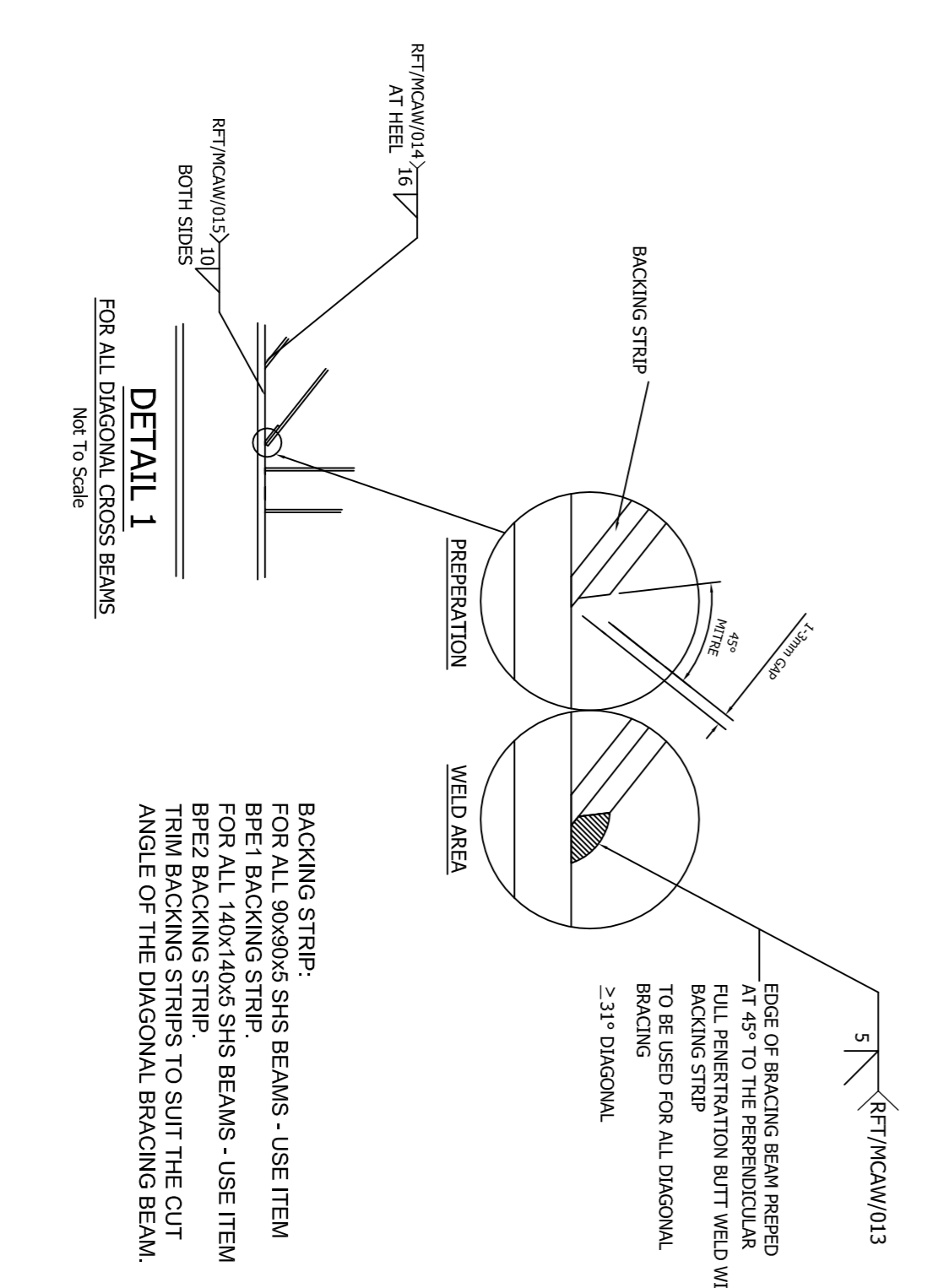
