

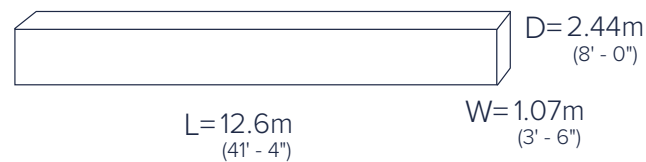
# GALVANIZING DESIGN DETAILS

## EDMONTON TANK SIZE LIMITATIONS

Lifting capacity = 10 tonnes

### SINGLE DIP MAX.

(Double dipping - subject to a premium)



### MAX. D/D DIMENSIONS FOR DEPTH



### MAX. D/D DIMENSIONS FOR LENGTH



## MINIMUM VENT & DRAIN HOLE SIZES

Must be the greater of the the following two options:

- 1.5 times the plate or wall thickness
- The following size chart:

| SQUARE OR ROUND SIZE |             | HOLE SIZE (PER END) |                |
|----------------------|-------------|---------------------|----------------|
| ≤ 2"                 | 60mm        | 2 holes @ 3/8"      | 2 holes @ 10mm |
| 2 1/2"               | 73mm        | 2 holes @ 1/2"      | 2 holes @ 13mm |
| 3" - 3 1/2"          | 89 - 102mm  | 2 holes @ 5/8"      | 2 holes @ 16mm |
| 4" - 5"              | 114 - 141mm | 2 holes @ 3/4"      | 2 holes @ 19mm |
| 6"                   | 168mm       | 2 holes @ 7/8"      | 2 holes @ 22mm |
| 7"                   | 190mm       | 2 holes @ 1"        | 2 holes @ 25mm |
| 8"                   | 219mm       | 2 holes @ 1 1/8"    | 2 holes @ 29mm |
| 10"                  | 273mm       | 2 holes @ 1 1/2"    | 2 holes @ 38mm |
| 12"                  | 324mm       | 2 holes @ 1 3/4"    | 2 holes @ 44mm |
| 14"                  | 356mm       | 2 holes @ 2"        | 2 holes @ 51mm |
| 16"                  | 406mm       | 2 holes @ 2 1/4"    | 2 holes @ 57mm |

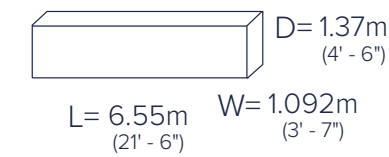
- Holes within 6mm (1/4") from corner or weld
- Minimum hole size: 10mm (3/8")
- Single drain diameter = 25% of section size

## SASKATOON TANK SIZE LIMITATIONS

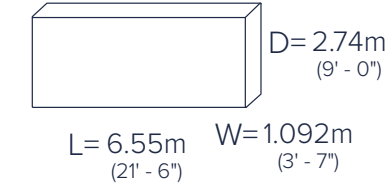
Lifting capacity = 6 tonnes

### SINGLE DIP MAX.

(Double dipping - subject to a premium)



