



FLAT SPOT NO.	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19
ANGLE (DEGREES)	0	22.5	45	67.5	90	112.5	135	157.5	180	202.5	225	247.5	270	292.5	315	337.5	360	382.5	405

APPROVED FOR CONSTRUCTION

Signature: *Munir 2025/03/27*

Date: 27.3.25

PLEASE NOTE:
FLAT SPOT ARE EQUAL SPACED AT 300mm AND
SPIRALED AT 22.5 DEGREES BETWEEN FLAT SPOTS

MATERIAL : 40mm Solid Bar BMS

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN MILLIMETERS. REMOVE ALL BURRS AND BREAK SHARP EDGES.

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REV#	DATE	BY	DESCRIPTION	APPROVED	NAME	DATE	SIGNATURE
0	26/03/2025	Progress	Progress	APPROVED	Michael Mathie	27.3.25	<i>[Signature]</i>
		Michael Mathie			Douglas Louw	27.3.25	<i>[Signature]</i>

General Manufacturing Notes

Material & Cutting

All materials must comply with SANS 50025 / EN 10025 (Structural Steel Grade S355JR or S275JR) unless otherwise specified.

Cutting to be performed using plasma cutting (ISO 9013:2017), chainsaw blade cutting, or milling as per drawing requirements.

Cut edges must be smooth, free from burrs, and without excessive heat-affected zones (HAZ).

Welding

All welding to be performed using MAG (ISO 4063:135) or Stick welding (ISO 4063:111) as specified in the drawing. Standard fillet weld size: 6mm, unless otherwise stated. Welding to conform to ISO 9606-1 (Welder Qualification) and ISO 15614-1 (Welding Procedure Qualification).

All welds must be continuous, free from cracks, porosity, and undercutting.

Welds must be cleaned after welding, and slag must be removed per ISO 8501-3 (Surface Preparation Standards).

Forming & Machining

Hot forming and pressing must be performed within tolerances and per ISO 7438 (Metallic Materials - Bend Test) without causing material damage.

Milling operations must meet required surface finish per ISO 1302 (Indication of Surface Texture).

Thin plate profiling must be performed to prevent warping and distortion, following ISO 9013 (Thermal Cutting - Classification of Cut Quality).

Center hole machining must comply with ISO 286 (Geometrical Product Specifications - Limits & Fits).

Tolerances

Cutting & Machining Tolerances: ±0.5 mm (ISO 2768-m)

Welded Assembly Tolerances: ±2 mm (ISO 13920-BF)

Hole Positioning: ±0.5 mm (ISO 286-1 IT9)

Surface Finish & Inspection

All components must be free from sharp edges, burrs, and welding splatter per ISO 13715 (Edges & Burrs Control). All assemblies must be inspected for dimensional accuracy before final processing.

Any deviations must be approved by the responsible engineer before proceeding.

QTY : 1 OFF

UNIT 6 REFURB

KRIEHL POWER STATION

DE DRIVE SHAFT

DRAWING NUMBER: JC-KRL-DE01-PT006

REVISION: 0

273 FLEMING ROAD MEADOWDALE JOHANNESBURG

J&C ENGINEERING (Pty) Ltd