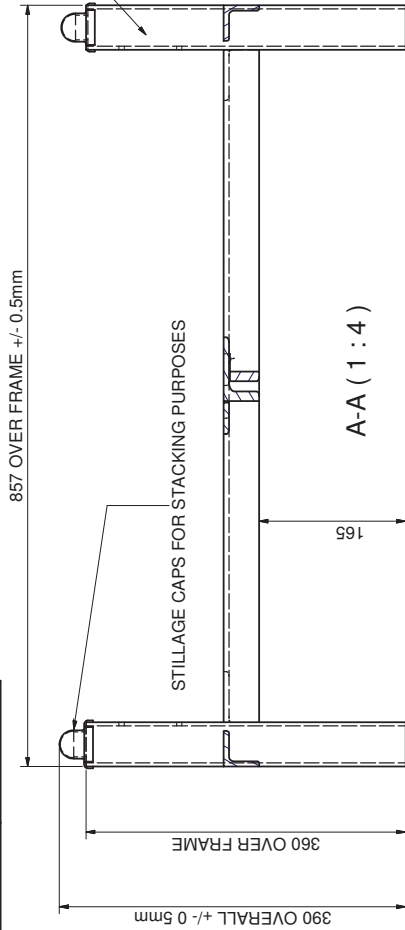
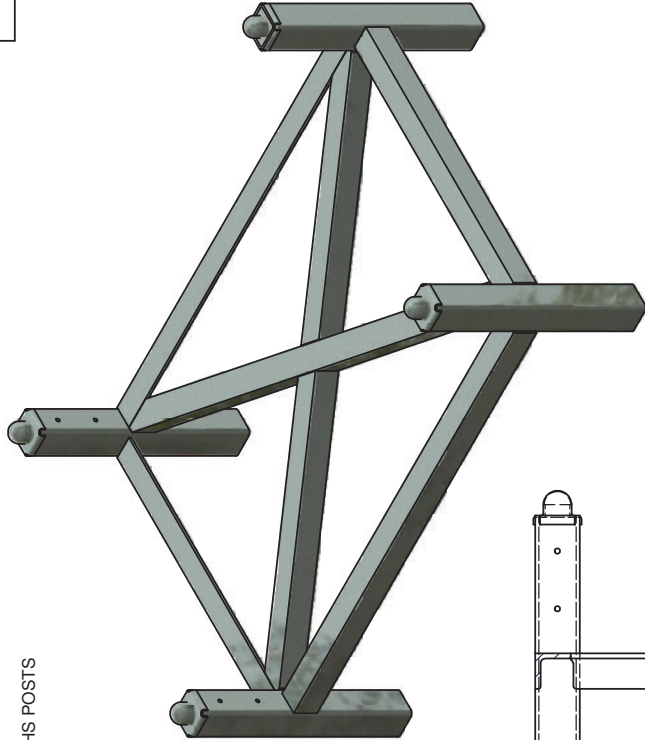