### MAX. D/D DIMENSIONS FOR DEPTH

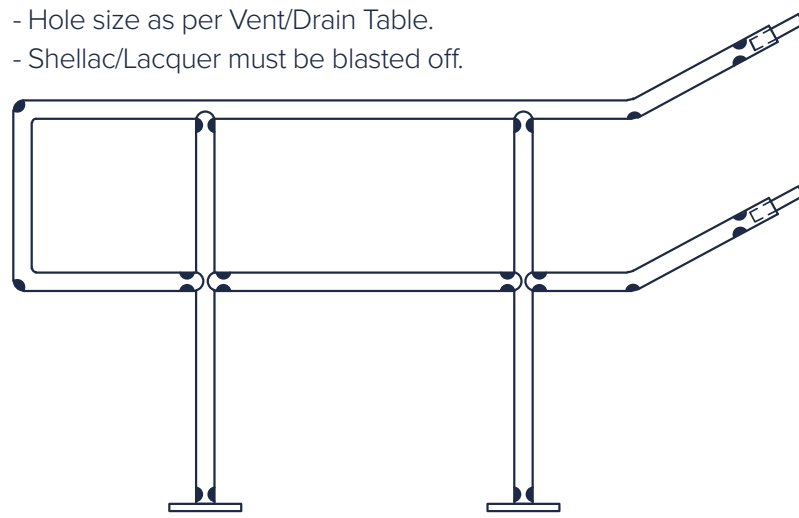


### MAX. D/D DIMENSIONS FOR LENGTH



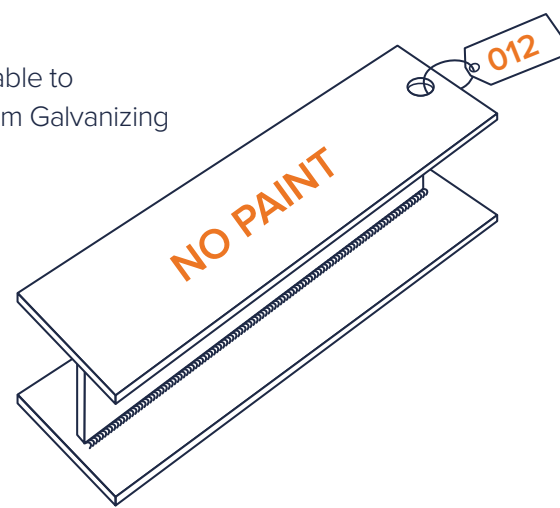
## PIPE HANDRAIL & H.S.S. FABRICATIONS

- Hole size as per Vent/Drain Table.
- Shellac/Lacquer must be blasted off.



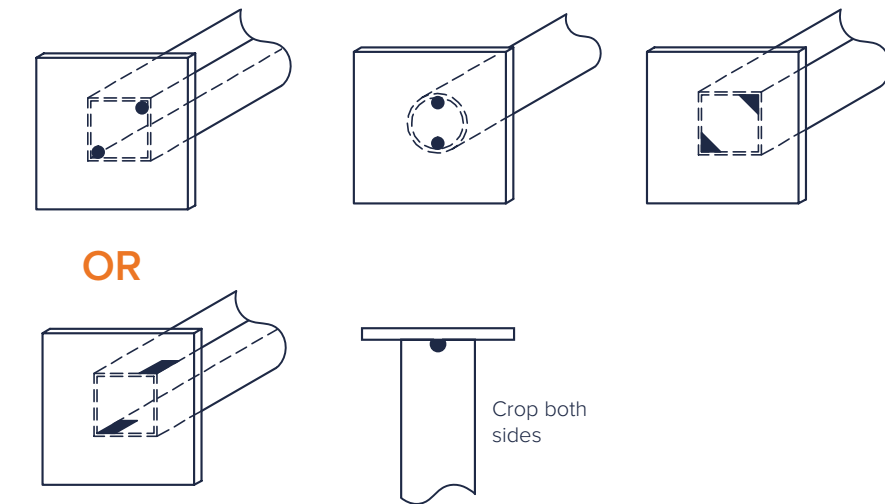
## IDENTIFICATION MARKINGS

- Metal tags
- Heavy emboss
- 1.3mm (1/16") wire
- Kettle tags available to purchase at Daam Galvanizing

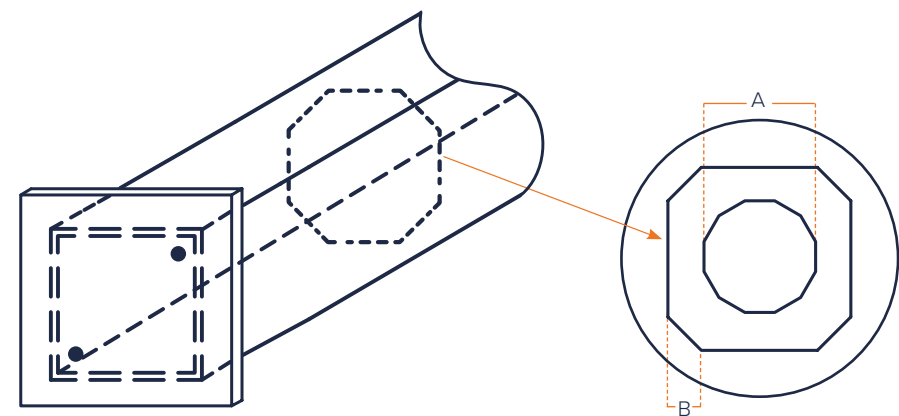


## HOLLOW COLUMNS

- Hole size as per Vent/Drain Table.
- In either base plate or pipe.



