



Joint Ring Solutions



Built to last. Designed to perform.

- For wetcast applications
- 12" through 144" diameters

www.afinitas.com

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

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)



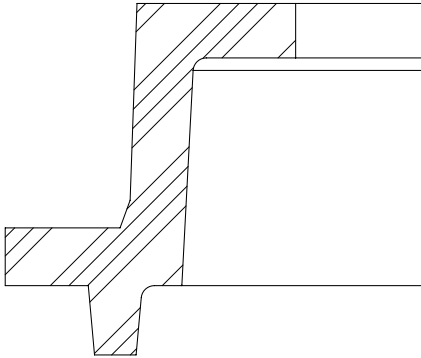
Tongue Forming Headers, Open Top with Form Hangers/Lifting Eyes

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

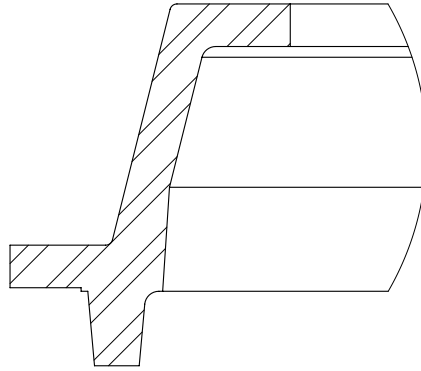


Joint Rings

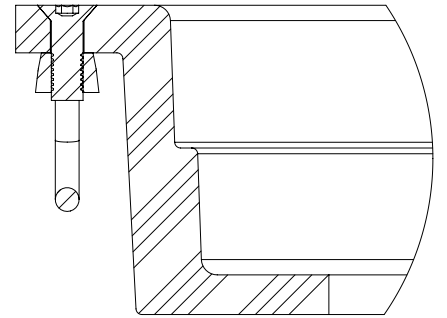
12" – 144" Diameter Round, Arch and Elliptical



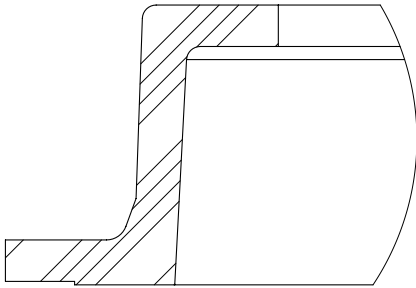
Single Offset Groove Forming
Pallet with Legs



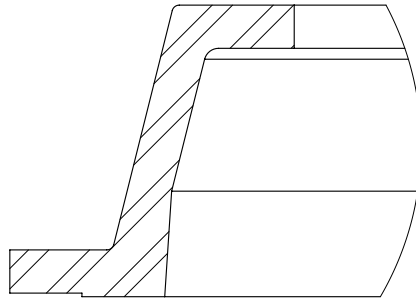
Mortar Joint Groove Forming
Pallet with Legs



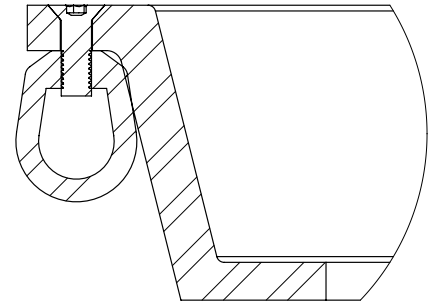
Single Offset Tongue Forming
Pallet with Lifting Eyes



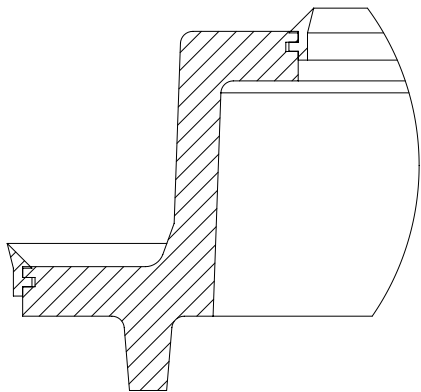
Single Offset Groove Forming
Pallet without Legs



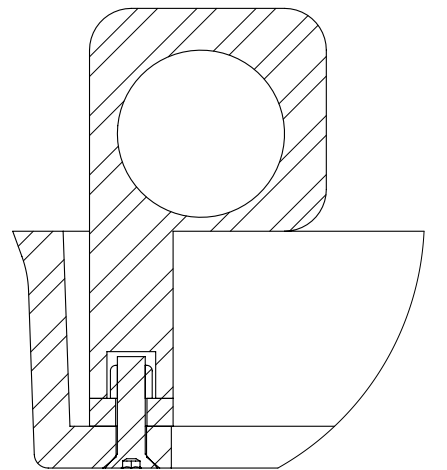
Mortar Joint Groove Forming
Pallet without Legs



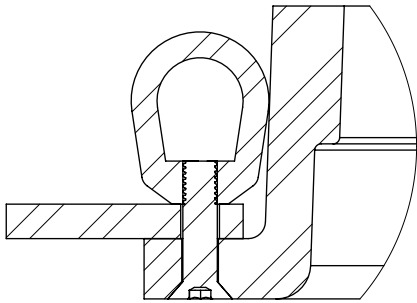
Mortar Joint Tongue Forming
Pallet with Lifting Eyes



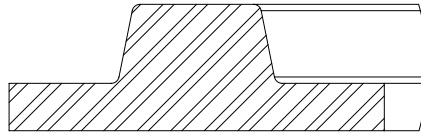
Single Offset Groove Forming
Pallet with Legs and ID/OD
Chamfer Seals



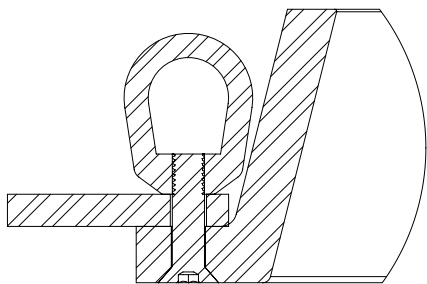
Single Offset Groove Forming
Header, Open Top with Lifting
Eyes and Core Tabs/Hangers



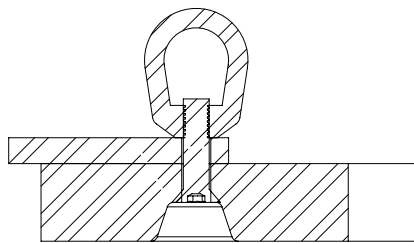
Single Offset Tongue Forming Header, Open Top with Lifting Eyes and Form Tabs



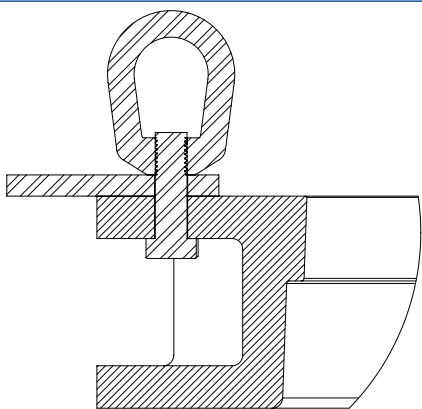
Key Lock Groove Forming Pallet



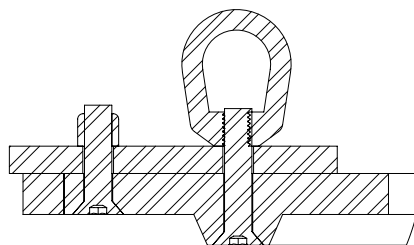
Mortar Joint Tongue Forming Header, Open Top with Lifting Eyes and Form Tabs