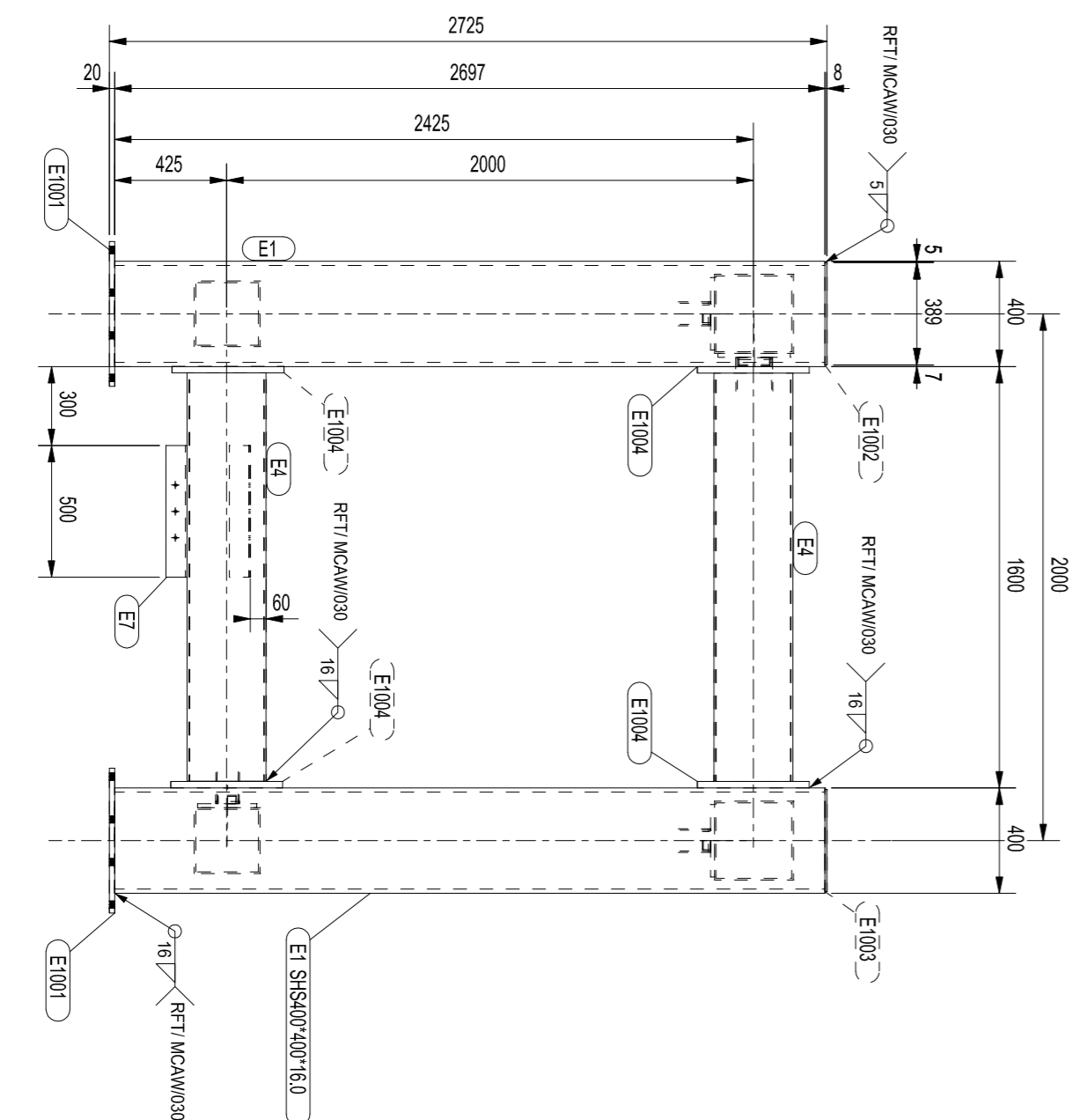
