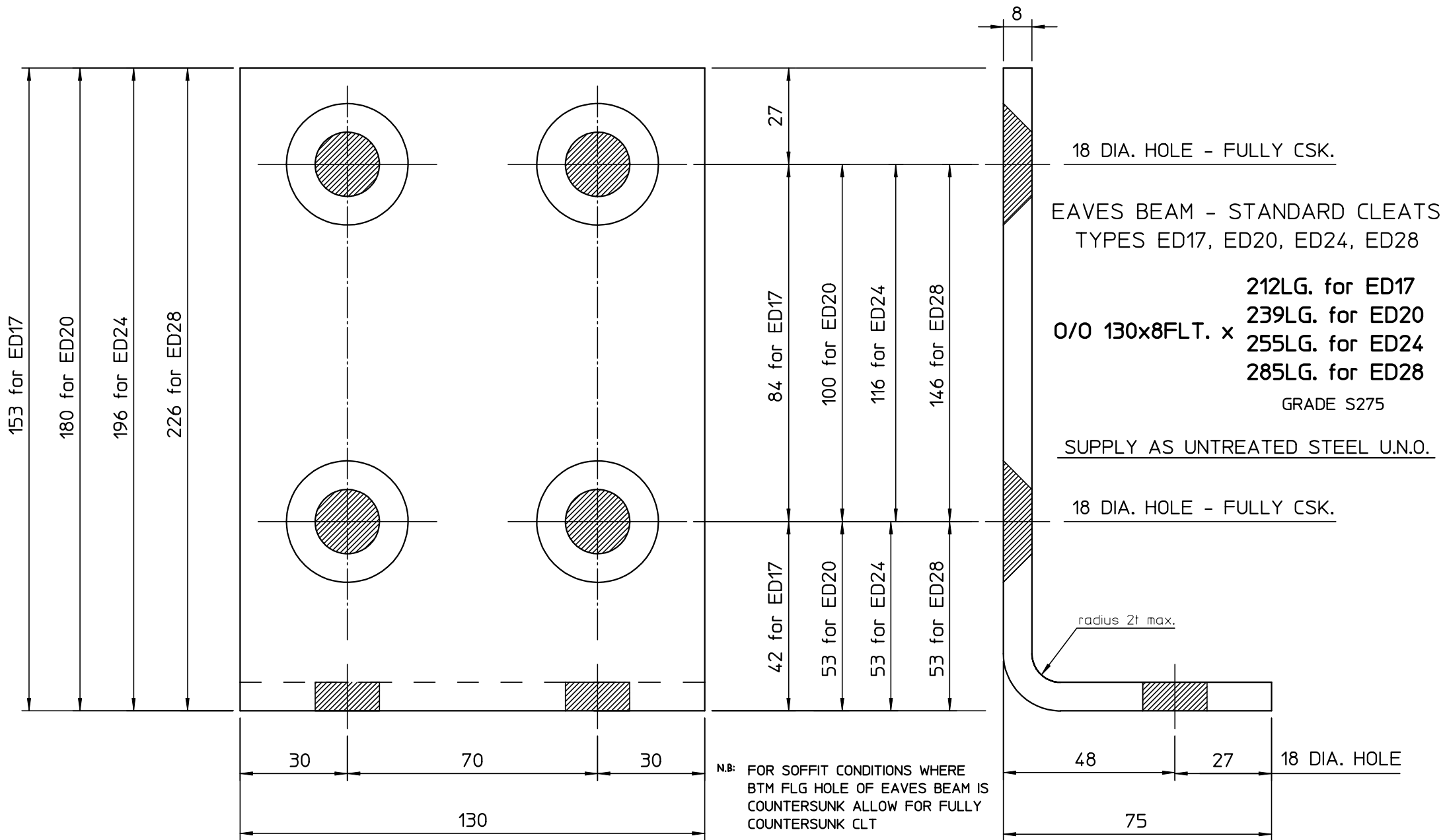
ISSUE:

6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
 SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN  
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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
EAVES BEAM DOUBLE STIFFENER CLEAT

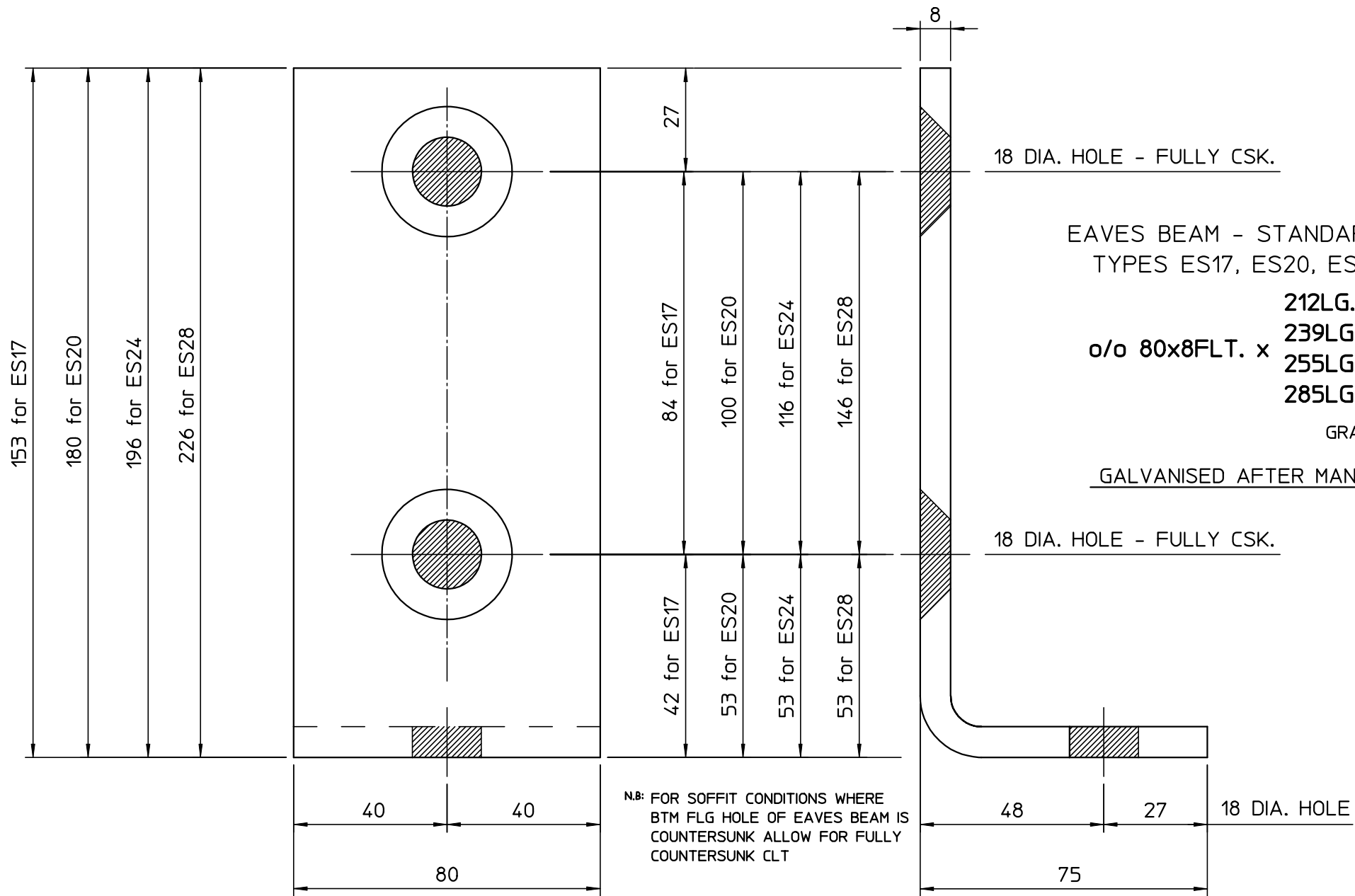
DRWN BY: DATE:

DRG No: HSP-018 Rev: ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM PLT TO BS EN 10025 S275  
SPIN GALVANISED TO BS ISO 1461

NOTES: 1: Tolerance - 1mm Edge Distance  
Tolerance - 1mm Hole Centres  
Tolerance - 1mm Plate Dimensions  
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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
EAVES BEAM SINGLE STIFFENER CLEAT

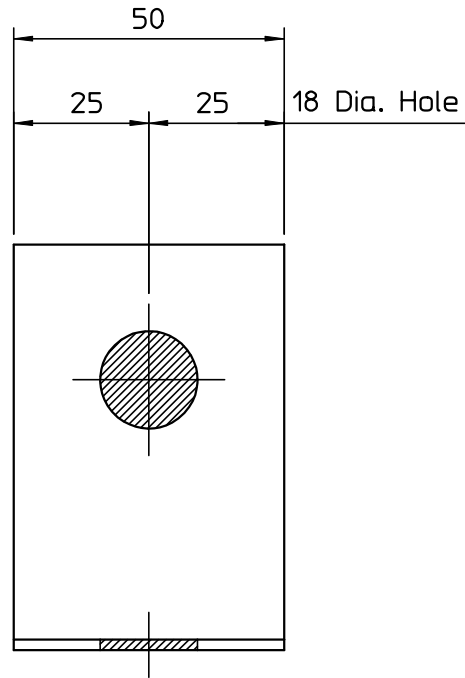
DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_

DRG No: HSP-019 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM PLT TO BS EN 10025 S275  
SPIN GALVANISED TO BE ISO 1461

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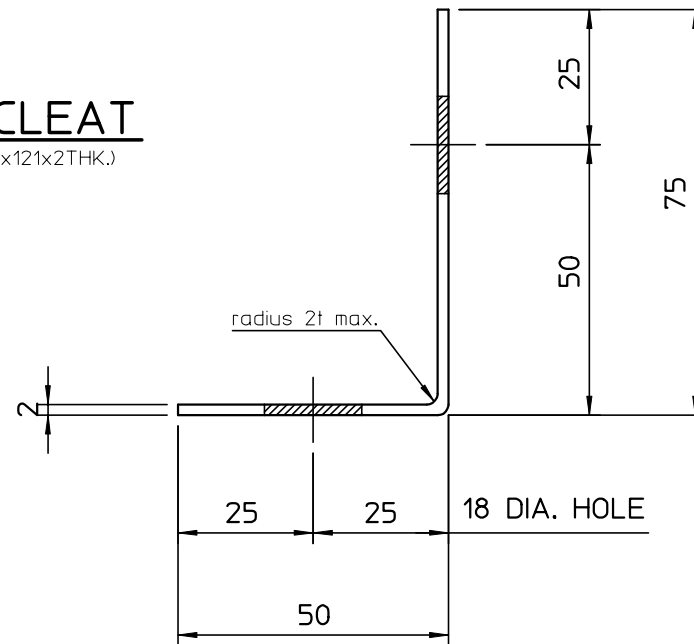
NOTES: 1: Tolerance - 1mm Edge Distance  
Tolerance - 1mm Hole Centres  
Tolerance - 1mm Plate Dimensions  
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PRE - GALVANISED

## FB CLEAT

(O/O 50x121x2THK.)



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
FB BRACKET

DRWN BY:

DATE:

DRG No: HSP-020

Rev: A

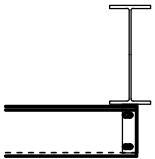
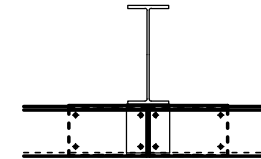
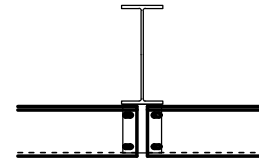
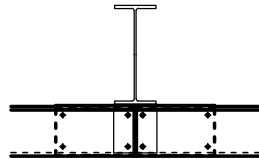
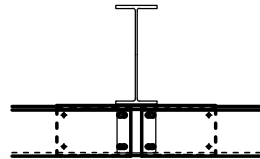
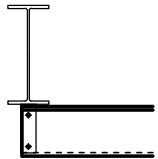
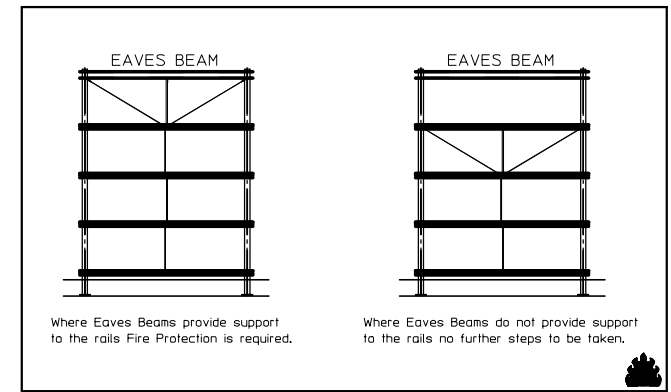
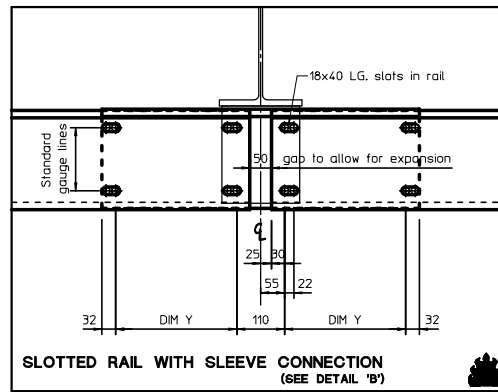
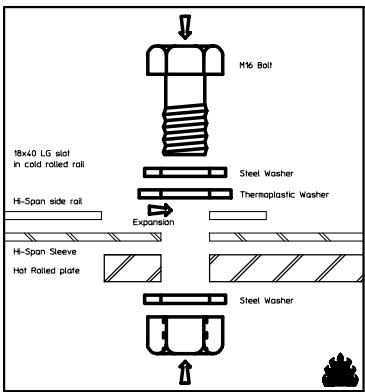
ISSUE:

6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN ACCORDANCE WITH BS EN ISO9001

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Standard side rail cleat, M16 bolts and steel washers.

Slotted connection required at this joint to allow expansion in one end of each rail  
NOTE: HI-SPAN FIREWALL SLEEVE USED TO ACHIEVE CONTINUITY

Standard sleeve to suit section size of rail no slots are required in this joint.

Slotted holes (18 x 38 LG) in Hi-Span side rail.

Standard sleeve to suit section size of rail no slots are required in this joint.

Slotted holes (18 x 38LG) in Hi-Span side rail.

DETAIL 'A'

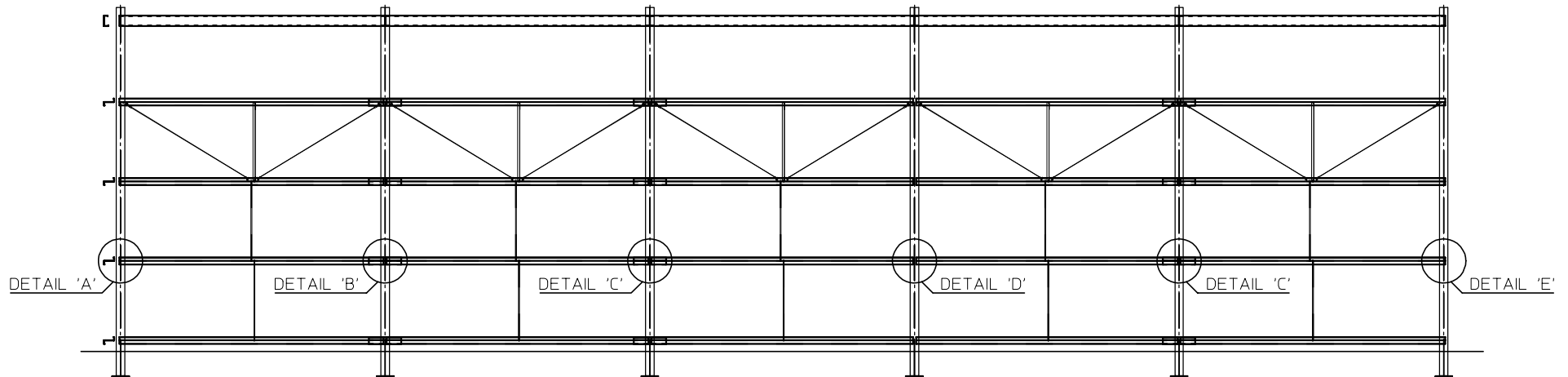
DETAIL 'B'

DETAIL 'C'

DETAIL 'D'

DETAIL 'C'

DETAIL 'E'



NOTE:

- Where an uneven number of bays is encountered a single line of Hi-Span Firewall Sleeves is necessary to achieve continuity.
- For situations where there are an even number of bays, alternate between details 'C','D' and 'E' to achieve continuity over two bays with expansion modes.
- See Hi-Span production drawing HSP-40, HSP-41 and HSP-42 for Firewall Sleeve dimensions.