IF IN DOUBT ASK | DO NOT SCALE

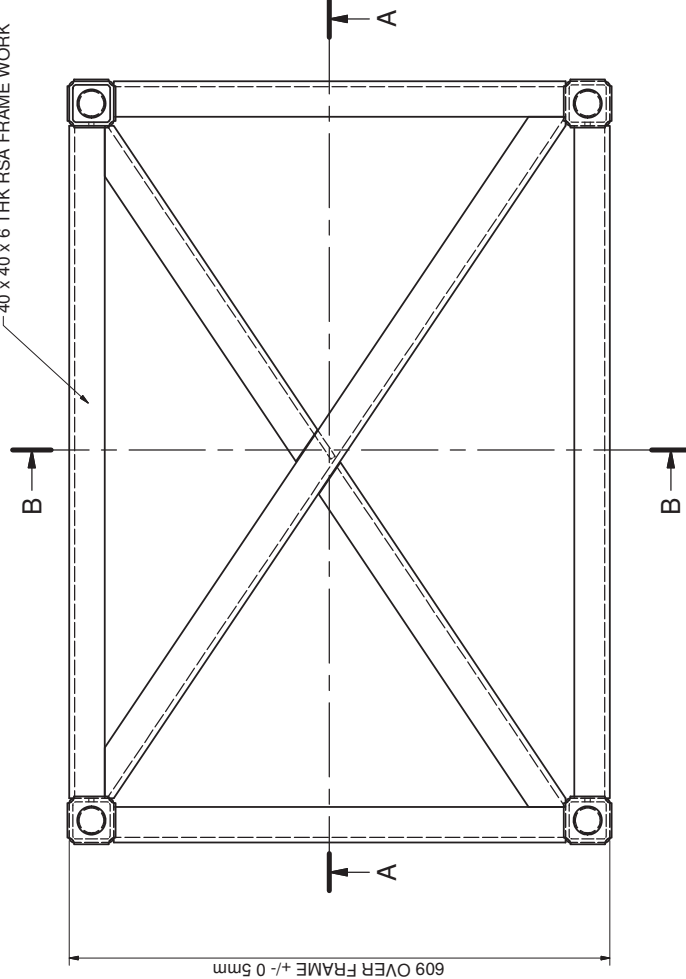
ALL DIMENSIONS IN MM UNLESS OTHERWISE STATED



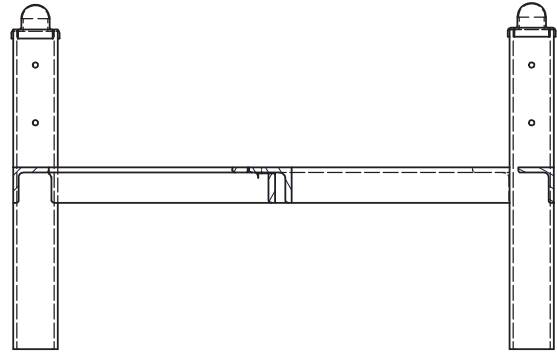
50 x 50 x 3.5 THK SHS POSTS



40 x 40 x 6 THK RSA FRAME WORK



B-B (1 : 4)



