

[H]

WELDING PROJECT

9 RECYCLE WASTE CONTAINER

MAT. COST	LTH. OR SQ. UNITS	UNIT COST	TOTAL
	PAINT		

THIS PROJECT IS MADE FROM 20 GAUGE MILD STEEL OR COLD ROLLED METAL. A LOT OF FABRICATING IS REQUIRED. THE PARTS CAN BE MADE AND THEN TACK WELDED WITH M.I.G.

THE PROJECT IS THEN COMPLETELY WELDED USING THE OXYACETYLENE PROCESS.

ONCE THE PROJECT HAS BEEN COMPLETED, CALCULATIONS OF ITS

CAPACITY SHOULD BE MADE.

TOTAL	
P. TX.	
F. TX.	
TOTAL	

LITRES:	GALLONS:

MATERIAL LIST

20 GAUGE MILD STEEL SHEET [COLD ROLLED]

* NOTE * A JIG MAY BE CONSTRUCTED WHICH WILL SERVE TO PRODUCE THE ENDS OF THE CONTAINER. THIS JIG IS USED IN THE PRESS TO CONSTRUCT THE ENDS. THE JIG IS MADE FROM A PIECE OF 278 MM. [10 7/8"] INSIDE DIAMETER PIPE 50 MM. [2"] LONG. THIS IS THE SLEEVE INTO WHICH THE METAL IS PRESSED. THE INSERT IS MADE FROM A PIECE OF 38 MM. [1 1/2"] STEEL PLATE CUT TO 273 MM. [10 3/4"] DIAMETER. THIS PLATE IS THEN MACHINED TO A GRADUAL CURVE, 19 MM. [3/4"] AT THE OUTSIDE.

ENDS TWO REQUIRED 267 MM. [10 1/2"] DIAMETER. CENTRE THIS METAL ON THE SLEEVE AND PRESS THE PLATE AND METAL THROUGH THE SLEEVE. PLACE A 25 MM. [1"] DIAMETER HOLE IN THE GAUGE METAL CENTERED AT 37 MM. [1 1/2"] FROM THE INSIDE EDGE OF THE PAN.

SIDE ONE PIECE 200 MM. X 915 MM. [8" X 36"]. PLACE A 25 MM. [1"] DIAMETER HOLE AT 457 MM. FROM THE END AND CENTERED 38 MM. FROM THE EDGE. ROLL THE METAL UNTIL AN INSIDE DIAMETER OF 273 MM. [10 3/4"] IS REACHED.

ASSEMBLE CLAMP THE UNIT TOGETHER SO THAT AN EDGE JOINT IS SET ON EACH END. THE INSIDE DRAIN HOLE IS SET 100 MM. [4"] BACK FROM THE DRAIN HOLE. THIS IS TO ALLOW THE LIQUID TO BE Poured FROM THE CONTAINER WITHOUT POURING FROM THE IN HOLE. CLAMP THE METAL SO THE OVERLAP OCCURS ON THE BOTTOM SIDE. TACK WELD THE UNIT TOGETHER. COMPLETELY WELD THE JOINTS. A TROUGH MAY BE DOWELLED [HAMMERED] SOFTELY FROM THE CENTRE TO THE HOLE. THIS WILL ALLOW ALL OF THE LIQUID TO DRAIN FROM THE PAN. ANOTHER METHOD OF PRODUCING THIS SLOPE IS TO PREFORM ONE SHEET AND PRESS IT SO THAT A HIGHER EDGE WILL BE SET ON THE HOLE SIDE.

SPOUT CUT THE METAL TO THE SIZE SPECIFIED ON THE DRAWING. ROLL THE METAL SO THE EDGES BUTT EACH OTHER. FIRST TACK WELD, THEN COMPLETELY WELD THE JOINT. AT THE MIDPOINT OF THE SPOUT CUT COMPLETELY THROUGH AT AN ANGLE OF 22.5°. ROTATE THE END ONE FULL TURN AND TACK WELD THE END BACK TOGETHER. COMPLETELY WELD THE JOINT. TACK WELD THE SPOUT IN PLACE WITH THE OUT END AT THE OUTER EDGE OF THE UNIT. WELD COMPLETELY.

HANDLE CONSTRUCT THE HANDLE USING THE SAME PROCESS USED FOR THE TRAY HANDLE. CHECK LENGTH.

BASE THE BASE SHOULD BE CUT SO IT IS 10 MM. NARROWER ON EACH THAN THE UNIT. IT SHOULD NOT EXTEND OUTSIDE AT ANY POINT. SEE DRAWING VIEW FOR LOCATION AND SHAPE.

EVALUATION	PROJ. SHT: / 10	WELD QUAL.: / 50	APPEARANCE: / 30	FINISH: / 10	MK:
NAME:	START DATE:	COMPLETION DATE:	HOURS:		

