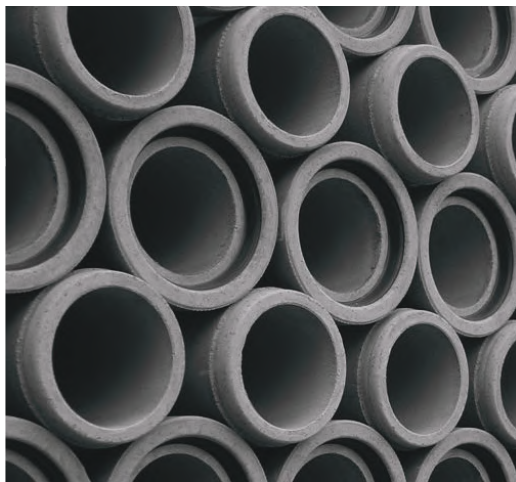




## Joint Ring Solutions



Built to last. Designed to perform.

- For wetcast applications
- 12" through 144" diameters

## Heavy steel construction designed for strength, durability and performance

Afinitas is known for bringing together the top engineering and manufacturing expertise in the industry to build best-in-class precast forming systems. Our wide range of quality products are backed by knowledgeable and responsive customer sales and manufacturing team members who are there to assist you throughout the life of your form. And to that point, our forms are built to last. We combine heavy-duty steel with an innovative approach to manufacturing that will ensure we can help you take your business where you want to grow.

Wetcast formwork is a core competency of the Afinitas team. We have been trusted for decades to engineer forms for a wide variety of applications, including:

- Manhole Cone Forms
- Manhole Riser Forms
- Manhole Slab Top, Transition Slab, Base Slab Forms
- Box Forms
- Flared End Forms
- Battery Grade Ring Forms
- Manhole Joint Rings



Manhole Cone Form



Box Form



Grade Ring Form



**Afinitas is your source**  
for Wetcast Forming Systems.

Contact our team at  
**+1 641-394-4111**  
or email [rfq@afinitas.com](mailto:rfq@afinitas.com)

# Joint Ring Types

Joint rings, also known as gaskets or seals, are flexible circular components designed to create a watertight seal between sections of precast concrete pipe, manholes, and other structures. They fill the gaps and prevent infiltration or exfiltration of water. Our high quality joint rings contribute to the overall stability and strength of your precast products, ensuring the integrity of your underground infrastructure projects.



**Groove Forming Pallets with Legs**

- Used with manhole slab tops, cones, riser or pipe forming
- Available sizes range from 24" – 144"  
(smaller diameter rings are available)



**Tongue Forming Headers, Open Top with Form Tabs**

- Used with manhole combination base/riser forming or pipe forming
- Available sizes range from 24" – 144"  
(smaller diameter rings are available)



**Tongue Forming Pallets with Lifting Eyes**

- Used with manhole monolithic base forming
- Available sizes range from 24" – 144"  
(smaller diameter rings are available)



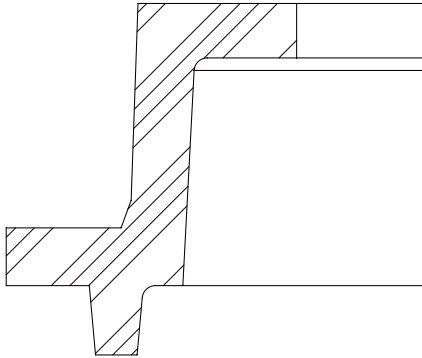
**Tongue Forming Headers, Open Top with Form Hangers/Lifting Eyes**

- Used with manhole - combination monolithic base/riser forming or pipe forming
- Available sizes range from 24" – 144"  
(smaller diameter rings are available)

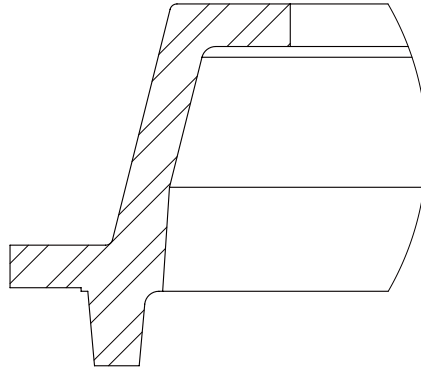


# Joint Rings

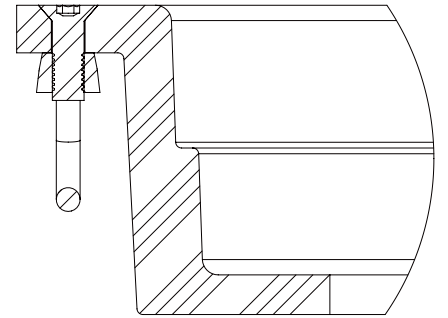
12" – 144" Diameter Round, Arch and Elliptical



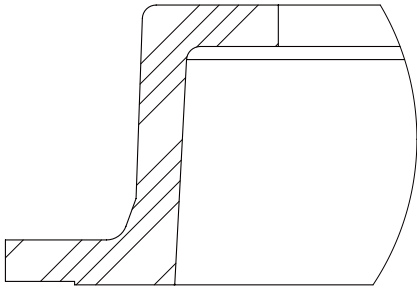
Single Offset Groove Forming Pallet with Legs



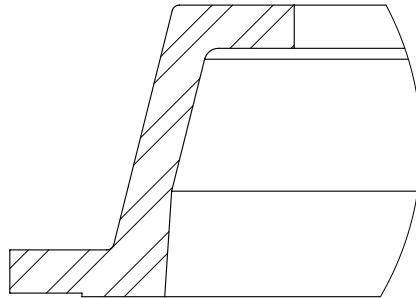
Mortar Joint Groove Forming Pallet with Legs



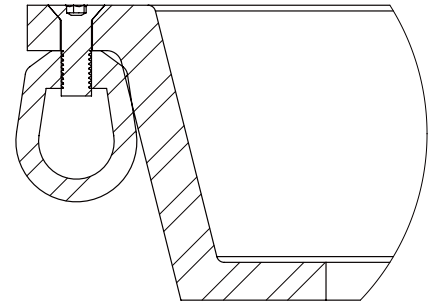
Single Offset Tongue Forming Pallet with Lifting Eyes



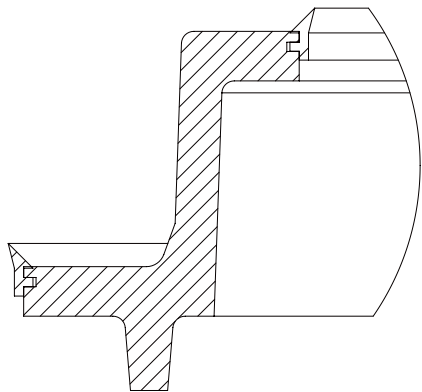
Single Offset Groove Forming Pallet without Legs



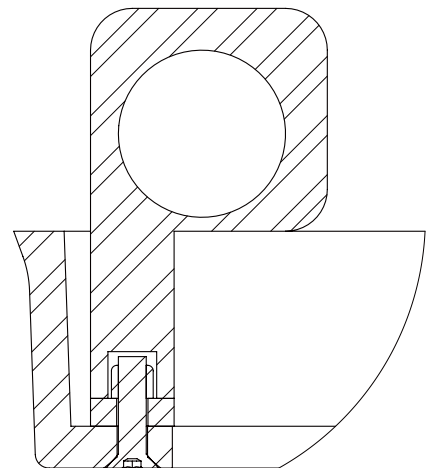
Mortar Joint Groove Forming Pallet without Legs



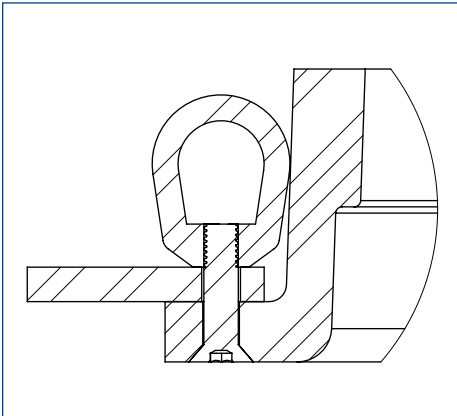
Mortar Joint Tongue Forming Pallet with Lifting Eyes



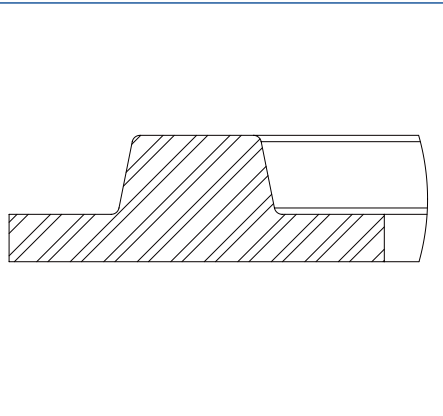
Single Offset Groove Forming Pallet with Legs and ID/OD Chamfer Seals



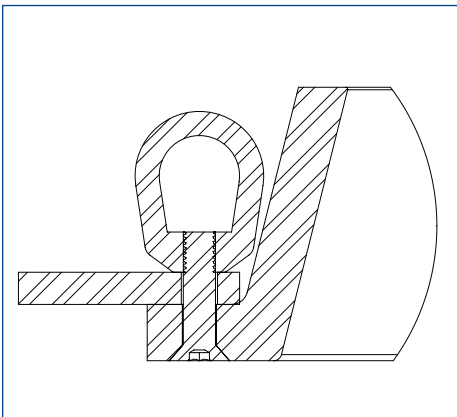
Single Offset Groove Forming Header, Open Top with Lifting Eyes and Core Tabs/Hangers



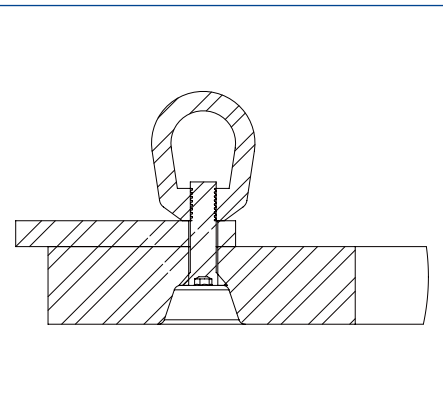
Single Offset Tongue Forming Header, Open Top with Lifting Eyes and Form Tabs



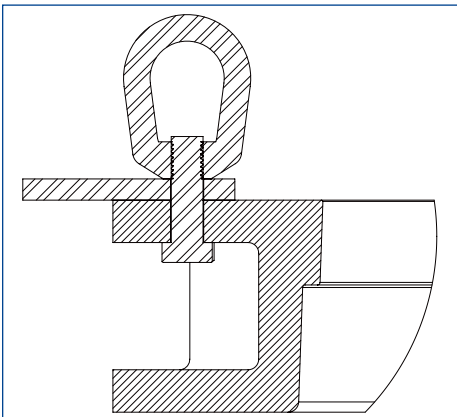
Key Lock Groove Forming Pallet



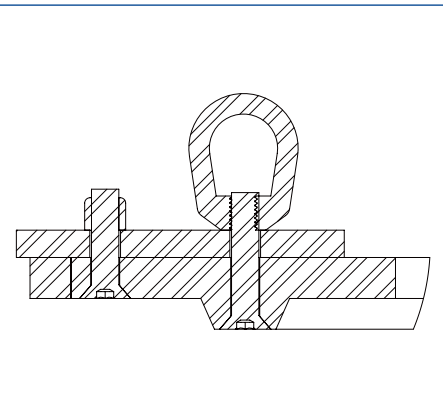
Mortar Joint Tongue Forming Header, Open Top with Lifting Eyes and Form Tabs



Key Lock Tongue Forming Header with Form Tabs and Lifting Eyes



Single Offset, Double Flange, Tongue Forming Header, Open Top with Lifting Eyes and Form Tabs (84" Dia. & Larger)