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 FIRE BOUNDARY WALL CONDITIONS

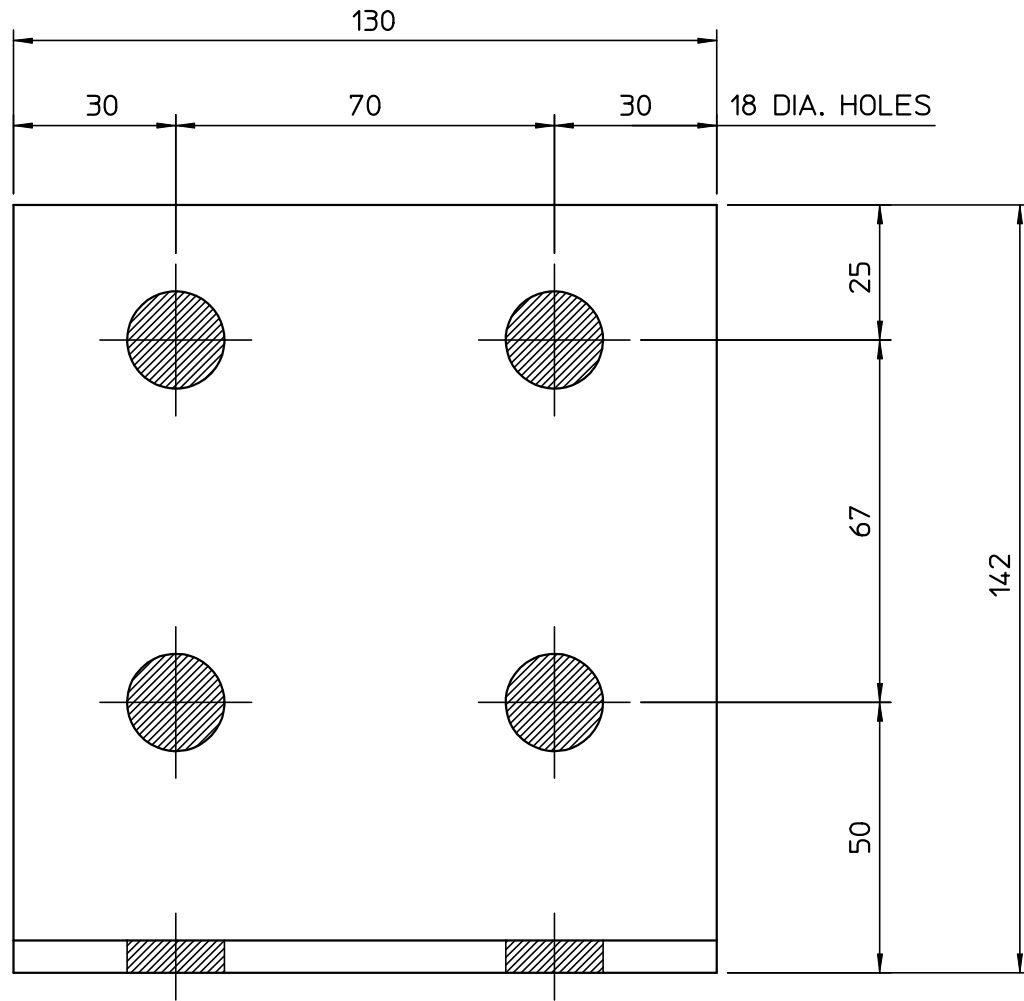
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DRG No: HSP-021 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

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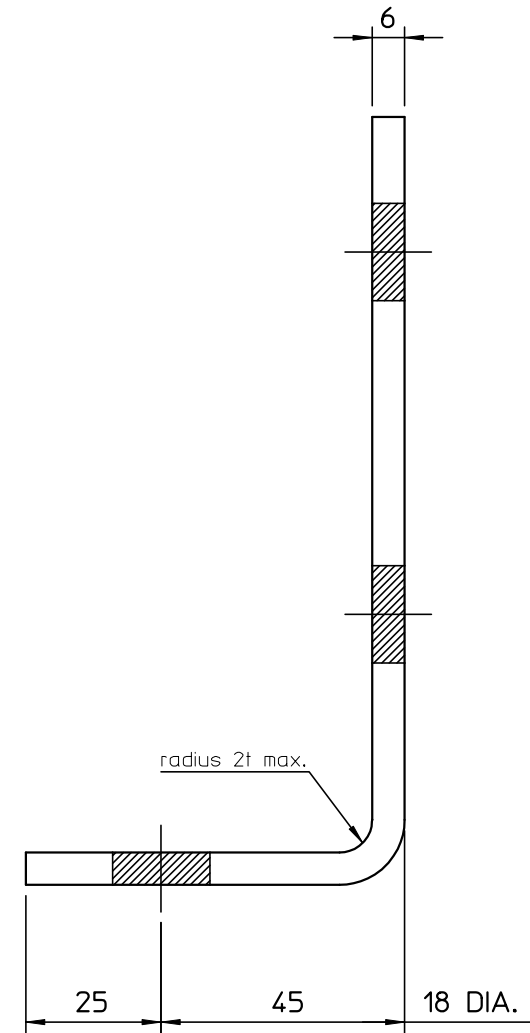
NOTES: 1: For tolerances please see HSP-014  
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**CLEAT 15**

GRADE S275

(O/O 130x6 FLT x 200 LG.)



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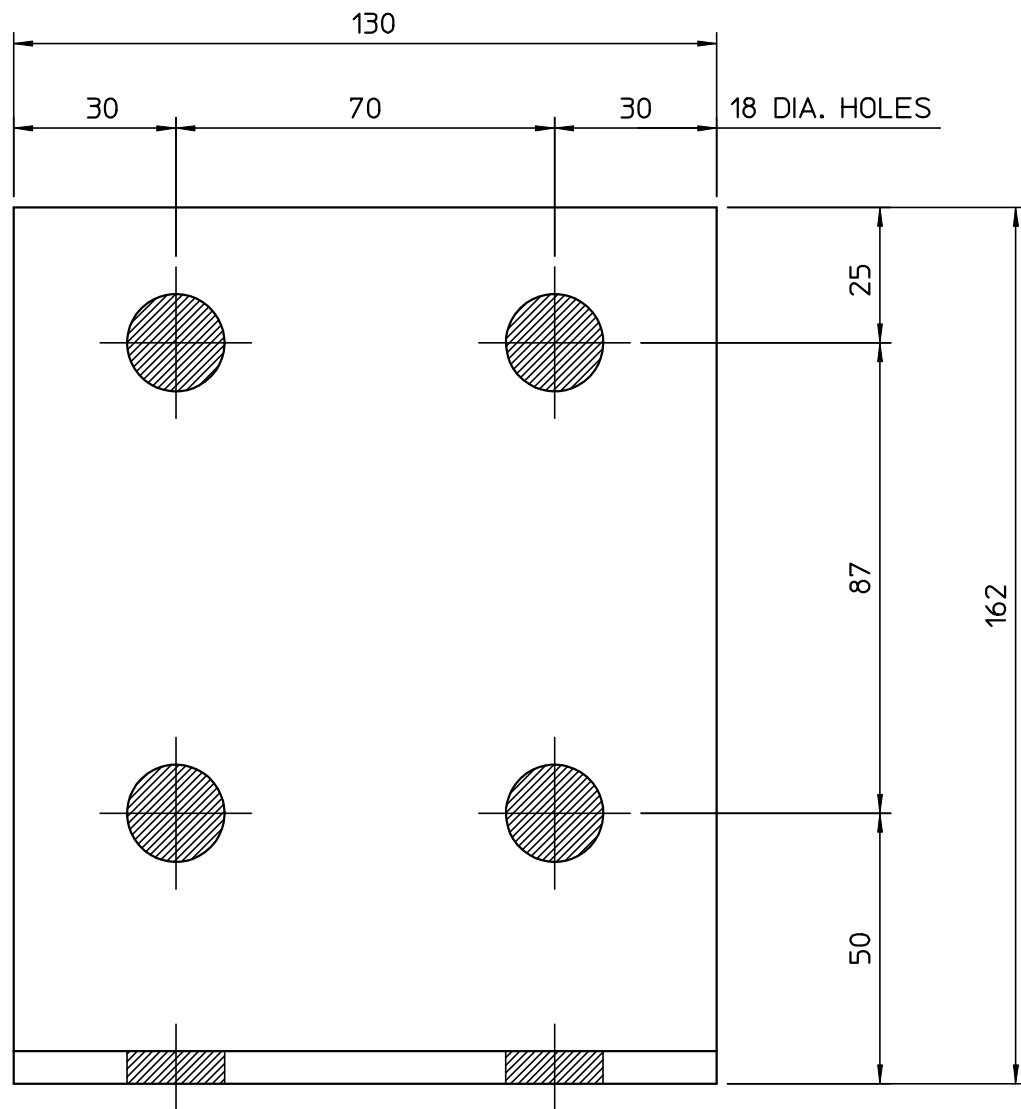


DRG TITLE: HI-SPAN PRODUCTION DRAWING	
BOLT ON CLEAT 15	
DRWN BY:	DATE:
DRG No: HSP-022	Rev: ISSUE: 6th ISSUE

MATERIAL:	MANUFACTURED FROM PLT TO BS EN 10025 S275
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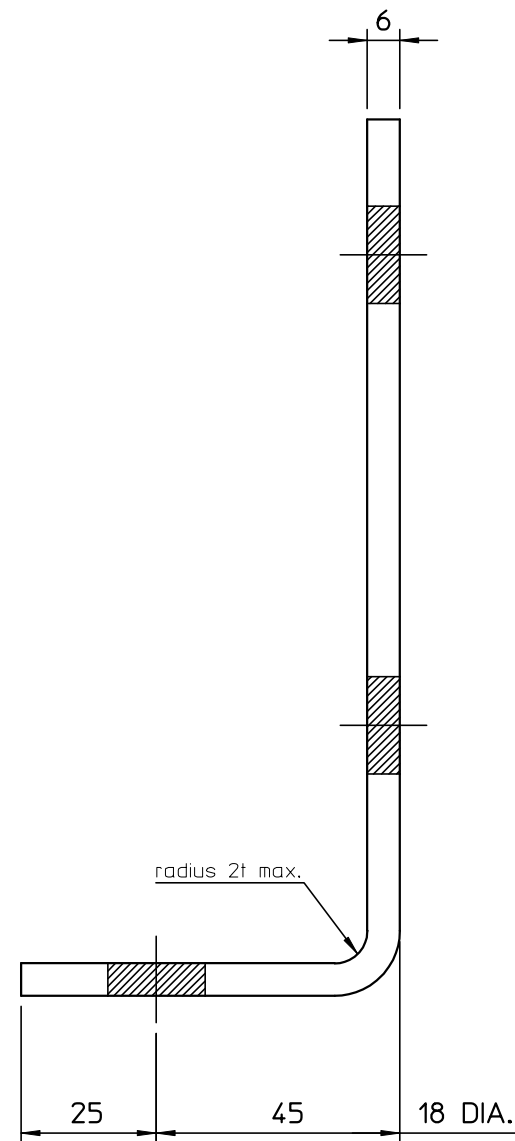
NOTES:	1: Tolerance - 1mm Edge Distance
	Tolerance - 1mm Hole Centres
	Tolerance - 1mm Plate Dimensions
	2: This drawing is copyright HI-SPAN, all rights reserved





### CLEAT 17

GRADE S275  
(0/0 130x6 FLT x 220 LG.)



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BOLT ON CLEAT 17

DRWN BY:

DATE:

DRG No: HSP-023

Rev:

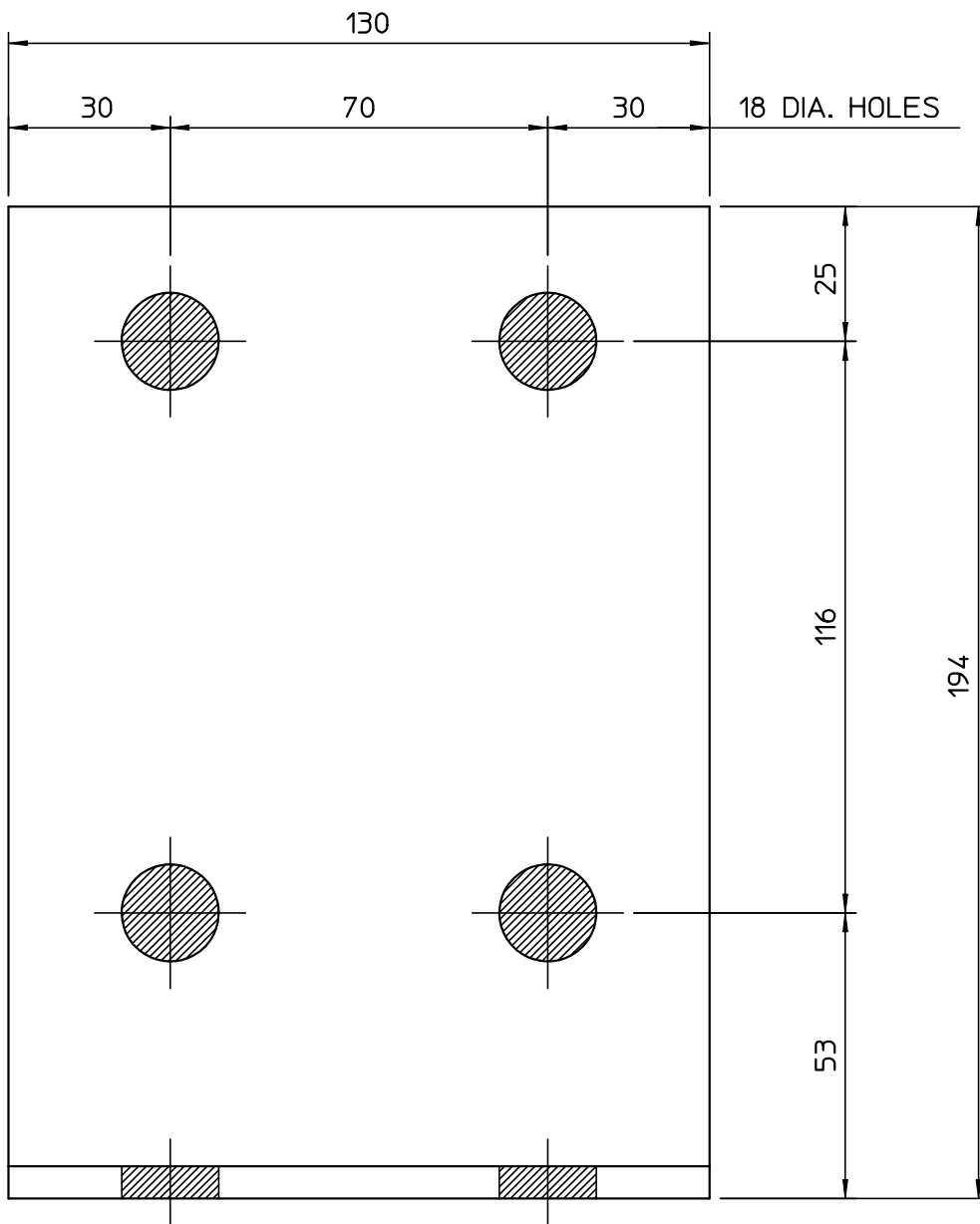
ISSUE:

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MATERIAL: MANUFACTURED FROM PLT TO BS EN 10025 S275  
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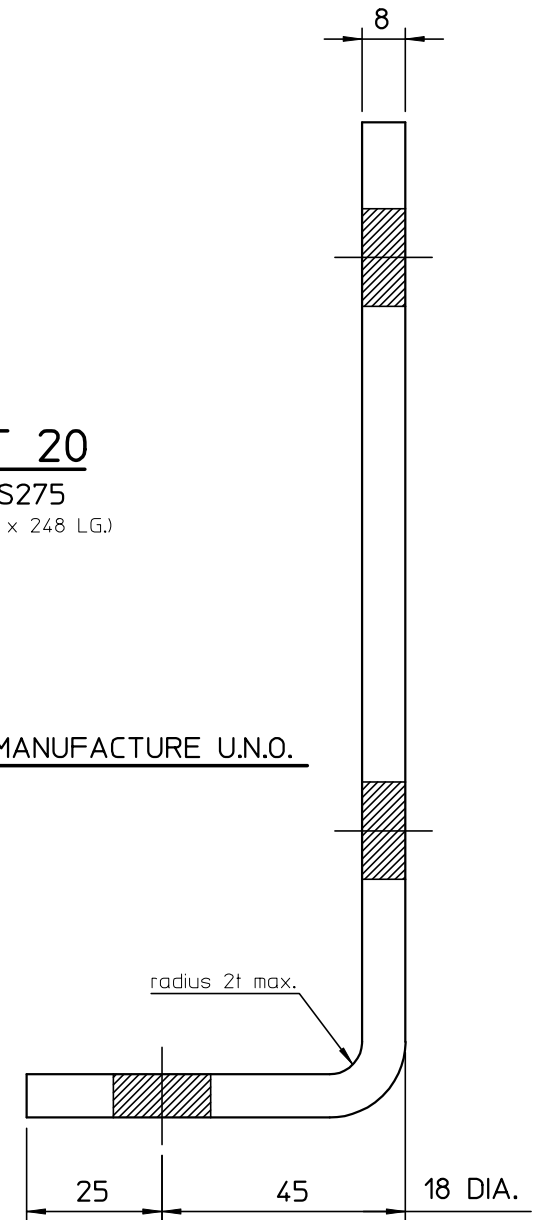


# CLEAT 20

GRADE S275

(O/O 130x8 FLT x 248 LG.)