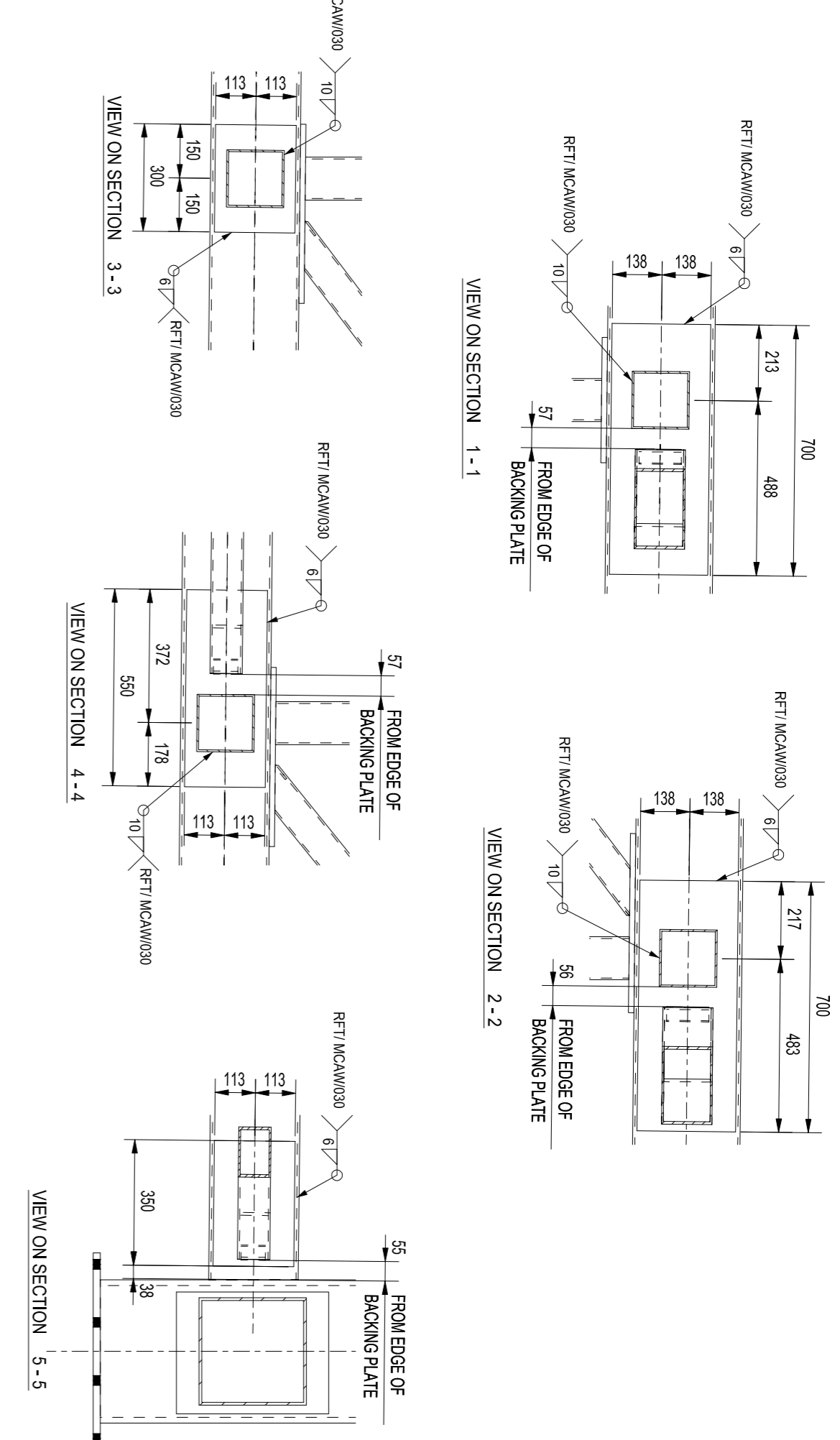