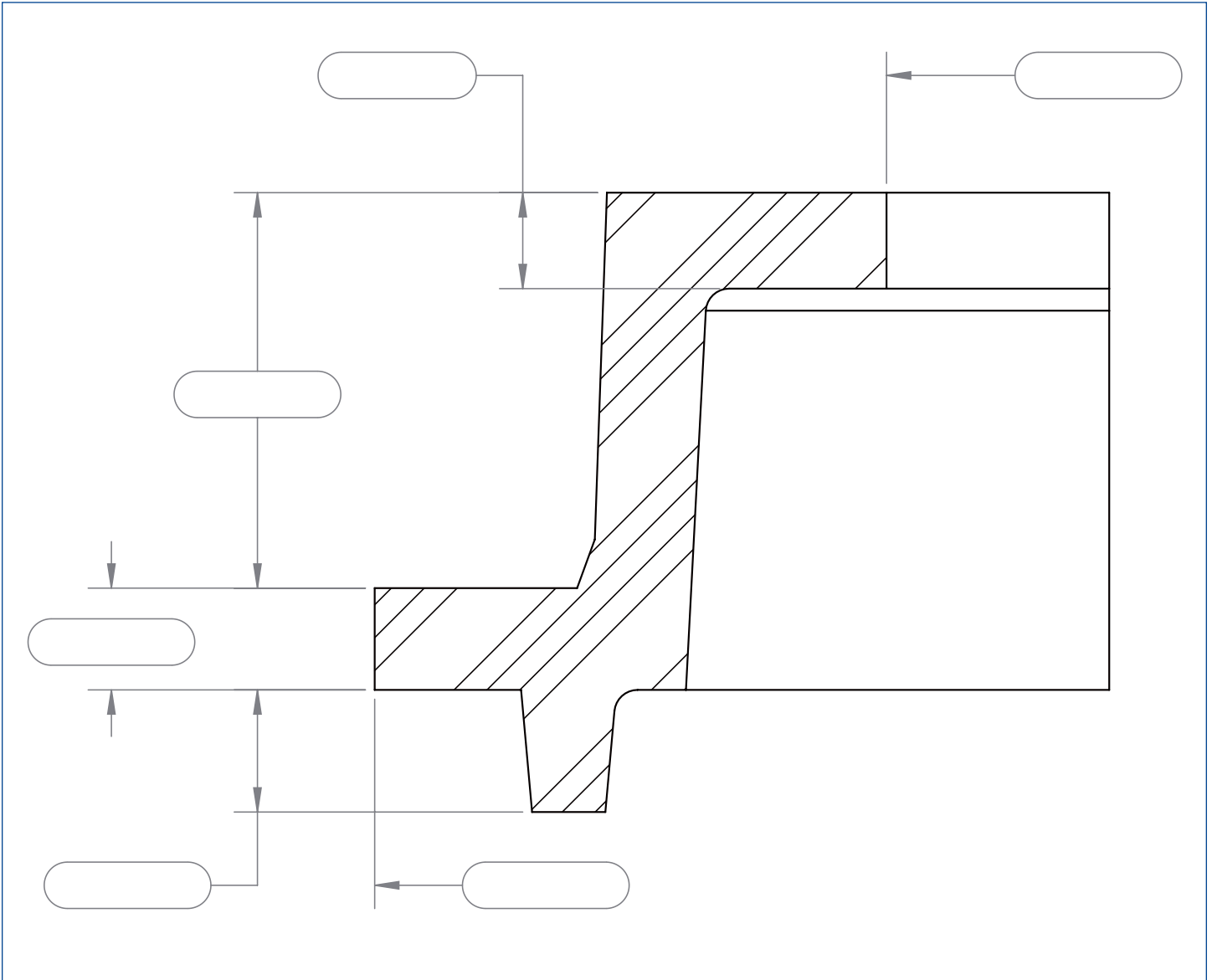


Key Lock Groove Forming Header with Form Tabs and Lifting Eyes

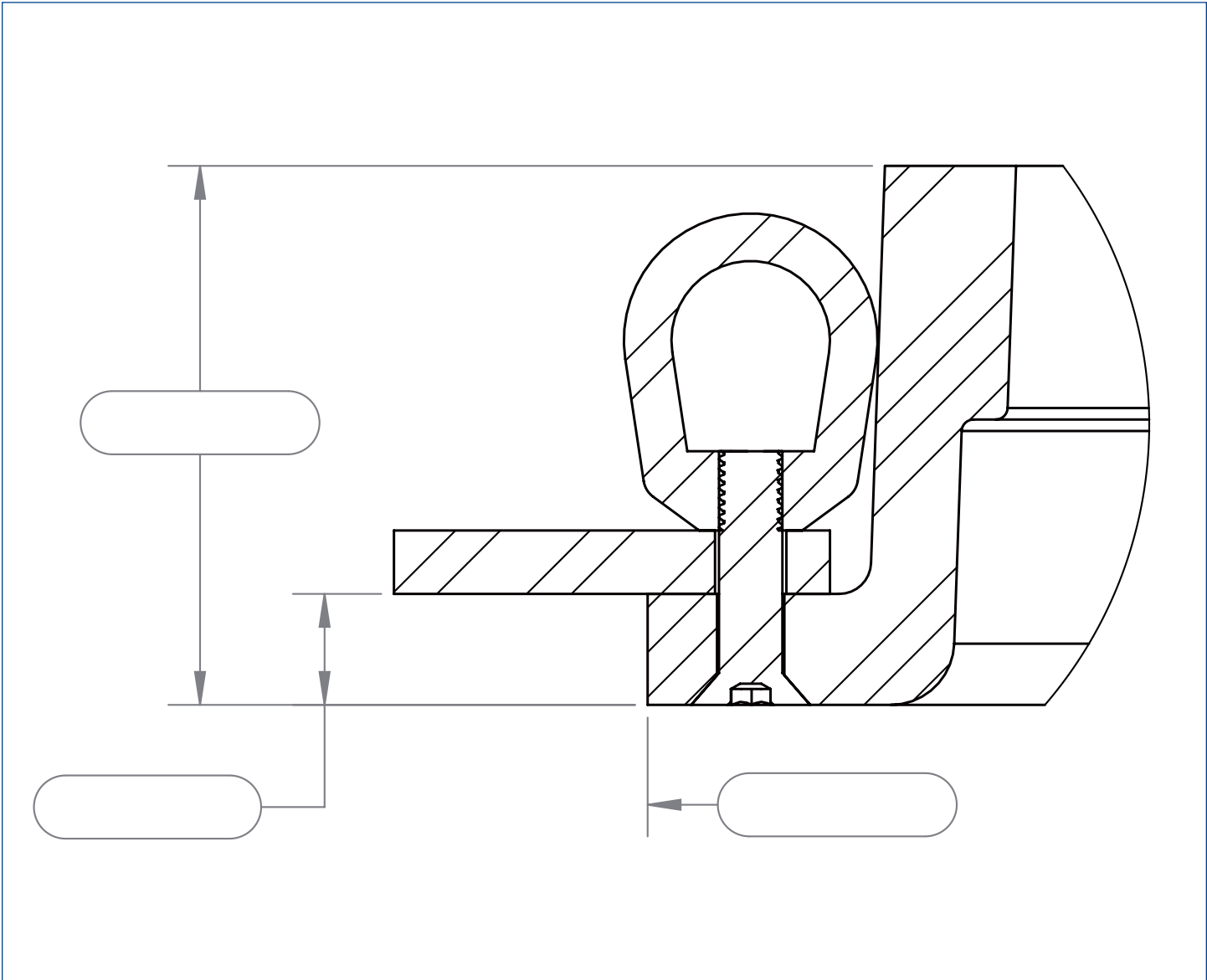


# Joint Rings

Fill In The Blank Worksheets



Groove Forming Pallet with Legs

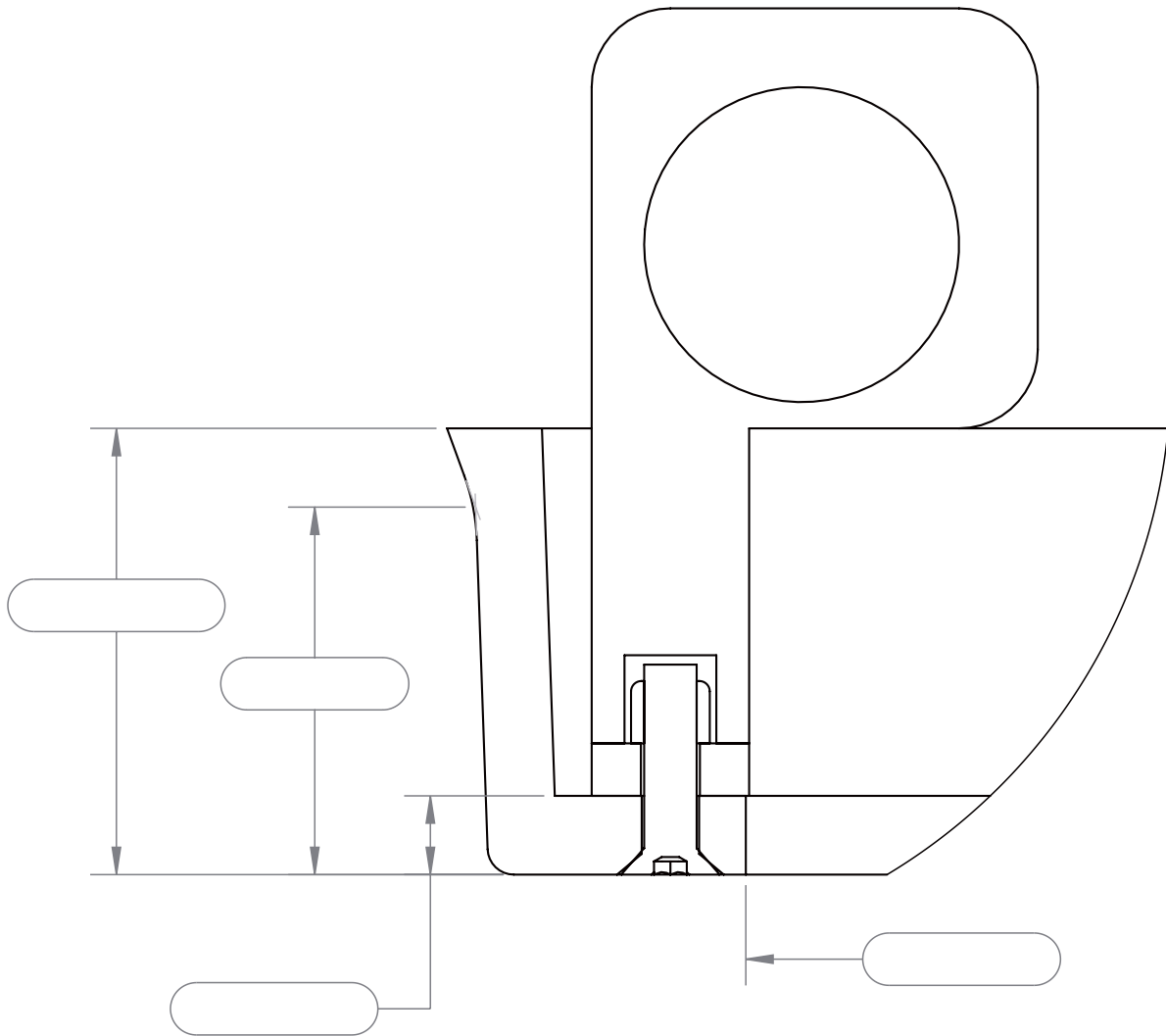


Tongue Forming Header, Open Top with Form Tabs and Lifting Eyes



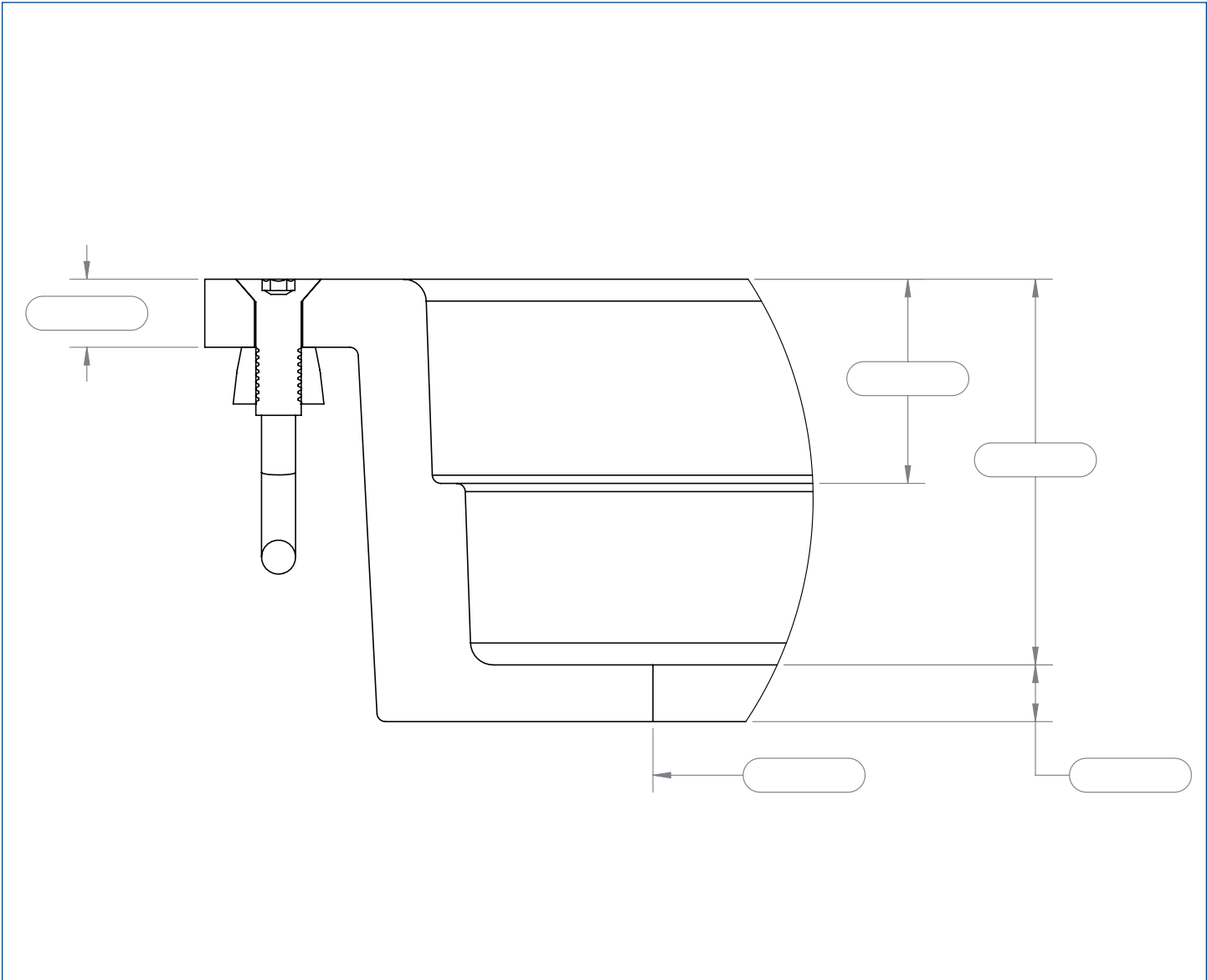
# Joint Rings

Fill In The Blank Worksheets



Groove Forming Header, Open Top with Core Tabs-Lifting Eyes



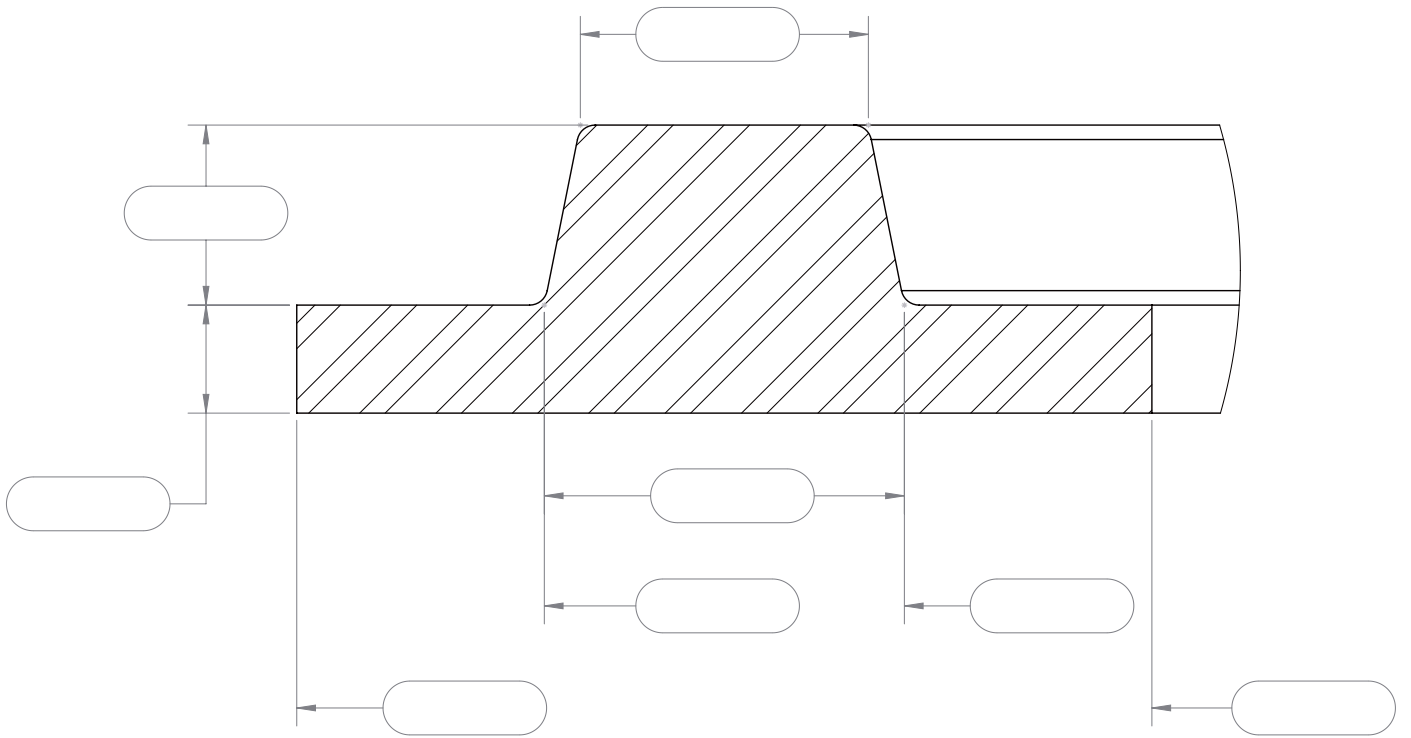


Tongue Forming Pallet with Lifting Eyes

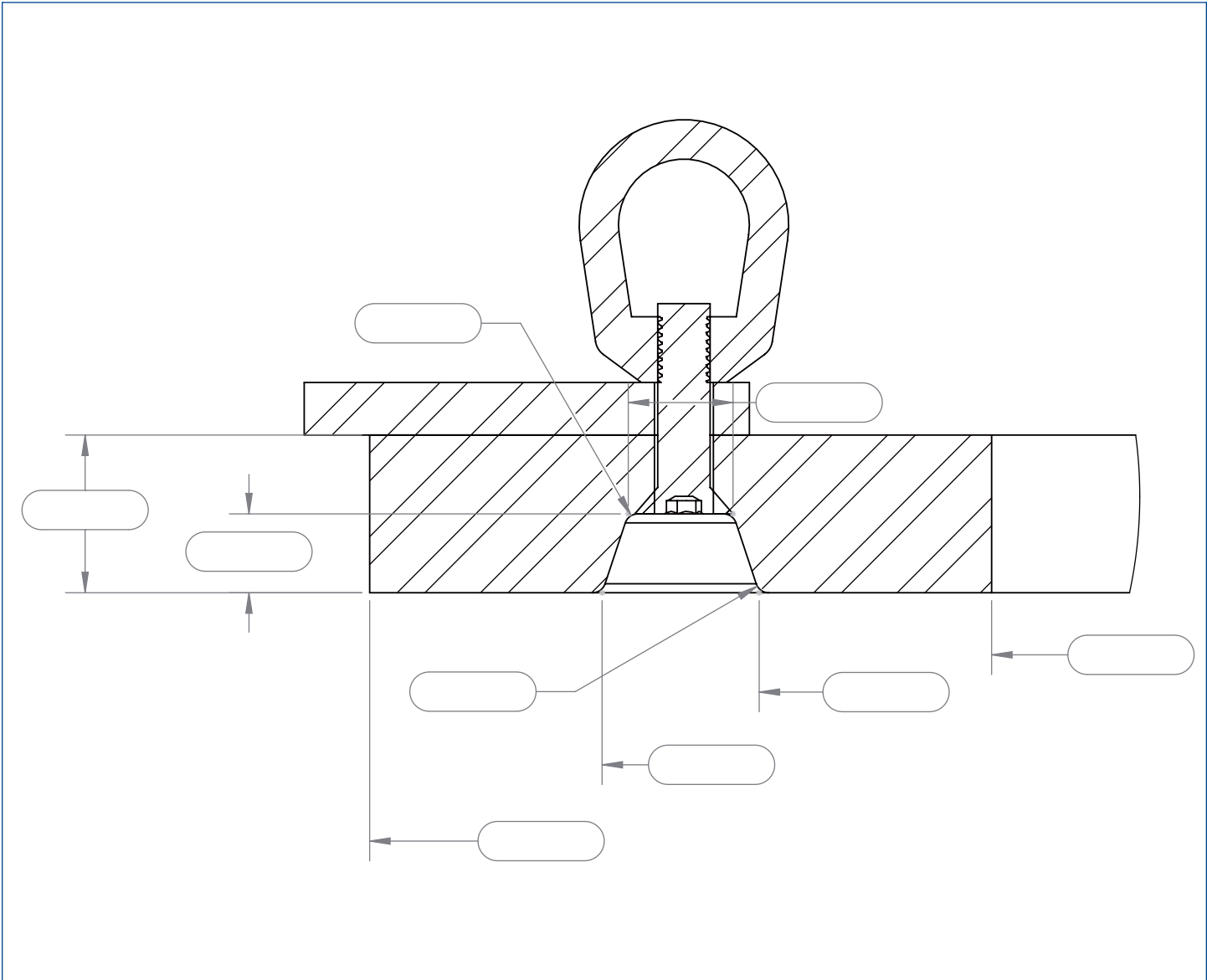


# Joint Rings

Fill In The Blank Worksheets



Groove Forming Pallet

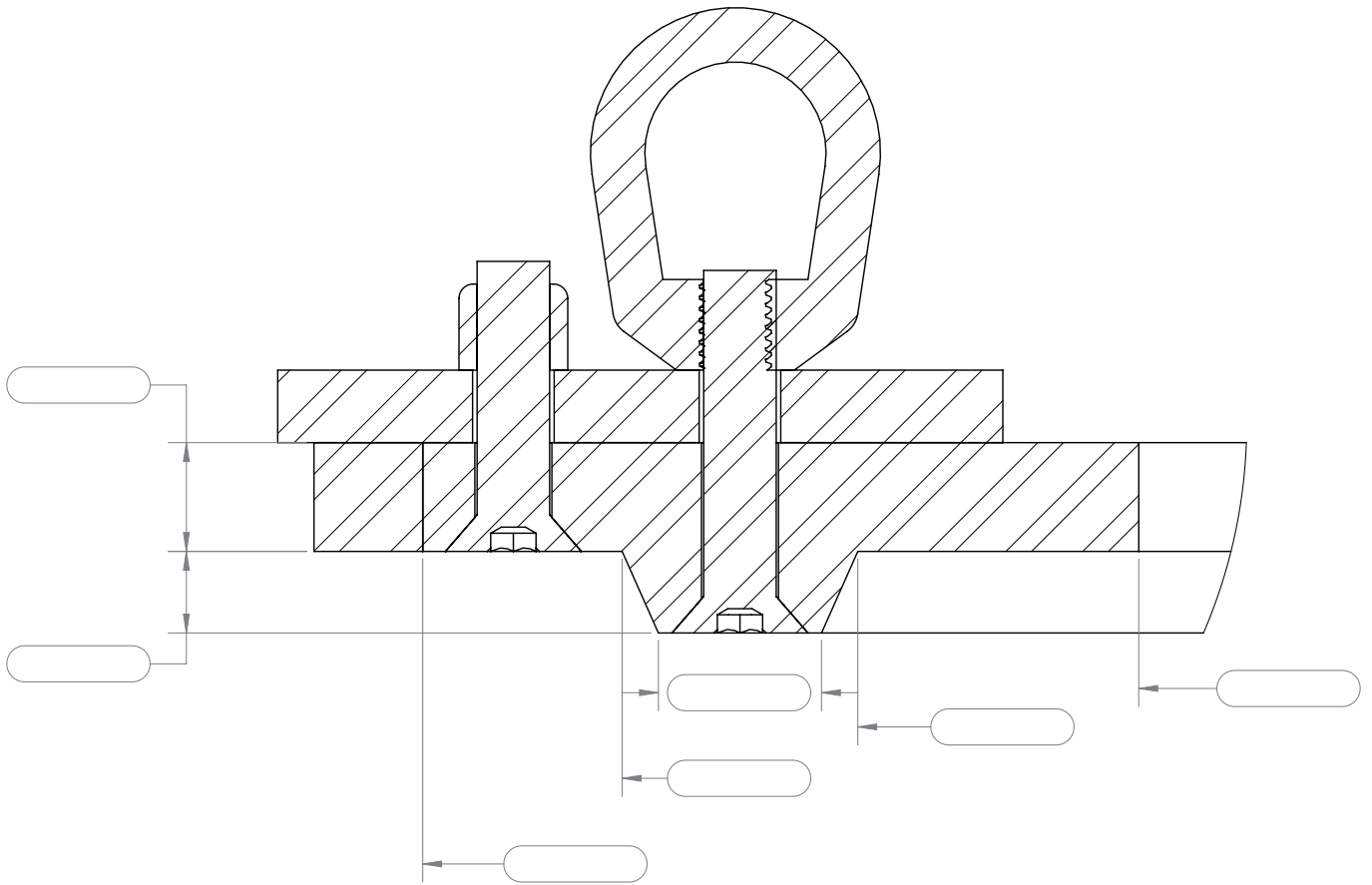


Tongue Forming Header with Lifting Eyes



# Joint Rings

Fill In The Blank Worksheets



Groove Forming Header with Form Tabs and Lifting Eyes

# QT/TSS JOINT 48"

## DRAWING APPROVAL

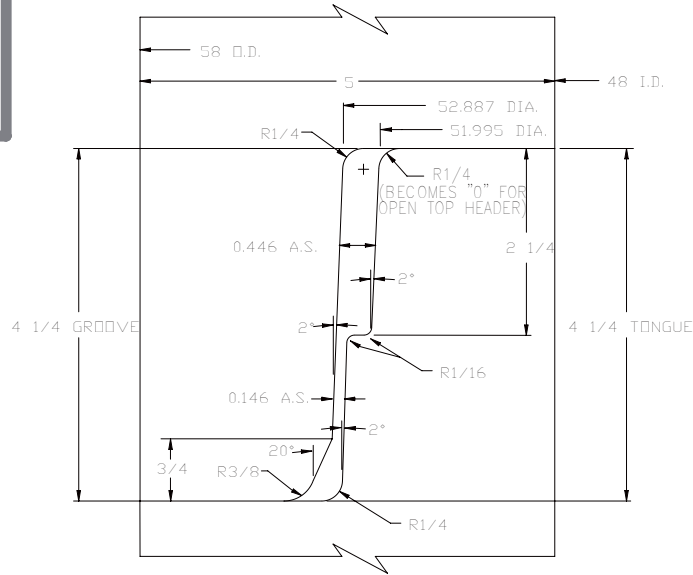
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Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

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48" QT/TSS  
HK 165/185  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: _____ DATE: _____ WEIGHT: LBS JOB NO: _____	 <p>AFINITAS FORMING SYSTEMS DIVISION</p> <p>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207</p>
FAB	MACHINING		CUTTING			
GENERAL TOLERANCES EXCEPT AS NOTED						
FRACTIONAL	DECIMAL		ANGULAR DEG		48" QT/HK 165/185 TSS 5" WALL	
