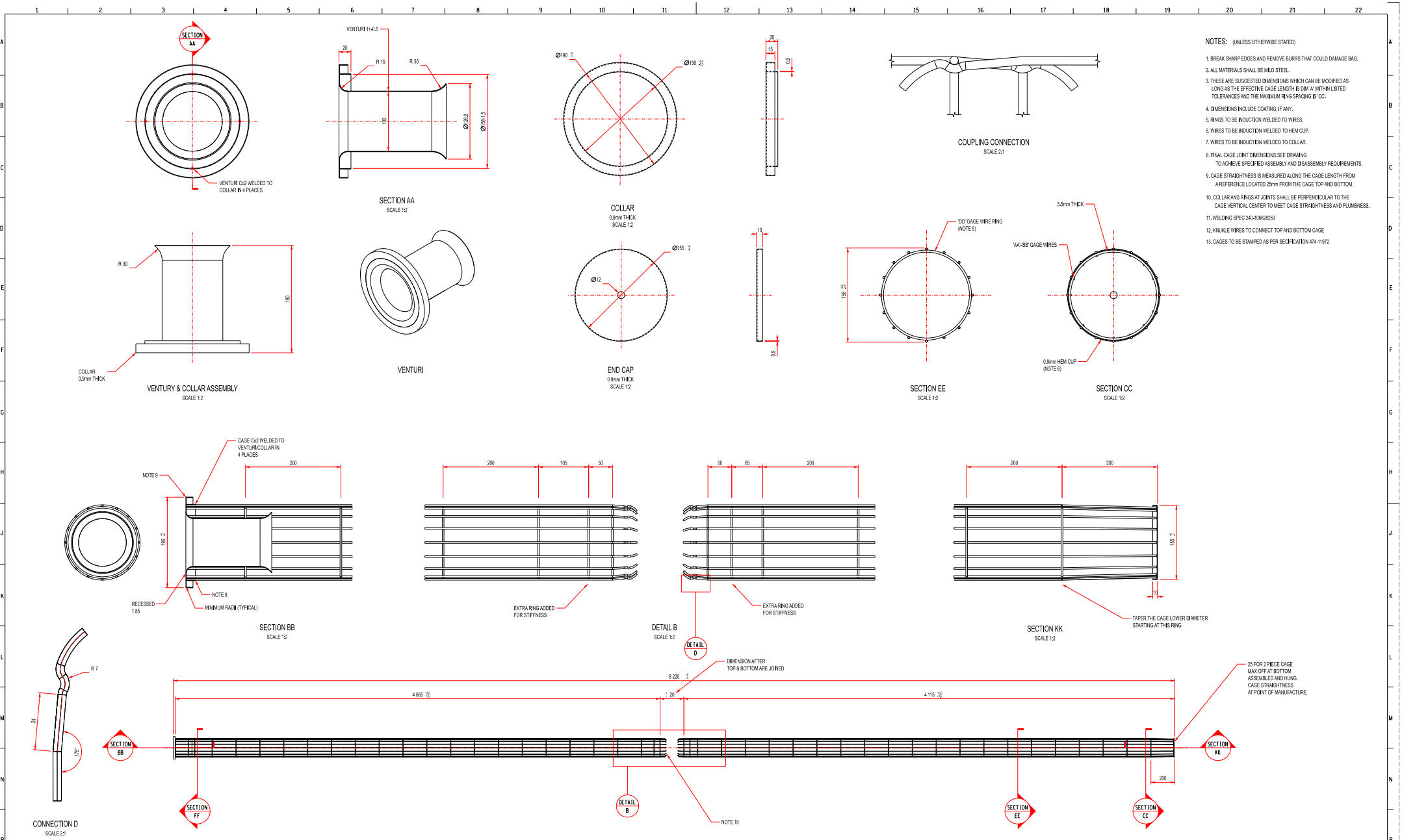

NOTES: (UNLESS OTHERWISE STATED)