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 RETURNABLE ON REQUEST

REFERENCE ONLY

FABRICATION TOLERANCES AS PER THE DWG

Part Loading XX

Clear Opening 857 x 609

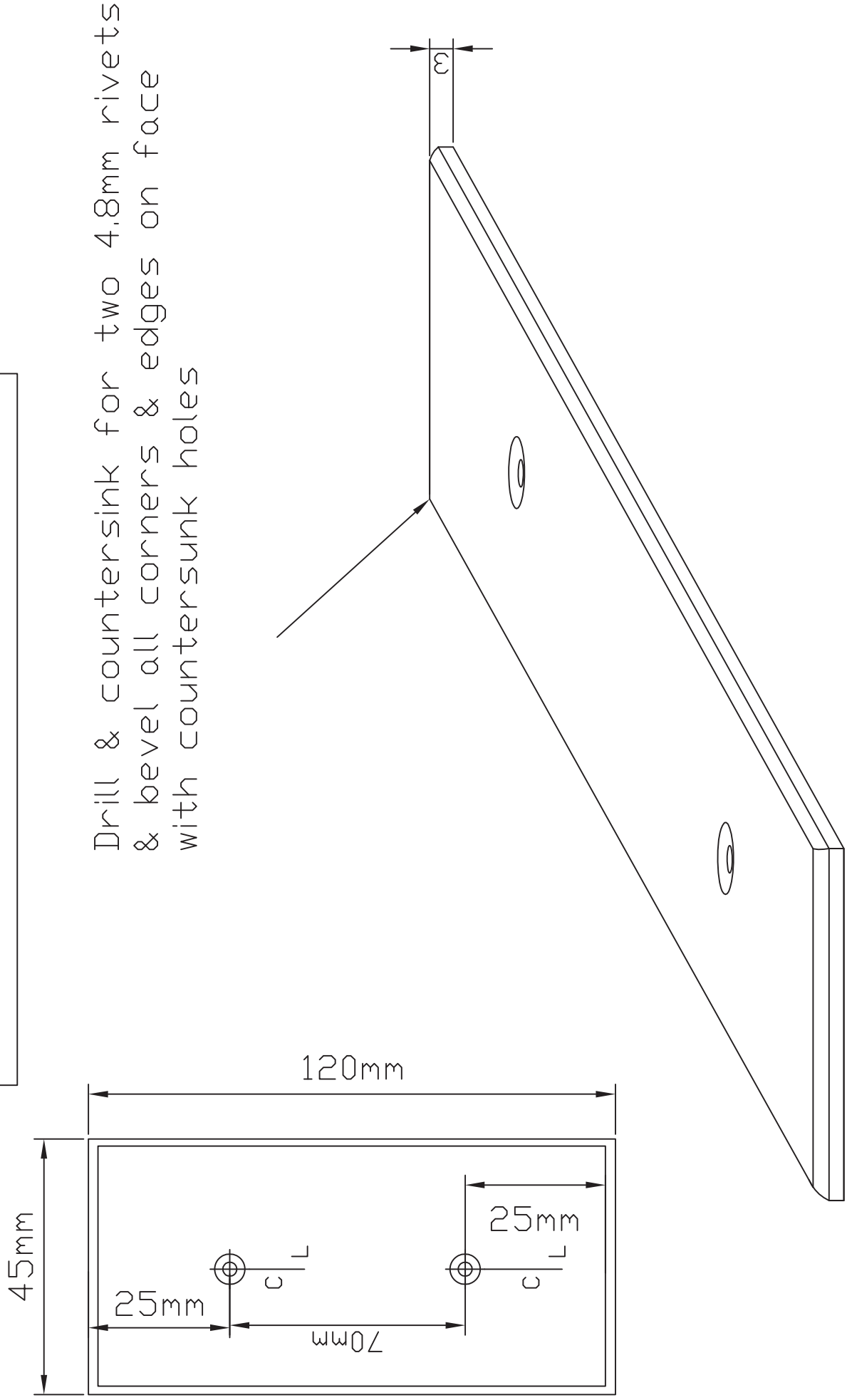
Drawing Title

Project BANK OF ENGLAND  
 Product Description BANK OF ENGLAND PALLET  
 Filename & Path

**Bank of England**  
 Threadneedle Street  
 London  
 EC2R 6AH  
 TEL : 0207 601 4444

Drawn by [Redacted] Date 8-03-2011  
 Quote Ref No XXX Order No [Redacted] Dtd Line XX  
 Drawing No Product Code BOE-PALLET Revision No A2 Sheet No X of X  
 PLEASE RETURN OR DESTROY PREVIOUS ISSUES

DWG DST220811/3/a  
B of E protector strip  
Material :- Type 6 Nylon

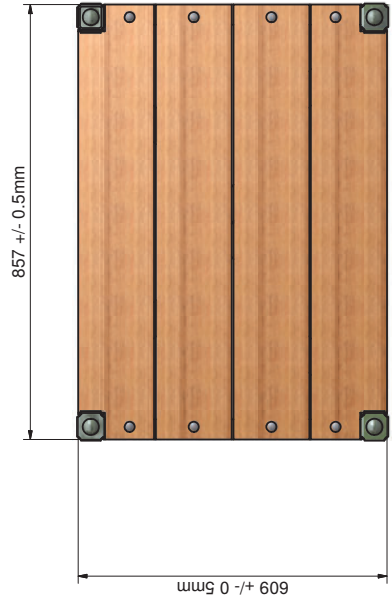


Drill & countersink for two 4.8mm rivets  
& bevel all corners & edges on face  
with countersunk holes