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		SHEET: 1 OF 1 QTY: _____ SCALE: 1:1 SIZE: <b>A</b> DWG NO: PD-48P-0135 REV. _____	

QT/TSS Joint 48"

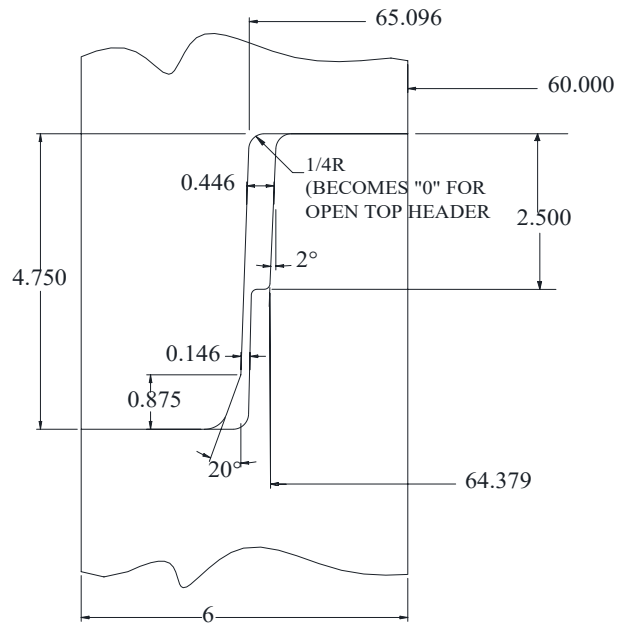
# QT/TSS JOINT 60"

## DRAWING APPROVAL


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 Authorized Signature \_\_\_\_\_  
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REV.	ECR	CHANGE	BY	DATE



60" QT/TSS  
 HK 165/185  
 JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED.	 AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207
FAB	MACHINING		CUTTING			
GENERAL TOLERANCES EXCEPT AS NOTED						
FRACTIONAL	DECIMAL		ANGULAR DEG		DRAWN BY:	60" QT/HK 165/185 TSS 6" WALL
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		DATE:	
WEIGHT: LBS		SHEET: 1 OF 1		SCALE: 1:1	SIZE: A	DWG NO: PD-60P-0095 REV.
JOB NO:		QTY:				

QT/TSS Joint 60"



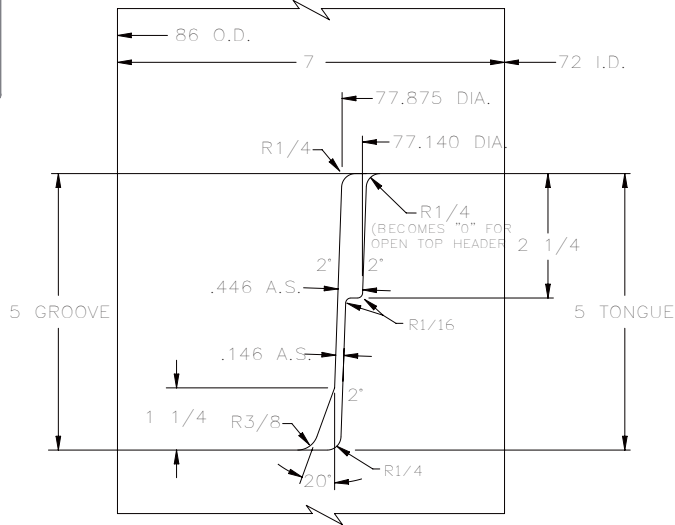
# QT/TSS JOINT 72"

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 Authorized Signature \_\_\_\_\_  
 Date \_\_\_\_\_

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



72 QT/TSS  
 HK 165/185  
 JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:		AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE    1701 MOLER ROAD NEW HAMPTON, IOWA 50659    COLUMBUS, OHIO 43207		
FAB	MACHINING		CUTTING						
GENERAL TOLERANCES EXCEPT AS NOTED									
FRACTIONAL	DECIMAL		ANGULAR DEG		72" QT/HK 165/185 TSS 7" WALL				
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		SHEET: 1 OF 1 QTY:	SCALE: <b>1:1</b>	SIZE <b>A</b>	DWG NO: <b>PD-72P-0093</b>	REV.