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 BOLT ON CLEAT 20

DRWN BY:

DATE:

DRG No: HSP-024

Rev:

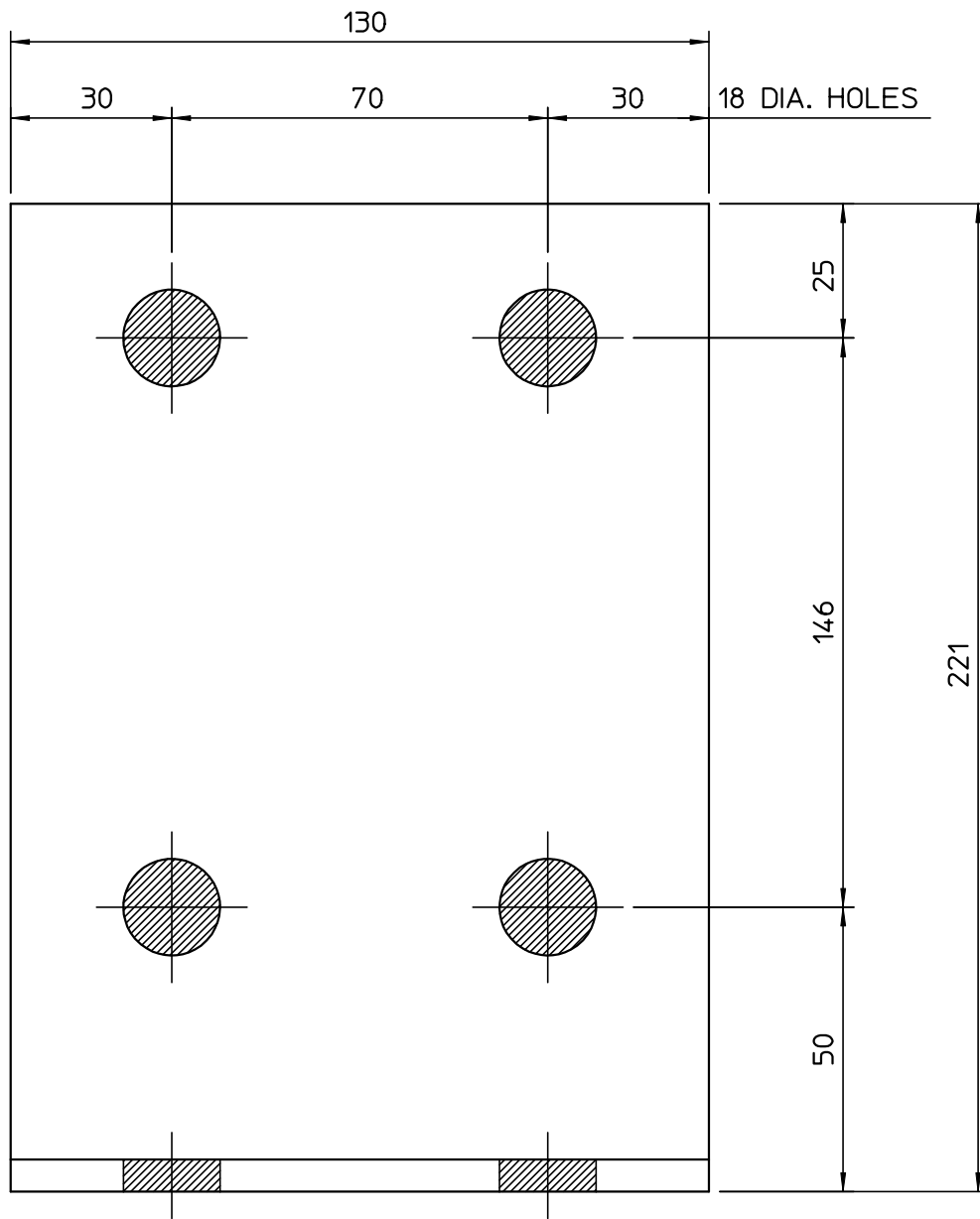
ISSUE:

6th ISSUE

MATERIAL: MANUFACTURED FROM PLT TO BS EN 10025 S275  
 SPIN GALVANISED TO BS ISO 1461

NOTES: 1: Tolerance - 1mm Edge Distance  
 Tolerance - 1mm Hole Centres  
 Tolerance - 1mm Plate Dimensions  
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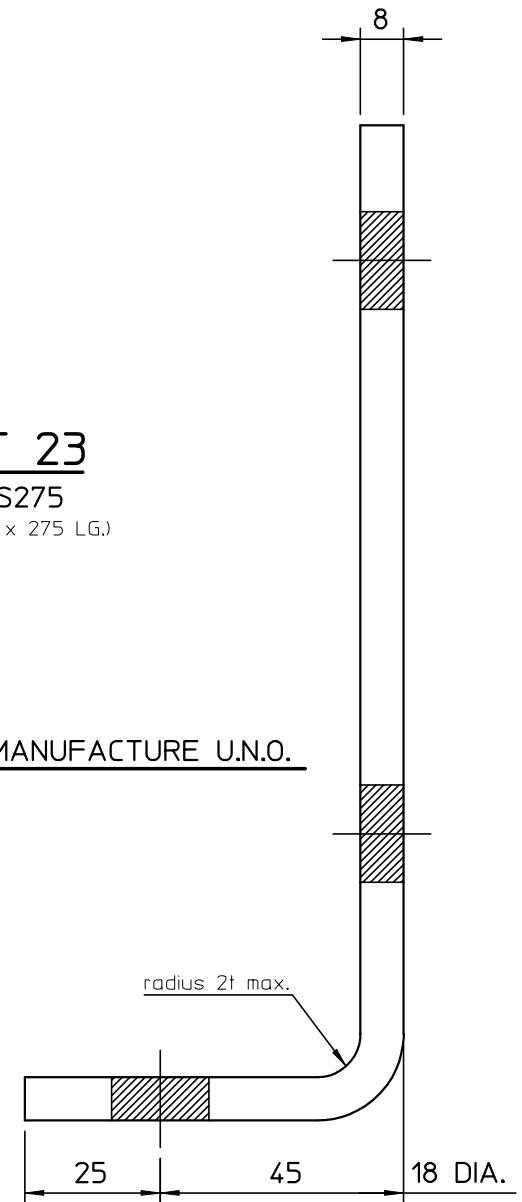


# CLEAT 23

GRADE S275

(O/O 130x8 FLT x 275 LG.)

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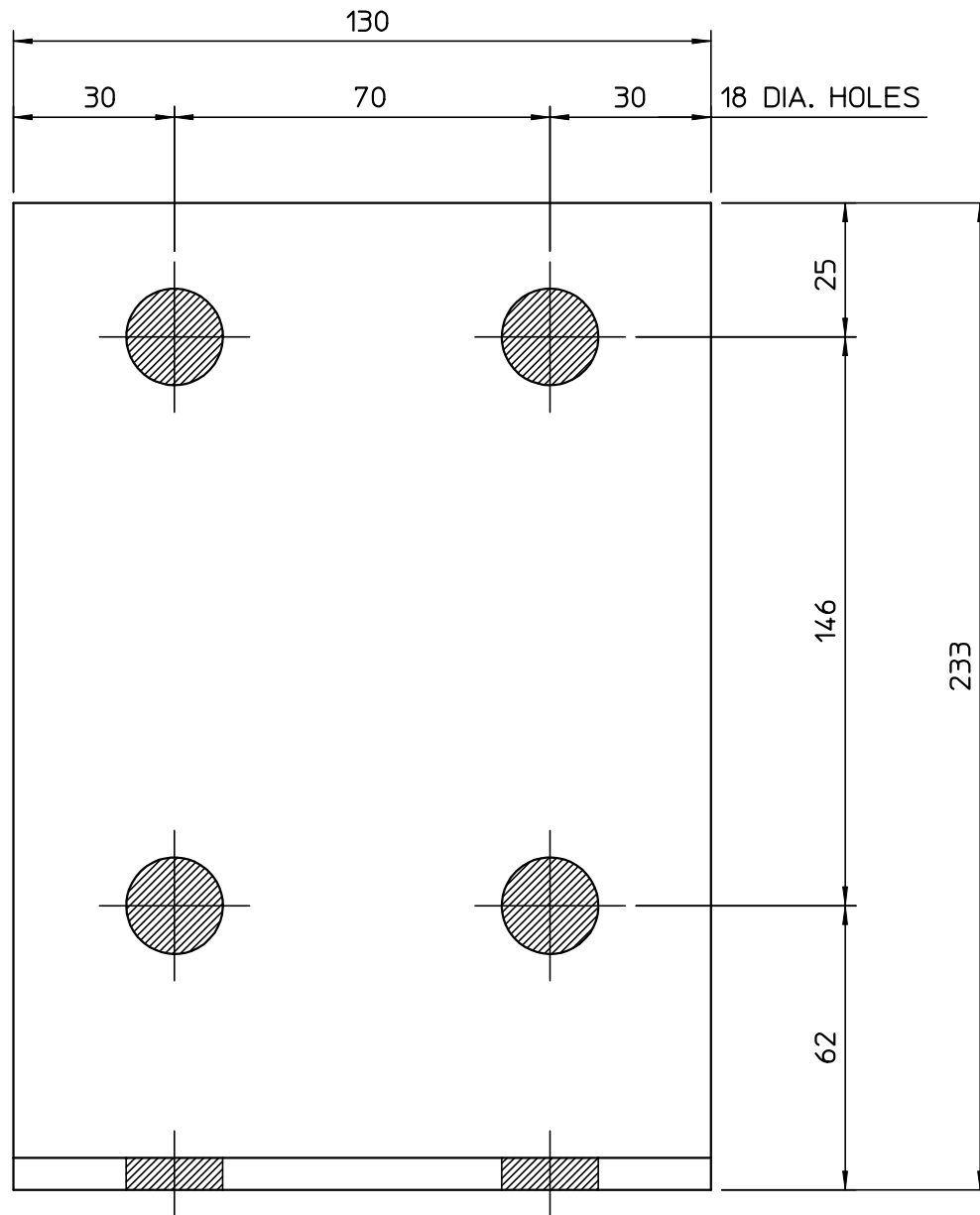


DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 BOLT ON CLEAT 23

DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
 DRG No: HSP-025 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM PLT TO BS EN 10025 S275  
 SPIN GALVANISED TO BS ISO 1461

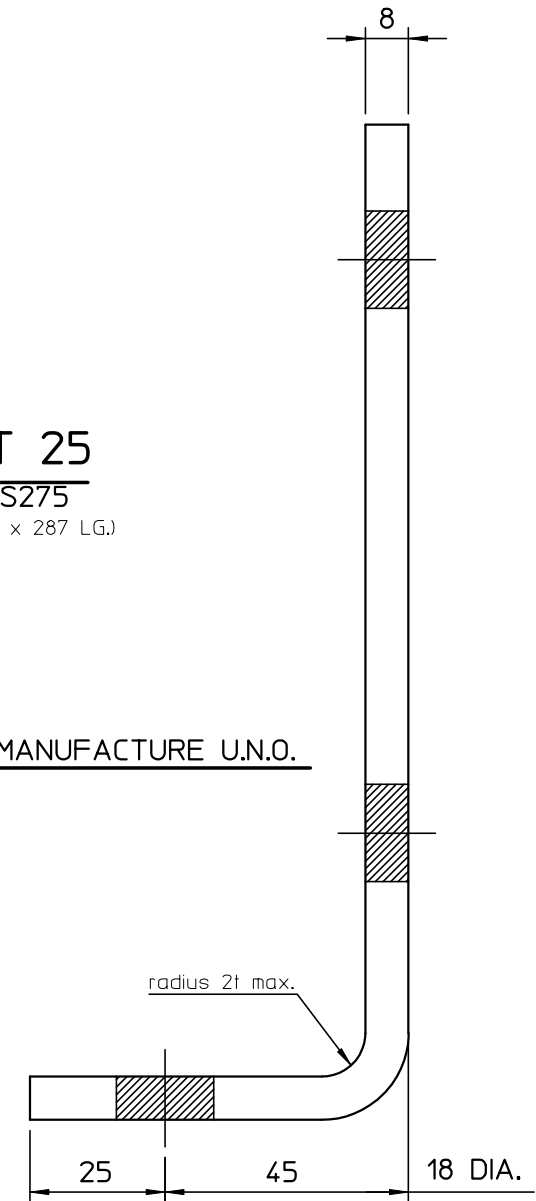
NOTES: 1: Tolerance - 1mm Edge Distance  
 Tolerance - 1mm Hole Centres  
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**CLEAT 25**  
**GRADE S275**

(0/0 130x8 FLT x 287 LG.)

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 BOLT ON CLEAT 25

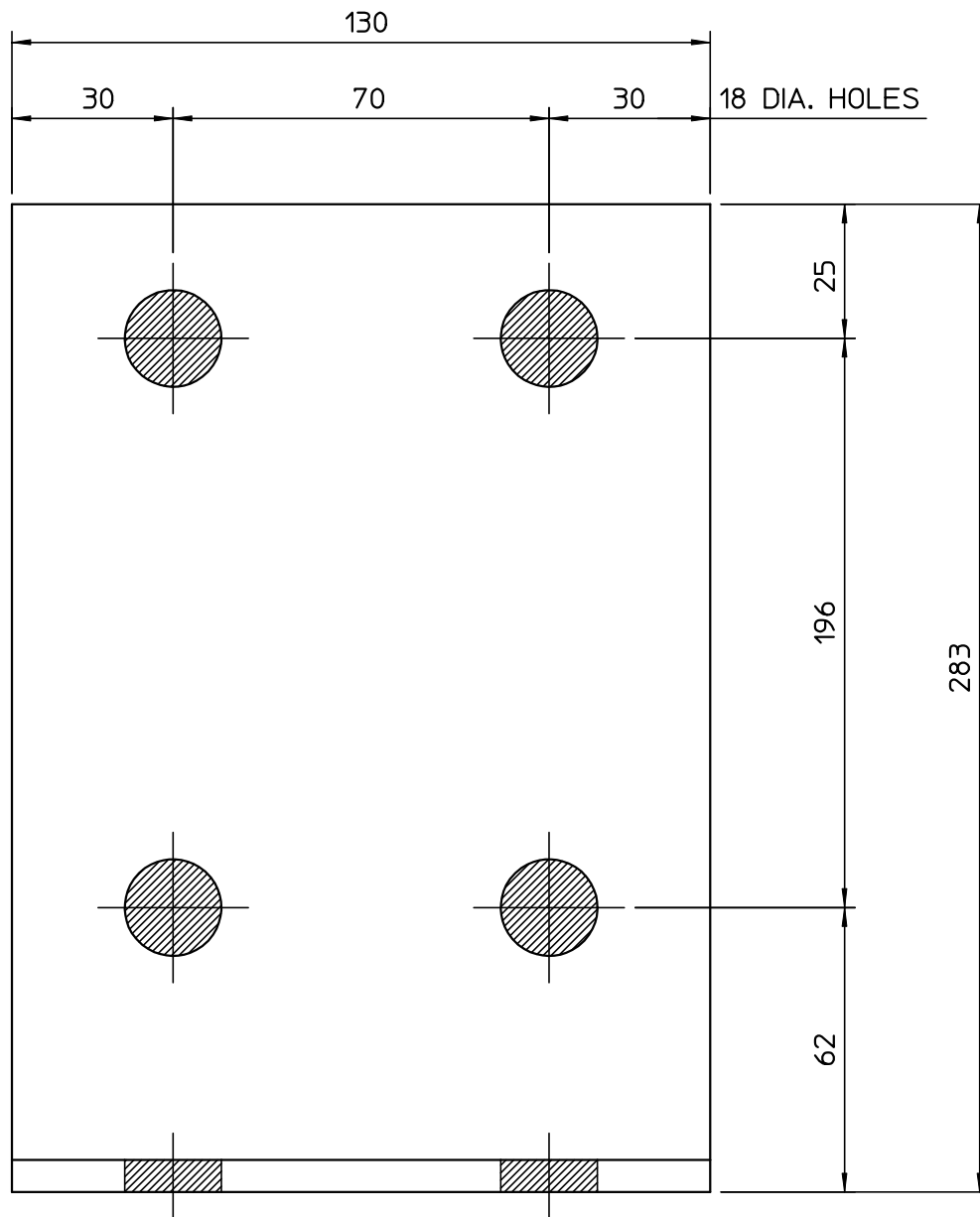
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DRG No: HSP-026 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

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 SPIN GALVANISED TO BE ISO 1461

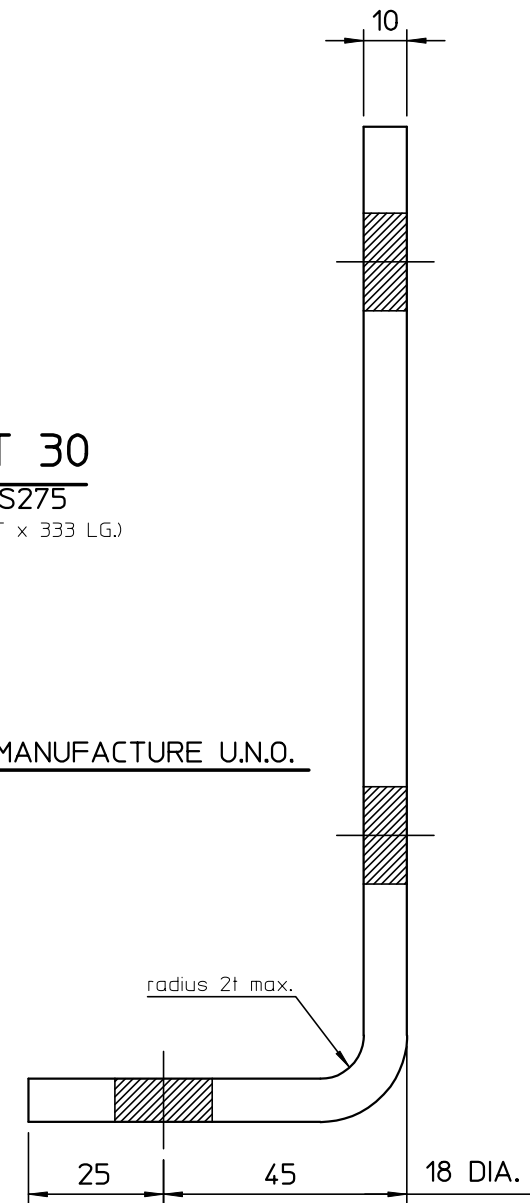
NOTES: 1: Tolerance - 1mm Edge Distance  
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**CLEAT 30**  
GRADE S275  
(O/O 130x10 FLT x 333 LG.)