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\"/>

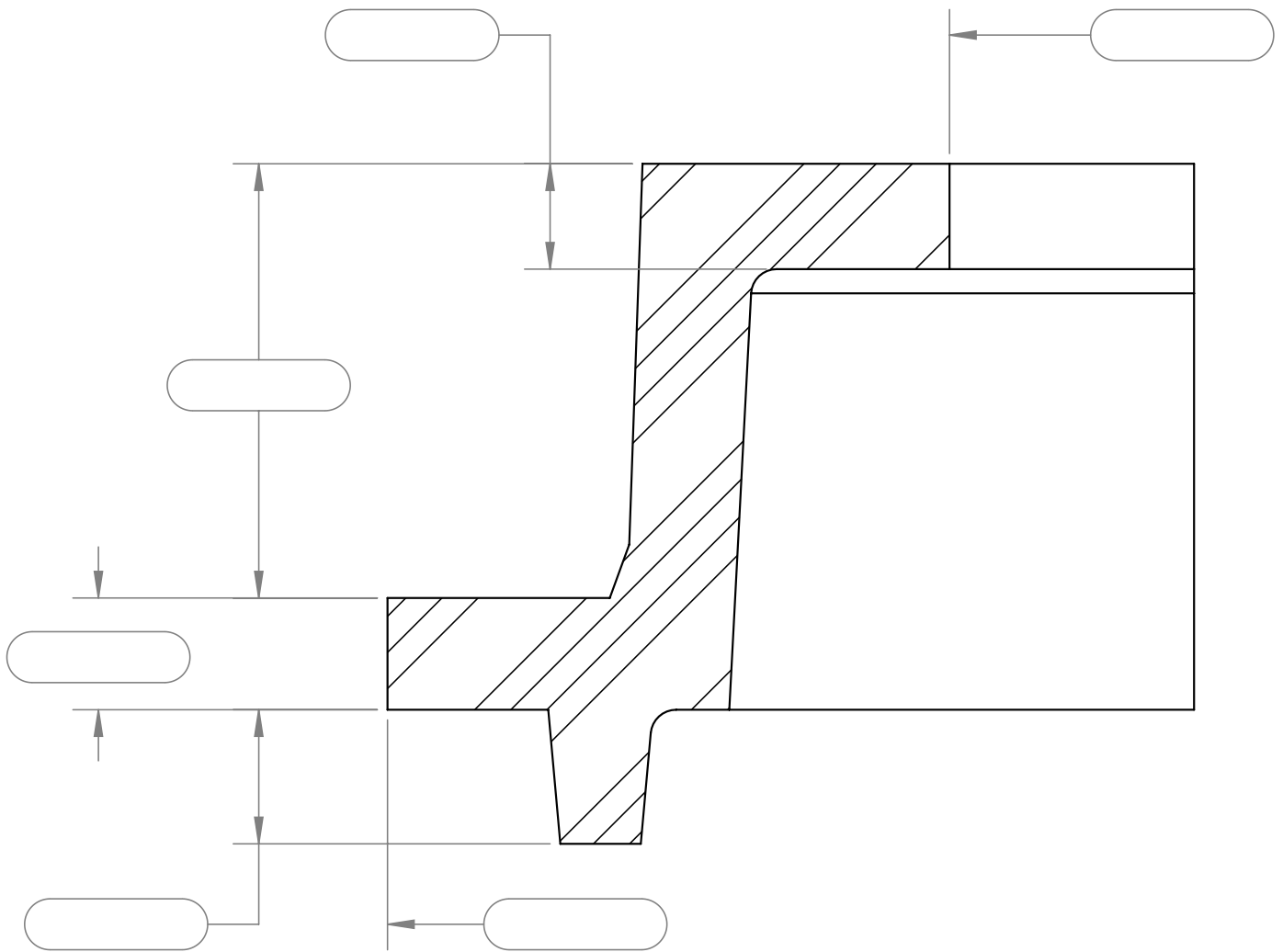


Key Lock Groove Forming Header with Form Tabs and Lifting Eyes

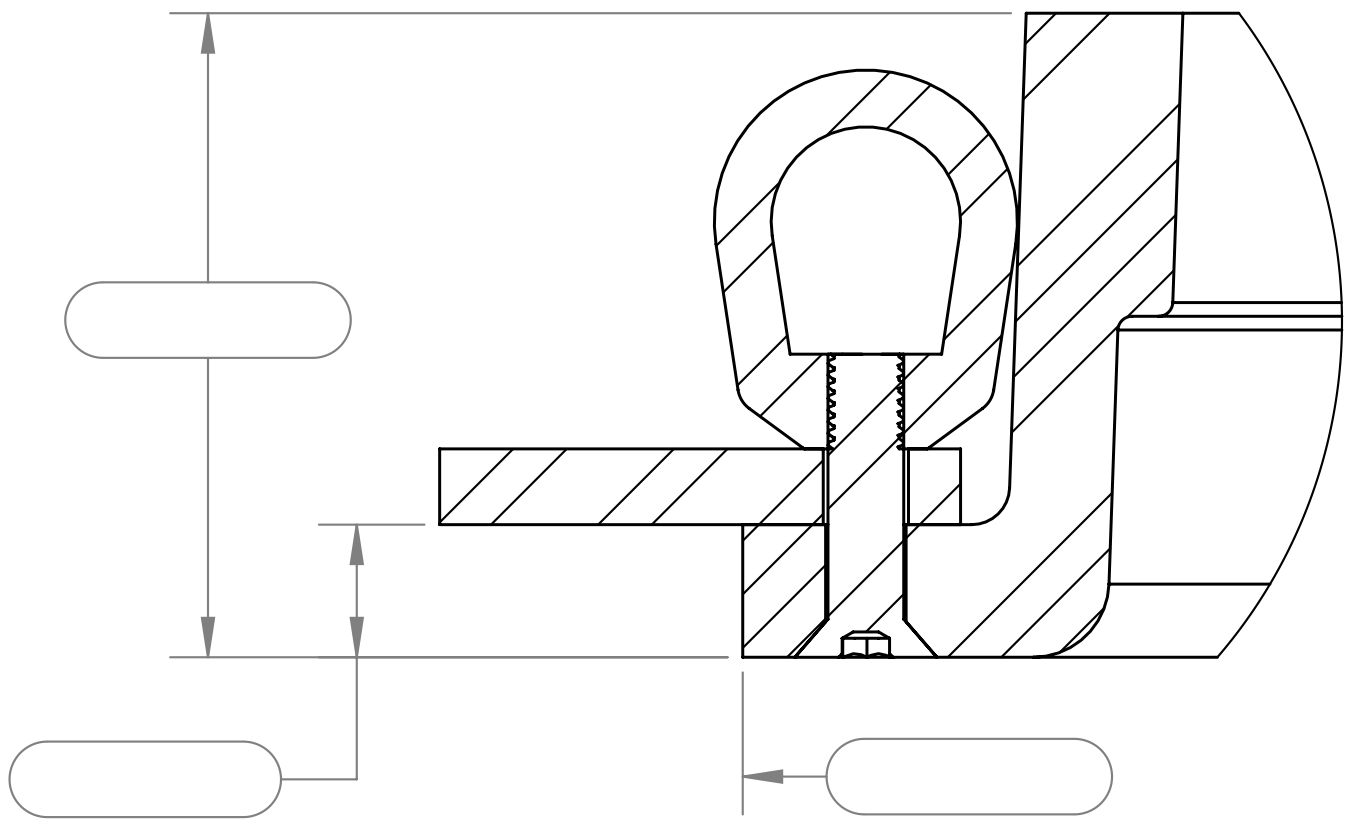


Joint Rings

Fill In The Blank Worksheets



Groove Forming Pallet with Legs

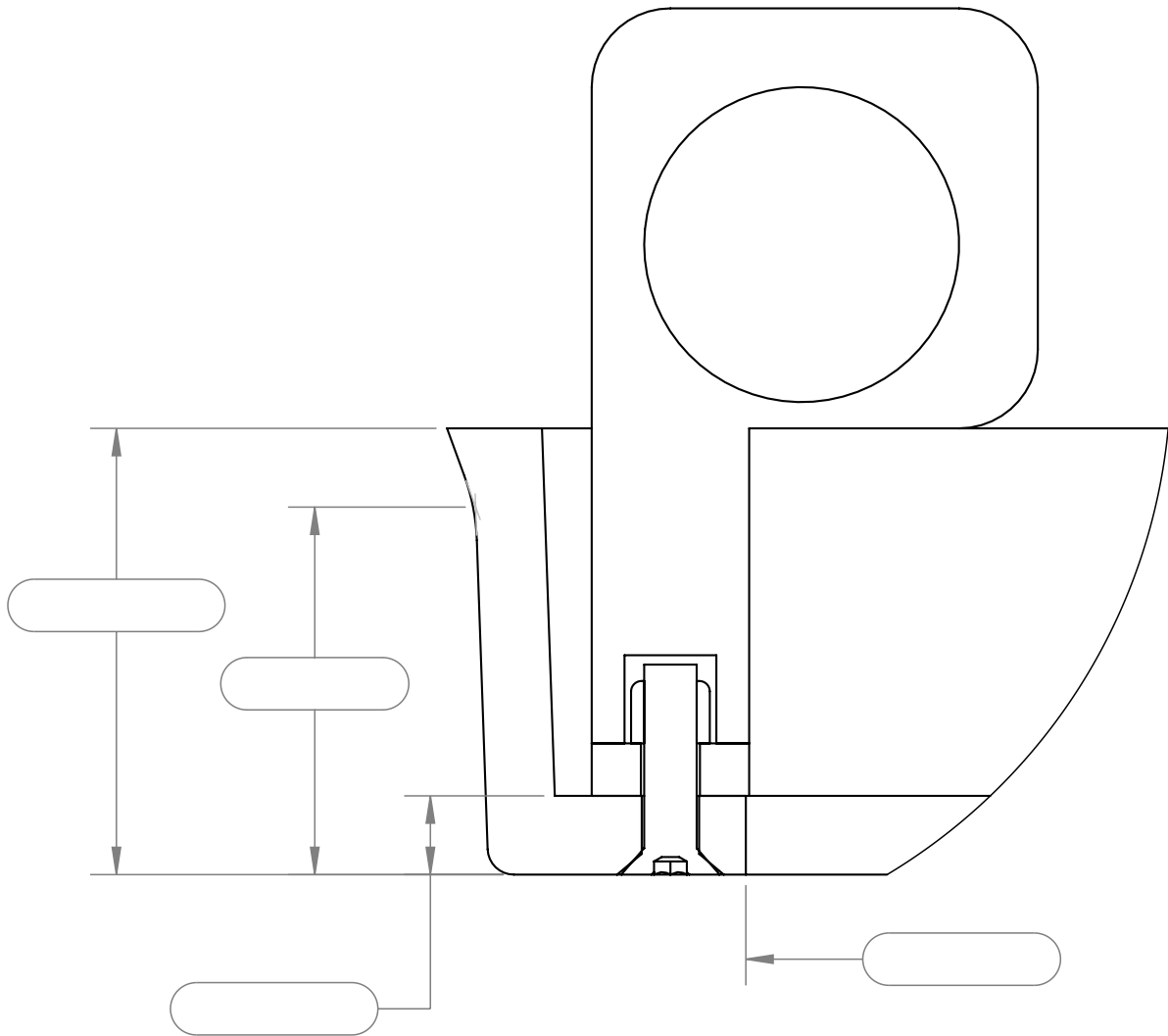


Tongue Forming Header, Open Top with Form Tabs and Lifting Eyes

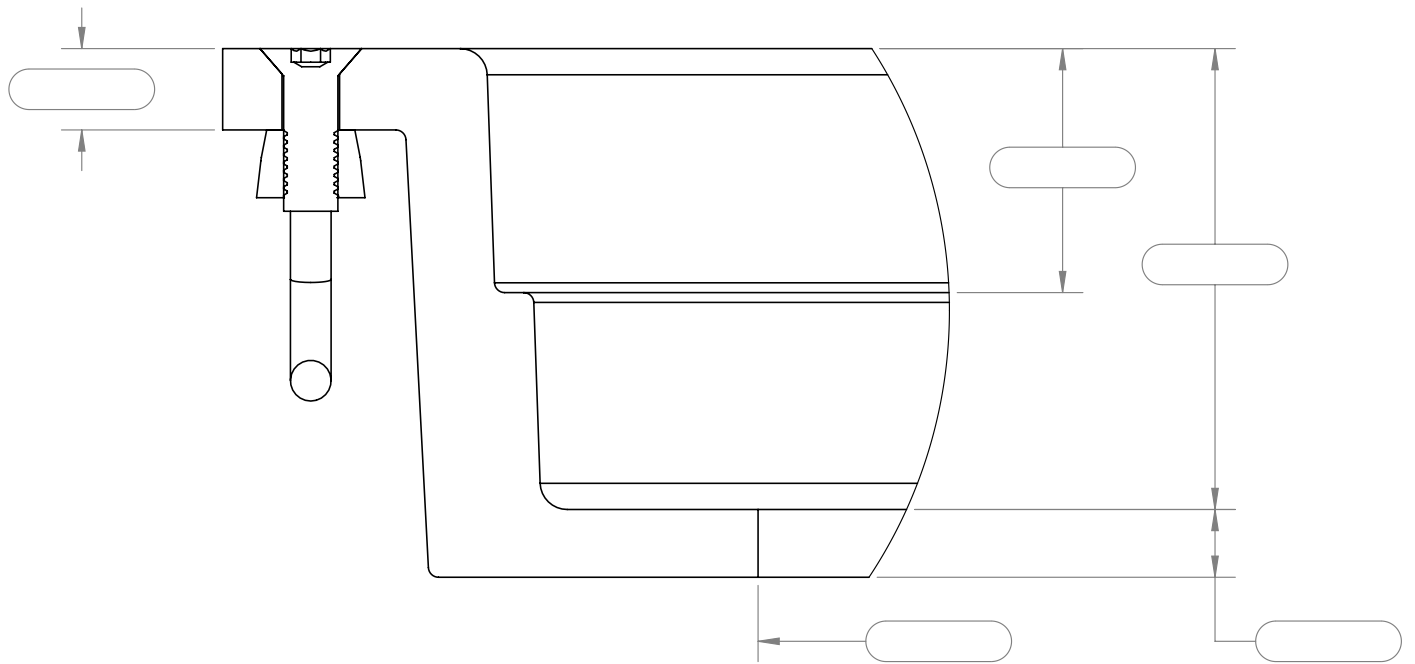


Joint Rings

Fill In The Blank Worksheets



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

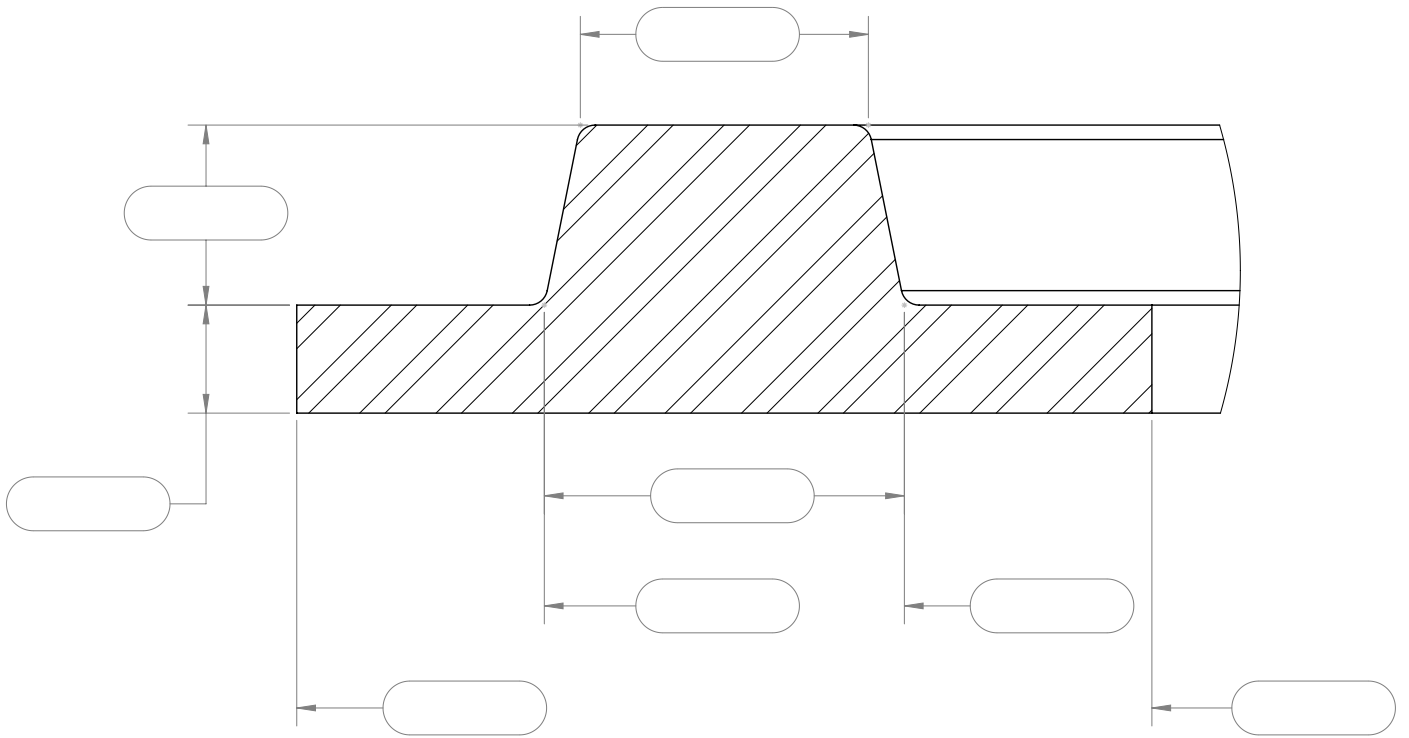


Tongue Forming Pallet with Lifting Eyes

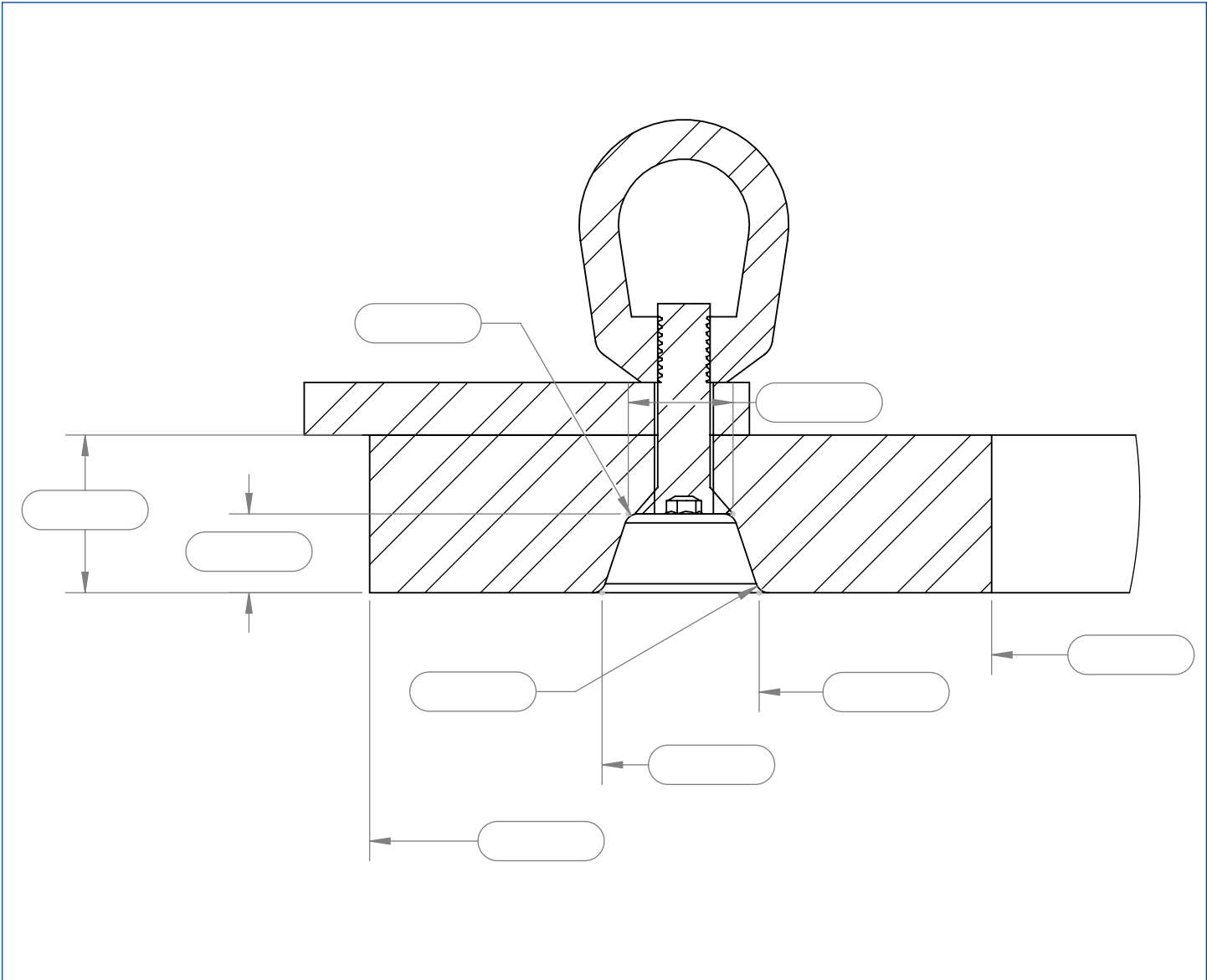


Joint Rings

Fill In The Blank Worksheets



Groove Forming Pallet

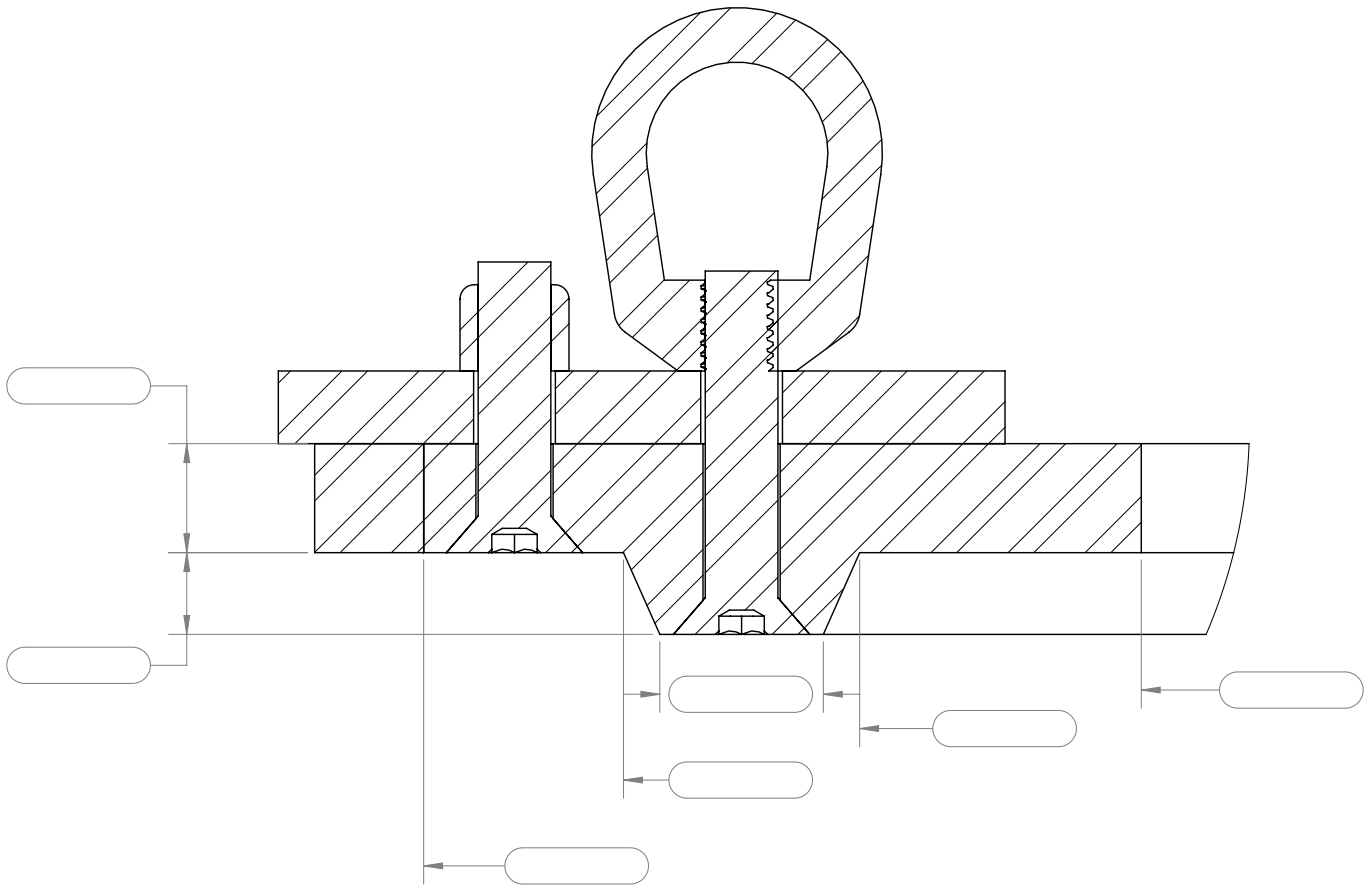


Tongue Forming Header with Lifting Eyes



Joint Rings

Fill In The Blank Worksheets



Groove Forming Header with Form Tabs and Lifting Eyes

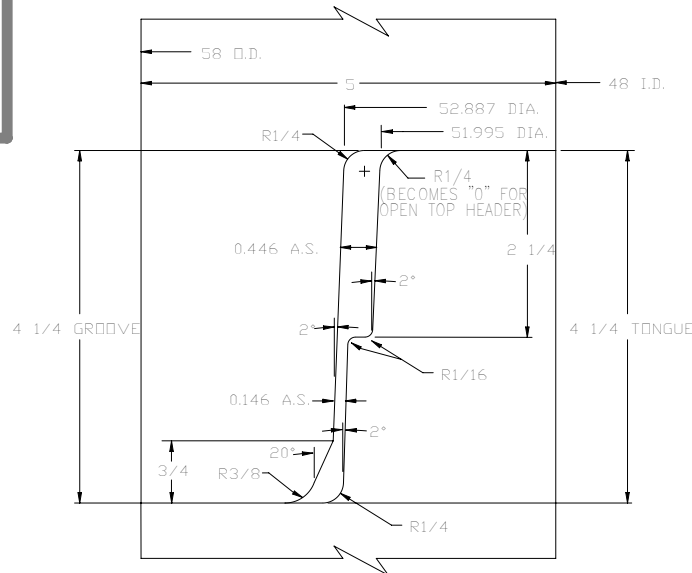