QT/TSS Joint 72"



# QT/HK165-HK185 JOINT

## 48"

### DRAWING APPROVAL

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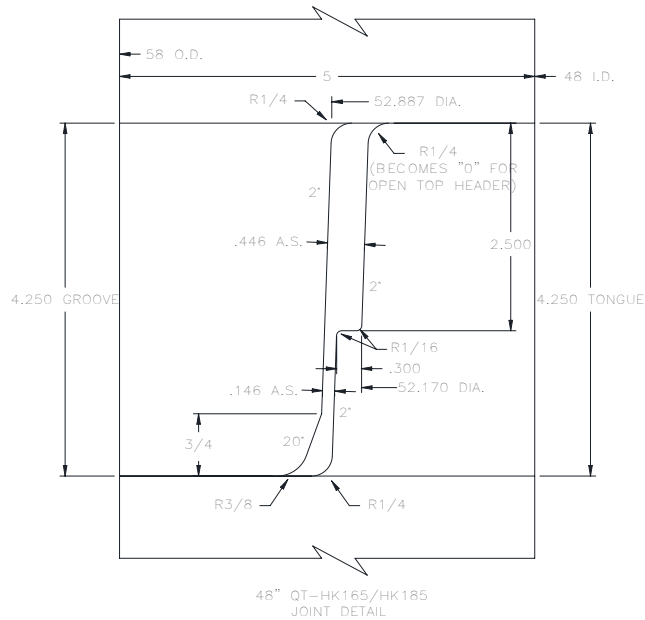
Company Name \_\_\_\_\_

Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

### REVISIONS

REV.	ECR	CHANGE	BY	DATE
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WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:		AFINITAS FORMING SYSTEMS DIVISION		928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659		1701 MOLER ROAD COLUMBUS, OHIO 43207			
FAB	MACHINING		CUTTING				GENERAL TOLERANCES EXCEPT AS NOTED							
FRACTIONAL		DECIMAL		ANGULAR DEG			48" QT-HK165/HK185 5" WALL							
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		SHEET: 1 OF 1		SCALE: 1:1		SIZE: A		DWG NO: PD-48P-0159		REV.

QT/HK165-HK185 JOINT 48"



# QT/HK165-HK185 JOINT

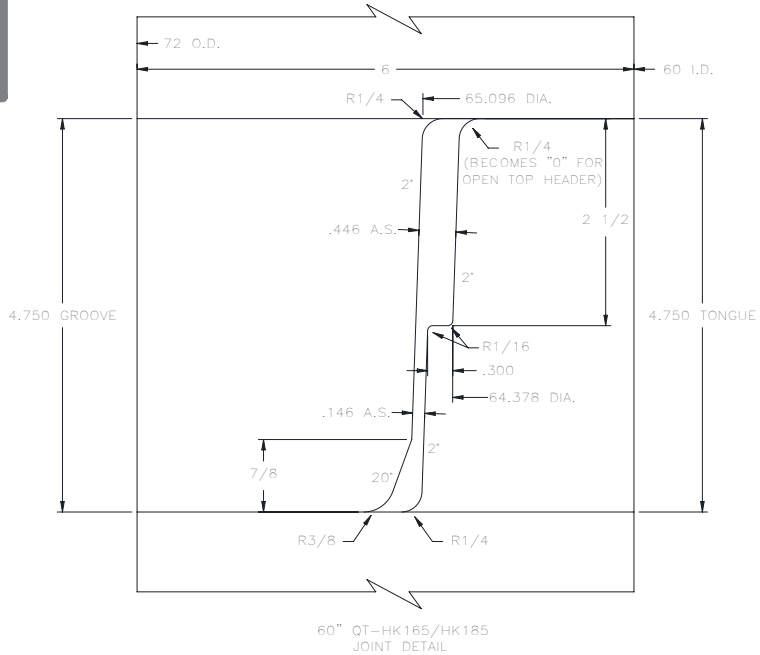
## 60"

### DRAWING APPROVAL


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 Authorized Signature \_\_\_\_\_  
 Date \_\_\_\_\_

REVISIONS				
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60" QT-HK165/HK185 JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207	60" QT-HK 165/HK185 6" WALL	SHEET: 1 OF 1 QTY:	SCALE: <b>1:1</b>	SIZE <b>A</b>	DWG NO: <b>PD-60P-0104</b>	REV.
FAB	MACHINING	CUTTING										
GENERAL TOLERANCES EXCEPT AS NOTED												
FRACTIONAL	DECIMAL	ANGULAR DEG										
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°										

QT/HK165-HK185 JOINT 60"

# QT/HK165-HK185 JOINT

## 72"

### DRAWING APPROVAL

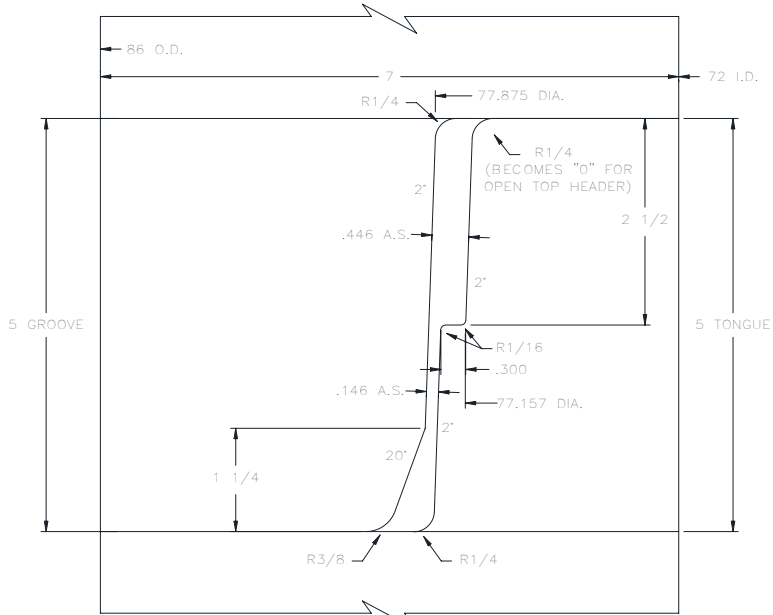
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Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



72" QT-HK165/HK185  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207	72" QT-HK165/HK185 7" WALL	SHEET: 1 OF 1 QTY:	SCALE: <b>1:1</b>	SIZE <b>A</b>	DWG NO: <b>PD-72P-0113</b>	REV.
FAB	MACHINING	CUTTING										
GENERAL TOLERANCES EXCEPT AS NOTED												
FRACTIONAL	DECIMAL	ANGULAR DEG										
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°										

QT/HK165-HK185 JOINT 72"



# 7R/HK165-HK185 JOINT

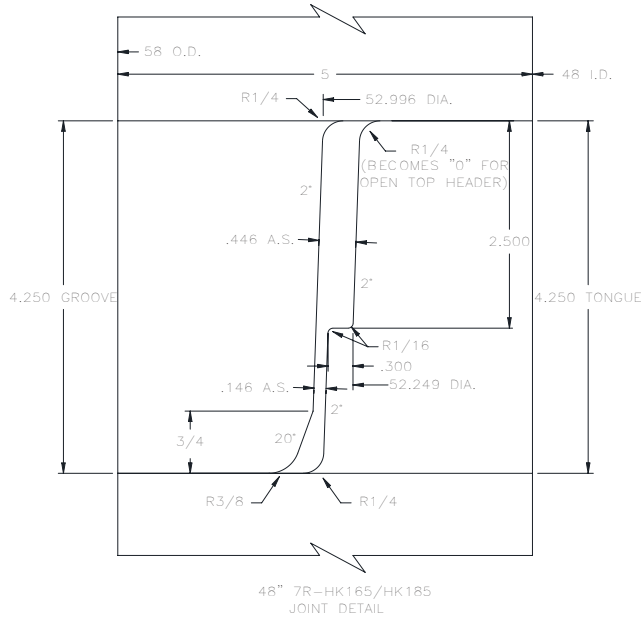
## 48"

### DRAWING APPROVAL

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 Authorized Signature \_\_\_\_\_  
 Date \_\_\_\_\_

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:		<b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659		1701 MOLER ROAD COLUMBUS, OHIO 43207	
FAB	MACHINING	CUTTING								
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL	ANGULAR DEG				48" 7R-HK165/HK185 5" WALL				
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°				SHEET: 1 OF 1	SCALE: 1:1	SIZE: A	DWG NO: PD-48P-0158	REV.

7R/HK165-HK185 JOINT 48"



# 7R/HK165-HK185 JOINT

## 60"

### DRAWING APPROVAL

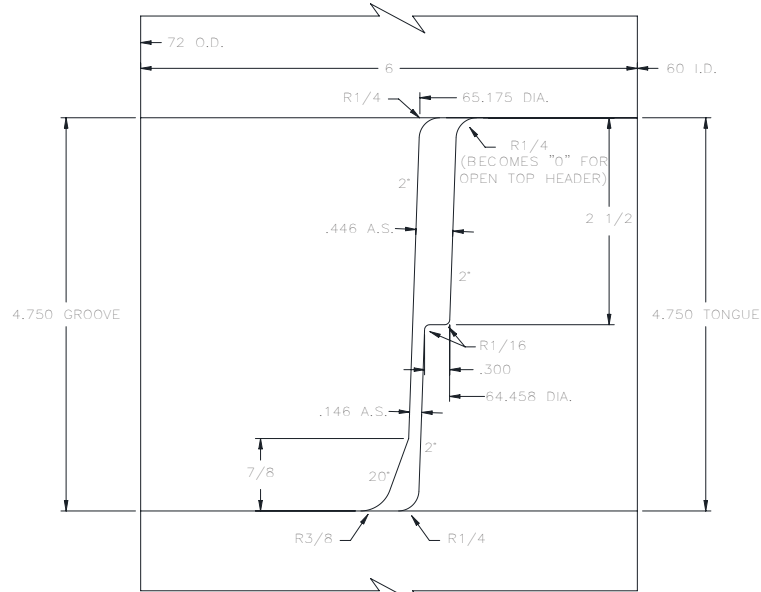
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Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



60" 7R-HK165/HK185 JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:		<b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659    1701 MOLER ROAD COLUMBUS, OHIO 43207			
FAB	MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL		ANGULAR DEG		60" 7R-HK165/HK185					
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		6" WALL					
					DATE:	SHEET: 1 OF 1	SCALE: 1:1	SIZE: A	DWG NO: PD-60P-0105	REV.
					WEIGHT: LBS	QTY:				

7R/HK165-HK185 JOINT 60"



# 7R/HK165-HK185 JOINT

## 72"

### DRAWING APPROVAL

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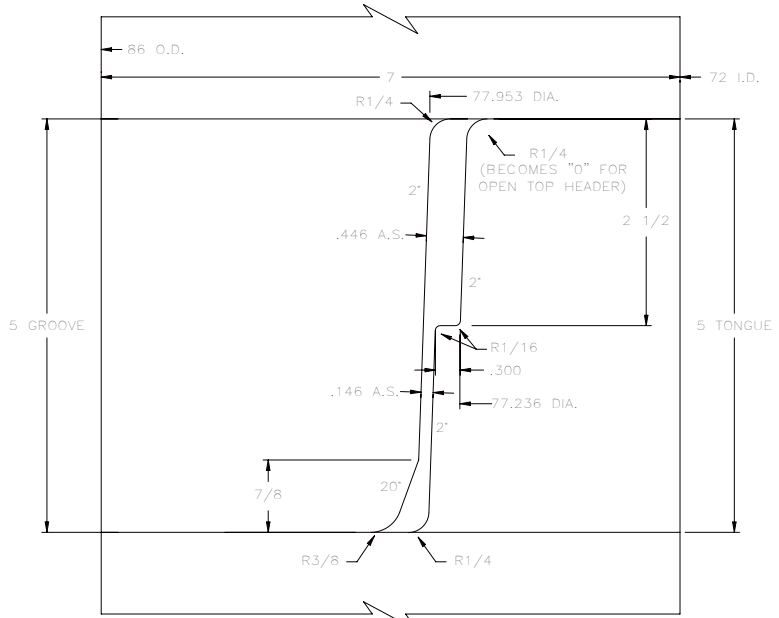
Company Name \_\_\_\_\_

Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

### REVISIONS

REV.	ECR	CHANGE	BY	DATE
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72" 7R-HK165/HK185 JOINT DETAIL

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FAB	MACHINING		CUTTING				GENERAL TOLERANCES EXCEPT AS NOTED					
							72" 7R-HK165/HK185 7" WALL					
FRACTIONAL		DECIMAL		ANGULAR DEG			SHEET:	SCALE:	SIZE:	DWG NO:	REV.	
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°			1 OF 1	1:1	A	PD-72P-0114		

7R/HK165-HK185 JOINT 72"

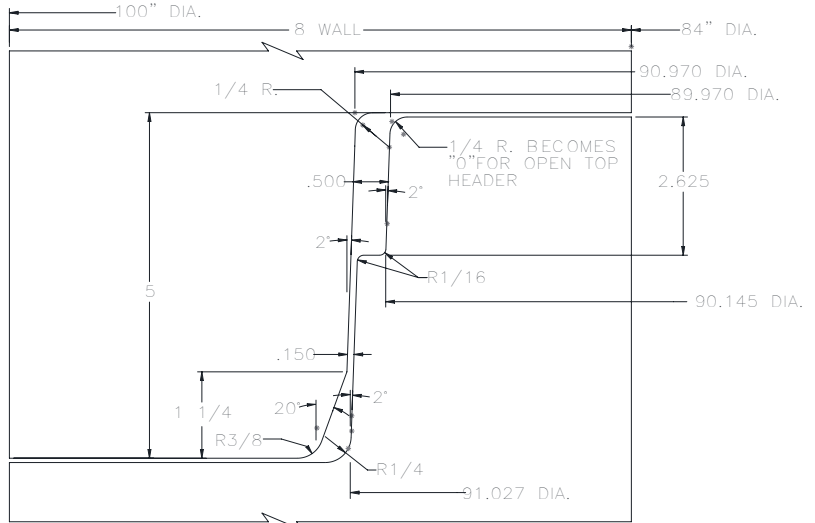
# 7R/HK200L JOINT 84"

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 Authorized Signature \_\_\_\_\_  
 Date \_\_\_\_\_

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REV.	ECR	CHANGE	BY	DATE



84" 7R-HK200L  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY:  DATE:	 <p>AFINITAS FORMING SYSTEMS DIVISION</p> <p>928 WEST MILWAUKEE    1701 MOLER ROAD          NEW HAMPTON, IOWA 50659    COLUMBUS, OHIO 43207</p>			
FAB	MACHINING	CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED									
FRACTIONAL	DECIMAL	ANGULAR DEG							
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°		84" 7R-TSS 200L 8" WALL	SHEET: 1 OF 1 QTY:	SCALE: 1:1	SIZE A	DWG NO: 84 7R-HK200L	REV.

