

# PROCEDURE:

## CASTINGS & STRAPS:

1. Inspect and repair any imperfections, then fettle castings.
2. Using correct jigs, mark timber mounting holes to casting, centre punch and drill to 3/8.
3. Drill and countersink fixing hole for pipe brace in end castings to 7/16 and counter sink to 11/16.
4. Drill 5/16 hole for the angled brace to fix to end castings, the hole is central in end castings (see sheet 3)
3. Using correct jig, mark & drill straps to 9/32.
5. Using correct jig, mark & drill feet of castings to 7/16.
6. Using correct jig & dies bend 20x5 flat bar to create angled brace drill both ends to 5/16 before pressing brace.
7. Weld 3/8 nuts in both ends of pipe support for fixing to end castings clean and finish welds.
8. Weld angled brace to pipe support using correct jig.
9. Remove sharps and deburr holes.

## TIMBERS:

1. Using correct jig, drill timber slat ends to 7/16.

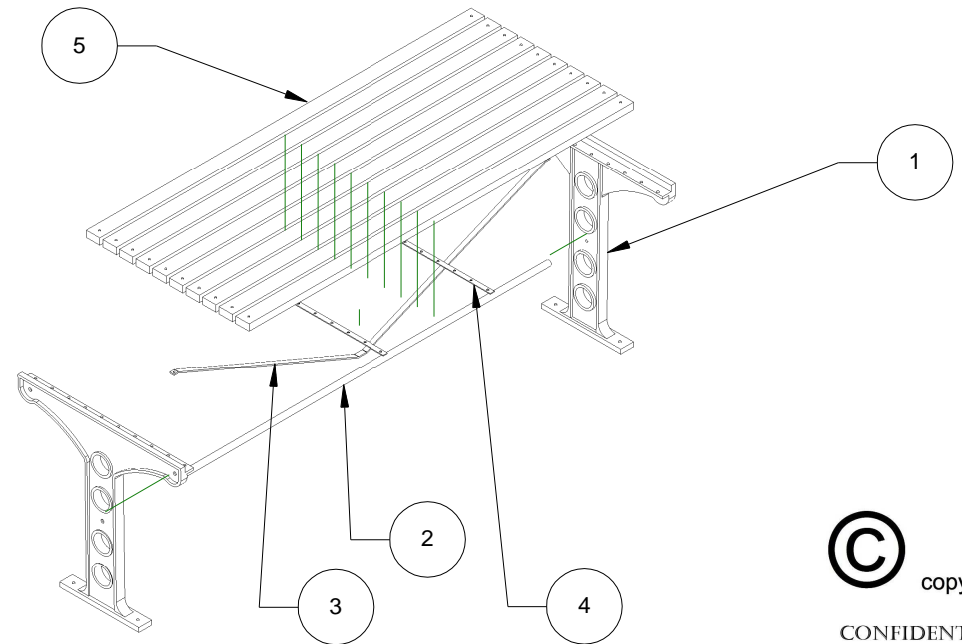
# ASSEMBLY:

1. Ensure you have all components.
2. Loosely bolt one timber to castings and stand upright.
3. Loosely bolt angled brace and pipe support in position.
3. Bolt remaining timbers in place.
4. Ensure table is square and timber gaps are uniform.
5. Tighten bolts.
6. Turn table upside down and using tek screws, fix straps in position, at equal distancing.
7. INSPECTION

ITEM	PART NUMBER	DESCRIPTION	QTY
1	WIPCASTGOV25	FIESTA TABLE END CASTING	2
2	RSCHS15NBM	PIPE 15NB STD WEIGHT, 1770 LG	1
3	RSFB20X5	M/S FLAT 20x5 1910 LG V BRACE	1
4	RSFB20X3	FLAT 20x3 740 LG TABLE STRAP	2
5	TIMCHA63X30X1800	TIMBER SLAT 63x30 1800 LG	10
6	PFIX0900029	TIMBER TEKS	20
7	PFIX0900008	COACH BOLT, 5/16" x 2" LG c/w NUT	20
8	PFIX0900107	3/8" COUNTERSUNK HEAD BOLT c/w NUT	2
9	PFIX090020	COUNTERSUNK HEAD BOLT 1/4 X 1" C/W NUT	2



Quality  
ISO 9001  
SAI GLOBAL



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REVISION	#	DESCRIPTION	BY	DATE	DRAWN	DRAWN DATE	CHECKED	CHECKED DATE	SCALE	A4
	1	ORIGINAL DRAWING	DN	8.10.10	R.CRIGTON	6.12.13			N/A	
2	FULL PRODUCT REVIEW	RBC	6.12.13							
3										
4										
5										

**FIESTA TABLE**  
BOM, PROCEDURE & ASSEMBLY

FFSA003012

REV. 2

SHEET 2 OF 3