QT/TSS JOINT 48"

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48" QT/TSS
HK 165/185
JOINT DETAIL

WELDING		MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL 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: SHEET: 1 OF 1 QTY: SCALE: 1:1 SIZE A DWG NO: PD-48P-0135 REV.	AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE 1701 MOLER ROAD NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207		48" QT/HK 165/185 TSS 5" WALL	
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/TSS Joint 48"



QT/TSS JOINT 60"

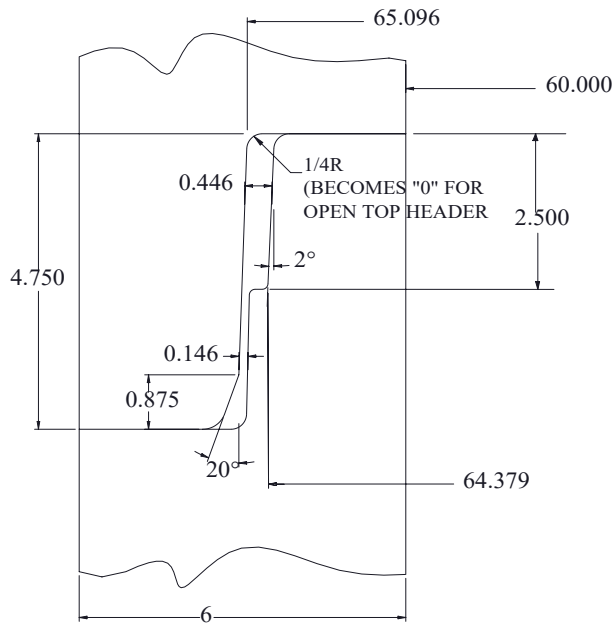
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60" QT/TSS
HK 165/185
JOINT DETAIL

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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/TSS Joint 60"

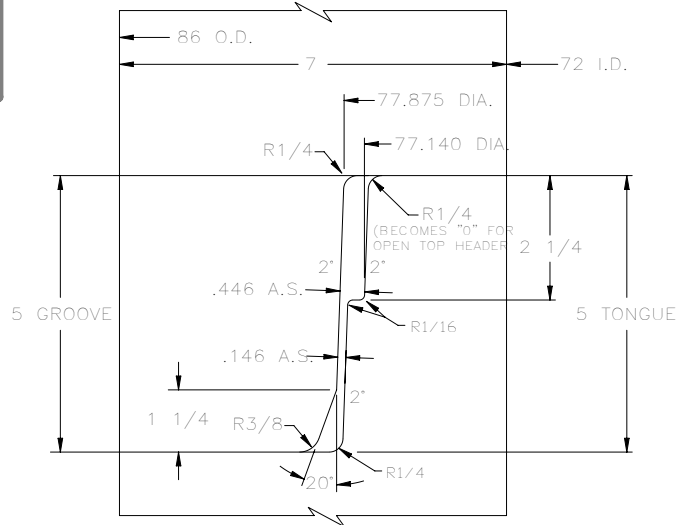


QT/TSS JOINT 72"

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72 QT/TSS
HK 165/185
JOINT DETAIL