7R/HK200L JOINT 84"

# 7R/HK200L JOINT 96"

## DRAWING APPROVAL

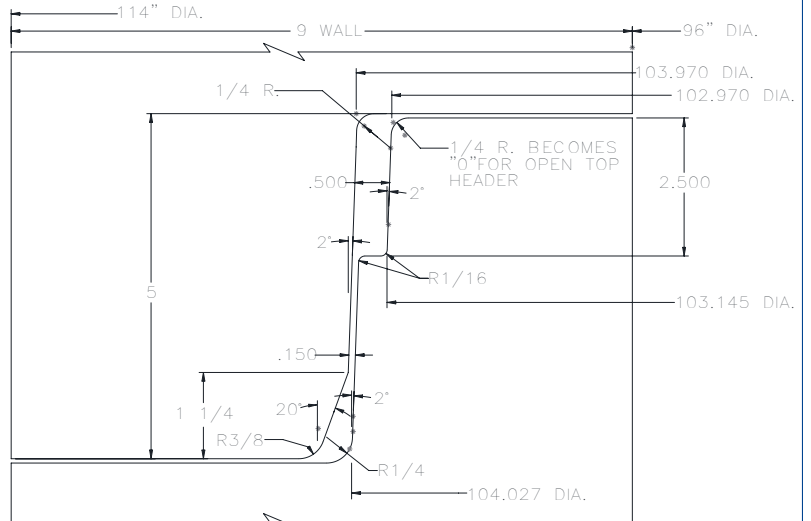
This print is forwarded for your approval. Please check thoroughly and return immediately, either giving approval or noting changes required. Production **WILL NOT** begin until an approved print is returned to us.

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Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



96" 7R-TSS 200L  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: _____ DATE: _____ WEIGHT: LBS JOB NO: _____	 <p>AFINITAS FORMING SYSTEMS DIVISION</p> <p>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207</p>
FAB	MACHINING		CUTTING			
GENERAL TOLERANCES EXCEPT AS NOTED						
FRACTIONAL	DECIMAL		ANGULAR DEG		96" - 7R/200L TSS	SHEET: 1 OF 1 QTY: _____ SCALE: 1:1 SIZE: <b>A</b> DWG NO: 96-7R 200L TSS REV.
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		8" WALL	

7R/HK200L JOINT 96"

# 7R/HK200L JOINT 120"

## DRAWING APPROVAL

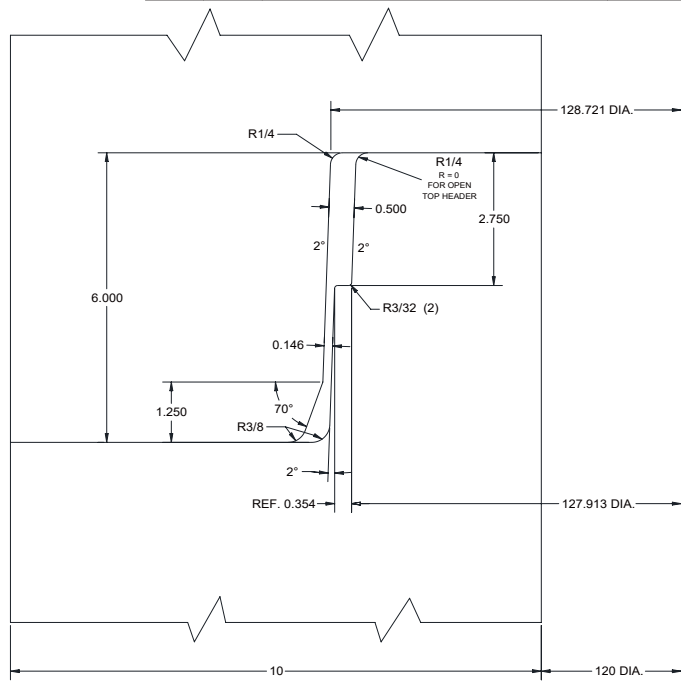
This print is forwarded for your approval. Please check thoroughly and return immediately, either giving approval or noting changes required. Production **WILL NOT** begin until an approved print is returned to us.

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Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

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REV.	ECR	CHANGE	BY	DATE



120" 7R/TSS (200L)  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE    1701 MOLER ROAD NEW HAMPTON, IOWA 50659    COLUMBUS, OHIO 43207		
FAB	MACHINING		CUTTING					
GENERAL TOLERANCES EXCEPT AS NOTED								
FRACTIONAL	DECIMAL		ANGULAR DEG		DATE:	120" 7R/TSS 200L 10" WALL		
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		WEIGHT: LBS			
					JOB NO:	SHEET: 1 OF 1 QTY:	SCALE: 1:1 SIZE: <b>A</b>	DWG NO: 120 7R TSS 200L REV.

7R/HK200L JOINT 120"



# 7R/HK200L JOINT 144"

## DRAWING APPROVAL

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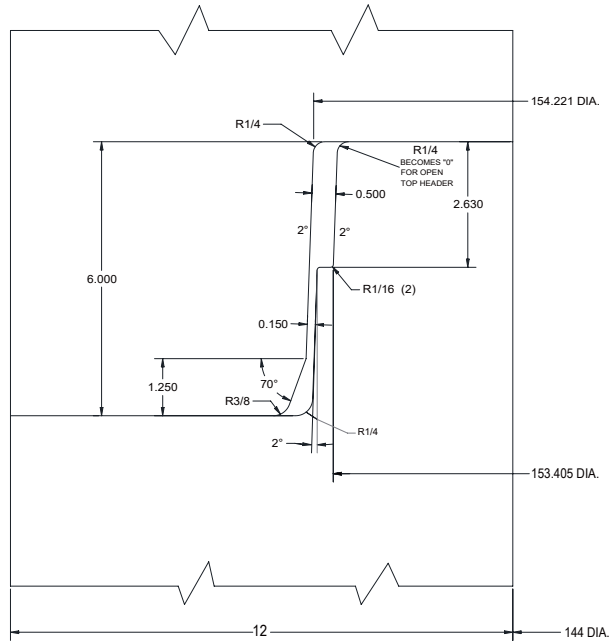
Company Name \_\_\_\_\_

Authorized Signature \_\_\_\_\_


Date \_\_\_\_\_

### REVISIONS

REV.	ECR	CHANGE	BY	DATE
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144" Q7R/HK200L-TSS  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY:  DATE:  WEIGHT: LBS JOB NO:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207		
FAB	MACHINING	CUTTING						
GENERAL TOLERANCES EXCEPT AS NOTED								
FRACTIONAL	DECIMAL	ANGULAR DEG						
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°		144 Q7R HK200L-TSS 12" WALL	SHEET: 1 OF 1 QTY:	SCALE: 1:1 SIZE: <b>A</b>	DWG NO: 144 Q7R HK-200L-TSS	REV.

7R/HK200L JOINT 144"



# 7R/250-210-4G JOINT

## 48"

### DRAWING APPROVAL

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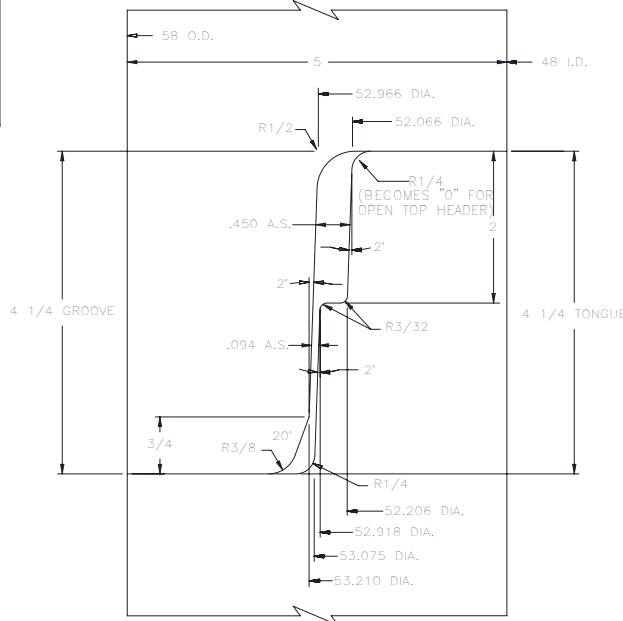
Company Name \_\_\_\_\_

Authorized Signature \_\_\_\_\_


Date \_\_\_\_\_

#### REVISIONS

REV.	ECR	CHANGE	BY	DATE
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48" 7R 250/210 4G  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: _____ DATE: _____ WEIGHT: LBS _____ JOB NO: _____	 <p>AFINITAS FORMING SYSTEMS DIVISION</p> <p>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207</p>	GENERAL TOLERANCES EXCEPT AS NOTED		48" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/2104G GASKET 5" WALL		REV.
FAB	MACHINING		CUTTING				SHEET: 1 OF 1	SCALE: 1:1	SIZE: A	DWG NO: PD-48P-0067	
FRACTIONAL	DECIMAL		ANGULAR DEG				QTY:				
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°								

7R/250-210-4G JOINT 48"



# 7R/250-210-4G JOINT

60"

### DRAWING APPROVAL

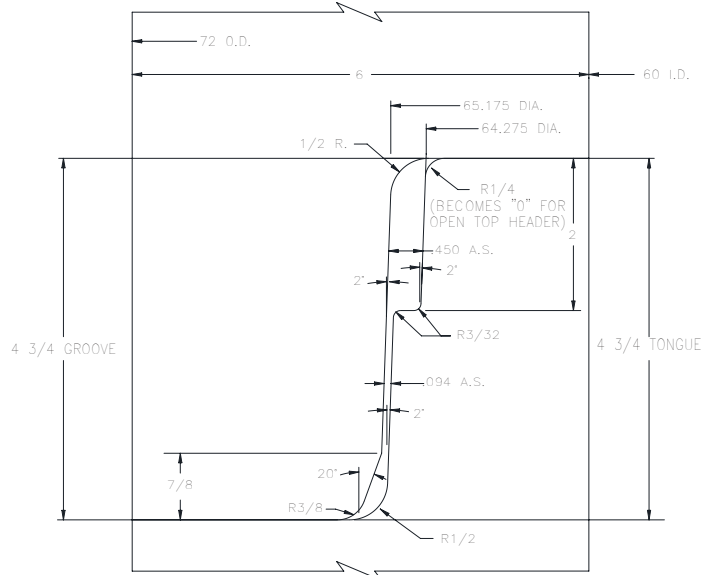
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Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

REVISIONS				
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60" 7R 250/210 4G JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: 11/10/20 DATE: _____ WEIGHT: LBS JOB NO: _____		AFINITAS FORMING SYSTEMS DIVISION		928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207	
FAB	MACHINING		CUTTING	GENERAL TOLERANCES EXCEPT AS NOTED						
FRACTIONAL		DECIMAL		ANGULAR DEG			60" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/210 4G GASKET 6" WALL			
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°	WEIGHT: LBS	SHEET: 1 OF 1	SCALE: 1:1	SIZE: A	DWG NO: PD-60P-0055	REV.

7R/250-210-4G JOINT 60"



# 7R/250-210-4G JOINT 72"

## DRAWING APPROVAL

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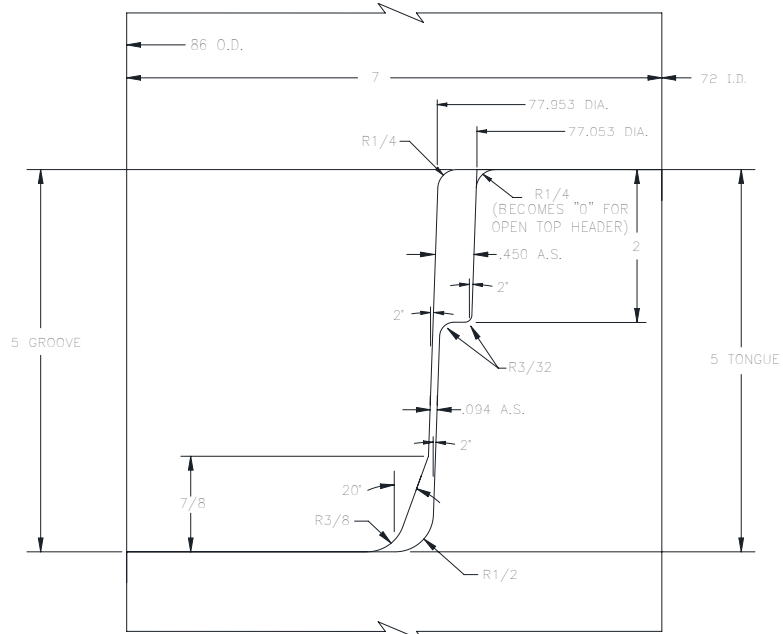
Company Name \_\_\_\_\_

Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

### REVISIONS

REV.	ECR	CHANGE	BY	DATE
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72" 7R 250/210 4G  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: 11/10/20 DATE: WEIGHT: LBS JOB NO:		AFINITAS FORMING SYSTEMS DIVISION		928 WEST MILWAUKEE 1701 MOLER ROAD NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207		
FAB	MACHINING		CUTTING				GENERAL TOLERANCES EXCEPT AS NOTED				
FRACTIONAL		DECIMAL		ANGULAR DEG			72" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/210 4G GASKET 7" WALL				
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		SCALE: 1:1		SIZE: A		DWG NO: PD-72P-0019 REV.	

7R/250-210-4G JOINT 72"



# 7R/250-210-4G JOINT

## 84"

### DRAWING APPROVAL

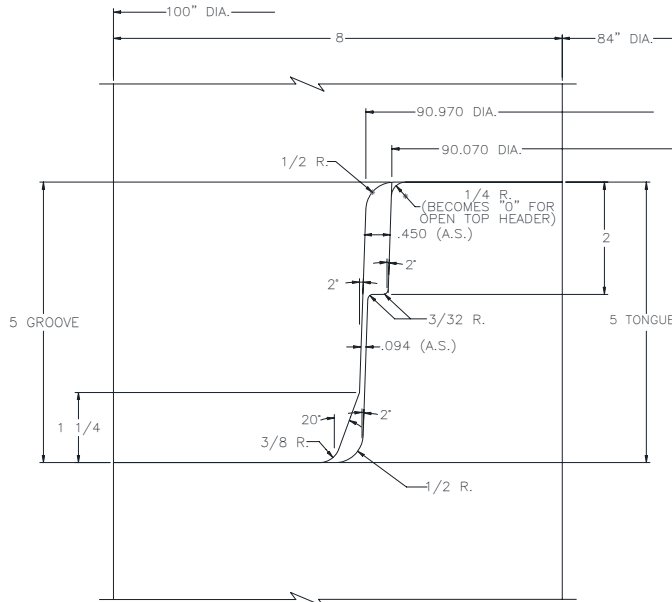
This print is forwarded for your approval. Please check thoroughly and return immediately, either giving approval or noting changes required. Production **WILL NOT** begin until an approved print is returned to us.