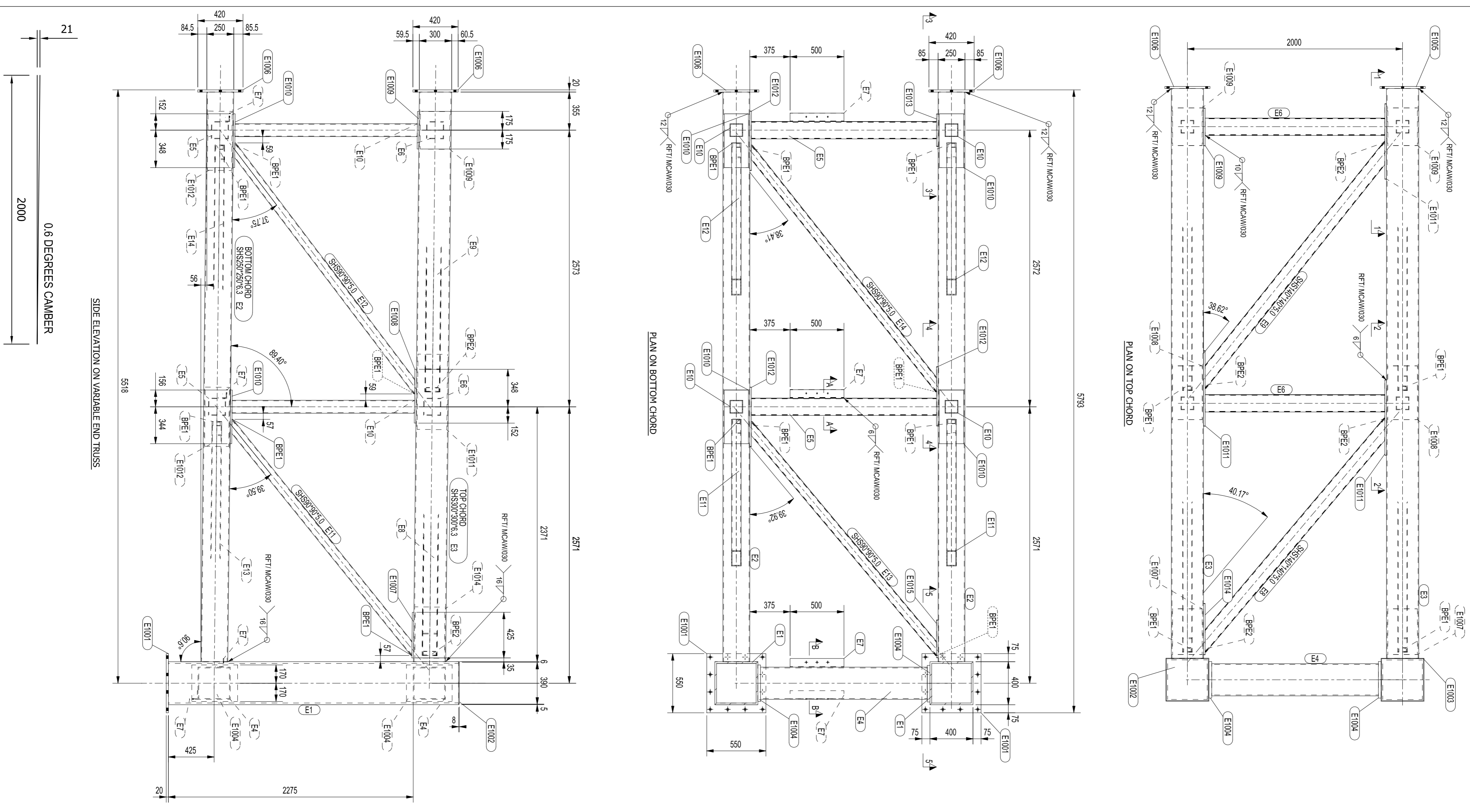