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FAB		MACHINING				CUTTING						AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE 1701 MOLER ROAD NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207	
GENERAL TOLERANCES EXCEPT AS NOTED													
FRACTIONAL		DECIMAL			ANGULAR DEG			72" QT/HK 165/185 TSS					
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005			± 1.0°			7" WALL					

QT/TSS Joint 72"



QT/HK165-HK185 JOINT 48"

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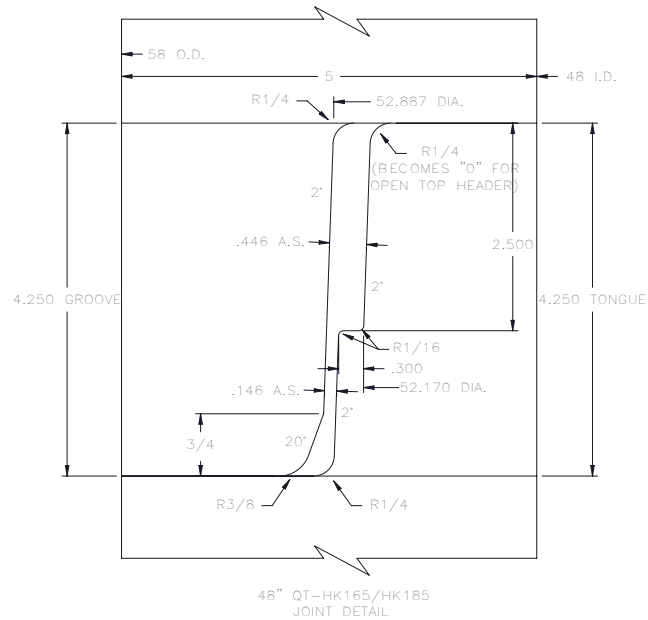
Company Name _____

Authorized Signature _____

Date _____

REVISIONS

REV.	ECR	CHANGE	BY	DATE
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WELDING		MACH		DRILL		SHAPING		CUTTING		PROPRIETARY AND CONFIDENTIAL 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: SHEET: 1 OF 1 QTY: SCALE: 1:1 SIZE A DWG NO: PD-48P-0159 REV.					
FAB		MACHINING				CUTTING					AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE 1701 MOLER ROAD NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207				
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 48"



QT/HK165-HK185 JOINT 60"

DRAWING APPROVAL

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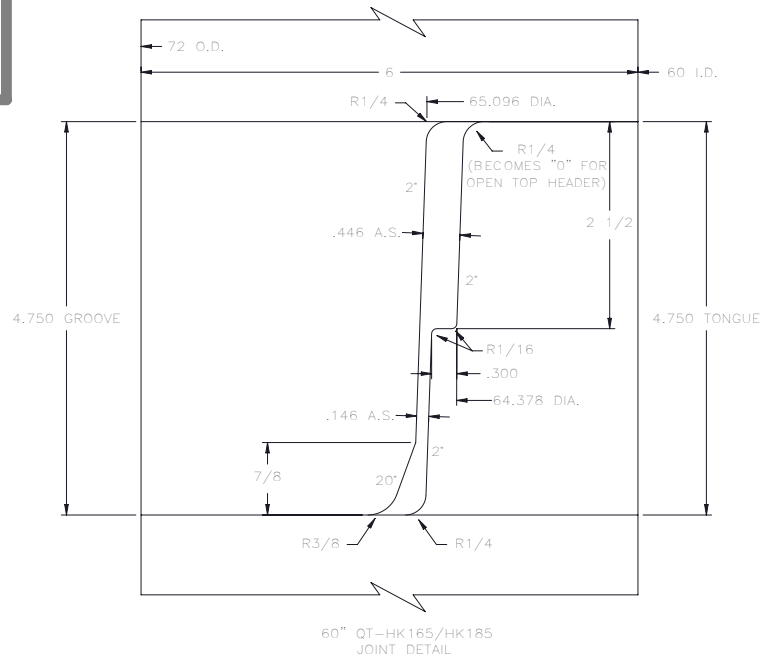
Company Name _____

Authorized Signature _____

Date _____

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WELDING	MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL 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 AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE1701 MOLER ROAD NEW HAMPTON, IOWA 50659COLUMBUS, OHIO 43207			
FAB	MACHINING		CUTTING			60" QT-HK 165/HK185			
GENERAL TOLERANCES EXCEPT AS NOTED						6" WALL			
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 A	DWG NO: PD-60P-0104	REV.

QT/HK165-HK185 JOINT 60"



QT/HK165-HK185 JOINT

72"

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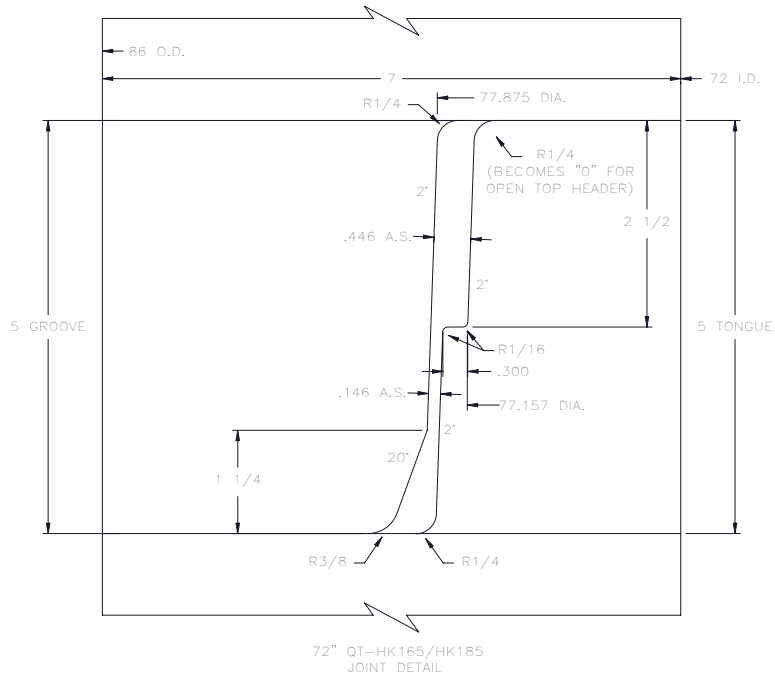
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Authorized Signature _____

Date _____

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WELDING		MACH		DRILL		SHAPING		CUTTING		PROPRIETARY AND CONFIDENTIAL 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: SHEET: 1 OF 1 QTY: SCALE: 1:1 SIZE A DWG NO: PD-72P-0113 REV.	
FAB		MACHINING				CUTTING					AFINITAS AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207
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"

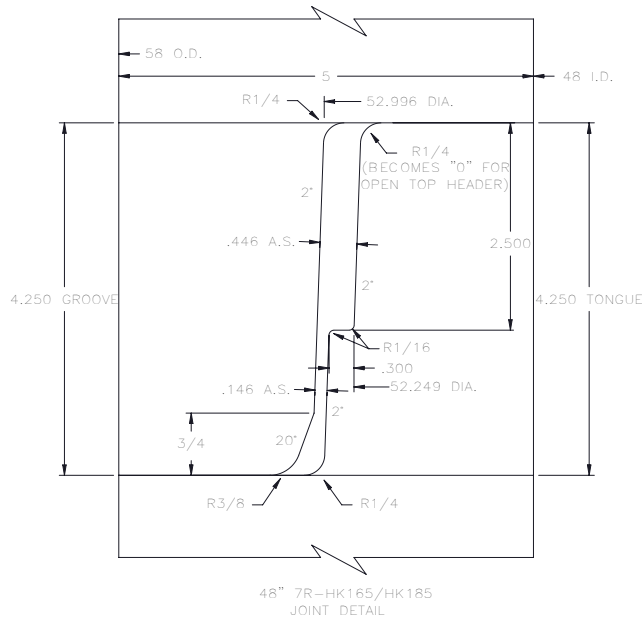
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FAB		MACHINING		CUTTING			GENERAL TOLERANCES EXCEPT AS NOTED				
FRACTIONAL		DECIMAL		ANGULAR DEG			48" 7R-HK165/HK185				
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°			5" WALL				
							SHEET: 1 OF 1	SCALE: 1:1	SIZE: A	DWG. NO: PD-48P-0158	REV.
							QTY:				

7R/HK165-HK185 JOINT 48"



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Authorized Signature _____
Date _____

72 O.D.

60 I.D.

6

65.175 DIA.

R1/4

2'

2 1/2

4.750 GROOVE

4.750 TONGUE

R1/16

.300

.64.458 DIA.

.146 A.S.

20'

7/8

R3/8

R1/4

R1/4 (BECOMES "D" FOR OPEN TOP HEADER)

60 inch 7R-HK165/HK165 JOINT DETAIL

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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" 7R-HK165/HK185 6" WALL											
							SHEET:		1 OF 1		SCALE:		SIZE		DWG NO:		REV.	
							QTY:				1:1		A		PD-60P-0105			

7R/HK165-HK185 JOINT 60"



7R/HK165-HK185 JOINT 72"

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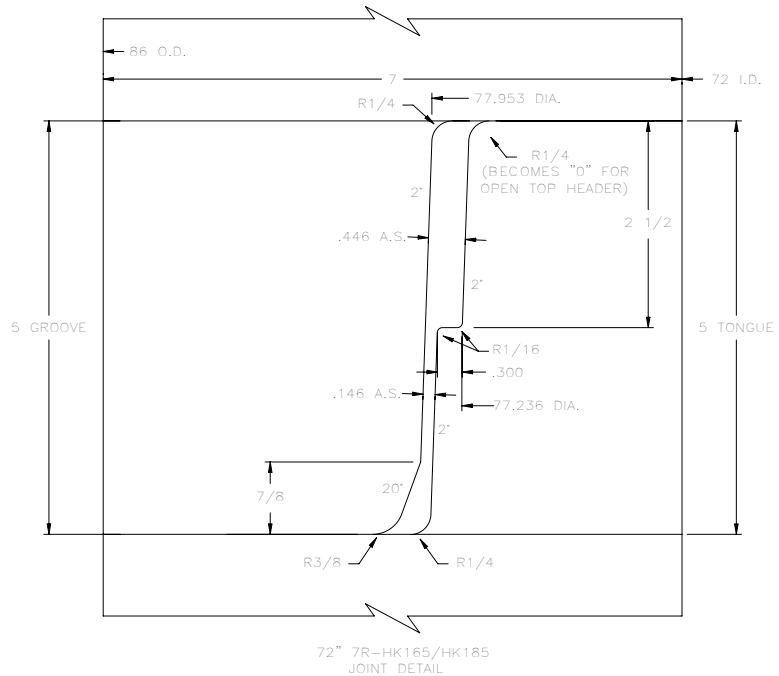
Company Name _____

Authorized Signature _____

Date _____

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WELDING	MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL 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 72" 7R-HK165/HK185 7" WALL SHEET: 1 OF 1 QTY: SCALE: 1:1 SIZE: A DWG. NO: PD-72P-0114 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°											

7R/HK165-HK185 JOINT 72"



7R/HK200L JOINT 84"

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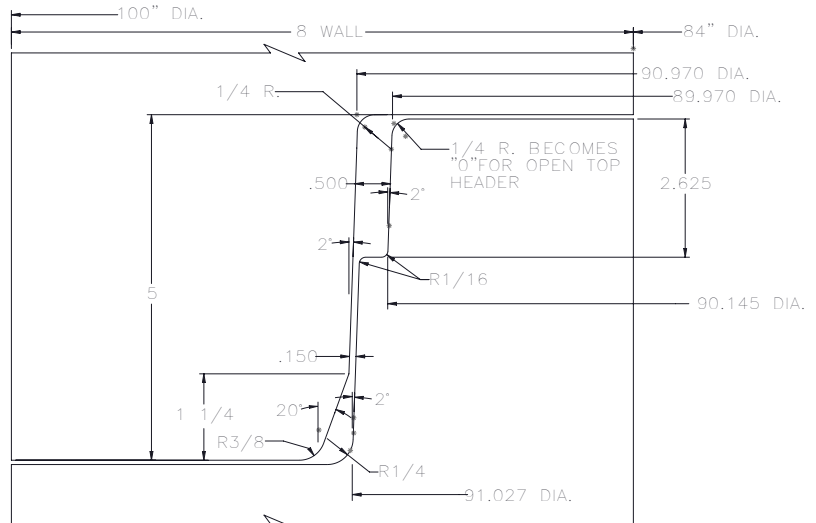
Company Name _____