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Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



84" 7R 250/210 4G  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:		AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207		
FAB	MACHINING		CUTTING						
GENERAL TOLERANCES EXCEPT AS NOTED									
FRACTIONAL	DECIMAL		ANGULAR DEG		84" SINGLE OFFSET JOINT -QR7 PRESS SEAL 250/210 4G GASKET 8" WALL				
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		SHEET: 1 OF 1 QTY:	SCALE: 1:1	SIZE: <b>A</b>	DWG NO: PD-84P-0040	REV.

7R/250-210-4G JOINT 84"



# 7R/250-210-4G JOINT

## 96"

### DRAWING APPROVAL

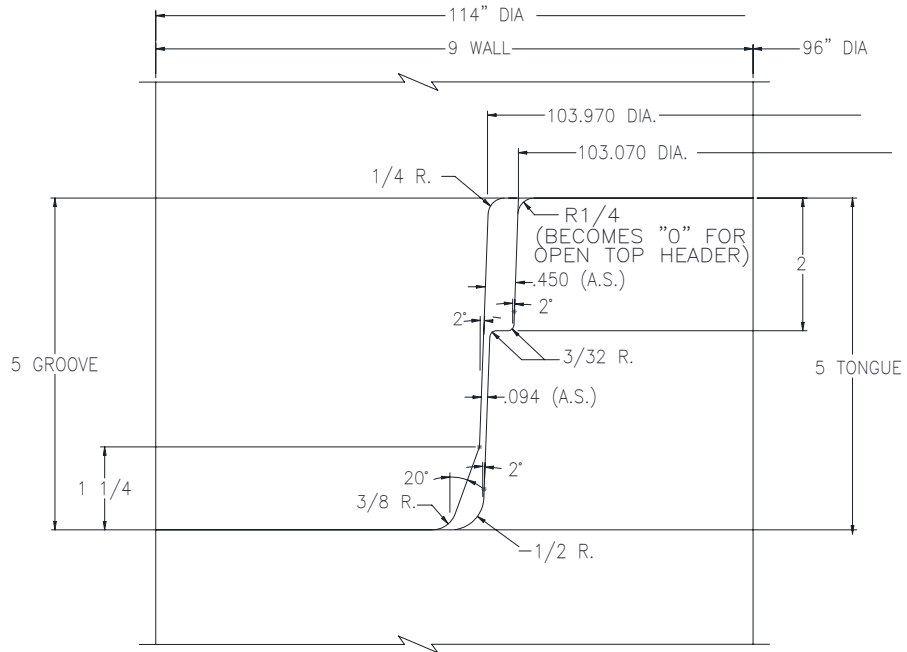
This print is forwarded for your approval. Please check thoroughly and return immediately, either giving approval or noting changes required. Production **WILL NOT** begin until an approved print is returned to us.

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Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

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96 QUINN 7R 250-4G  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:		AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207			
FAB	MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL		ANGULAR DEG		96" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/210 4G GASKET 9"WALL	SHEET: 1 OF 1	SCALE: 1:1	SIZE A	DWG NO: PD-96P-0061	REV.
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°							

7R/250-210-4G JOINT 96"

Joint Profile is NOT recommended for 84" diameter and larger (Recommend using the 7R/288-4G Joint)



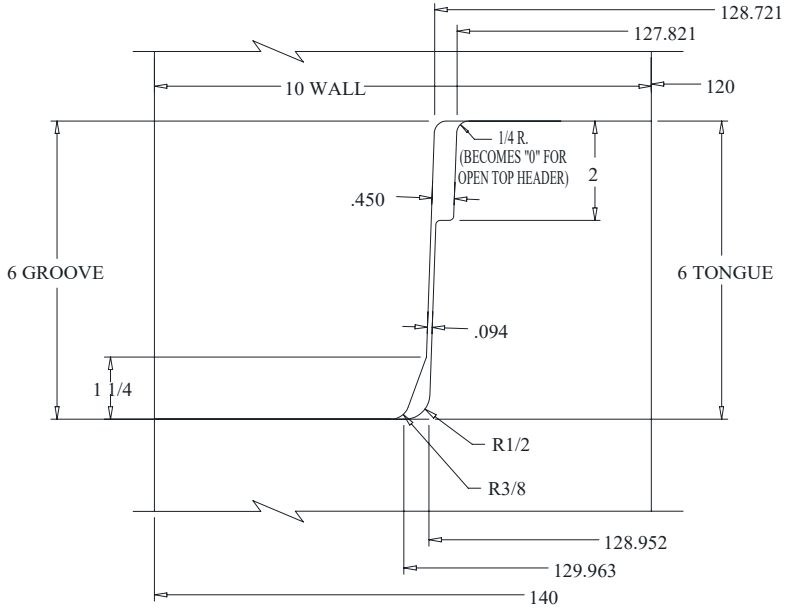
# 7R/250-210-4G JOINT 120"

## DRAWING APPROVAL

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 Authorized Signature \_\_\_\_\_  
 Date \_\_\_\_\_

REVISIONS				
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120 JOINT DETAIL  
QUINN 7R / 250-4G

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:		AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207	
FAB	MACHINING	CUTTING						
GENERAL TOLERANCES EXCEPT AS NOTED								
FRACTIONAL	DECIMAL	ANGULAR DEG						
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°		120" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/210 4G GASKET 10" WALL	SHEET: 1 OF 1 QTY:	SCALE: 1:1 SIZE: A	DWG NO: PD-120P-0025	REV.

7R/250-210-4G JOINT 120"



# 7R/250-210-4G JOINT 144"

## DRAWING APPROVAL

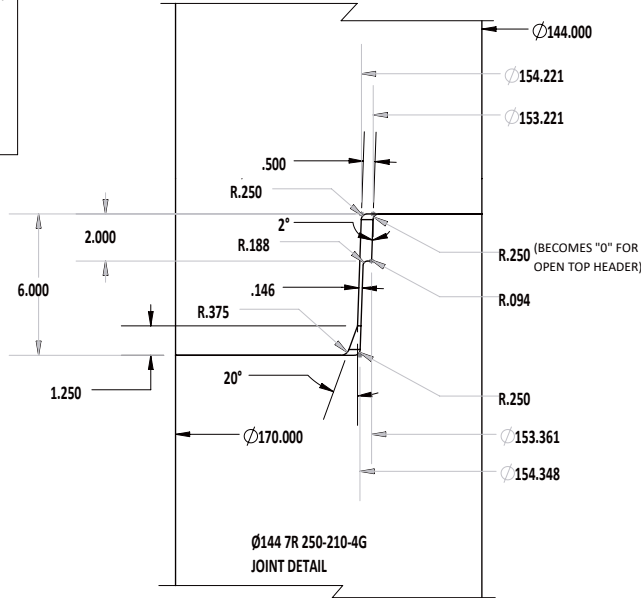
This print is forwarded for your approval. Please check thoroughly and return immediately, either giving approval or noting changes required. Production **WILL NOT** begin until an approved print is returned to us.

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Authorized Signature \_\_\_\_\_

Date \_\_\_\_\_

REVISIONS				
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WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: _____ DATE: _____ WEIGHT: 217777.07 LBS JOB NO: _____		AFINITAS FORMING SYSTEMS DIVISION		928 WEST MILWAUKEE    1701 MOLER ROAD NEW HAMPTON, IOWA 50659    COLUMBUS, OHIO 43207		
FAB	MACHINING		CUTTING				GENERAL TOLERANCES EXCEPT AS NOTED				
FRACTIONAL		DECIMAL		ANGULAR DEG			144" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/210 4G GASKET 13" WALL				
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°			SHEET:	SCALE:	SIZE:	DWG NO:	REV.
					1 OF 1	1:64	A	144-7R-250-210-4GDETAIL			

7R/250-210-4G JOINT 144"

Joint Profile is NOT recommended for 84" diameter and larger (Recommend using the 7R/288-4G Joint)



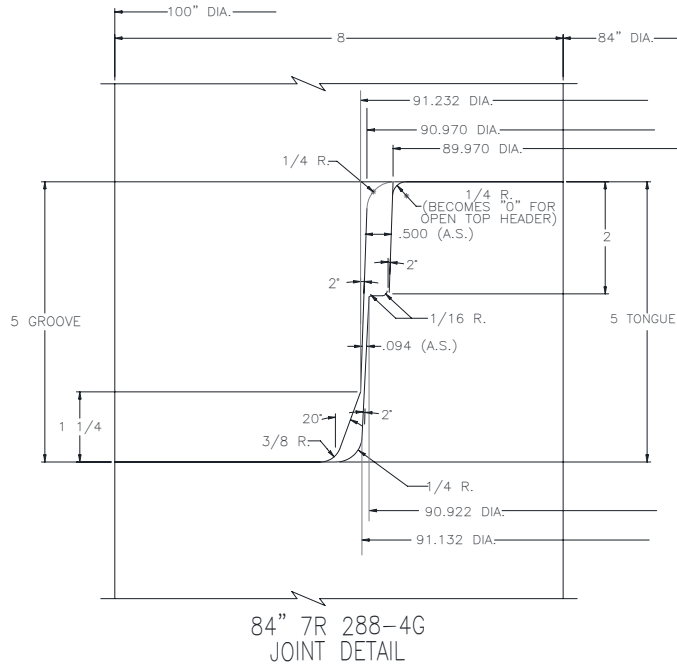
# 7R/288-4G JOINT 84"


## DRAWING APPROVAL

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either giving approval or noting changes required.  
Production **WILL NOT** begin until an  
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WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY:  DATE:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207		
FAB	MACHINING	CUTTING						
GENERAL TOLERANCES EXCEPT AS NOTED								
FRACTIONAL	DECIMAL	ANGULAR DEG						
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°		84" 7R 288-4G 8" WALL	SHEET: 1 OF 1 QTY:	SCALE: 1:1 SIZE: <b>A</b>	DWG NO: PD-84P-0041	REV.

7R/288-4G JOINT 84"

**NOTICE! Recommended joint to use for 84" diameter and larger!**

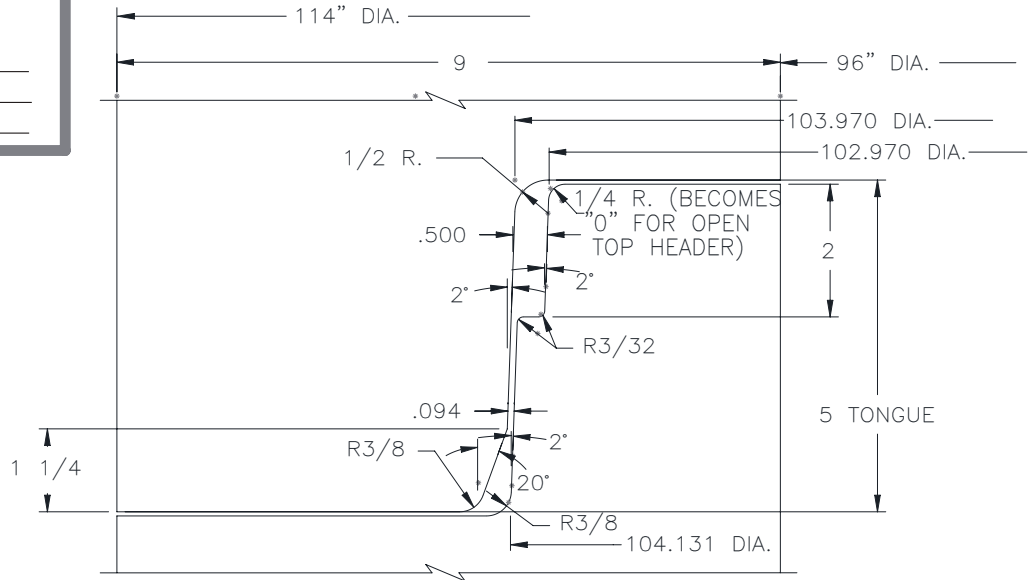
# 7R/288-4G JOINT 96"

## DRAWING APPROVAL

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Company Name \_\_\_\_\_  
 Authorized Signature \_\_\_\_\_  
 Date \_\_\_\_\_

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



### JOINT DETAIL

QUINN 7R / PRESS SEAL 288-4G

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207
FAB	MACHINING		CUTTING			
GENERAL TOLERANCES EXCEPT AS NOTED						
FRACTIONAL	DECIMAL		ANGULAR DEG			
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°	DATE:	96" QUINN 7R / PRESS SEAL 288-4G	SHEET: 1 OF 1 SCALE: 1:1 SIZE: <b>A</b> DWG NO: PD-96P-0062 REV.
WEIGHT: LBS	JOB NO:		DATE:	9" WALL		
QTY:	DATE:		DATE:	DATE:		

7R/288-4G JOINT 96"

**NOTICE! Recommended joint to use for 84" diameter and larger!**

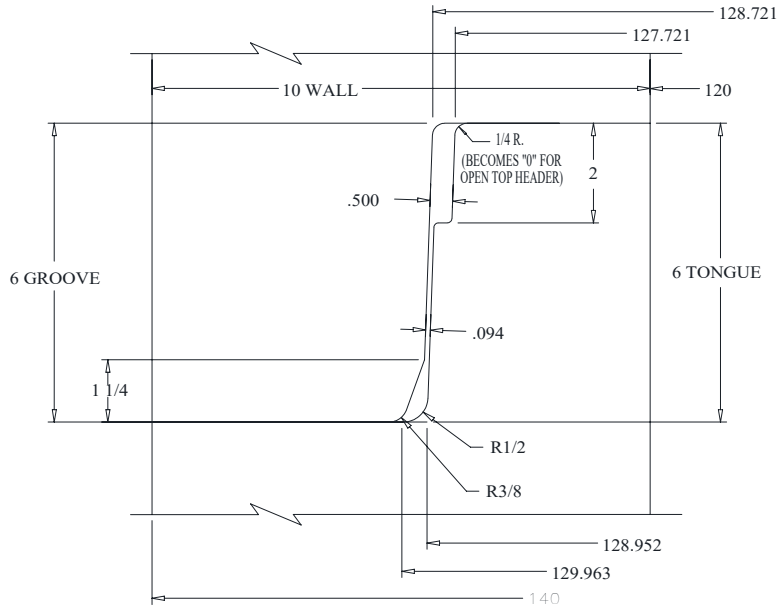
# 7R/288-4G JOINT 120"

## DRAWING APPROVAL


This print is forwarded for your approval. Please check thoroughly and return immediately, either giving approval or noting changes required. Production **WILL NOT** begin until an approved print is returned to us.