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BOLT ON CLEAT 30

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Rev:

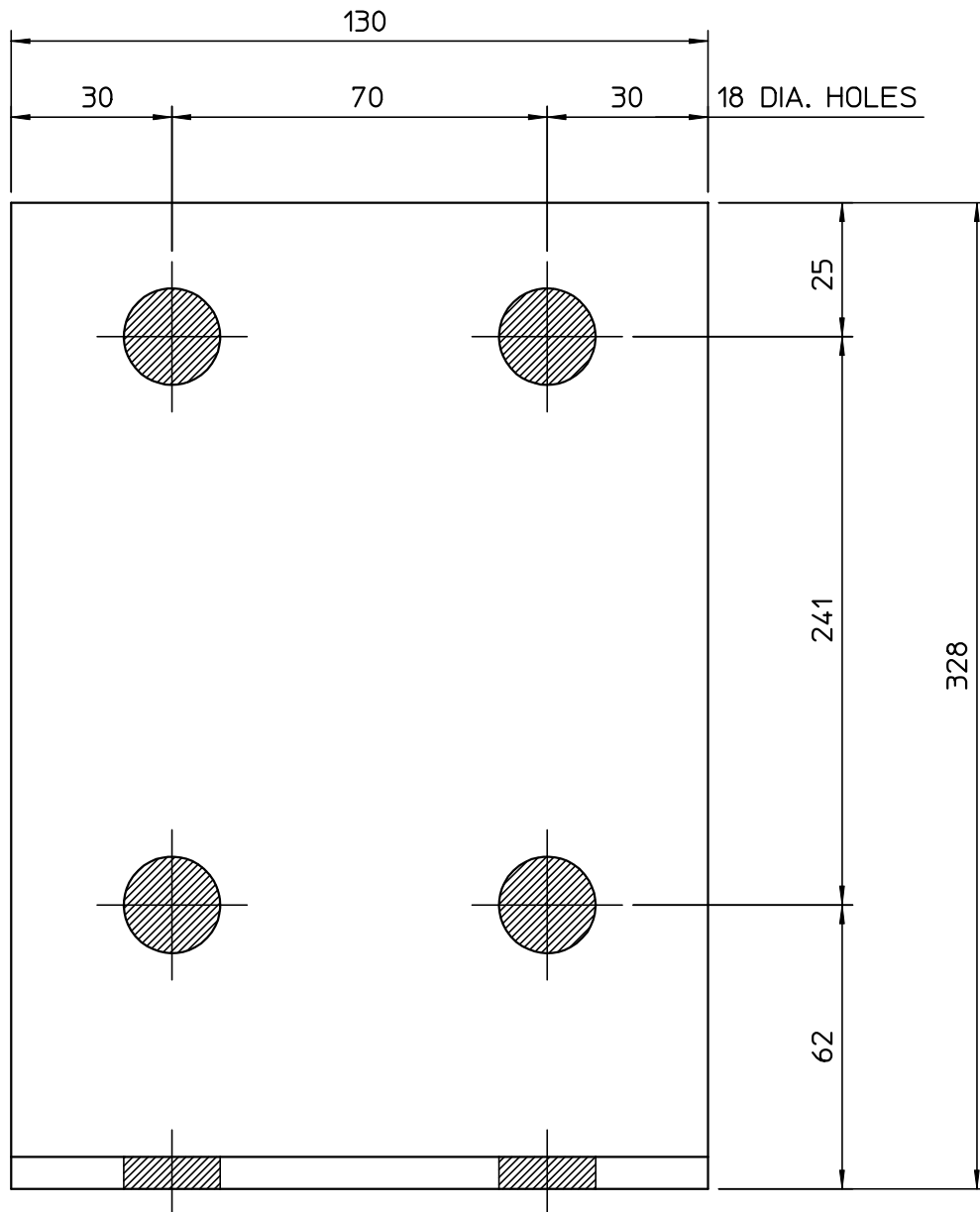
ISSUE:

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MATERIAL: MANUFACTURED FROM PLT TO BS EN 10025 S275  
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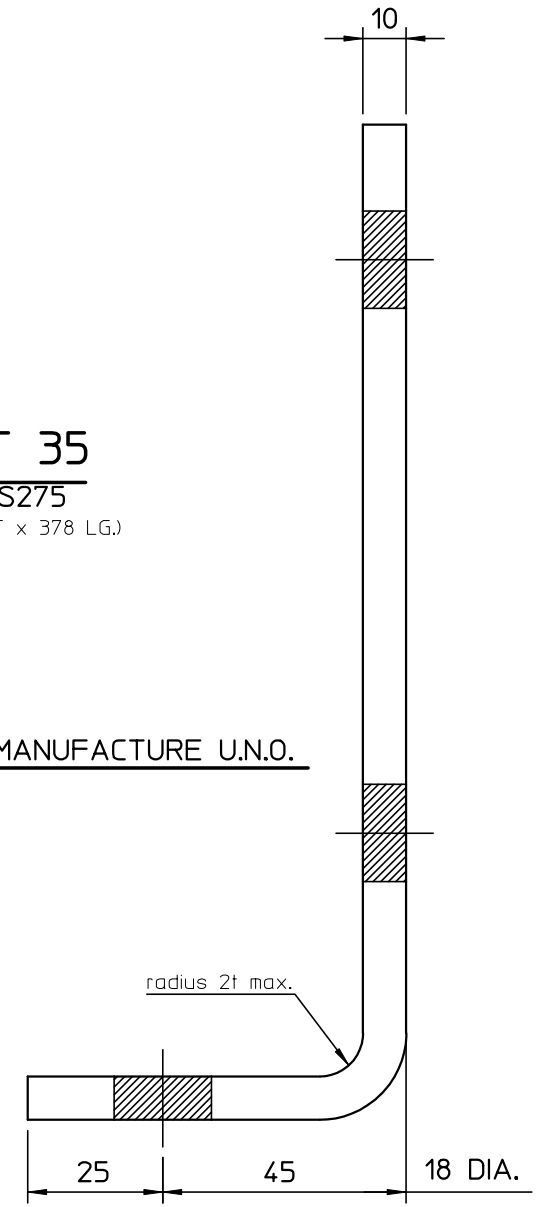


# CLEAT 35

GRADE S275

(0/0 130x10 FLT x 378 LG.)

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BOLT ON CLEAT 35	
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DRG No: HSP-028	Rev: ISSUE: 6th ISSUE

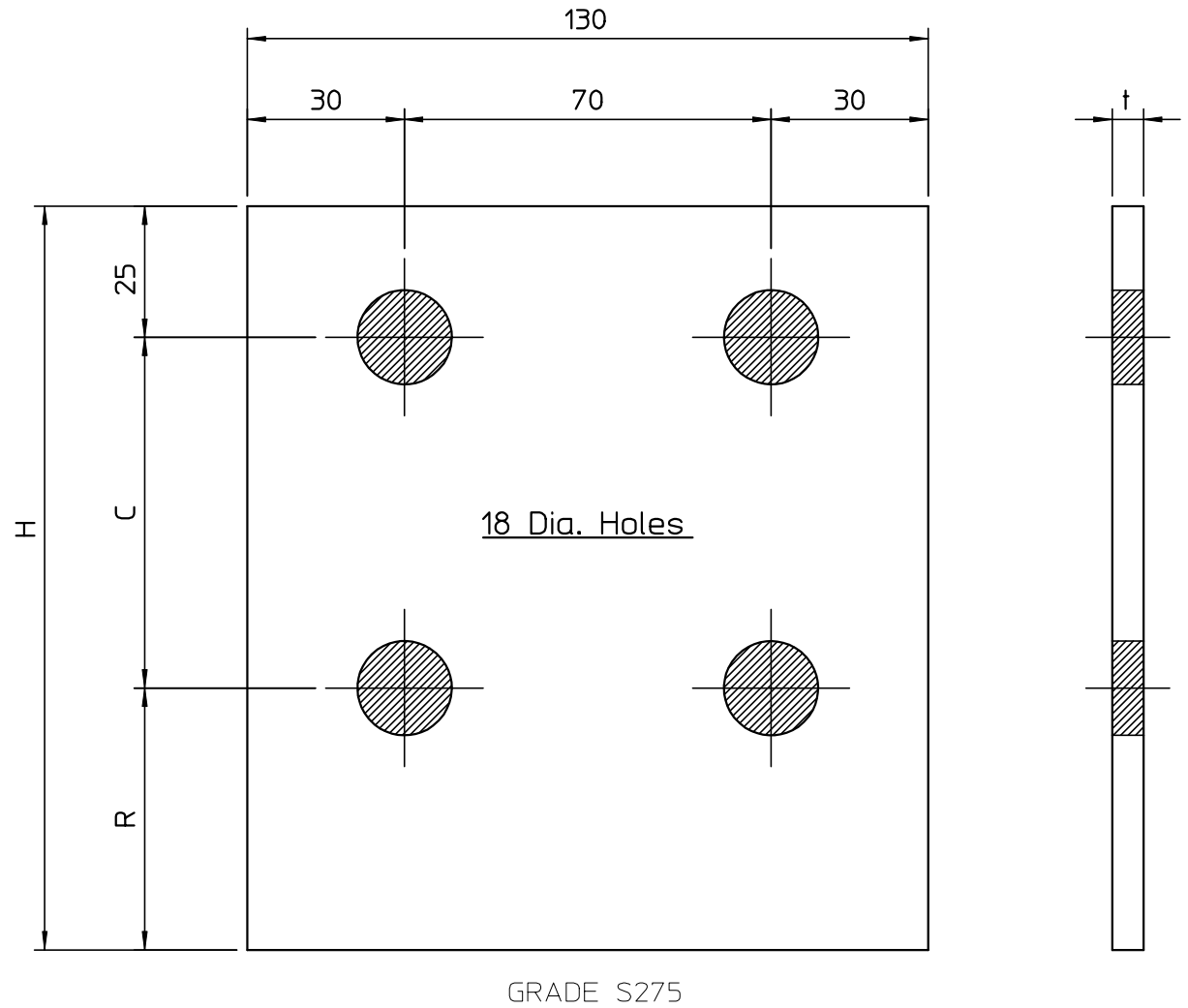
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CLEAT REF.	HEIGHT	THK.	HOLE CTRS.	
	H mm	t mm	C mm	R mm
PC15	142	6	67	50
PC17	162	6	87	50
PC20	194	8	116	53
PC23	221	8	146	50
PC25	233	8	146	62
PC30	283	10	196	62
PC35	328	10	241	62

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 WELD ON CLEAT

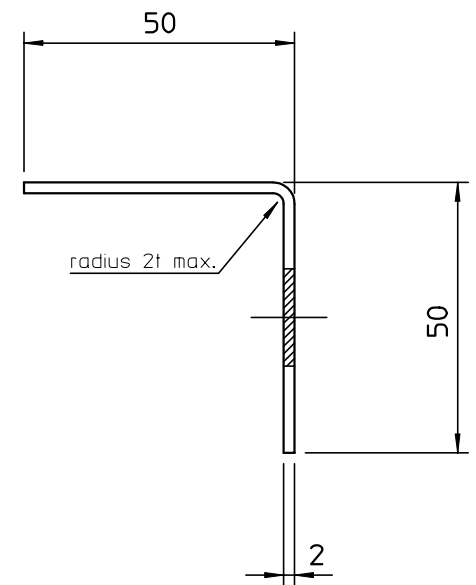
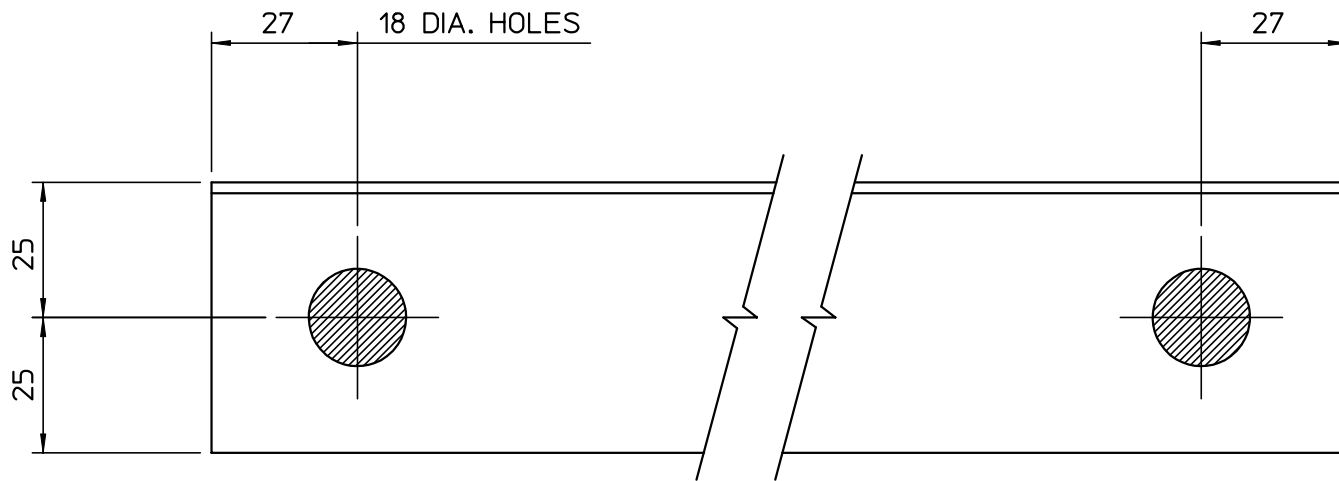
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DRG No: HSP-029 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

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## RAFTER/COLUMN STAYS

50x50x2 PRE-GALVANISED ANGLE

(0/0 96 WIDE STRIP)



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Rev:

ISSUE:

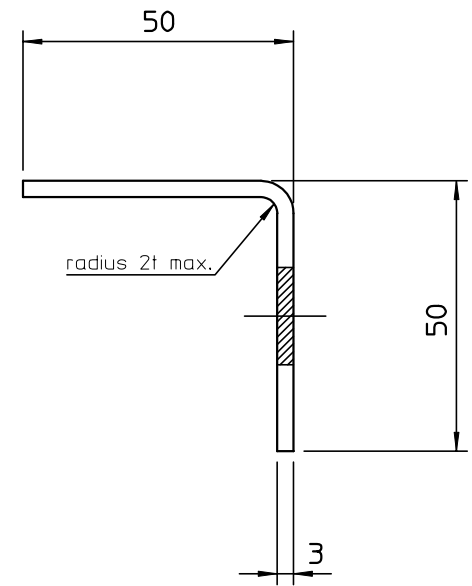
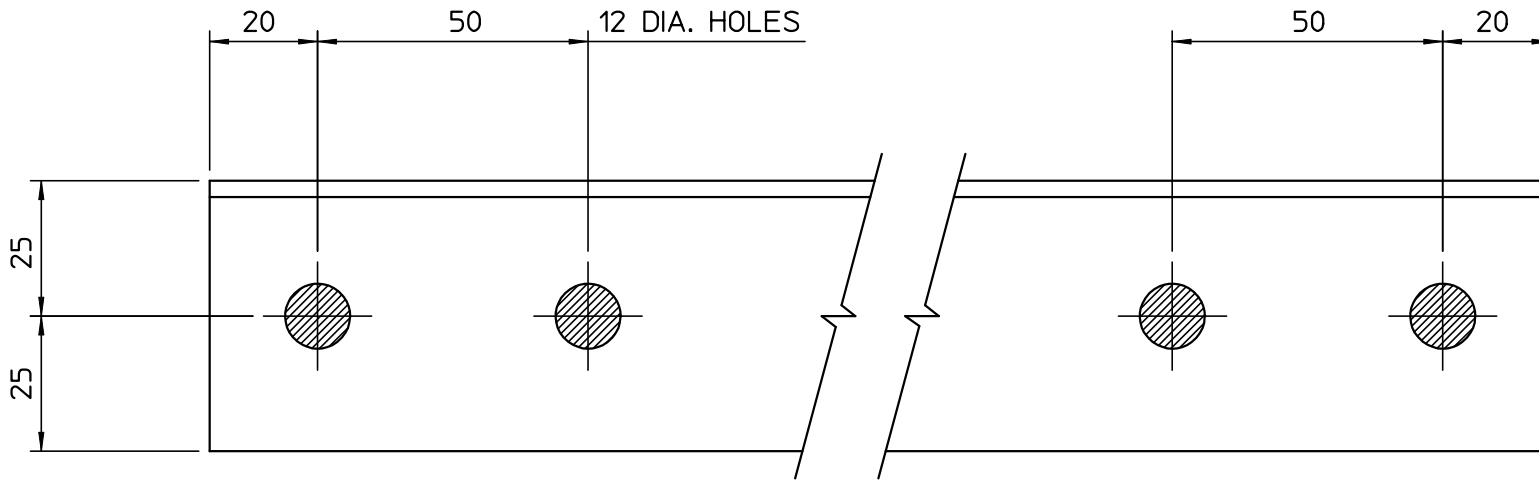
6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
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**RIGID APEX STRUT**  
**50x50x3 PRE-GALVANISED ANGLE**  
(O/O 94 WIDE STRIP)



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RIGID APEX STRUT

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Rev:

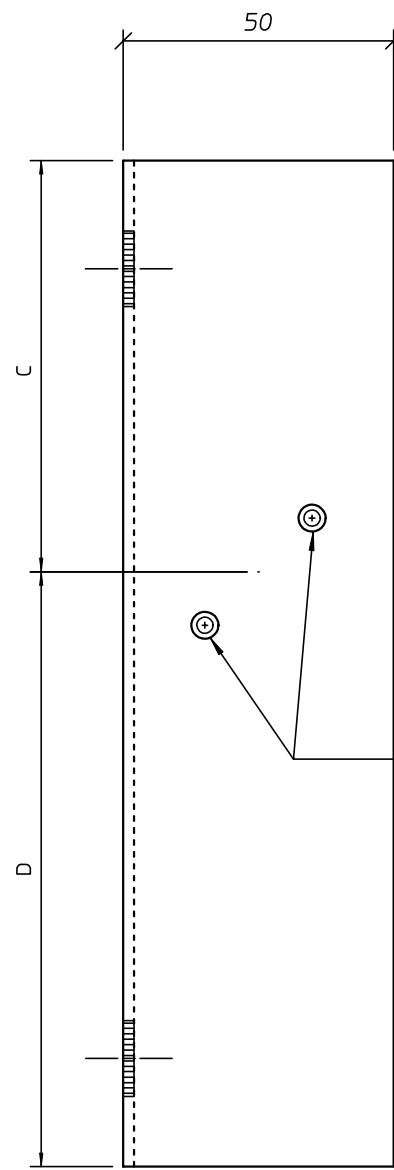
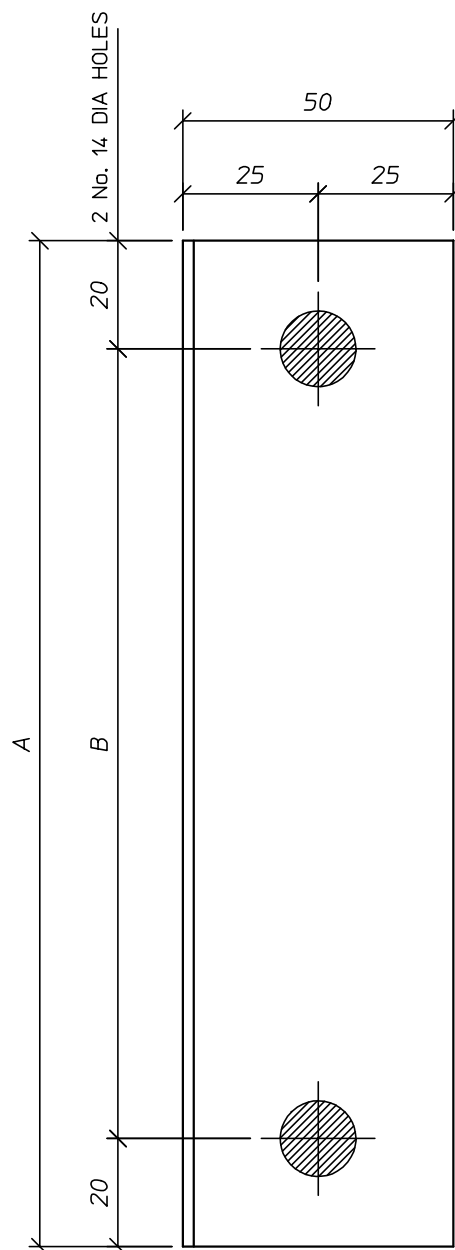
ISSUE:

6th ISSUE

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SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN  
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CLEAT	TYPE	A	B	C	D	CUT FROM
ST15	156	107	67	68	39	96x107x2 THK
ST17	176	127	87	63	64	96x127x2 THK
ST20	206	156	116	78	78	96x156x2 THK
ST23	238	186	146	93	93	96x186x2 THK
ST25	258	186	146	93	93	96x186x2 THK
ST30	309	236	196	118	118	96x236x2 THK
ST35	359	281	241	141	140	96x281x2 THK

2 No. 5 DIA SELF-PIERCING RIVETS

View A-A



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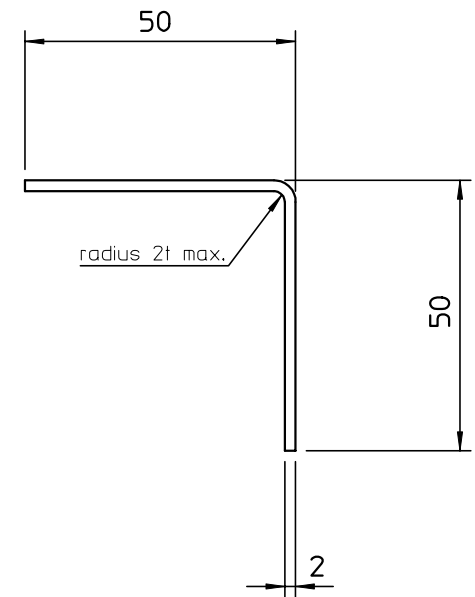
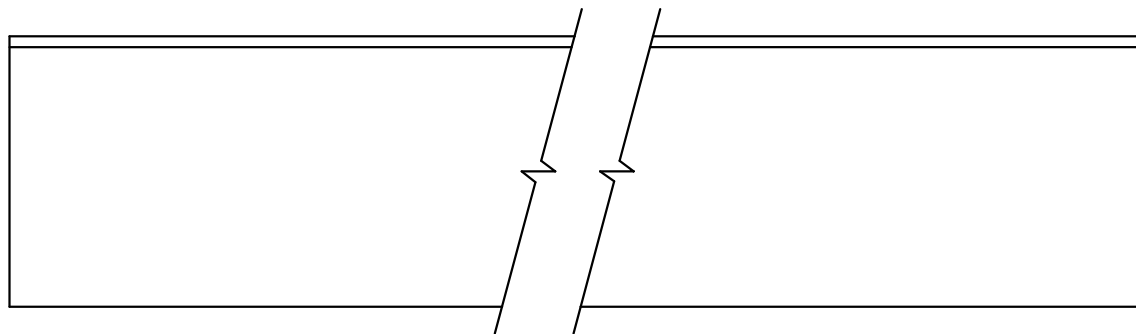
DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 RIGID-FIX STRUT END CLEATS

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DRG No: HSP-032 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

**MATERIAL:** MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN ACCORDANCE WITH BS EN ISO9001

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## RIGID-FIX STRUT SECTION

50x50x2 PRE-GALVANISED ANGLE

(0/0 96 WIDE STRIP)



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 RIGID-FIX STRUT

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DRG No: HSP-033

Rev:

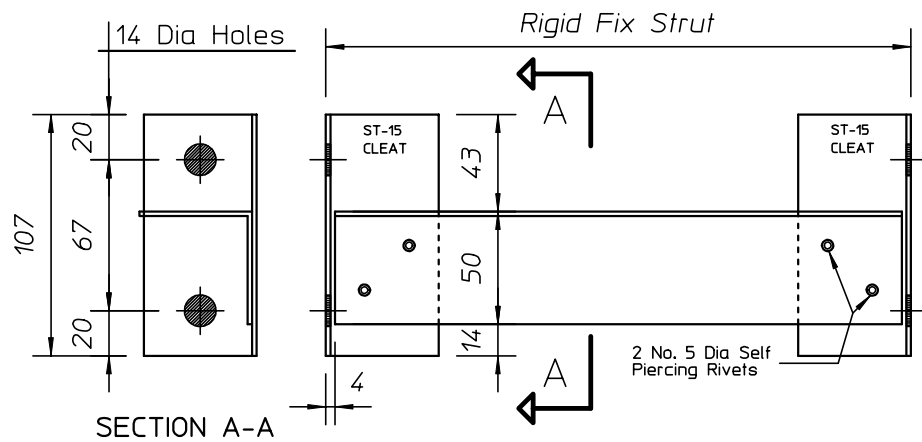
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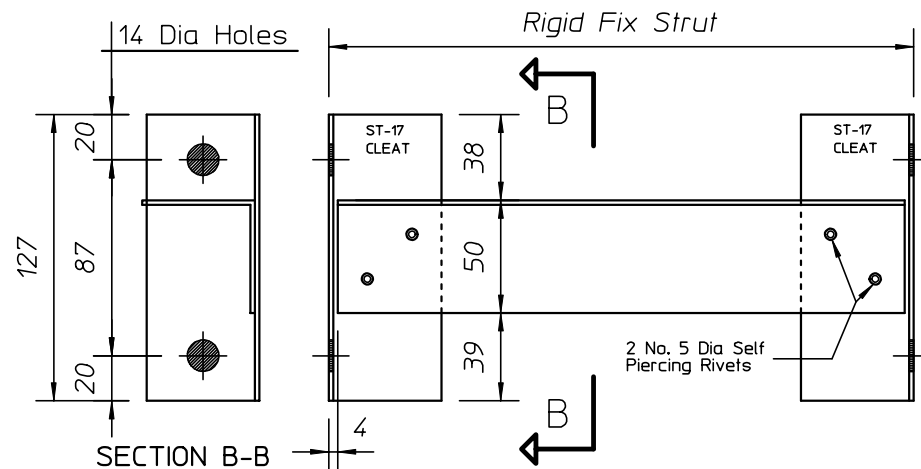
MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
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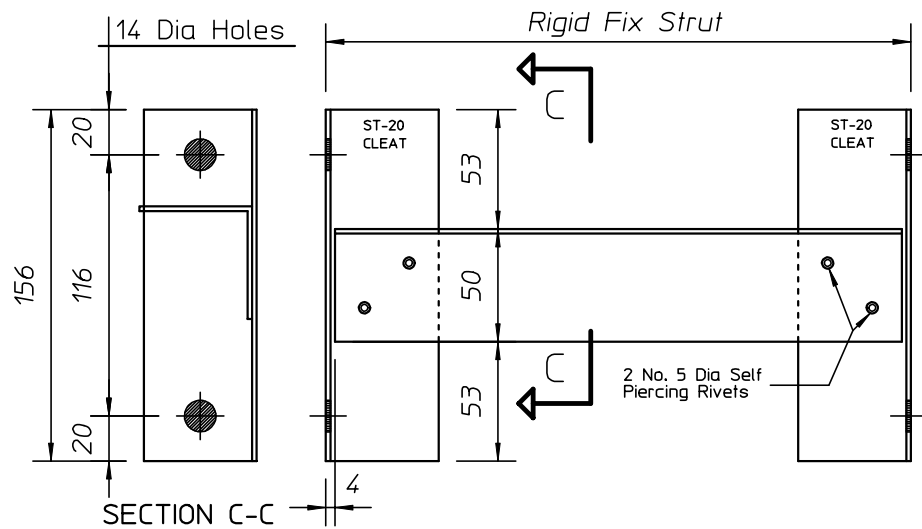
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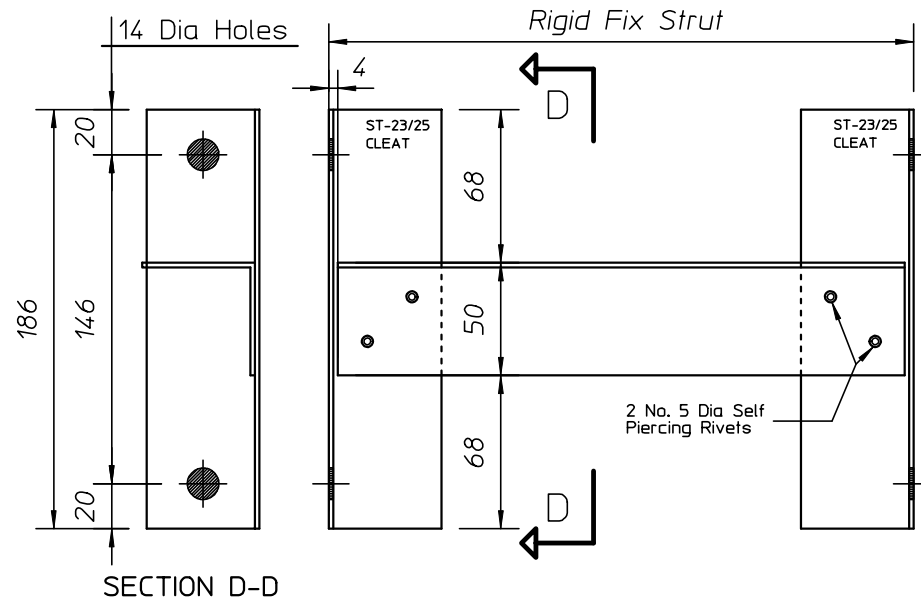
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**DATE:**

**DRG No:** HSP-034

**Rev:** A

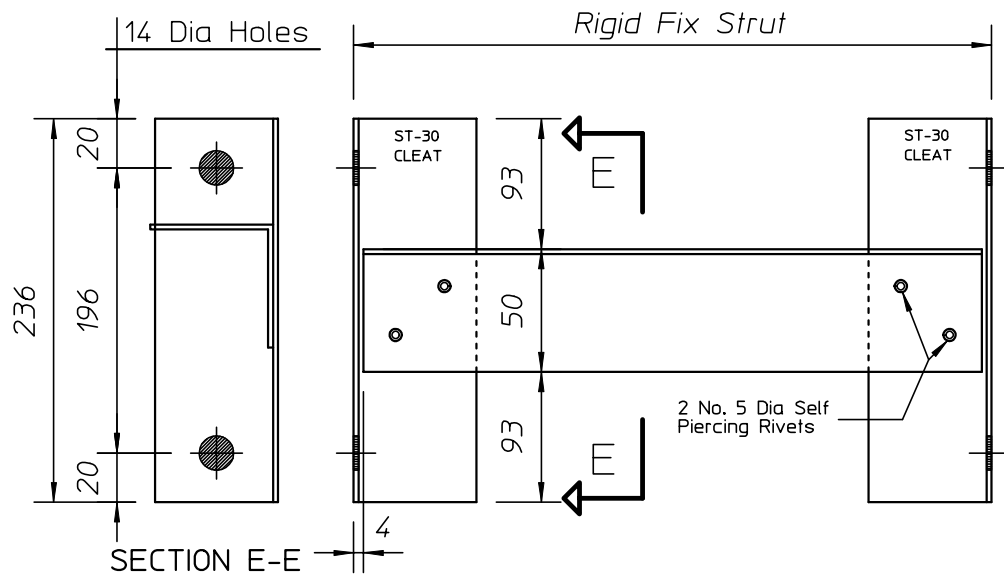
**ISSUE:**

6th ISSUE

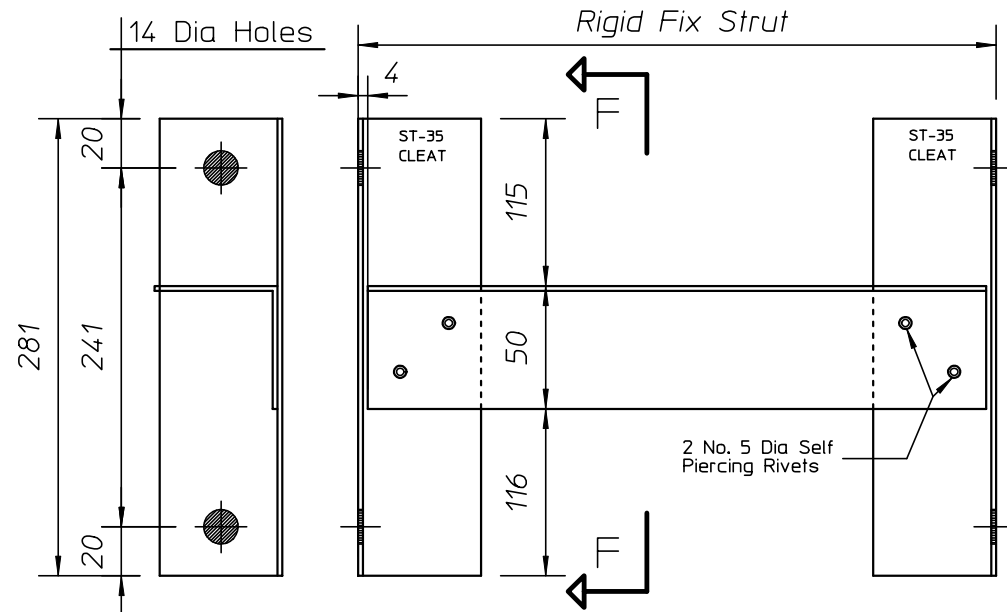
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 RIGID-FIX STRUT ASSEMBLY CONT.

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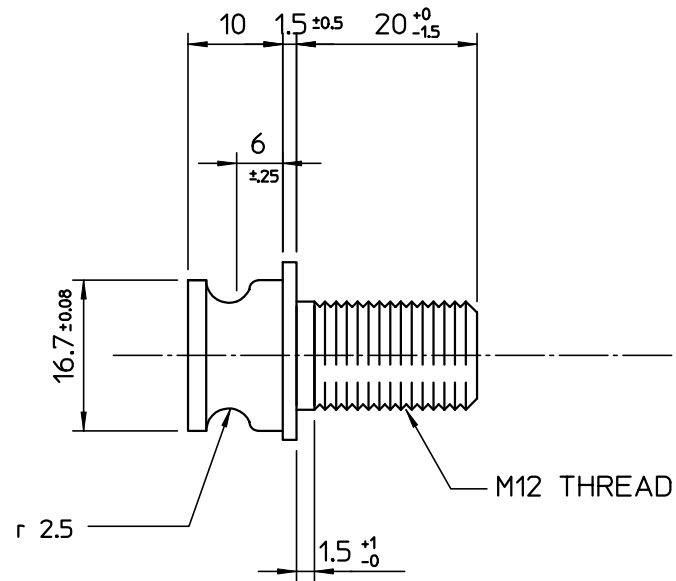
DRG No: HSP-035 Rev: ISSUE: 6th ISSUE

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## 20mm SCREWED SAG BAR END

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 SCREWED SAG BAR END 20mm

DRWN BY:

DATE:

DRG No: HSP-037

Rev:

ISSUE:

6th ISSUE

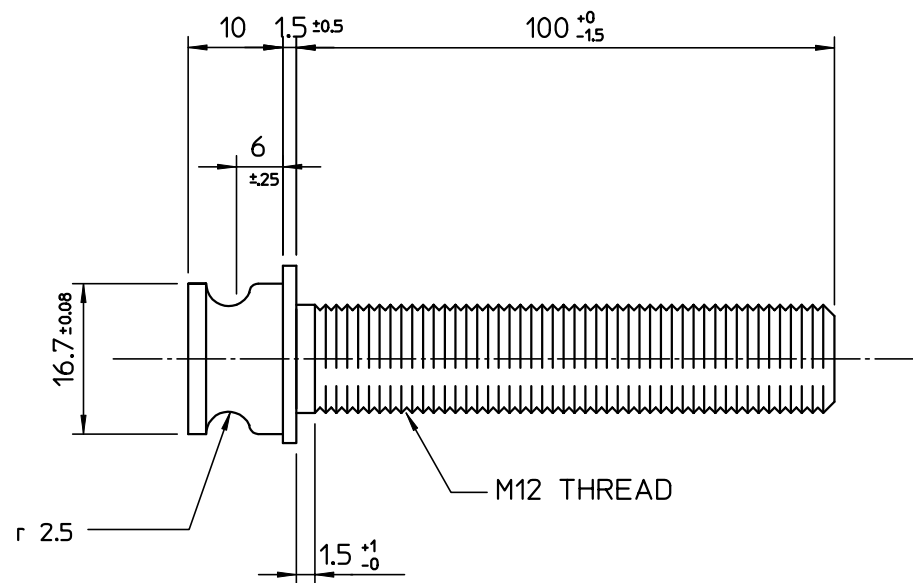
MATERIAL:

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## 100mm SCREWED SAG BAR END

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 SCREWED SAG BAR END 100mm

DRWN BY:

DATE:

DRG No: HSP-039

Rev:

ISSUE:

6th ISSUE

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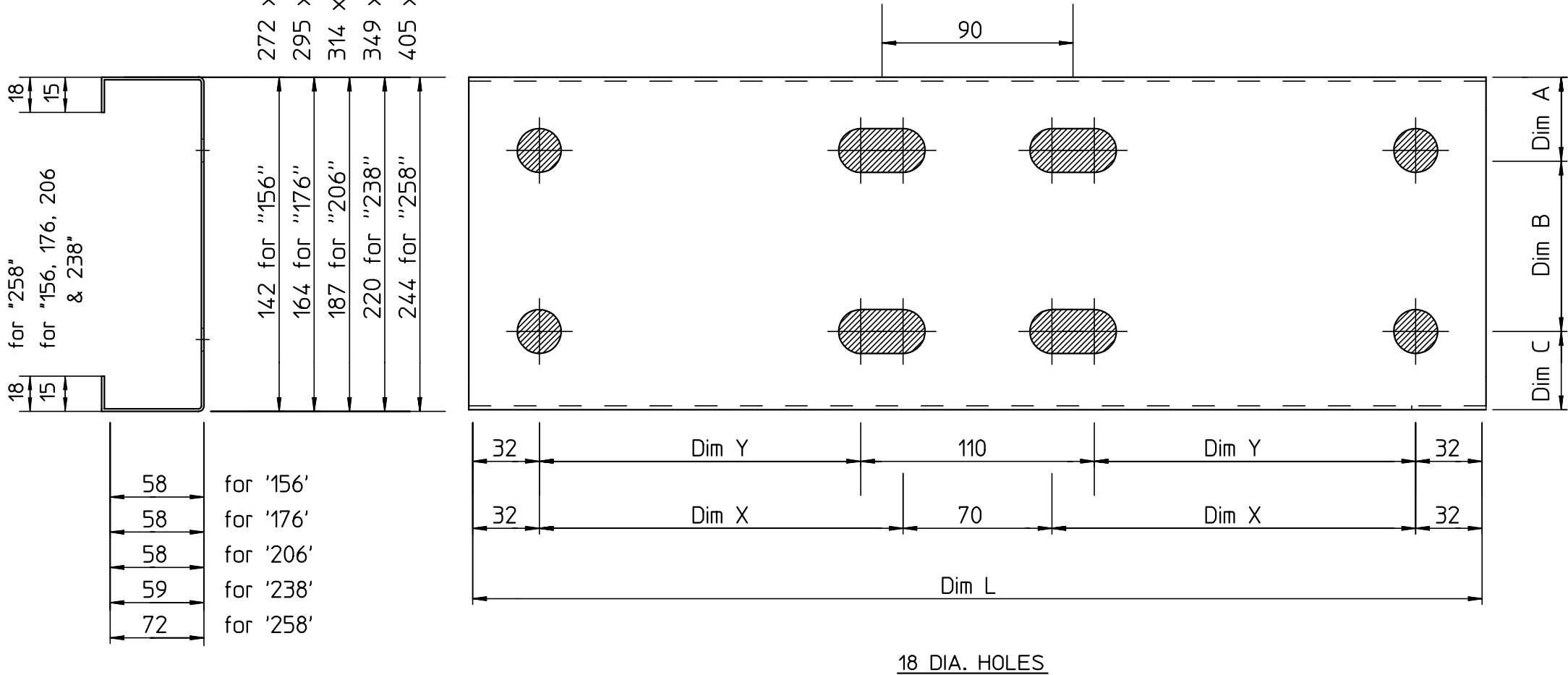


Note: Sleeves suitable for Channels up to and including 1.8mm Thk.