Authorized Signature _____

Date _____

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84" 7R-HK200L
JOINT DETAIL

WELDING		MACH	DRILL	SHAPING		CUTTING	PROPRIETARY AND CONFIDENTIAL 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: SHEET: 1 OF 1 QTY: SCALE: 1:1 SIZE A DWG NO: 84 7R-HK200L REV.	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°					

7R/HK200L JOINT 84"



7R/HK200L JOINT 96"

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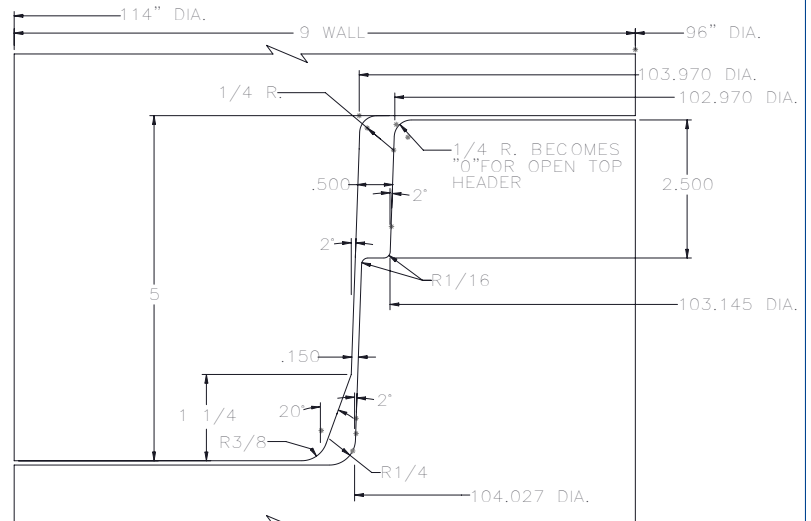
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Date _____

REVISIONS				
REV.	ECR	CHANGE	BY	DATE



96" 7R-TSS 200L
JOINT DETAIL

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FAB	MACHINING		CUTTING			96" - 7R/200L TSS 8" 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 A DWG NO: 96-7R 200L TSS REV.						

7R/HK200L JOINT 96"



7R/HK200L JOINT 120"

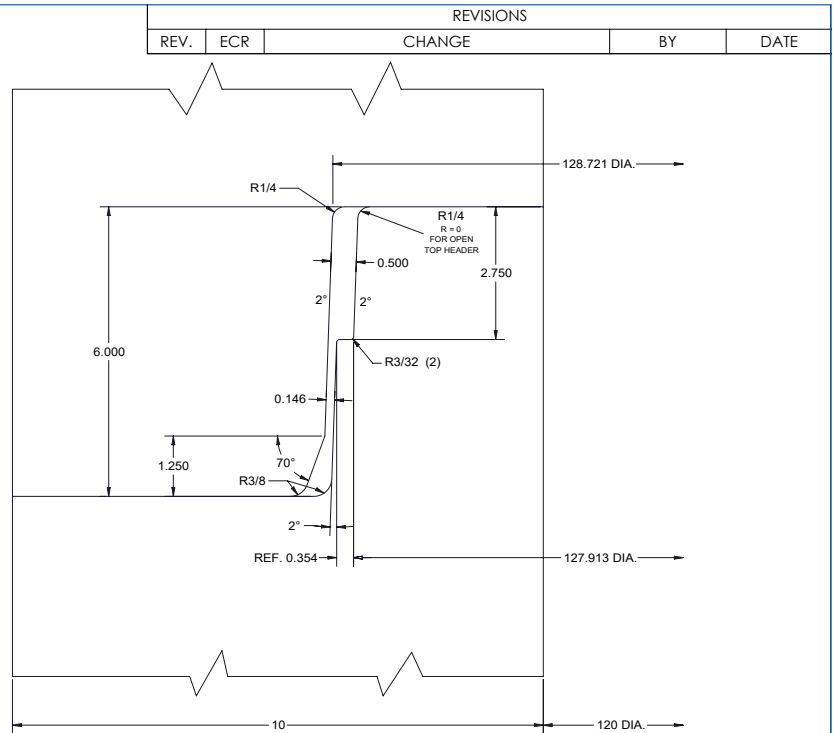
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120" 7R/TSS (200L)
JOINT DETAIL

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FAB	MACHINING		CUTTING			GENERAL TOLERANCES EXCEPT AS NOTED			
FRACTIONAL	DECIMAL		ANGULAR DEG			120" 7R/TSS 200L			
				10" 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 A	DWG NO: 120 7R TSS 200L	REV.	

7R/HK200L JOINT 120"



7R/HK200L JOINT 144"

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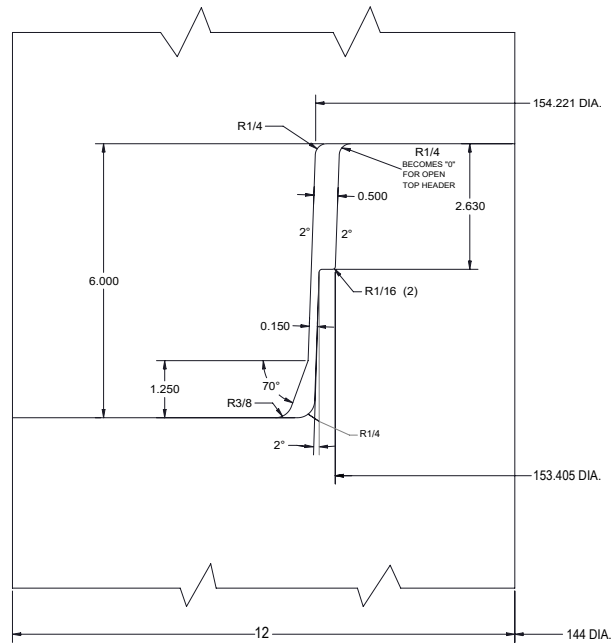
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Date _____

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144" Q7R/HK200L-TSS
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING
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FAB	MACHINING	CUTTING
-----	-----------	---------

GENERAL TOLERANCES EXCEPT AS NOTED

FRACTIONAL	DECIMAL	ANGULAR DEG
------------	---------	-------------

$X \pm 1/16$	$X.X \pm 0.030$ $X.XX \pm 0.015$ $X.XXX \pm 0.005$	$\pm 1.0^\circ$
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DATE:

WEIGHT: LBS

JOB NO:



AFINITAS
FORMING SYSTEMS DIVISION

928 WEST MILWAUKEE 1701 MOLER ROAD
NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207

144 Q7R HK200L-TSS
12" WALL

SHEET: 1 OF 1	SCALE: 1:1	SIZE A	DWG NO: 144 Q7R HK-200L-TSS	REV.
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7R/HK200L JOINT 144"



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

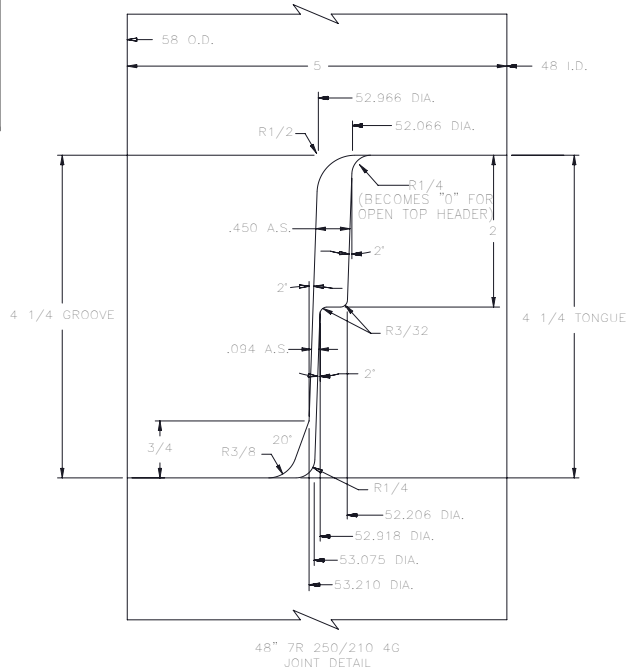
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WELDING	MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL 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			48" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/2104G GASKET 5" WALL			
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°						
DRAWN BY:					DATE:				
WEIGHT: LBS									
JOB NO:					SHEET: 1 OF 1	SCALE: 1:1	SIZE A	DWG. NO: PD-48P-0067	REV.

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



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

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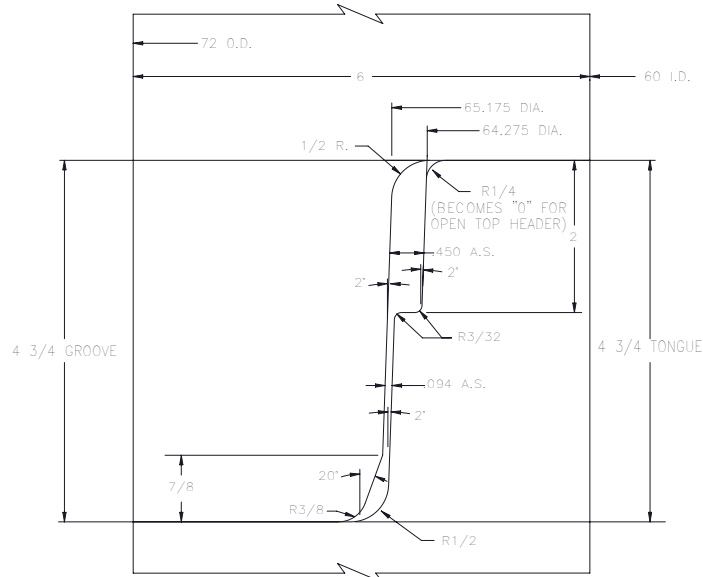
Company Name _____

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Date _____

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60" 7R 250/210 4G
JOINT DETAIL

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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°													

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



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

DRAWING APPROVAL

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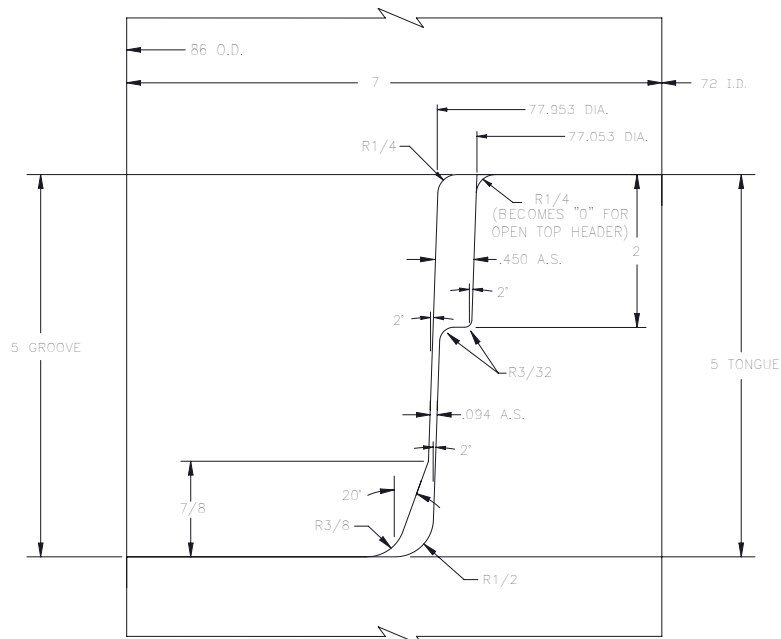
Company Name _____

Authorized Signature _____

Date _____

REVISIONS

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

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FAB		MACHINING		CUTTING							AFINITAS AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207				
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°											

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



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

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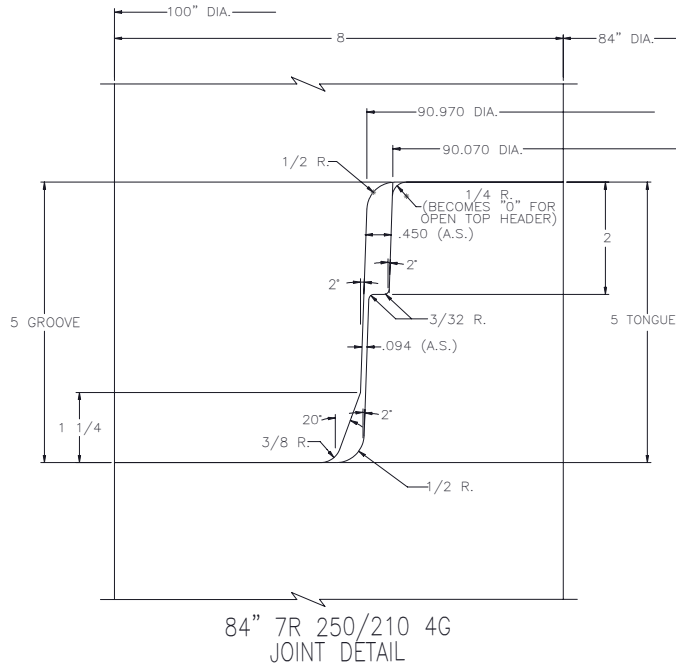
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FAB	MACHINING		CUTTING					AFINITAS AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207			
GENERAL TOLERANCES EXCEPT AS NOTED											
FRACTIONAL		DECIMAL		ANGULAR DEG		84" SINGLE OFFSET 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 °							