1. BREAK SHARP EDGES AND REMOVE BURRS THAT COULD DAMAGE BAG.
2. ALL MATERIALS SHALL BE MILD STEEL.
3. THESE ARE SUGGESTED DIMENSIONS WHICH CAN BE MODIFIED AS LONG AS THE EFFECTIVE CAGE LENGTH IS DIM 'A' WITHIN LISTED TOLERANCES AND THE MAXIMUM RING SPACING IS 'CC'.
4. DIMENSIONS INCLUDE COATING, IF ANY.
5. RINGS TO BE INDUCTION WELDED TO WIRES.
6. WIRES TO BE INDUCTION WELDED TO HEM CUP.
7. WIRES TO BE INDUCTION WELDED TO COLLAR.
8. FINAL CAGE JOINT DIMENSIONS SEE DRAWING TO ACHIEVE SPECIFIED ASSEMBLY AND DISASSEMBLY REQUIREMENTS.
9. CAGE STRAIGHTNESS IS MEASURED ALONG THE CAGE LENGTH FROM A REFERENCE LOCATED 25mm FROM THE CAGE TOP AND BOTTOM.
10. COLLAR AND RINGS AT JOINTS SHALL BE PERPENDICULAR TO THE CAGE VERTICAL CENTER TO MEET CAGE STRAIGHTNESS AND PLUMBNESS.
11. WELDING SPEC 240-106628253
12. KNUKLE WIRES TO CONNECT TOP AND BOTTOM CAGE
13. CAGES TO BE STAMPED AS PER SECIFICATION 474-11972

GAGE EQUIVALENT			
WIRE GA	SHEET GA		MM
10	-		3.5
WIRE GA REF. ASTM A510/A510M SHEET GA REF. ASTM A109/A109M			

WIRE GAGE AND COUPLING CONNECTIONS							
COMPONENT	VERTICAL WIRES			HORIZONTAL WIRE RINGS			COUPLING CONNS
REFERENCE	AA	BB	-	CC	DD	-	TYPE A
CAGE SIZE DESIGNATION	NUMBER OF WIRES	GAGE	EQUIVALENT WIRE DIA	RING SPS (MAXIMUM)	GAGE	EQUIVALENT WIRE DIA	DOUBLE ENDED (NOTE 1)
16-WIRE	16	10	3,5mm	200mm	10	3,5mm	YES

CAGE CONSTRUCTION	
CAGE SIZE DESIGNATION	DESCRIPTION
16 WIRE	16 VERTICAL WIRES, 10 GA BWG: 3,5 MM DIAMETER. HORIZONTAL WIRE RINGS SPACED AT (200 MM MAX., 10 GA BWG: 3.5 MM DIAMETER. ALL WIRES COATED SKS BLACK EDGING PRIMER SMK10, FERRO-PAK615 OR APPROVED EQUIVALENT

TOLERANCES

UNLESS STATED OTHERWISE DIMENSIONS ARE IN MM AND THE FOLLOWING TOLERANCES SHALL APPLY:

FRACTIONS - LINEAR = ±1.5 & DIAMETRAL = ±0.381

DECIMAL - X.XX = ±0.762 / X.XXX = ±0.254

ANGULAR - ±1/4°

D.O.	REV	DATE	REVISION	REV BY	CHECK BY	APP BY	AUTH BY	ACC APP	REFERENCE DRAWINGS
00	04	2010-03	INITIAL DIMENSION MODIFIED TO INCLUDE THE COLLAR	MM					
00	03	2010-01	DIMENSION CHANGES	MM	EP	MB	SC	JH	366M-CS-GD-E2G-0000
00	02	2010-03	AGE MANUFACTURING DATA REVISED						ESKOM PLANT BAG DETAILS

AUTHORISED FOR ESKOM BY: CLASSIFICATION: 008224
PROJ PATH: 400
CONFIDENTIAL BY:
APPROVED BY:
CHECKED BY:
CREATED BY: MM 2010-01
SCALE: AS SHOWN

JH Hodgman
29/11/2004
Boiler Engineer

KUSILE POWER STATION
GENERAL ARRANGEMENT
UNITS 1-6 PJFF
16 WIRE CAGES
FOR 160mm BAGS

Eskom
ESKOM HOLDINGS SOC Ltd
REG No. 2002/015527/30

ESKOM DRAWING NO: 366-263277
SHT 01 REV 04
SIZE A0L

DRAWING CLASSIFICATION: CONTROLLED DISCLOSURE