(For Channels > 1.8mm Thk see Drg. No. HSP-041)

272 x 2.0mm Strip  
 295 x 2.0mm Strip  
 314 x 2.4mm Strip  
 349 x 2.4mm Strip  
 405 x 2.4mm Strip

Section Ref.	Dim L	Dim X	Dim A	Dim B	Dim C	Dim Y
156	584	225	38	67	37	205
176	584	225	39	87	38	205
206	734	300	36	116	35	280
238	734	300	37	146	37	280
258	934	400	49	146	49	380




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**DRG TITLE:** HI-SPAN PRODUCTION DRAWING  
 SLEEVES C SECTION < 1.8mm THK

**DRWN BY:** \_\_\_\_\_ **DATE:** \_\_\_\_\_

**DRG No:** HSP-040 **Rev:** \_\_\_\_\_ **ISSUE:** 6th ISSUE

**MATERIAL:** MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE SHEET TO BS EN 10346 S450GD+Z275 N-A-C SUPPLIED IN ACCORDANCE WITH BS EN ISO9001

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**NOTES:** 1: For tolerances please see HSP-014  
 2: This drawing is copyright HI-SPAN, all rights reserved

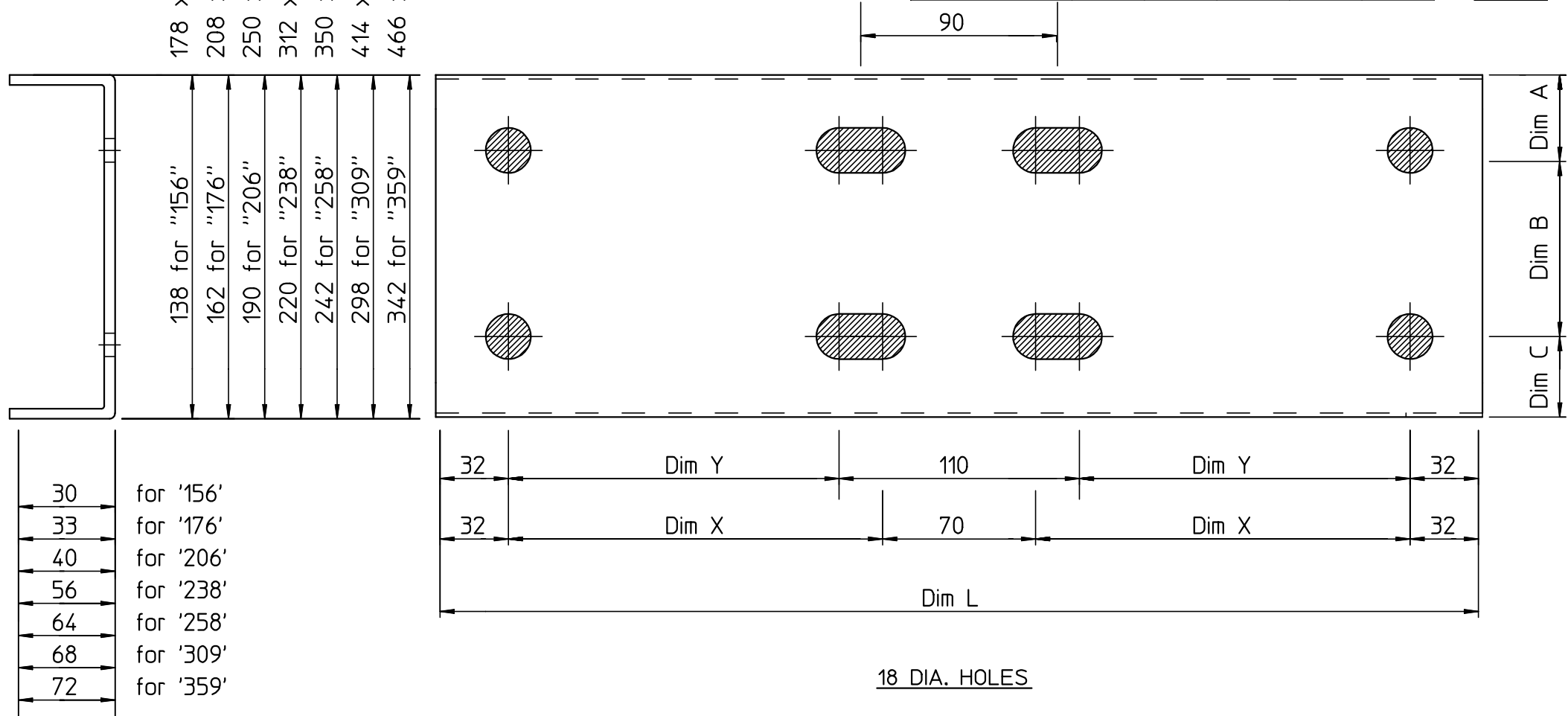


Note: Sleeves suitable for Channels > 1.8mm Thk.

(For Channels < 1.8mm Thk see Drg No. HSP-040)

178 x 5.0mm Strip  
 208 x 5.0mm Strip  
 250 x 5.0mm Strip  
 312 x 5.0mm Strip  
 350 x 5.0mm Strip  
 414 x 5.0mm Strip  
 466 x 5.0mm Strip

Section Ref.	Dim L	Dim X	Dim A	Dim B	Dim C	Dim Y
156	584	225	36	67	35	205
176	584	225	38	87	37	205
206	734	300	37	116	37	280
238	734	300	37	146	37	280
258	934	400	49	146	48	380
309	1334	600	51	196	51	580
359	1524	695	51	241	50	675



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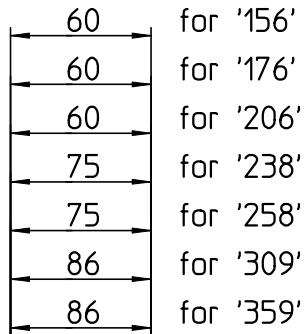


DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 SLEEVES C SECTION > 1.8mm THK

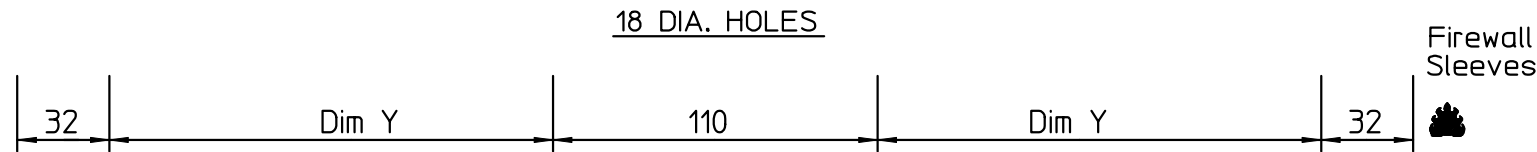
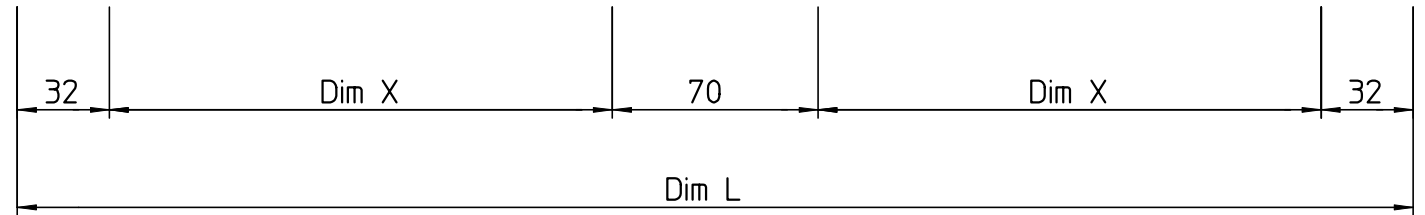
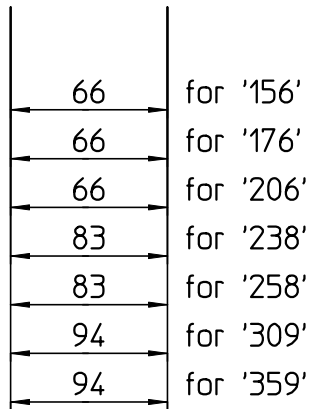
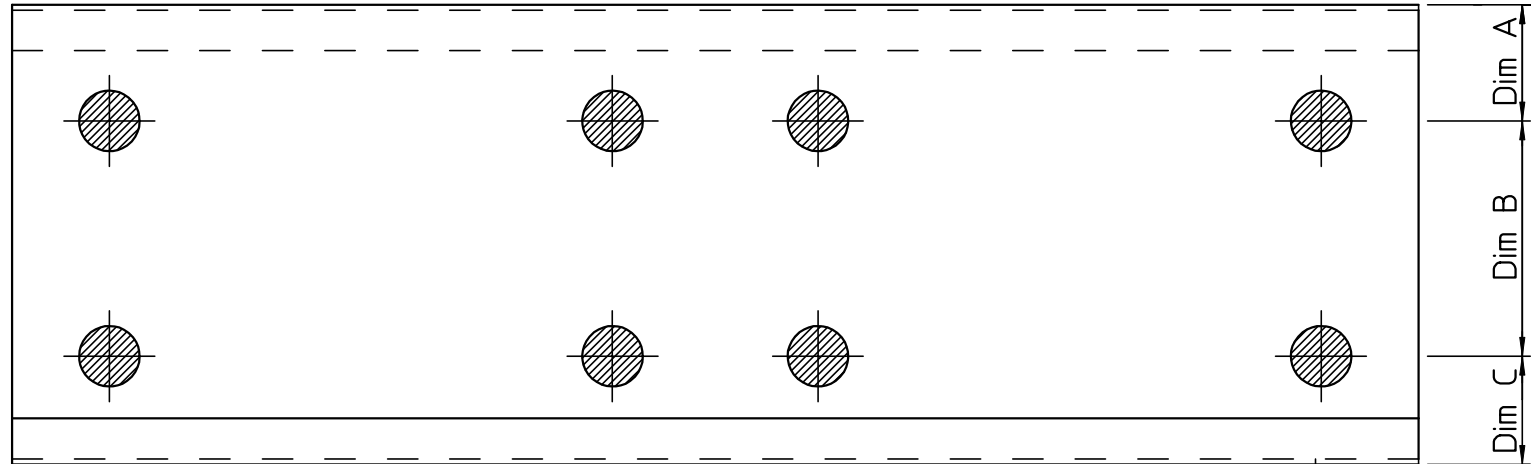
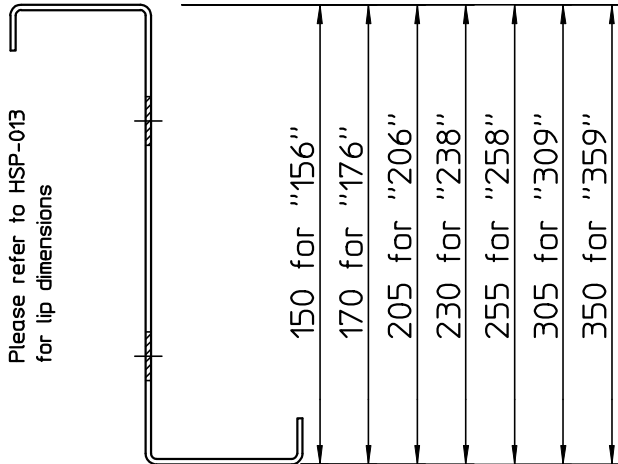
DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
 DRG No: HSP-041 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
 SHEET TO BS EN 10346 S275GD+Z275 N-A-C SUPPLIED IN  
 ACCORDANCE WITH BS EN ISO9001

NOTES: 1: For tolerances please see HSP-014  
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Section Size.	Dim L	Dim X	Dim A	Dim B	Dim C	Dim Y
156	584	225	40	67	43	205
176	584	225	40	87	43	205
206	734	300	43	116	46	280
238	734	300	40	146	44	280
258	934	400	52	146	57	380
309	1334	600	52	196	57	580
359	1524	695	52	241	57	675




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**DRG TITLE:** HI-SPAN PRODUCTION DRAWING  
 SLEEVES Z SECTION

**DRWN BY:** \_\_\_\_\_ **DATE:** \_\_\_\_\_

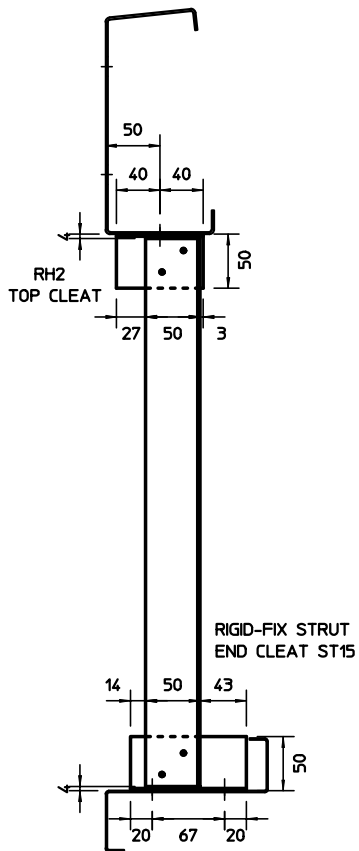
**DRG No:** HSP-042 **Rev:** \_\_\_\_\_ **ISSUE:** 6th ISSUE

**MATERIAL:** MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE SHEET TO BS EN 10346 S450+Z275 N-A-C SUPPLIED IN ACCORDANCE WITH BS EN ISO9001

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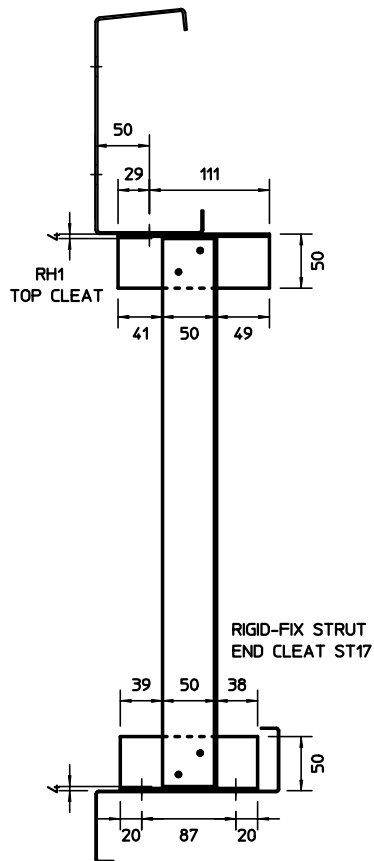
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Hi-SPAN Eaves Beam