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



7R/250-210-4G JOINT

96"

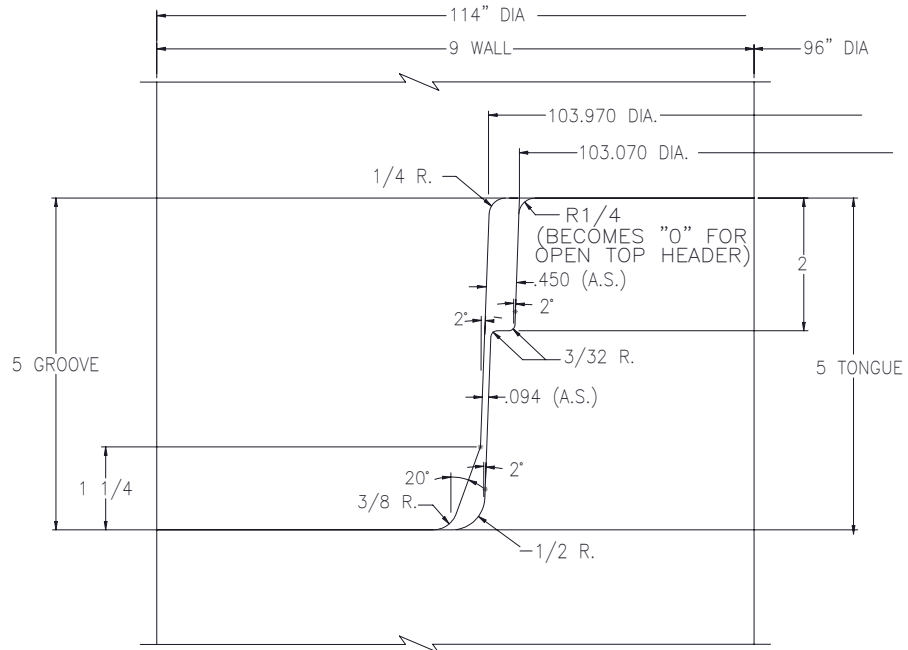
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96 QUINN 7R 250-4G
JOINT DETAIL

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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°									
AFINITAS AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207 96" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/210 4G GASKET 9"WALL														

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

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

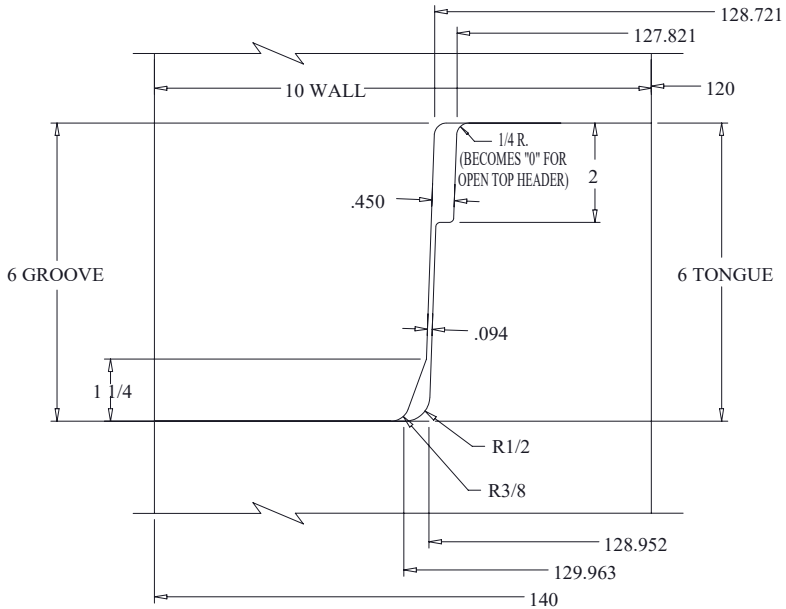


7R/250-210-4G JOINT 120"

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120 JOINT DETAIL
QUINN 7R / 250-4G

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FAB	MACHINING		CUTTING			120" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/210 4G GASKET 10" WALL			
GENERAL TOLERANCES EXCEPT AS NOTED									
FRACTIONAL	DECIMAL		ANGULAR DEG			SCALE: 1:1 SIZE A DWG NO: PD-120P-0025 REV.			
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°						

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



7R/288-4G JOINT 144"

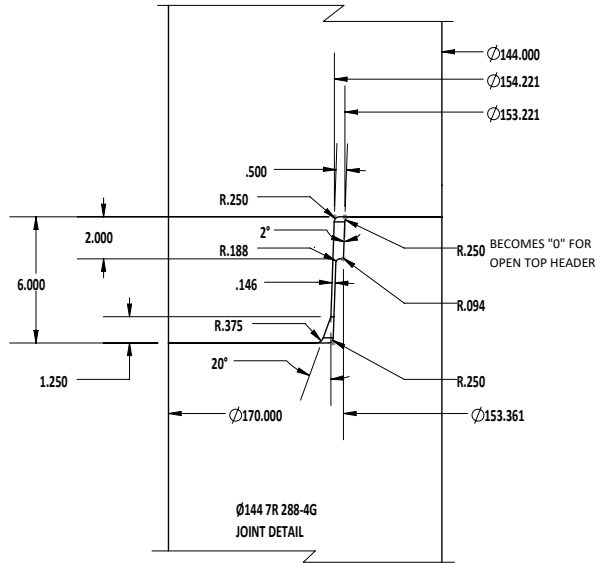
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WELDING		MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: 217777.82 LBS JOB NO:		AFINITAS 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°									
						144-7R-288-4G		13" WALL					
						SHEET: 1 OF 1		SCALE: 1:64		SIZE A			
						QTY:		DWG NO: 144-7R-288-4GDETAIL		REV.			

7R/288-4G JOINT 144"

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



7R/288-4G JOINT 84"

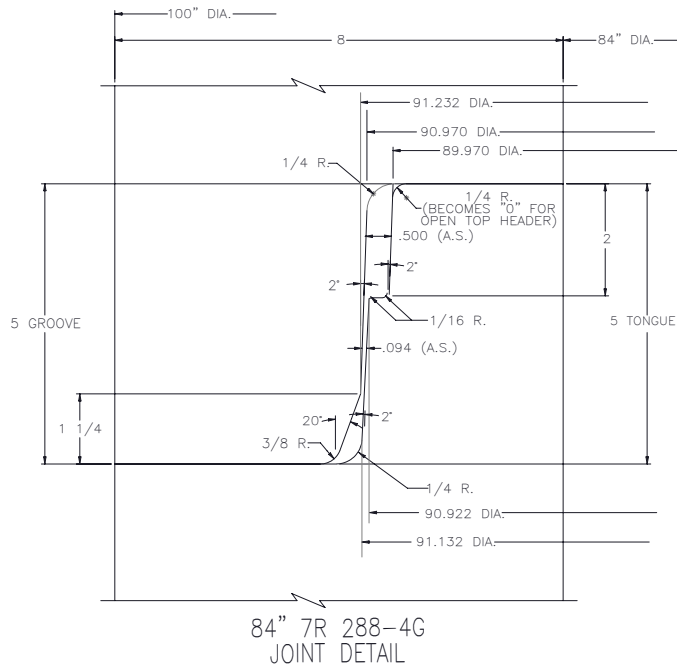
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FAB		MACHINING		CUTTING											
GENERAL TOLERANCES EXCEPT AS NOTED															
FRACTIONAL		DECIMAL		ANGULAR DEG											
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°											
AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207 84" 7R 288-4G 8" WALL															

7R/288-4G JOINT 84"

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



7R/288-4G JOINT 96"

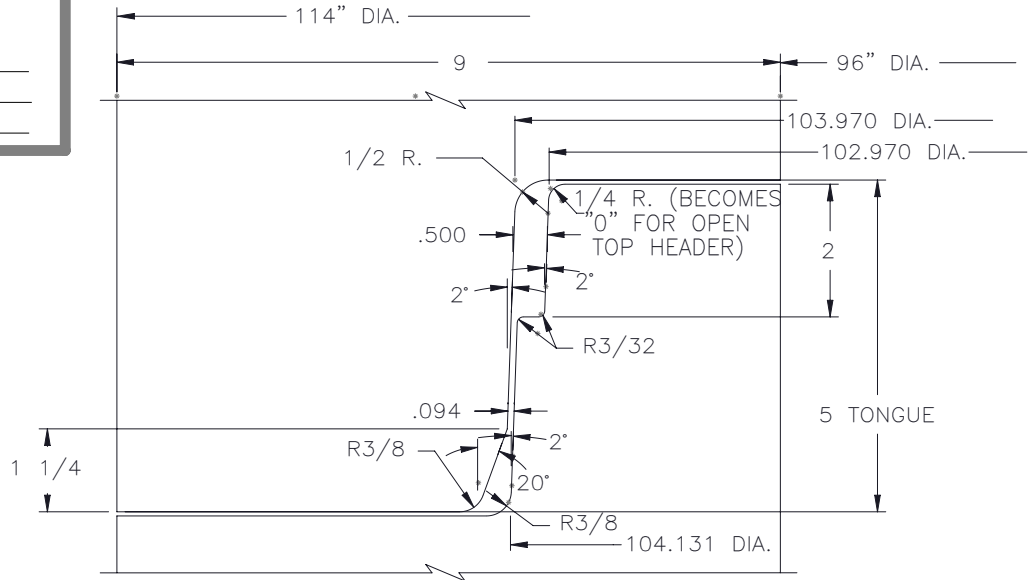
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JOINT DETAIL

QUINN 7R / PRESS SEAL 288-4G

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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°											

7R/288-4G JOINT 96"

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



7R/288-4G JOINT 120"

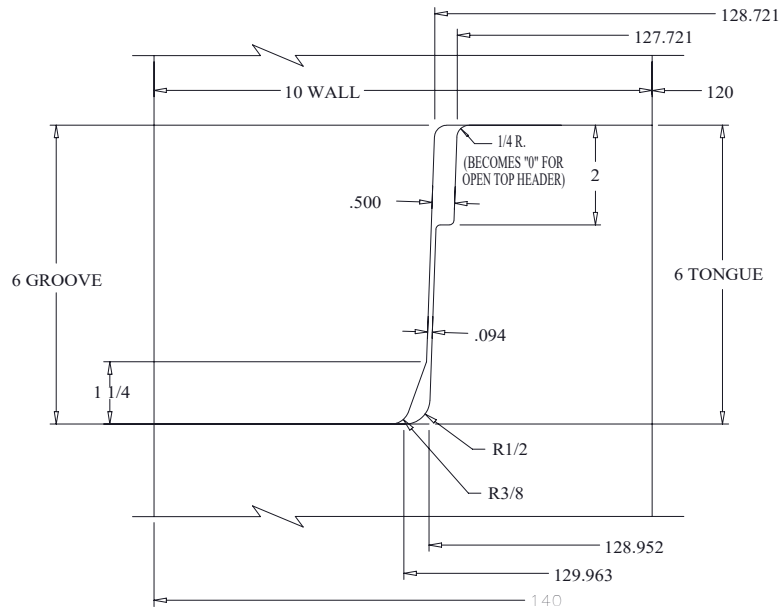
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FAB		MACHINING		CUTTING									
GENERAL TOLERANCES EXCEPT AS NOTED													
FRACTIONAL		DECIMAL		ANGULAR DEG									
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°									

7R/288-4G JOINT 120"

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



7R/288-4G JOINT 144"