Company Name \_\_\_\_\_  
 Authorized Signature \_\_\_\_\_  
 Date \_\_\_\_\_

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



120 JOINT DETAIL  
Q7R / 288-4G

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY:  DATE:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207		
FAB	MACHINING		CUTTING					
GENERAL TOLERANCES EXCEPT AS NOTED								
FRACTIONAL	DECIMAL		ANGULAR DEG					
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°	WEIGHT: LBS JOB NO:	SHEET: 1 OF 1 QTY:	SCALE: 1:1 SIZE <b>A</b>	DWG NO: PD-120P-0024	REV.

7R/288-4G JOINT 120"

**NOTICE! Recommended joint to use for 84" diameter and larger!**



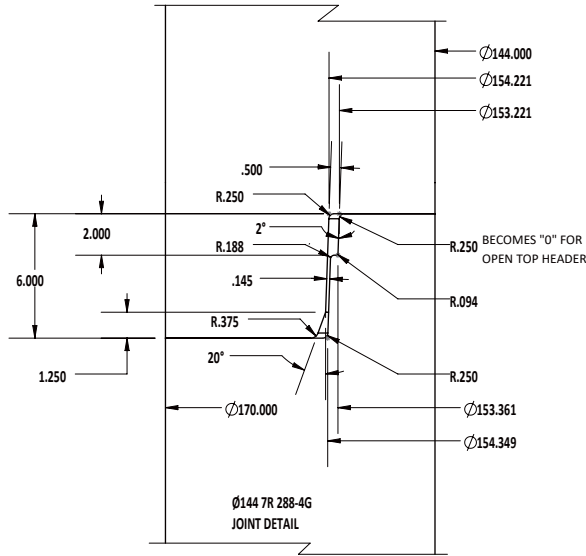
# 7R/288-4G JOINT 144"


## DRAWING APPROVAL

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 Authorized Signature \_\_\_\_\_  
 Date \_\_\_\_\_

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY:  DATE:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207				
FAB	MACHINING	CUTTING								
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL	ANGULAR DEG								
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°		WEIGHT: 217777.82 LBS	SHEET: 1 OF 1	SCALE: 1:64	SIZE <b>A</b>	DWG NO: 144-7R-288-4GDETAIL	REV.	
					JOB NO:	QTY:				

7R/288-4G JOINT 144"

**NOTICE! Recommended joint to use for 84" diameter and larger!**

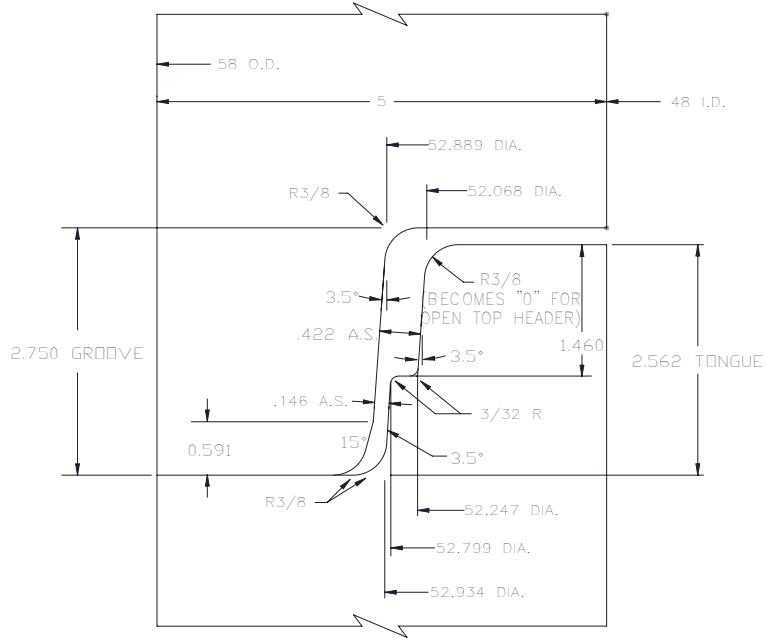
# SHORT S/O JOINT 48"

## DRAWING APPROVAL


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 Authorized Signature \_\_\_\_\_  
 Date \_\_\_\_\_

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



48" F-114 SJ  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207				
FAB	MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL		ANGULAR DEG		48" SHORT S/O JOINT 5" WALL	SHEET: 1 OF 1 QTY:	SCALE: <b>1:1</b>	SIZE <b>A</b>	DWG NO: <b>PD-48P-0138</b>	REV.
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°							

SHORT S/O JOINT 48"

# SHORT S/O JOINT 60"

## DRAWING APPROVAL

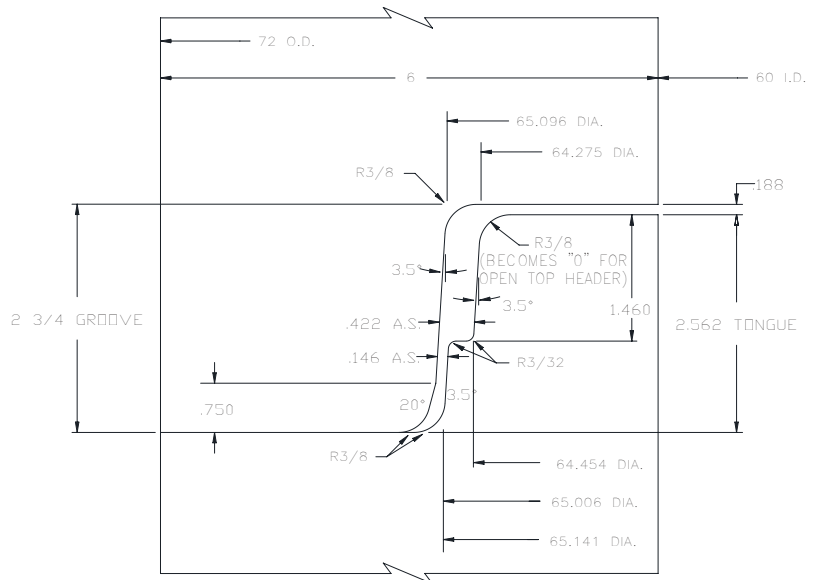
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Date \_\_\_\_\_

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REV.	ECR	CHANGE	BY	DATE



60" F-114 SJ  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: 11/10/20 DATE: _____ WEIGHT: LBS JOB NO: _____	 <p><b>AFINITAS</b></p> <p>FORMING SYSTEMS DIVISION</p> <p>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207</p>	
FAB	MACHINING	CUTTING					
GENERAL TOLERANCES EXCEPT AS NOTED							
FRACTIONAL	DECIMAL	ANGULAR DEG					
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°		60" SHORT S/O JOINT 6" WALL	SHEET: 1 OF 1 QTY: _____	SCALE: 1:1 SIZE: <b>A</b>	DWG NO: PD-60P-0102 REV. _____

SHORT S/O JOINT 60"



# SHORT S/O JOINT

## 72"

### DRAWING APPROVAL

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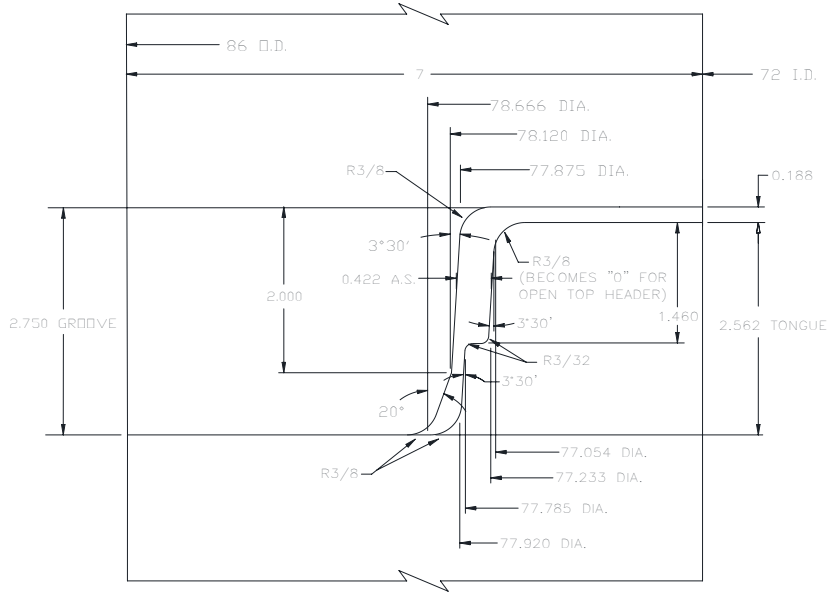
Company Name \_\_\_\_\_

Authorized Signature \_\_\_\_\_


Date \_\_\_\_\_

### REVISIONS

REV.	ECR	CHANGE	BY	DATE
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F-114 SJ  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: 11/11/20 DATE:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE    1701 MOLER ROAD NEW HAMPTON, IOWA 50659    COLUMBUS, OHIO 43207
FAB	MACHINING	CUTTING				
GENERAL TOLERANCES EXCEPT AS NOTED						
FRACTIONAL	DECIMAL	ANGULAR DEG		72" SHORT S/O JOINT 7" WALL		
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°		WEIGHT: LBS	SHEET: 1 OF 1	SCALE: 1:1
				JOB NO:	QTY:	SIZE: <b>A</b>
						DWG NO: PD-72P-0042
						REV.

SHORT S/O JOINT 72"

# 1M MORTAR JOINT 48"

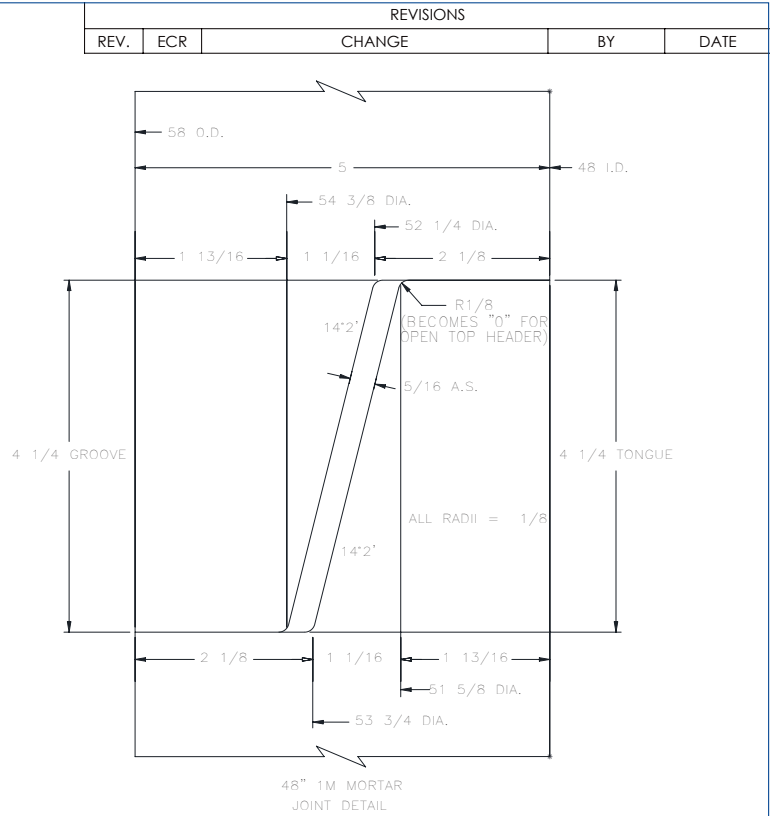
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WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: 11/10/20 DATE: WEIGHT: LBS JOB NO:	 <b>AFINITAS</b>	<b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207		
FAB	MACHINING	CUTTING		48" 1M MORTAR JOINT 5" WALL					
GENERAL TOLERANCES EXCEPT AS NOTED									
FRACTIONAL	DECIMAL	ANGULAR DEG							
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°			SHEET: 1 OF 1	SCALE: 1:1	SIZE <b>A</b>	DWG NO: PD-48P-0157	REV.

1M MORTAR JOINT 48"





# 1M MORTAR JOINT 60"

## DRAWING APPROVAL

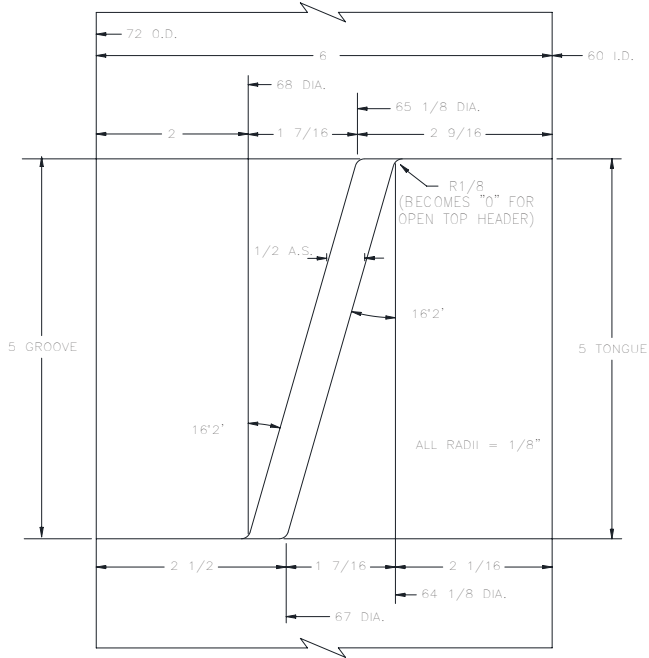
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Authorized Signature \_\_\_\_\_

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60" 1M MORTAR JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: 11/10/20 DATE:		AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659    1701 MOLER ROAD COLUMBUS, OHIO 43207			
FAB	MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL		ANGULAR DEG		60" 1M MORTAR JOINT 6" WALL					
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		WEIGHT: LBS	SHEET: 1 OF 1	SCALE: 1:1	SIZE: A	DWG NO: PD-60P-0103	REV.
					JOB NO:	QTY:				

1M MORTAR JOINT 60"