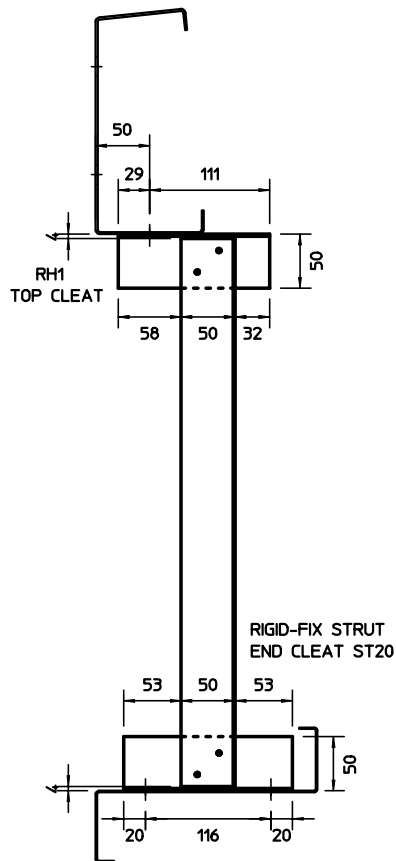
156 Series

Hi-SPAN Eaves Beam



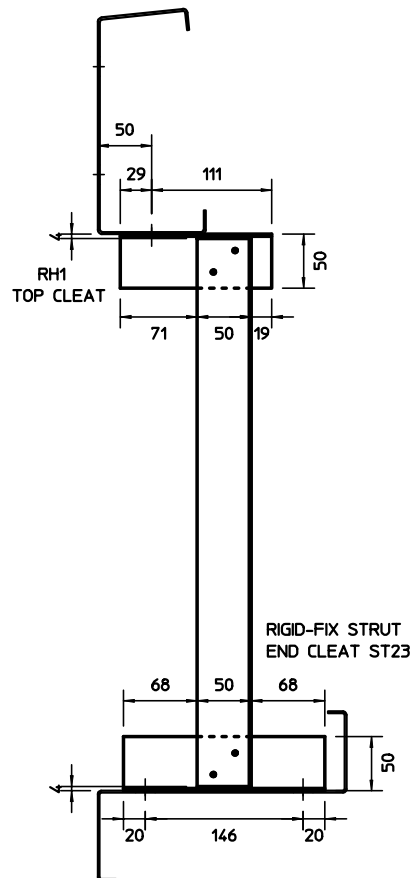
176 Series

Hi-SPAN Eaves Beam



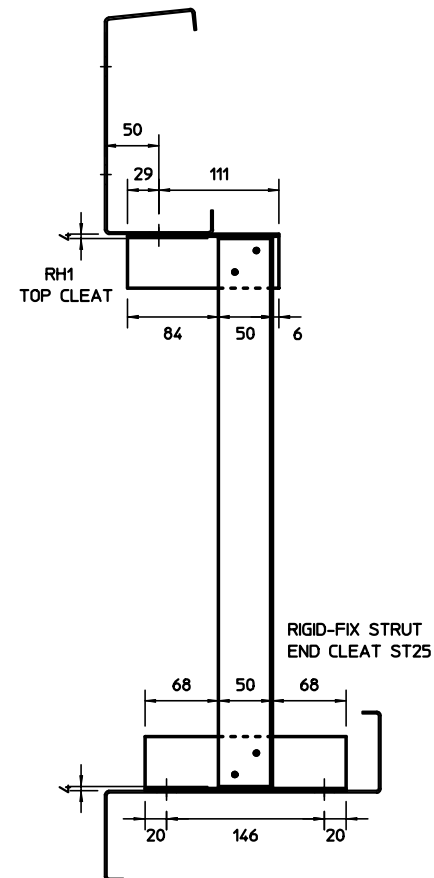
206 Series

Hi-SPAN Eaves Beam



238 Series

Hi-SPAN Eaves Beam



258 Series



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 STRUT TO EAVES BEAM CLEAT ASSEMBLY

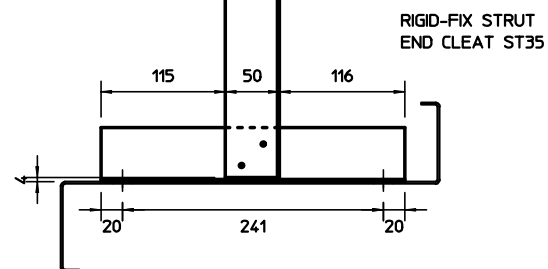
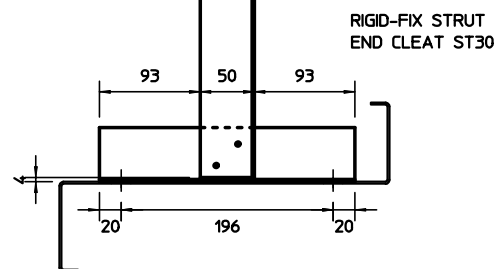
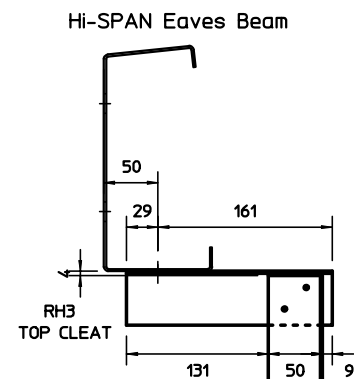
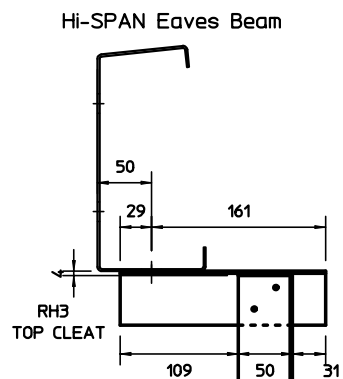
DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_

DRG No: HSP-043 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
 SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN  
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309 Series

359 Series



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
STRUT TO EAVES BEAM CLEAT ASSEMBLY 309 / 359

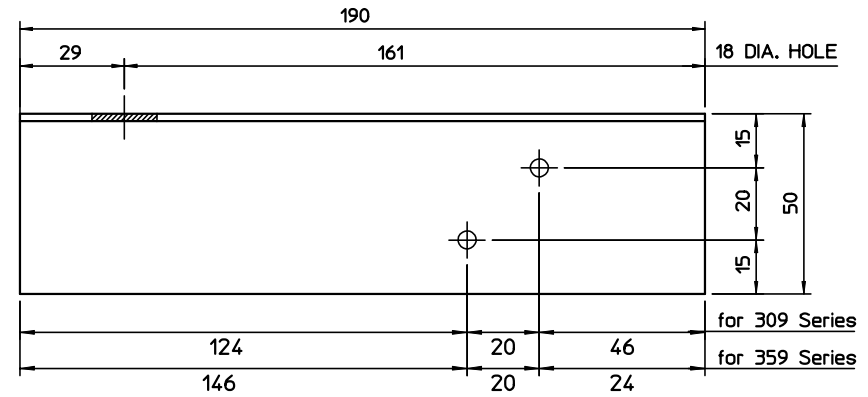
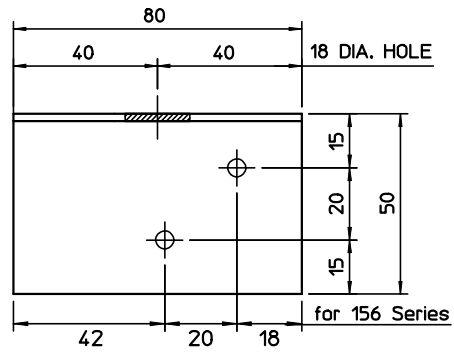
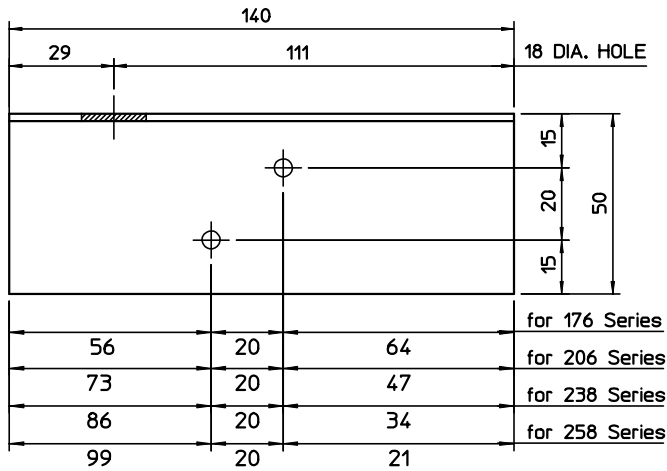
DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_

DRG No: HSP-044 Rev: \_\_\_\_\_ ISSUE: 6th ISSUE

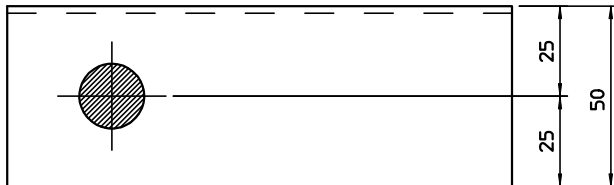
MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN  
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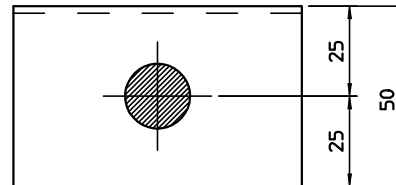


PLAN VIEW



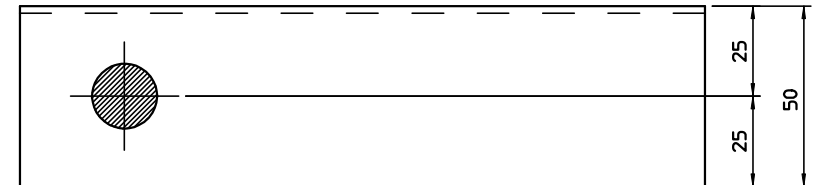
SIDE RAIL HANGER TOP CLEAT MKD. 'RH1'  
o/o 140x96x2THK. PRE-GALVANISED SHEET

PLAN VIEW



SIDE RAIL HANGER TOP CLEAT MKD. 'RH2'  
o/o 80x96x2THK. PRE-GALVANISED SHEET

PLAN VIEW



SIDE RAIL HANGER TOP CLEAT MKD. 'RH3'  
o/o 190x96x2THK. PRE-GALVANISED SHEET

⊕ 5 DIA. SELF-PIERCING RIVETS



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
STRUT TO EAVES BEAM CLEAT DETAILS

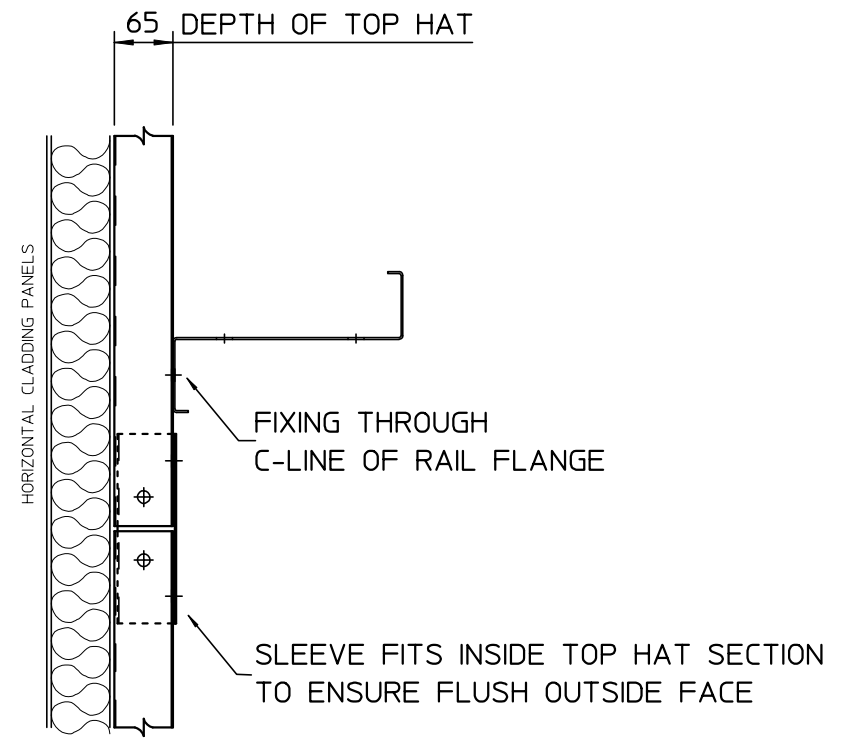
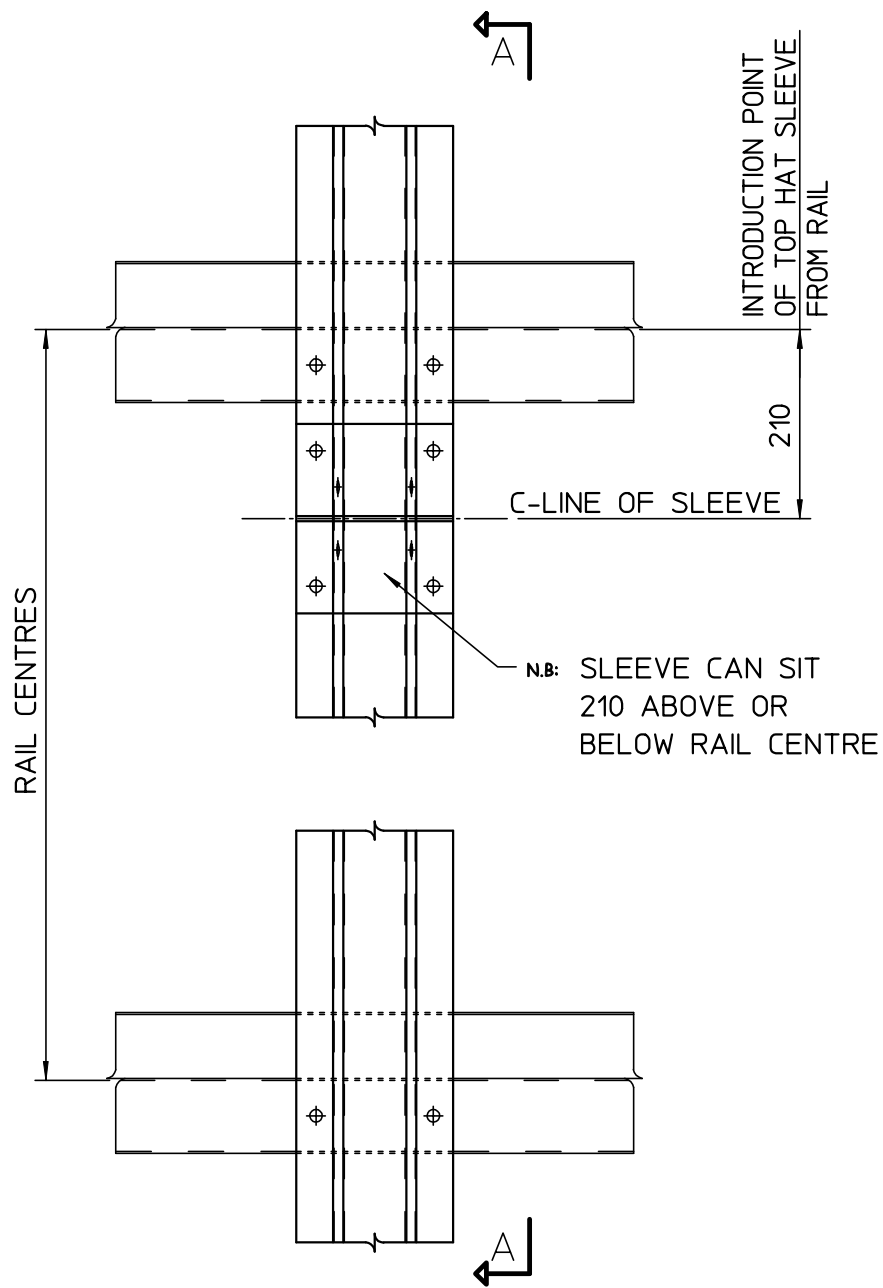
DRWN BY: DATE:

DRG No: HSP-045 Rev: ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN ACCORDANCE WITH BS EN ISO9001

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VIEW A-A

TOP HAT SLEEVE REQUIRED EVERY 4m MAX.  
 TH70 SECTION REQ'D FOR INTERMEDIATE PANEL SUPPORTS  
 TH140 SECTION REQ'D @ PANEL JOINT POSITIONS



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 TOP HAT ASSEMBLY DRAWING

DRWN BY:

DATE:

DRG No: HSP-046

Rev:

ISSUE:

6th ISSUE

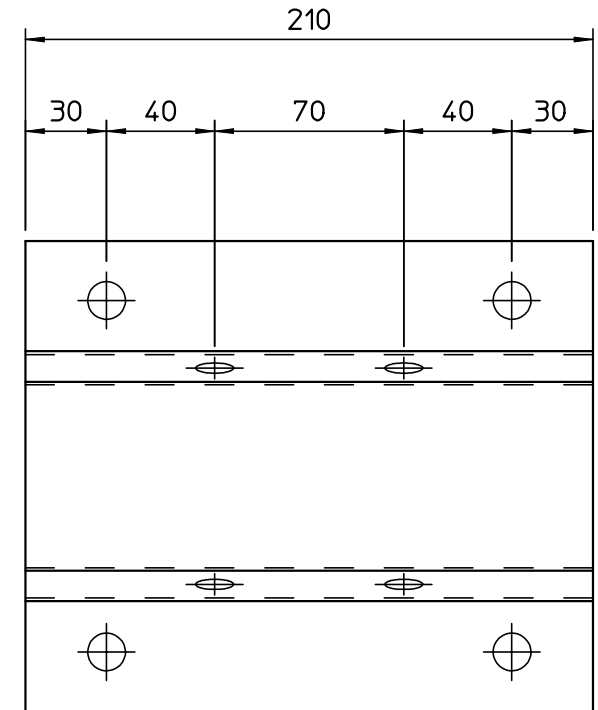
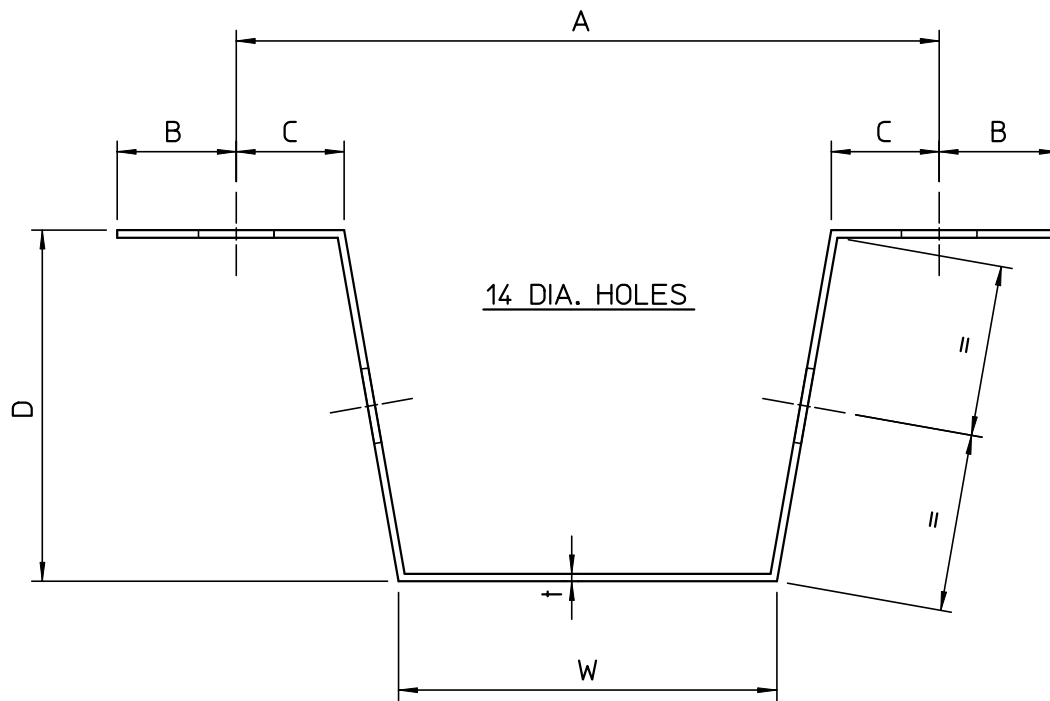
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SECTION REF	DEPTH	WIDTH	THKNESS	STANDARD PUNCHING LINES		
	D (mm)	W (mm)	t (mm)	A (mm)	B (mm)	C (mm)
TH70	65	70	1.5	130	22	20
TH140	65	140	1.5	200	25	20
THSL70	65	64	1.5	130	22	23
THSL140	65	134	1.5	200	25	23