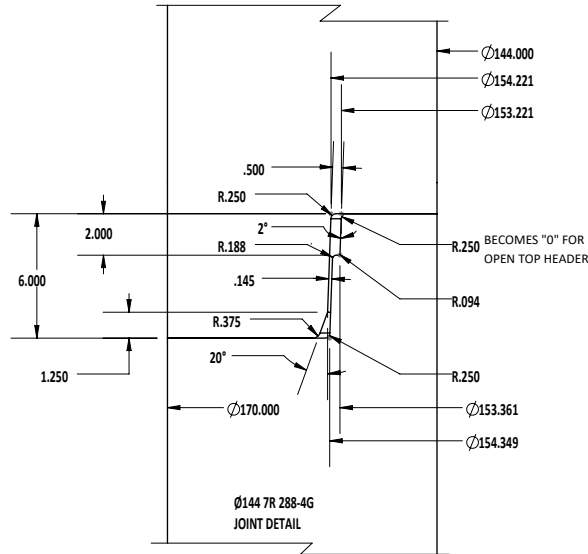
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FAB		MACHINING		CUTTING											
GENERAL TOLERANCES EXCEPT AS NOTED															
FRACTIONAL		DECIMAL		ANGULAR DEG											
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°											

7R/288-4G JOINT 144"

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



SHORT S/O JOINT 48"

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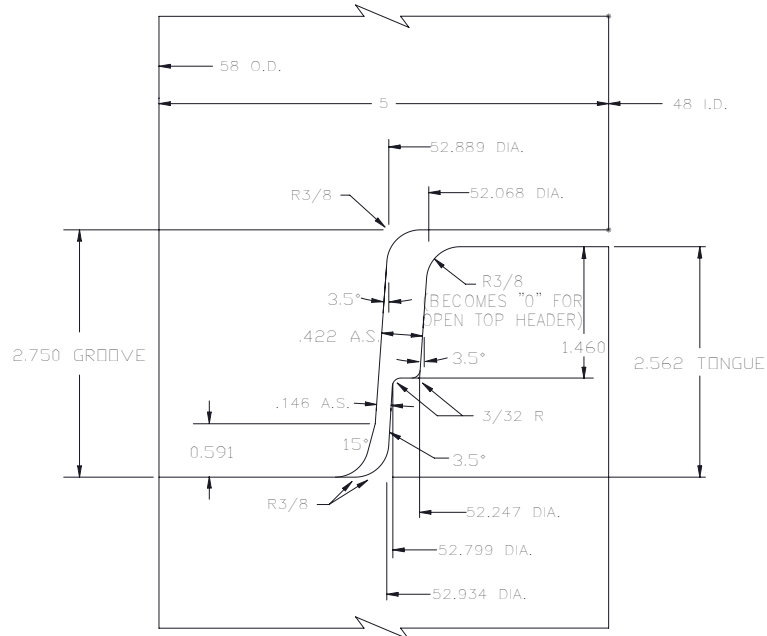
Company Name _____

Authorized Signature _____

Date _____

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48" F-114 SJ
JOINT DETAIL

WELDING		MACH		DRILL		SHAPING		CUTTING		PROPRIETARY AND CONFIDENTIAL 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: SHEET: 1 OF 1 QTY: SCALE: 1:1 SIZE A DWG NO: PD-48P-0138 REV.									
FAB		MACHINING				CUTTING									AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE 1701 MOLER ROAD NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207				
GENERAL TOLERANCES EXCEPT AS NOTED															48" SHORT S/O JOINT				
FRACTIONAL		DECIMAL				ANGULAR DEG				5" WALL									
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"

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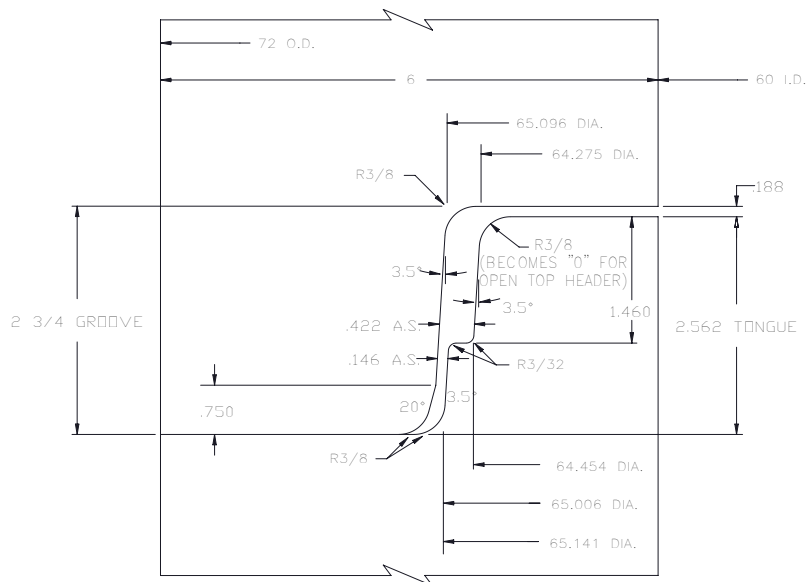
Company Name _____

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Date _____

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

WELDING		MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL 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 AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659 1701 MOLER ROAD COLUMBUS, OHIO 43207		60" SHORT S/O JOINT 6" WALL					
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°										
							SHEET: 1 OF 1	SCALE: 1:1	SIZE A	DWG NO: PD-60P-0102	REV.			
							QTY:							

SHORT S/O JOINT 60"



SHORT S/O JOINT 72"

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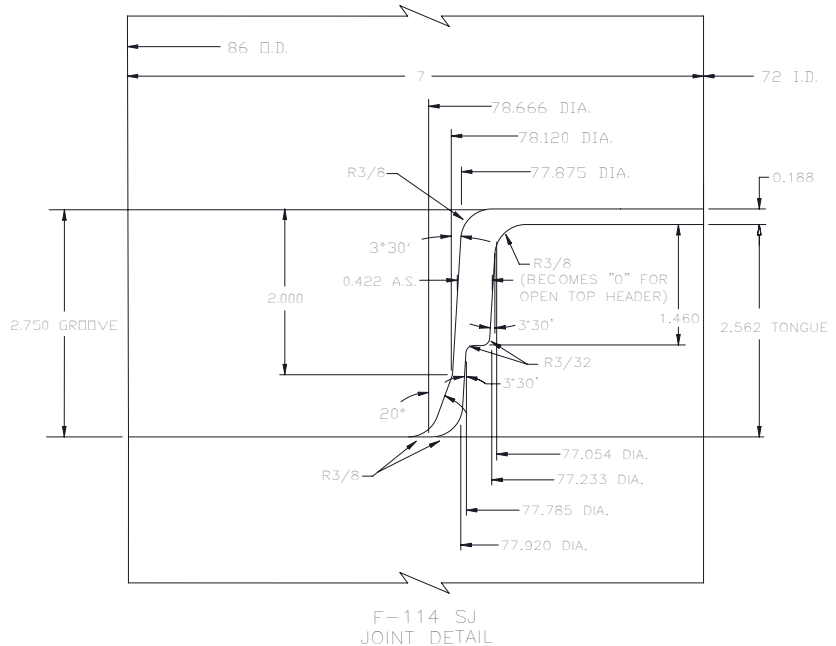
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FAB		MACHINING		CUTTING													GENERAL TOLERANCES EXCEPT AS NOTED							
FRACTIONAL		DECIMAL		ANGULAR DEG																				
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0 °																				

SHORT S/O JOINT 72"



1M MORTAR JOINT 48"

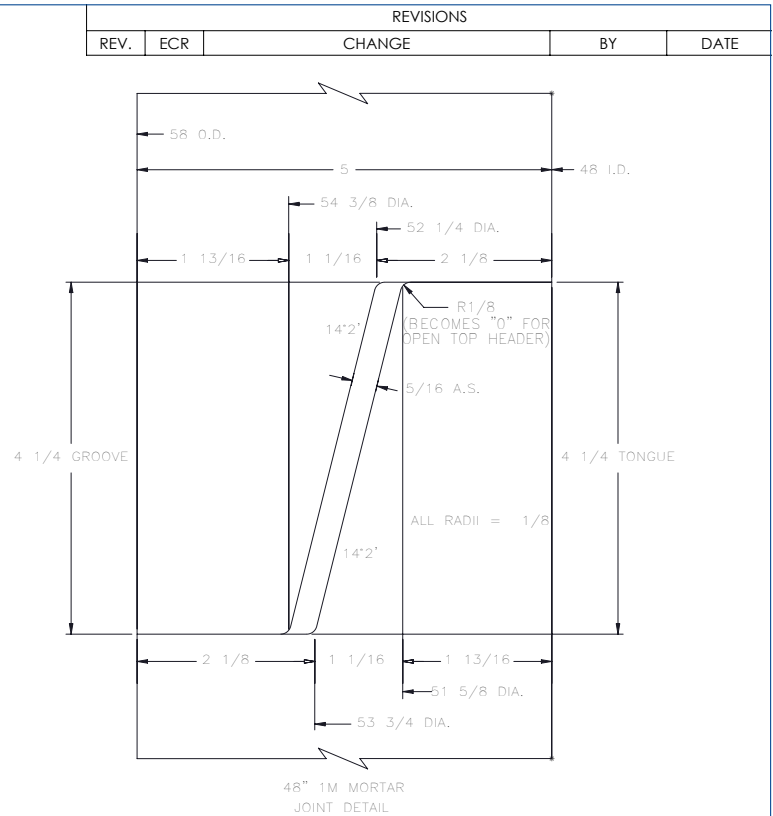
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FAB	MACHINING		CUTTING			GENERAL TOLERANCES EXCEPT AS NOTED				
FRACTIONAL	DECIMAL		ANGULAR DEG			48" 1M MORTAR JOINT				
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0 °		5" WALL				
						SHEET: 1 OF 1	SCALE: 1:1	SIZE A	DWG NO: PD-48P-0157	REV.

1M MORTAR JOINT 48"



1M MORTAR JOINT 60"

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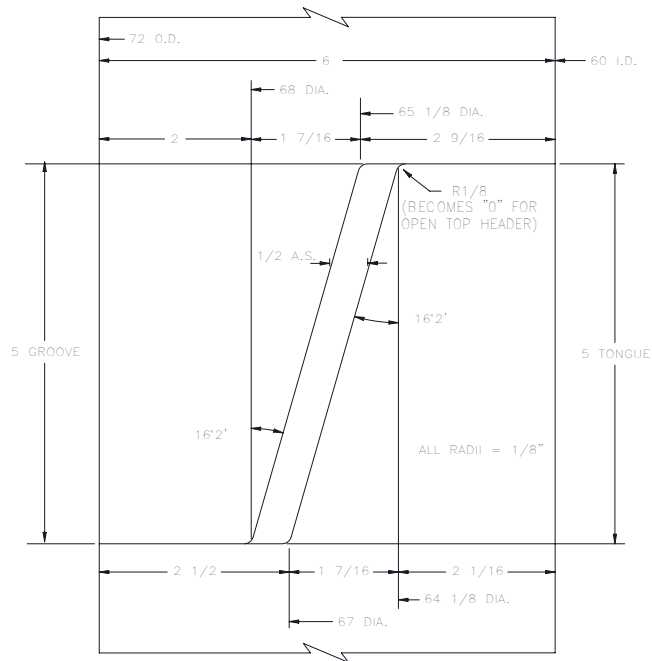
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Date _____

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60" 1M MORTAR
JOINT DETAIL

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FAB		MACHINING		CUTTING			GENERAL TOLERANCES EXCEPT AS NOTED			
FRACTIONAL		DECIMAL		ANGULAR DEG			60" 1M MORTAR JOINT			
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0 °			6" WALL			

1M MORTAR JOINT 60"



1M MORTAR JOINT 72"

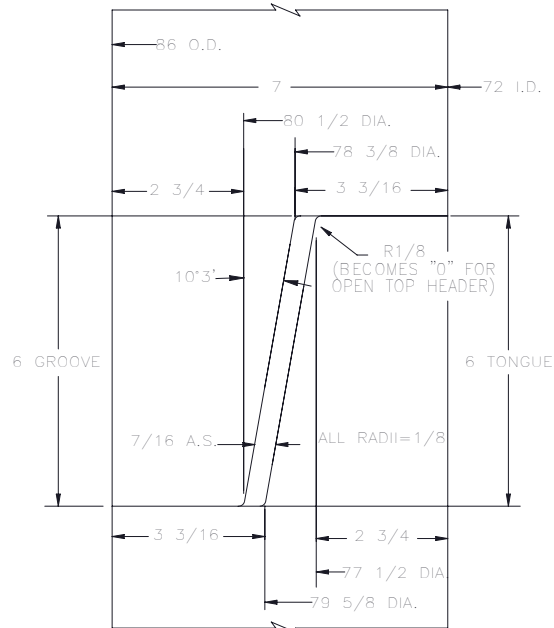
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72" 1M
MORTAR JOINT