NOTE:- RIVET HEADS TO BE .5mm BELOW FACE OF PAD

8 IF IN DOUBT ASK DO NOT SCALE

3 ALL DIMENSIONS IN MM UNLESS OTHERWISE STATED



PLAN VIEW ( 1 : 7 )

- STILLAGES OVERALL SIZE 857 x 609
- MILD STEEL FABRICATED STILLAGE
- 4-OFF WOODEN SLATS FIXED TO THE STEEL OUTER ANGLE THROUGH M8 DIA DOME HEADED BOLTS.
- SLATS 21mm THICK MACHINED FROM RED HARD WOOD (TBC)
- 4-OFF PLASTIC OR NYLON WEAR STRIPS FITTED TO POSTS
- STILLAGE SUPPLIED WITH STILLAGE CAPS FOR STACKING PURPOSES
- STILLAGE POWER COATED BLUE IN LINE WITH CURRENT PAINT COLOUR

REFERENCE ONLY

FABRICATION TOLERANCES AS PER DWG

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Project	BANK OF ENGLAND	Clear Opening	857 x 609	Face Loading	XX
Product Description	BANK OF ENGLAND PALLET				
Filename & Path					

Bank of England Threadneedle Street London EC2R-6AH		Drawn by	Order No	Date	8-03-2011
	TEL : 0207 601 4444	Quote Ref No	XXX	Order No	XXX
		Drawing No/Product Code	BOE-PALLET		Sheet No
		Revision No	A2	Revision No	X of X

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# **Bank of England – Stillage Specification**

## **1. Scope**

This specification outlines the general requirements for the supply and manufacture of stillages to the Bank of England.

## **2. Materials**

All stillages to be fabricated from steel conforming to BS EN 10025, BS EN 10210-1, BS EN 10219-1, BS EN 10130 or BS EN 10056.

All wood supplied for the bases shall be of a red hardwood origin, kiln dried and have a minimum density of 530kg/m<sup>3</sup>.

All fixings shall be stainless steel grade A2.

Nylon wear strips shall be manufactured from a high wear resistant nylon “type 6”.

## **3. Welding**

The specification and qualification of welding procedures for shall conform to BS EN ISO 15609.

The fabrication of fusion welded component parts shall be undertaken by a welder approved by the procedures in BS EN 287-1 for steel systems.

The fabrication of resistance welded metallic components shall conform to the quality requirements of BS EN ISO 14554.

The approval testing of welding operators for fusion welding and of resistance weld setters for fully mechanised and automatic welding of metallic materials shall conform to BS EN 1418.

Welds shall be tested to BS EN 571-1.

## **4. Surface Finish**

All steel powder coated blue. No galvanising is required. All wood to have a light spray varnish

## **5. Design**

Manufacture shall be in accordance to drawing reference BOE-PALLET (2 drawings - Frame Assembly and Pallet Assembly), all tolerances to be noted and adhered too, pay special attention to any special notes on the drawing.

### **5.1 Stillage caps**

On each corner a 50mm stillage cap shall be welded to the top of the post, this will allow for stacking in situ, the tolerance is +/- 1mm on the fixing of the cap.

### **5.1.1 Welding**

Each stillage shall be fully welded at the corners and at the cross base supporting angles.

### **5.1.2 Wooden slats**

4 number wooden slats (Red Hard Wood) shall be fixed to the stillage base; each slat shall accommodate an M10x40 dome headed stainless steel coach bolt mechanically fixed from the underside with a stainless steel M10 nut and washer.

The slats are to be 150mm wide and when fitted a gap of 3mm maximum between each slat shall be accommodated for.

The 2 end slats shall have a 53mm x 53mm cut-out to allow for fixing into the corners of the stillage.

## **6. Quality Control**

Factories shall be certified to ISO 9001:2000. Manufacture shall be free from defects such as weld spottles, sharp material, any excessive welds shall be ground where required.

## **7. Life expectancy**

The stillage shall last for a minimum of 30 years in a dry controlled atmosphere.