## INTERNAL STIFFENERS

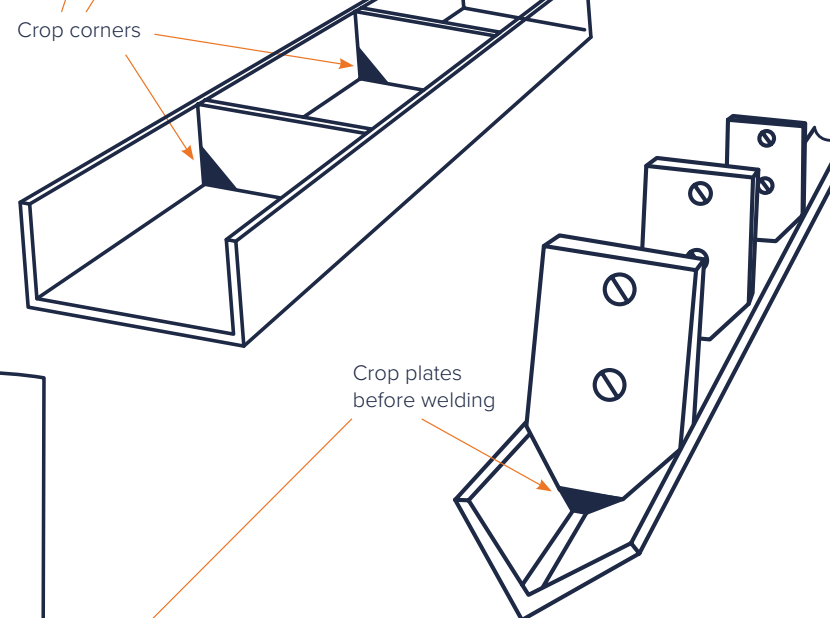
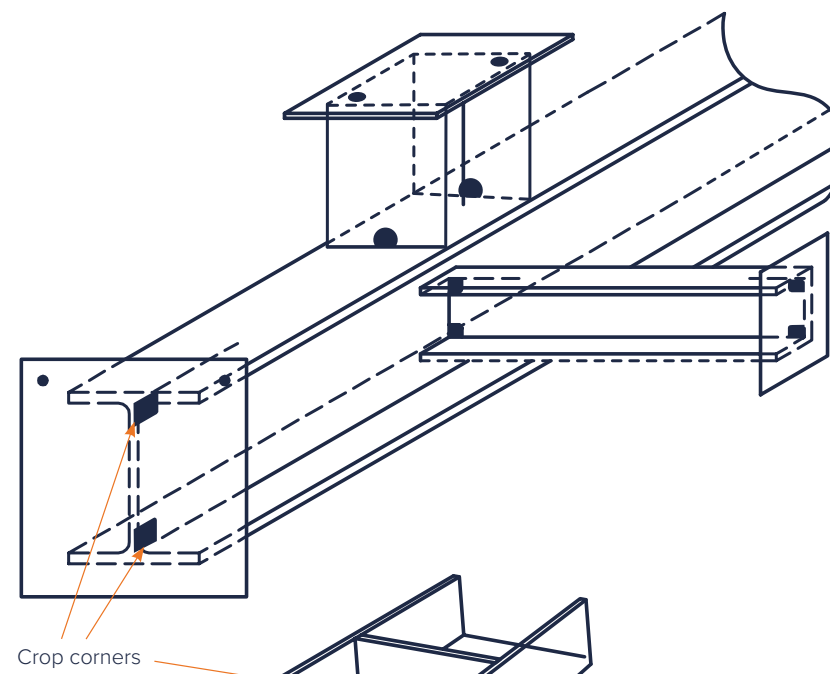


| BOX SIZE |        | HOLE SIZE (A) |       | CORNER SIZE (B) |       |
|----------|--------|---------------|-------|-----------------|-------|
| 48"      | 1219mm | 8"            | 203mm | 6"              | 152mm |
| 38"      | 914mm  | 6"            | 152mm | 5"              | 127mm |
| 32"      | 813mm  | 6"            | 152mm | 4"              | 102mm |
| 28"      | 711mm  | 6"            | 152mm | 3"              | 76mm  |
| 24"      | 610mm  | 5"            | 127mm | 3"              | 76mm  |
| 20"      | 508mm  | 4"            | 102mm | 3"              | 76mm  |
| 16"      | 406mm  | 4"            | 102mm | 2"              | 51mm  |
| 12"      | 305mm  | 3"            | 76mm  | 2"              | 51mm  |