WELDING		MACH	DRILL	SHAPING	CUTTING	PROPRIETARY AND CONFIDENTIAL 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		72" MORTAR JOINT-Q1M 7" WALL		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°											
						SHEET: 1 OF 1		SCALE: 1:1		SIZE A		DWG NO: PD-72P-0095			

1M MORTAR JOINT 72"



3M MORTAR JOINT 48"

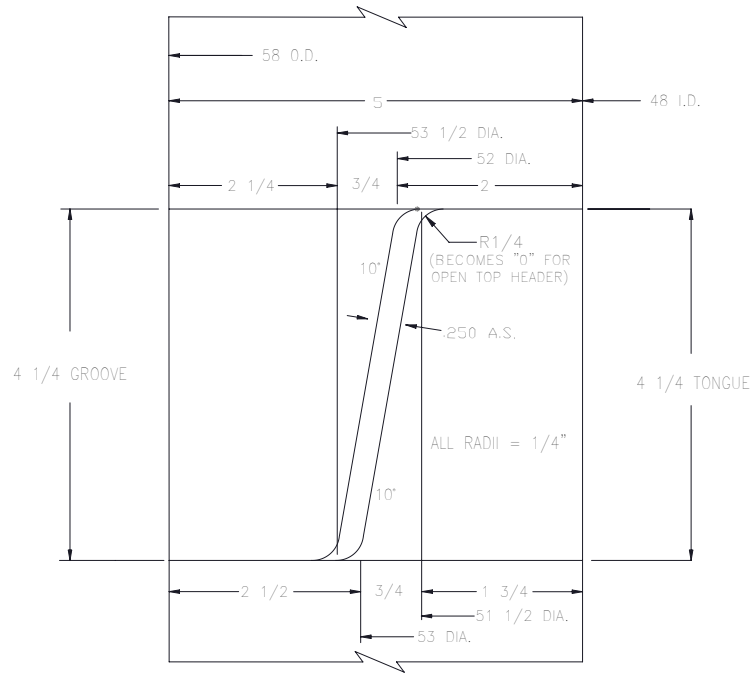
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48" 3M MORTAR
JOINT DETAIL

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FAB	MACHINING		CUTTING															
GENERAL TOLERANCES EXCEPT AS NOTED								928 WEST MILWAUKEE		1701 MOLER ROAD								
								NEW HAMPTON, IOWA 50659		COLUMBUS, OHIO 43207								
FRACTIONAL		DECIMAL		ANGULAR DEG			48: 3M MORTAR JOINT DETAIL											
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°		5" WALL												
						DRAWN BY:	11/10/20											
						DATE:												
						WEIGHT:	LBS	SHEET:	1 OF 1		SCALE:		SIZE		DWG NO:		REV.	
						JOB NO:		QTY:			1:1		A	PD-48P-0152				

3M MORTAR JOINT 48"



3M MORTAR JOINT 60"

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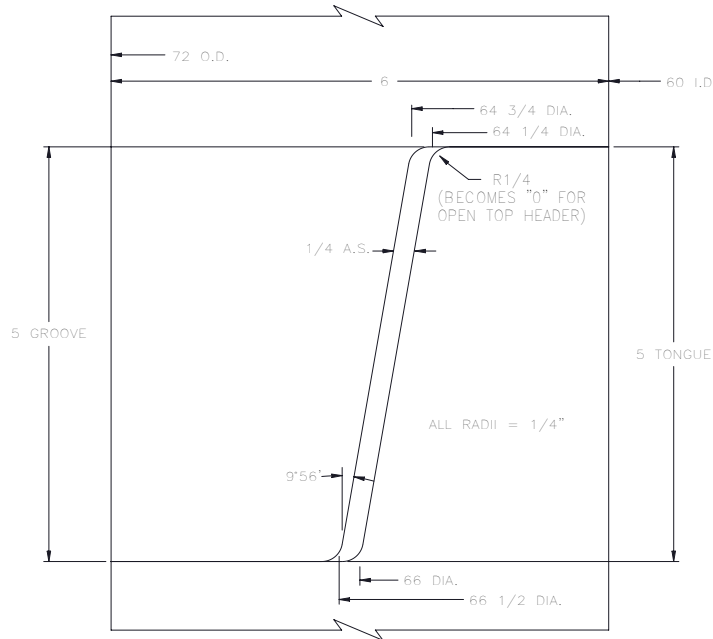
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Date _____

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REV.	ECR	CHANGE	BY	DATE
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60" 3M MORTAR
JOINT DETAIL

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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" 3M MORTAR JOINT						6" WALL		

3M MORTAR JOINT 60"



3M MORTAR JOINT 72"

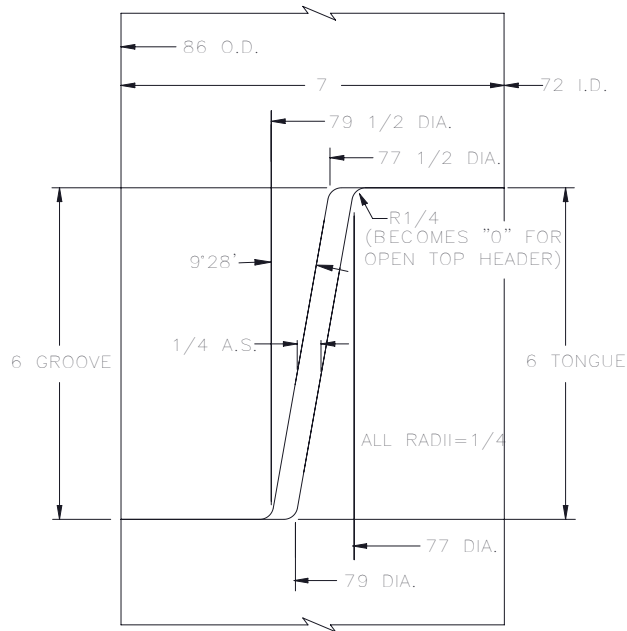
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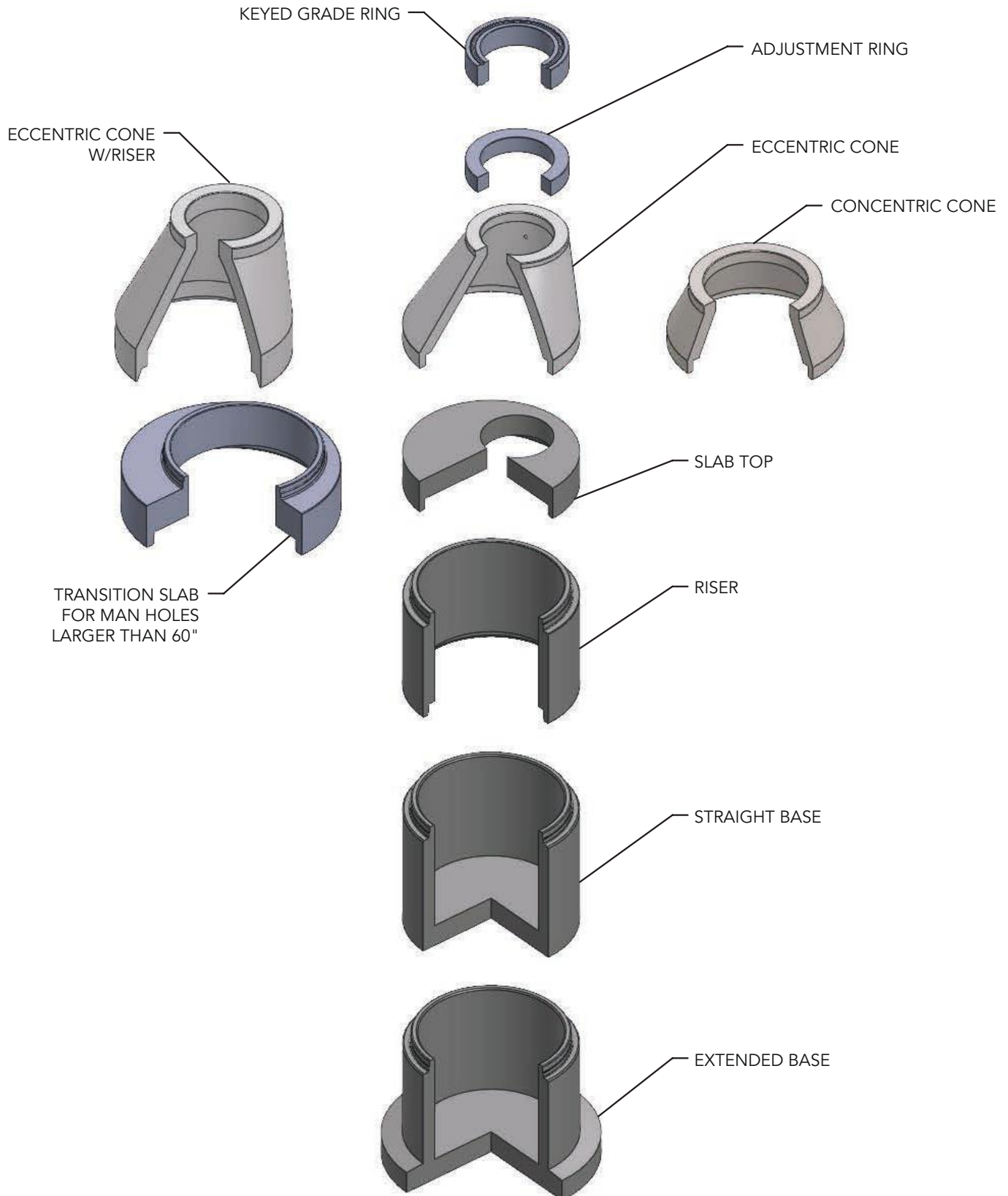
72" 3M
MORTAR JOINT

WELDING		MACH		DRILL		SHAPING		CUTTING		PROPRIETARY AND CONFIDENTIAL 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: SHEET: 1 OF 1 QTY: SCALE: 1:1 SIZE A DWG NO: PD-72P-0112 REV.						
FAB		MACHINING				CUTTING					AFINITAS FORMING SYSTEMS DIVISION 928 WEST MILWAUKEE 1701 MOLER ROAD NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207					
GENERAL TOLERANCES EXCEPT AS NOTED											72" MORTAR JOINT-Q3M					
FRACTIONAL		DECIMAL				ANGULAR DEG					7" WALL					
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005				± 1.0°										

3M MORTAR JOINT 72"



Manhole Cone Stack-Up



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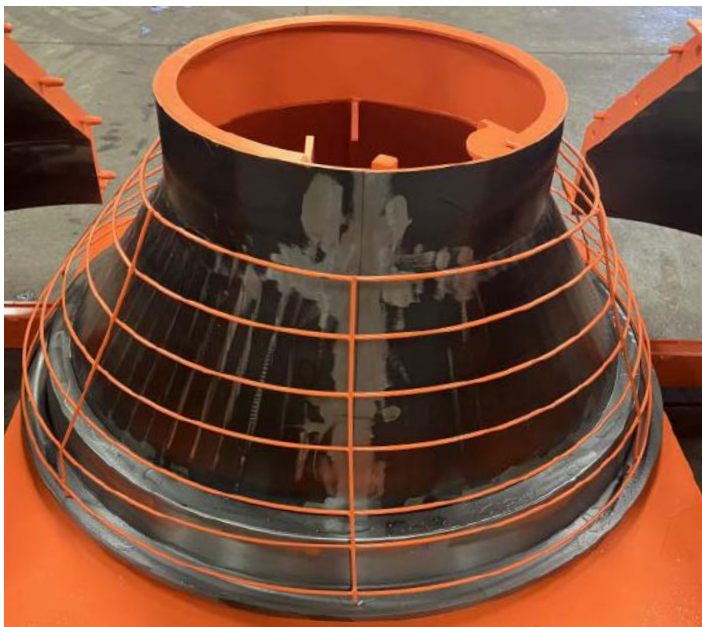
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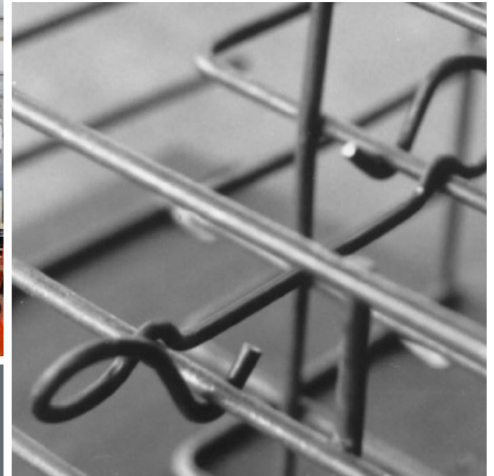


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