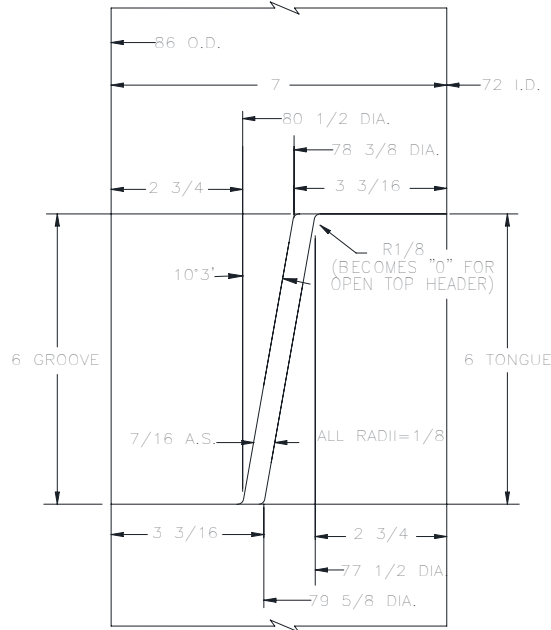
# 1M MORTAR JOINT 72"

## DRAWING APPROVAL


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72" 1M  
MORTAR JOINT

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: 11/10/20 DATE: _____ WEIGHT: LBS JOB NO: _____	 <p>AFINITAS FORMING SYSTEMS DIVISION</p> <p>928 WEST MILWAUKEE 1701 MOLER ROAD          NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207</p>	
FAB	MACHINING		CUTTING				
GENERAL TOLERANCES EXCEPT AS NOTED							
FRACTIONAL	DECIMAL		ANGULAR DEG				
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°	72" MORTAR JOINT-Q1M 7" WALL	SHEET: 1 OF 1 QTY: _____	SCALE: 1:1 SIZE: A	DWG NO: PD-72P-0095 REV. _____

1M MORTAR JOINT 72"



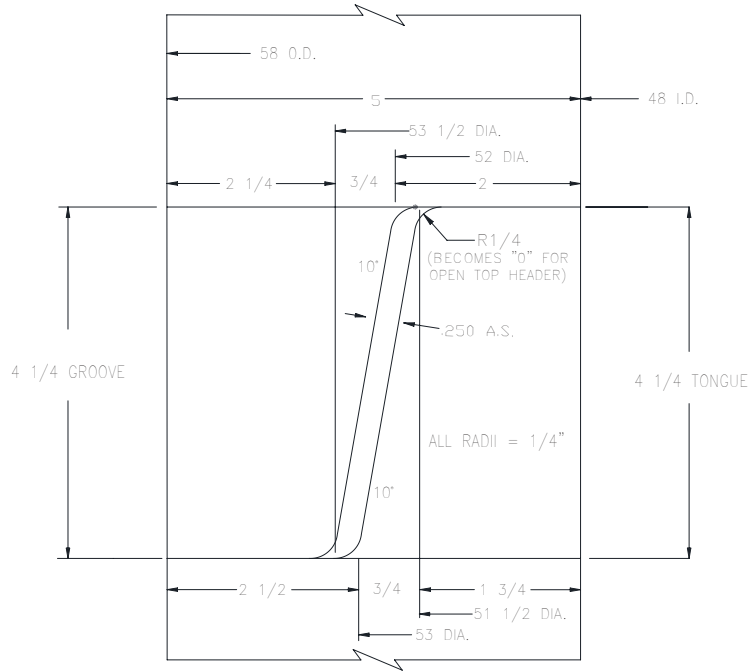
# 3M MORTAR JOINT 48"

## DRAWING APPROVAL


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 Date \_\_\_\_\_

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48" 3M MORTAR  
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: 11/10/20 DATE:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207
FAB	MACHINING		CUTTING			
GENERAL TOLERANCES EXCEPT AS NOTED						
FRACTIONAL	DECIMAL		ANGULAR DEG		48: 3M MORTAR JOINT DETAIL 5" WALL	REV.
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°			
WEIGHT: LBS		SHEET: 1 OF 1		SCALE: 1:1	SIZE: <b>A</b>	DWG NO: PD-48P-0152
JOB NO:		QTY:				

3M MORTAR JOINT 48"

# 3M MORTAR JOINT 60"

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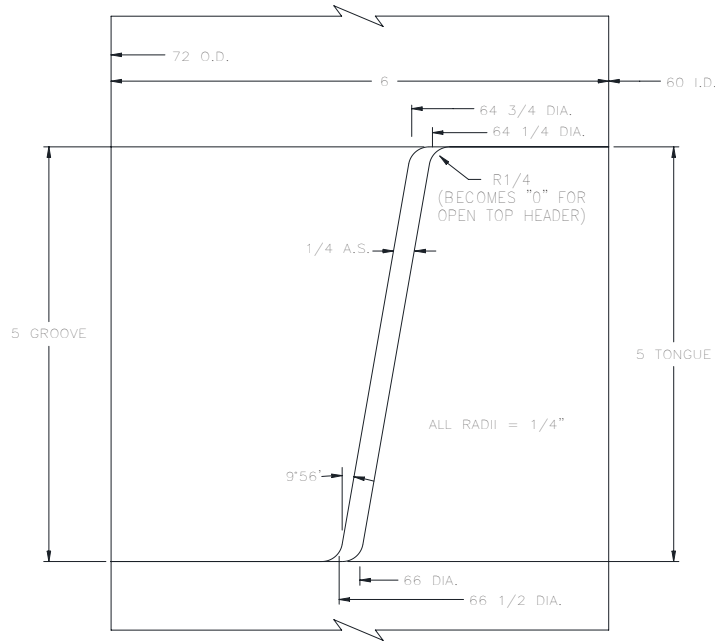
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Authorized Signature \_\_\_\_\_


Date \_\_\_\_\_

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60" 3M MORTAR JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: 11/10/20 DATE:	 <b>AFINITAS</b> FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207
FAB	MACHINING	CUTTING				
GENERAL TOLERANCES EXCEPT AS NOTED						
FRACTIONAL	DECIMAL	ANGULAR DEG		60" 3M MORTAR JOINT 6" WALL		
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0°		WEIGHT: LBS	SHEET: 1 OF 1	SCALE: 1:1
				JOB NO:	QTY:	SIZE: <b>A</b>
					DWG NO: PD-60P-0058	
					REV.	

3M MORTAR JOINT 60"



# 3M MORTAR JOINT

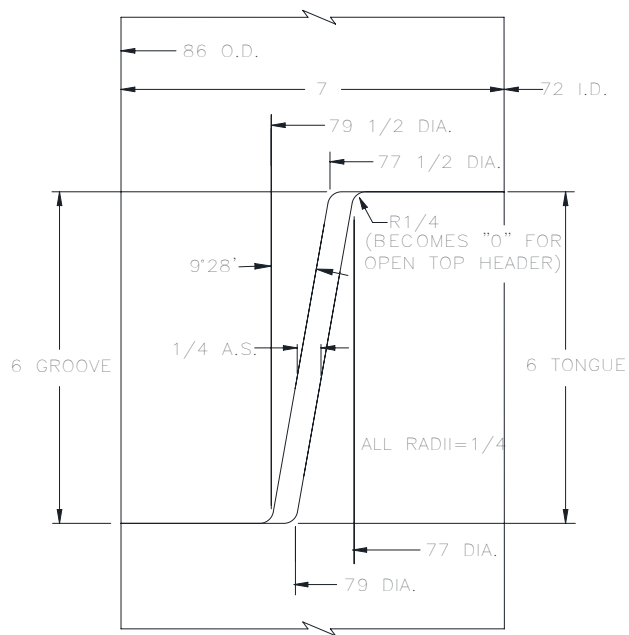
## 72"

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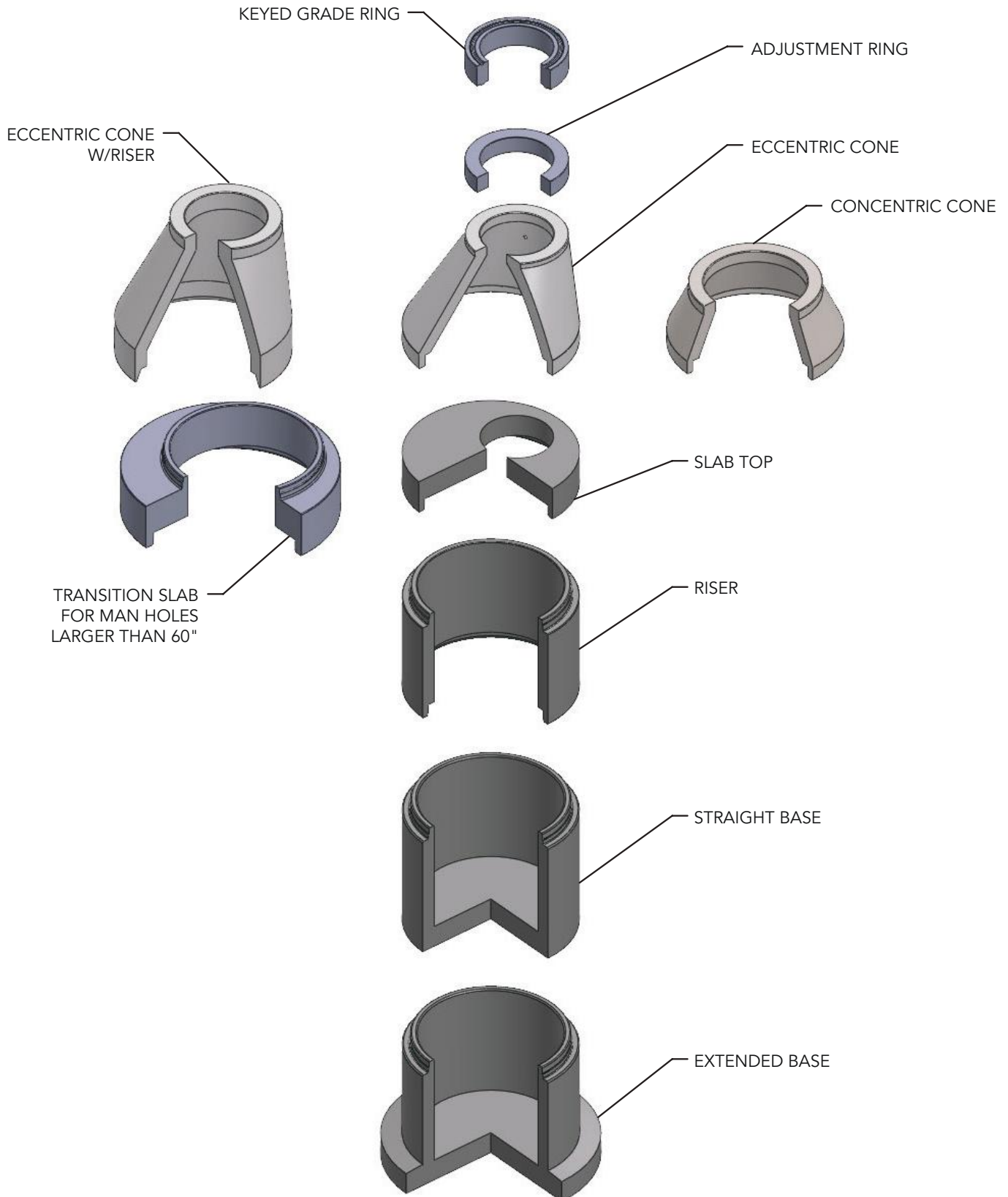
REVISIONS				
REV.	ECR	CHANGE	BY	DATE



72" 3M  
MORTAR JOINT

WELDING	MACH	DRILL	SHAPING	CUTTING	<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: 11/10/20 DATE:		AFINITAS FORMING SYSTEMS DIVISION			
FAB	MACHINING		CUTTING	928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659    1701 MOLER ROAD COLUMBUS, OHIO 43207						
GENERAL TOLERANCES EXCEPT AS NOTED							72" MORTAR JOINT-Q3M			
							7" WALL			
FRACTIONAL	DECIMAL		ANGULAR DEG		WEIGHT: LBS	SHEET: 1 OF 1	SCALE: 1:1	SIZE: A	DWG NO: PD-72P-0112	REV.
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		JOB NO:	QTY:				

# Manhole Cone Stack-Up



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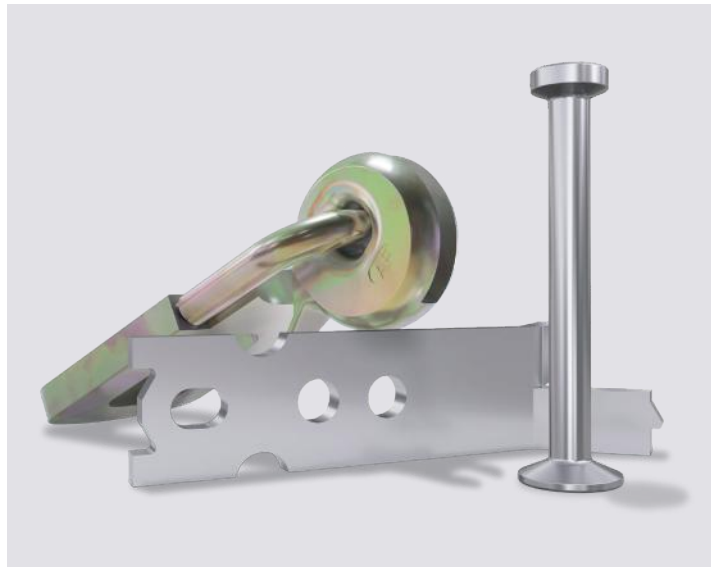
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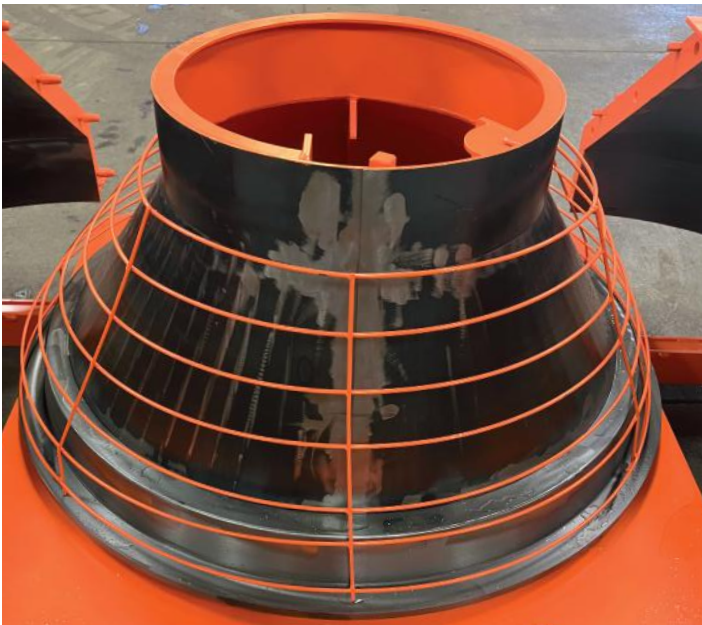
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