## PROPER DRAINAGE

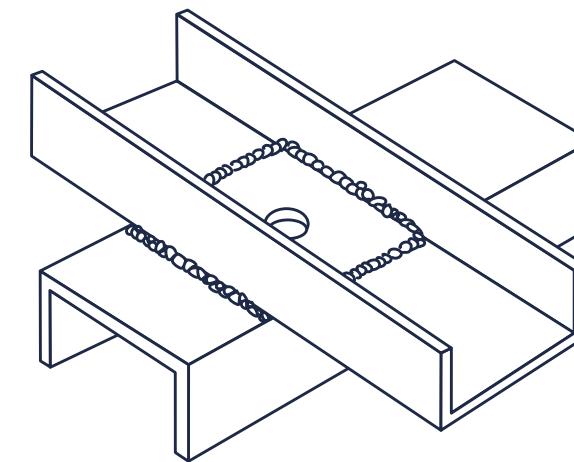
### NOTCHES OR HOLES REQUIRED

- Hole size as per Vent/Drain Table.
- Minimum crop = 25mm x 25mm (1" x 1")
- Enclosed section hole size as per vent and drain table.



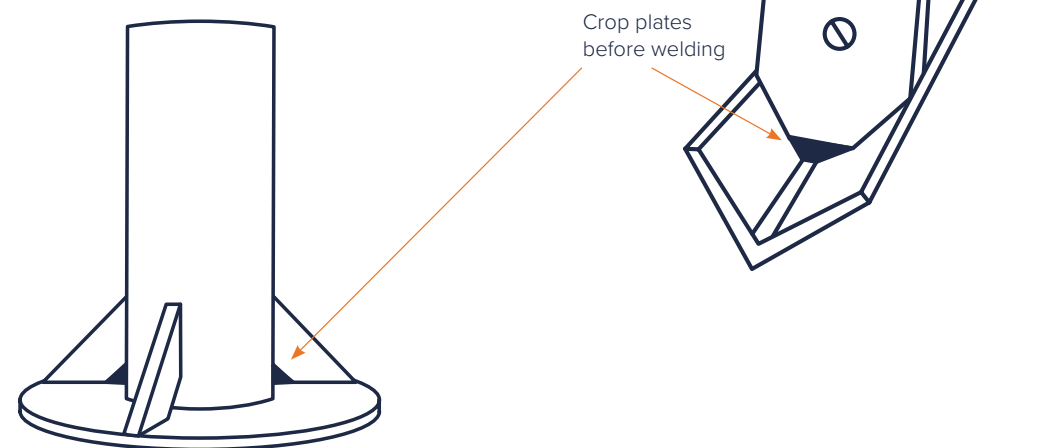
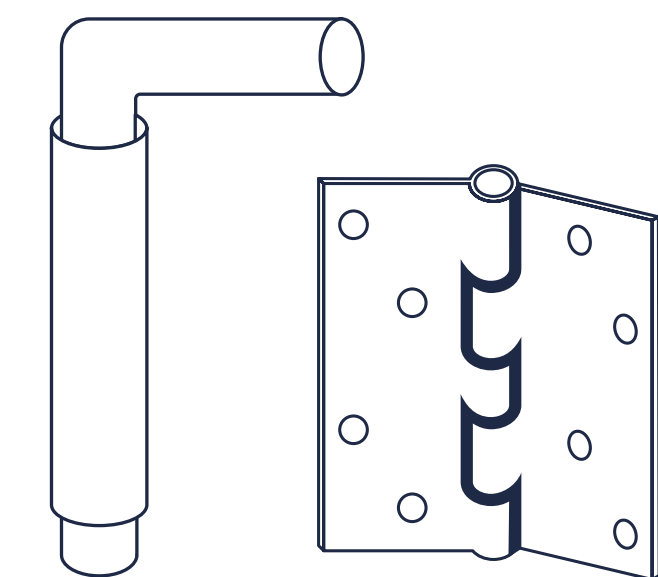
## WELDING LARGER OVERLAPPING SURFACES

- Areas 400cm<sup>2</sup> (64in<sup>2</sup>) and larger must be vented.
- Hole size 1.5 times wall thickness.



## RADIAL CLEARANCE

- 3mm (1/8") recommended
- 1.5mm (1/16") minimum



## HANGING HOLES

- If length is less than 2.4m (8' - 0") only one hole is needed.
- Please contact us for more complex structures.