**DO NOT SCALE. IF IN DOUBT – ASK**  
 ALL DIMENSIONS ARE IN MILLIMETRES – UNLESS NOTED OTHERWISE.



VARIABLE END TRUSS ASSEMBLY WEIGHT			
NOTE:- All weights are approximate only & prior to surface coatings. Please to individual components have not been taken into account in weight calculation.			
MARK	QTY	PROFILE	WEIGHT (kg)
BP001	12	FL15*90	88
BP002	4	FL15*90	118
E10	2	SHS400*400*16.0	2897
E11	2	SHS250*250*6.3	1035.4
E12	2	SHS250*250*6.3	5301
E13	2	SHS500*300*6.3	509.5
E14	2	SHS300*300*8.0	612.6
E15	2	SHS500*300*8.0	225.8
E16	2	SHS160*160*5.0	17.20
E17	2	SHS160*160*5.0	80.5
E18	4	L80*80*6	500
E19	1	SHS140*140*5.0	2741
E20	1	SHS140*140*5.0	59.8
E21	4	SHS120*120*5.0	121.9
E22	1	SHS120*120*5.0	1896
E23	2	SHS90*90*5.0	2760
E24	1	SHS90*90*5.0	73.1
E25	1	SHS90*90*5.0	2874
E26	1	SHS90*90*5.0	36.8
E27	1	SHS90*90*5.0	38.0
E28	1	SHS90*90*5.0	95.0
E29	1	PT8*388.7	390
E30	2	PT8*388.7	550
E31	1	PT78*388.7	390
E32	1	PT78*388.7	9.5
E33	4	FL225*425	340
E34	1	FL225*425	113.4
E35	1	PLATE20*420	27.7
E36	3	PLATE20*420	83.1
E37	2	FL15*275	425
E38	2	FL15*275	27.5
E39	3	FL15*275	500
E40	3	FL15*275	350
E41	4	PLATE15*225	34.0
E42	3	FL15*225	53.0
E43	3	FL15*225	700
E44	3	PLATE15*225	68.0
E45	3	PLATE15*225	550
E46	1	FL15*300	43.7
E47	1	FL15*300	7.9
E48	1	FL15*350	15.4
E49	1	FL15*350	9.3
TOTALS		WEIGHT EACH	3.66 T

**GENERAL NOTES:-**

- All dimensions are in millimetres - unless noted otherwise.
- All tolerances to be  $\pm 1.0mm$  - unless noted otherwise.
- All welds shall be done in conformance with approved AWS/FI/WPS. Fillet weld sizes shown are leg lengths - unless noted otherwise.
- 'Break' / radii corners of plates to remove sharp points.
- All hollow sections to be grade S355J2H to EN 10 210 - unless noted otherwise.
- All other sections (e.g. open sections and plates) to be grade S355J2 to EN 10 025 - unless noted otherwise.
- All fillet welds shall be proportioned to achieve a minimum throat thickness of 0.71 times the stated leg length.
- All welds to be 10mm continuous fillet - unless noted otherwise.
- All steelwork shall be close fitting. All hollow sections to splice joints and base plate joints shall be machine finished to ensure full contact throughout the section.
- Where two surfaces mate, there must NOT be a gap greater than 0.5mm.

# Gantry No.31 - Chainage 10390

## SMIS No. M1/59.60/S

**Varley & Gulliver Ltd.**  
 HALESFIELD 18,  
 TELFORD,  
 SHROPSHIRE TR7 4JL,  
 TEL: 01952 588788  
 FAX: 01952 588144

**DETAIL 1**  
 FOR ALL DIAGONAL CROSS BEAMS  
 NOT TO SCALE

BACKING STRIP:-  
 FOR ALL 90X90X5 SHS BEAMS - USE ITEM BP001 BACKING STRIP.  
 FOR ALL 140X140X5 SHS BEAMS - USE ITEM BP002 BACKING STRIP.  
 TRIM BACKING STRIPS TO SUIT THE CUT ANGLE OF THE DIAGONAL BRACING BEAM.

EDGE OF BRACING BEAM FINISHED AT 45° TO THE PERPENDICULAR FULL PENETRATION BUTT WELD WITH BACKING STRIP TO BE USED FOR ALL DIAGONAL BRACING  $\geq 31^\circ$  DIAGONAL

NO	REVISION	DATE	BY	CHK
00	ISSUE FOR REVIEW	26.05.12	MTX	CMK
REVISIONS				
NO	DESCRIPTION	DATE	BY	CHK

PROJECT: M1 JUNCTIONS 10-13 HSR IMPROVEMENTS

DRAWING TITLE: GENERAL ARRANGEMENT OF GANTRY 31 VARIABLE END TRUSS NORTHBOUND AND SOUTHBOUND

DRAWN BY: MTX  
 CHECKED BY: TM  
 DATE: 21.05.12  
 SCALE: 1:25

PRODUCT NO: 11727  
 DRAWING NO: VG1039-CD-CON-3102  
 REV: 00