THSL70 / THSL140  
STANDARD TOP HAT SLEEVE



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
TOP HAT SECTIONS & SLEEVES

DRWN BY:

DATE:

DRG No: HSP-047

Rev:

ISSUE:

6th ISSUE

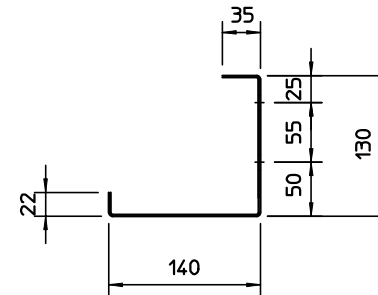
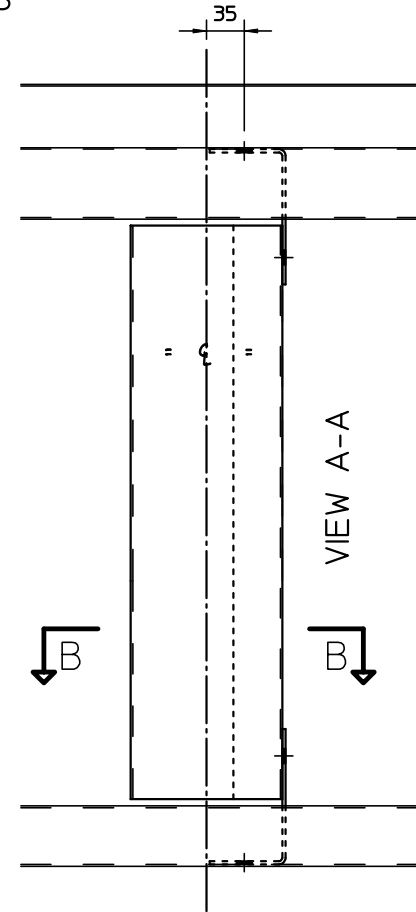
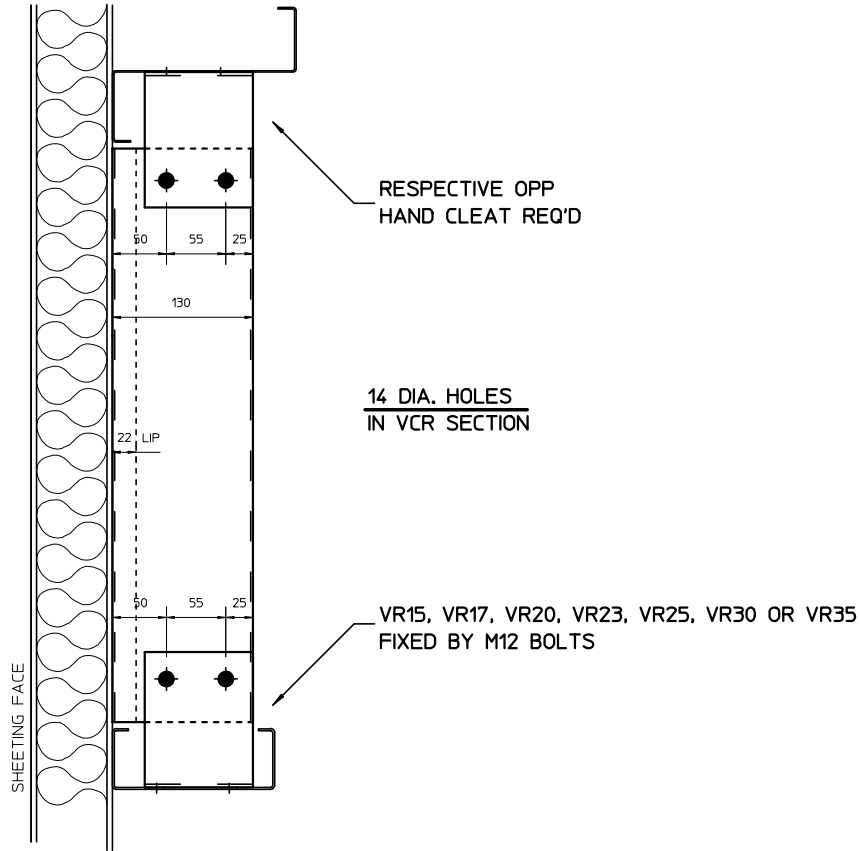
MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
SHEET TO BS EN 10346 S450GD+Z275 N-A-C SUPPLIED IN  
ACCORDANCE WITH BS EN ISO9001

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A

N.B: THE VCR IS USED ON PANEL JOINTS



A



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 VERTICAL CLADDING RAIL ASSEMBLY

DRWN BY: DATE:

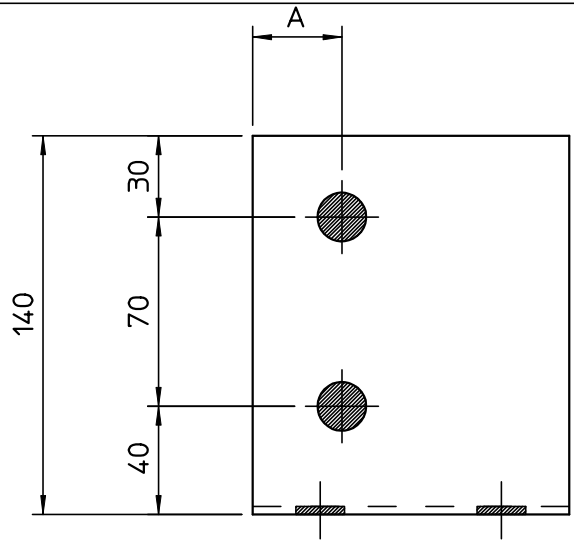
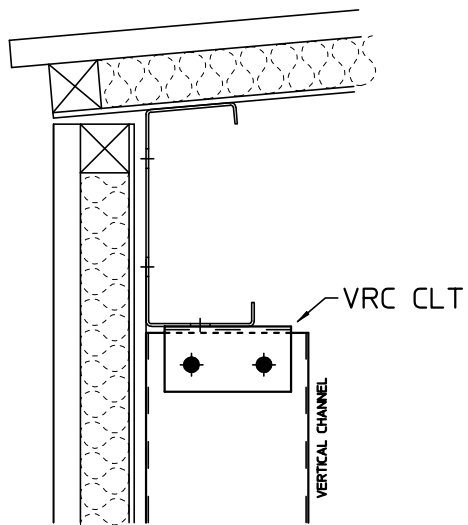
DRG No: HSP-048 Rev: ISSUE: 6th ISSUE

MATERIAL:

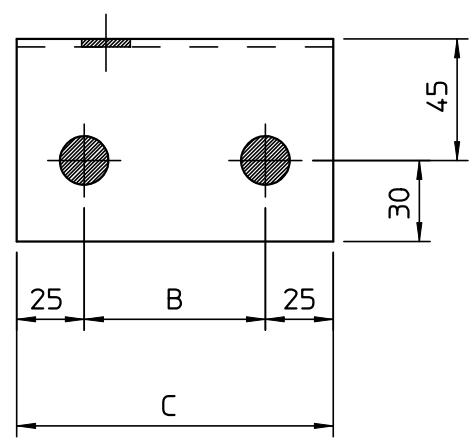
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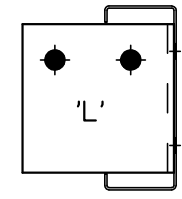
ALL HOLES 18 DIA.



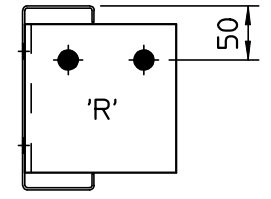
O/O: 3THK PRE-GALV

TYPE	A	B	C	CUT FROM
VRC 127	45	67	117	117x3PLT x209
VRC 156	33	67	117	117x3PLT x209
VRC 176	33	87	137	137x3PLT x209
VRC 206	30	116	166	166x3PLT x209
VRC 220	23	116	166	166x3PLT x209
VRC 238	33	146	196	196x3PLT x209
VRC 258	20	146	196	196x3PLT x209
VRC 309	20	196	246	246x3PLT x209
VRC 359	20	241	291	291x3PLT x209

N.B: EACH CLEAT POST FIXED 'L'/LEFT HAND OR 'R'/RIGHT HAND



'O/SIDE'



VERTICAL CHANNEL TOP CLT TO U/S EAVES BEAM



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DRG TITLE: HI-SPAN PRODUCTION DRAWING  
 VERTICAL CLADDING RAIL CLEATS TO EAVES BEAM

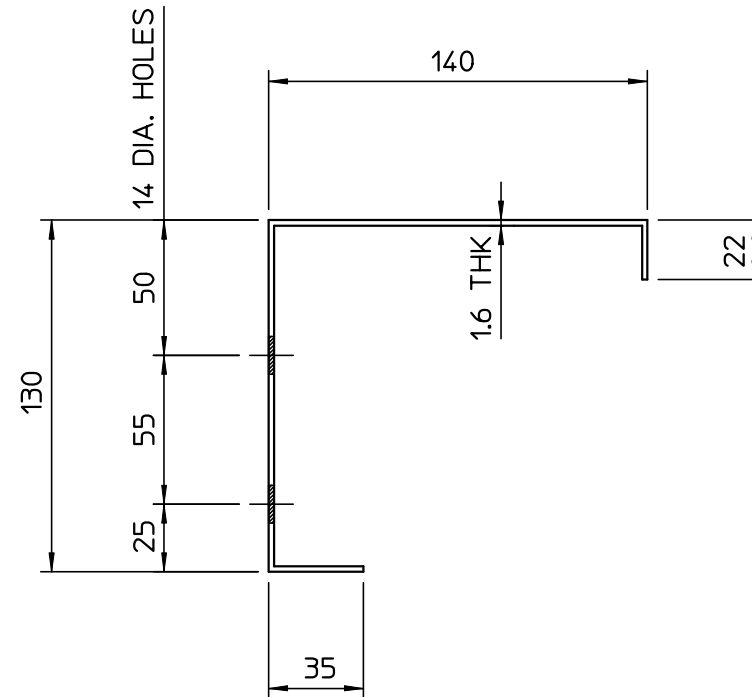
DRWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_

DRG No: HSP-050 Rev: A ISSUE: 6th ISSUE

MATERIAL: MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE SHEET TO BS EN 10346 DX51D+Z275 N-A-C SUPPLIED IN ACCORDANCE WITH BS EN ISO9001

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**DRG TITLE:** HI-SPAN PRODUCTION DRAWING  
 VERTICAL CLADDING RAIL DIMENSIONS

**DRWN BY:**

**DATE:**

**DRG No:** HSP-051

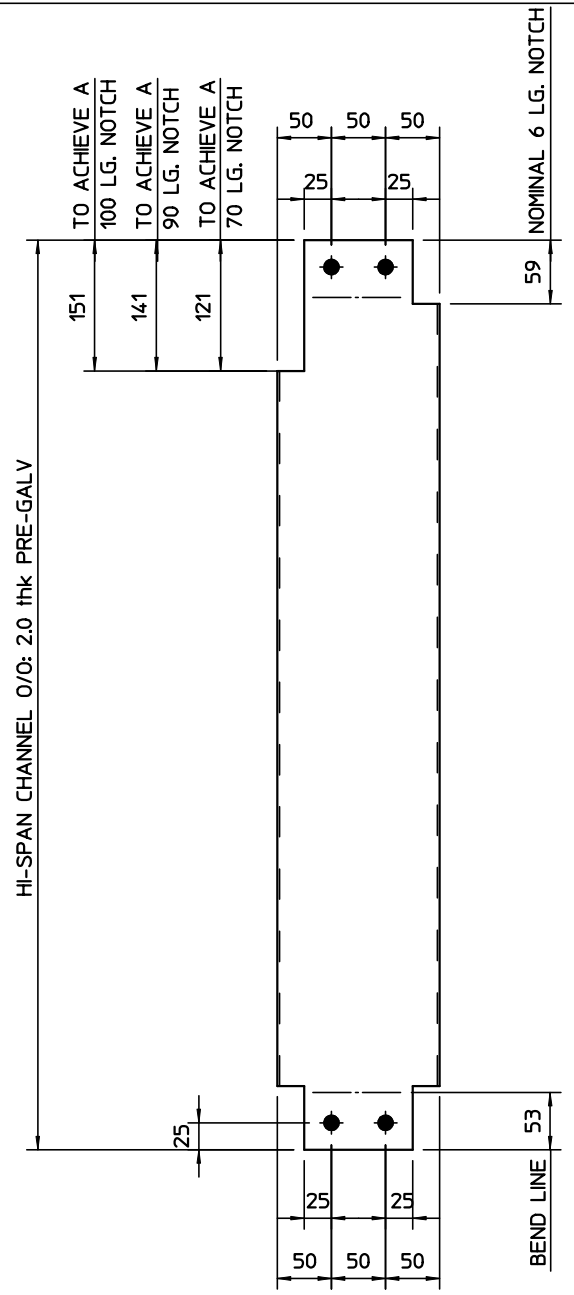
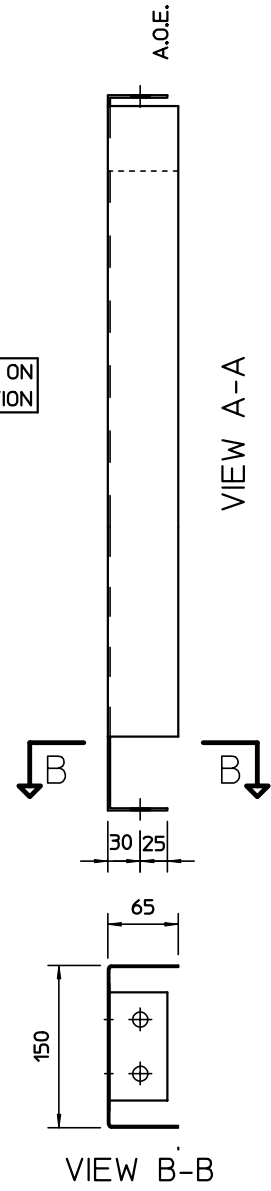
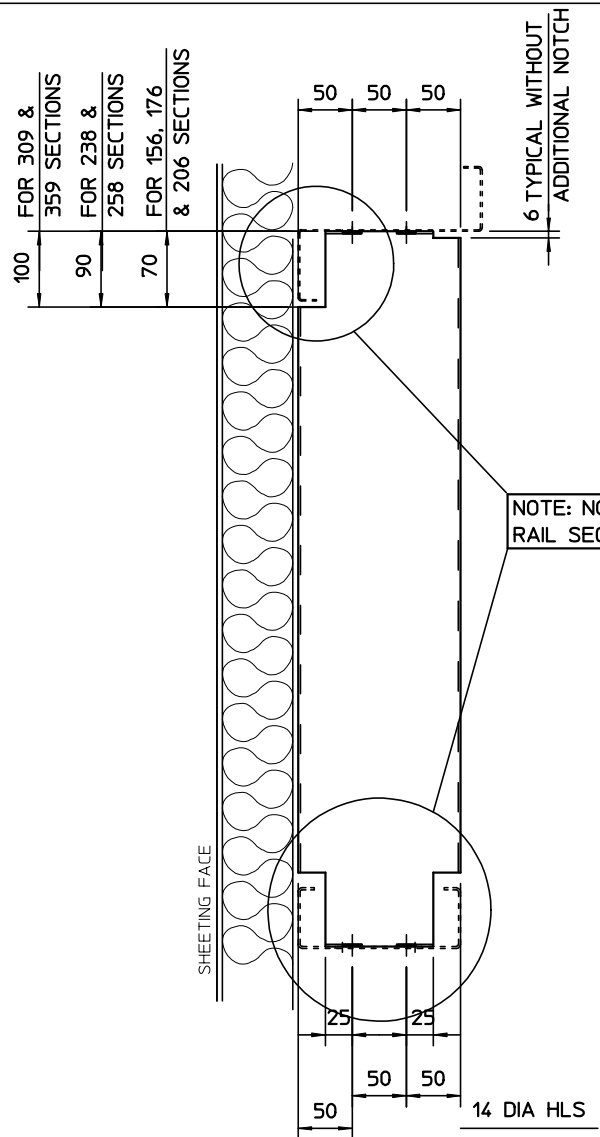
**Rev:** A

**ISSUE:** 6th ISSUE

**MATERIAL:** MANUFACTURED FROM HOT DIPPED PRIME BRIGHT SPANGLE  
 SHEET TO BS EN 10346 S450GD+Z275 N-A-C SUPPLIED IN  
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CHANNEL PROFILE BEFORE ENDS BENT



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DRG TITLE: HI-SPAN PRODUCTION DRAWING	
WCP ASSEMBLY DRAWING	
DRWN BY:	DATE:
DRG No: HSP-052	Rev: ISSUE: 6th ISSUE

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