



TECHNICAL OFFER

Technical notes on Standard technical specifications

AISI – Definition is American Iron and Steel Institute
SWG - Definition is Standard wire gauge.
Grade – 304.

Material AISI 304

All material used in fabrication will be food grade.

- 1.1 Where ever Stainless Steel is used will be AISI 304 grade unless it is specified
- 1.2 All tops will be fabricated out of 16 SWG
- 1.3 All panels will be fabricated out of 20 SWG
- 1.4 All uprights will be of 38 mm Square and 16 SWG
- 1.5 All cross support will be of 25 mm square weld pipes out of 20 SWG
- 1.6 All frame structures will be out of 24 mm square pipes out of 20 SWG

Thickness (SWG)

- 2.1 Wall thickness of the pipe will vary from 1 to 1.6 mm depending up on the area of Usage
- 2.2 Wall thickness of all pipes used as specified above is in confirmation.
- 2.3 All sinks (Die – Pressed) will fabricated out of 16 SWG SS AISI - SS 304
- 2.3 SS sinks will be provided with slope for water flow
- 2.4 All coved corners welded will be finished without dirt pockets
If work tops are provided with Splash back it will be straight to sight
- 2.5 The height of the Splash back will be 150 mm and a built in angle of not more than 45 degrees

Electrical Components

- 3.1 All bullet feet would be of Nylon or Aluminum as prescribed
- 3.2 All pans and containers would be of GN standards and die pressed.



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- 3.3 Thickness of the pans could vary form .7 to .8 mm depending on the size of the container
- 3.4 All pans and containers lids would be of GN standards and die pressed.
- 3.4 Thickness of the pans could vary form .6 to .7 mm depending on the size of the container
- 3.5 All Electrical components would be ISI marked
- 3.6 SS components of intricate shape would be laser cut.
- 3.7 All hangers would be out of 10 SWG
- 3.8 All SS sinks will be provided with the standard drain coupling of 1.5 inches diameter fabrication
- 3.9 All Electrical Circuit will be having isolated circuits with MCB/ELCB
- 3.10 All heavy electrical connections (above 1.5 KW) will be provided with heavy gauge FR wires
- 3.11 All screws and fasteners used will be IS standards mm thread

Finish

Five Stage finishing Process would be adopted for all stainless Steel Surfaces

- 4.1 Stages 1 Emery grit 60,
- 4.2 stage 2: Fine Emery grit 120
- 4.3 Stage 3: Flap,
- 4.4 Stage 4: Wire
- 4.5 Stage 5: Final

All Tubes shall be clean and free from Scales, cracks clauses
Cut ends of the tubes.

All SS surfaces will be free from Laminations

Finished tubes and up rights would be straight and have smooth ends free from burrs .

They shall be free form injurious defects and shall have a work manlike finish.



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Welding Process

5.1 Only TIG welding will be used for fabrication welding of SS sheets.

5.2 The welding procedure will be in accordance with the Indian Welders Manual.

5.3 The inert gas in use will a gas combination of 98% Ar and 2% O₂

5.4 Filler Rod of AISI 316 L will be used for TIG welding

5.5 All tig welded area will be finished to a minimum RA value of 20 as per IS

5.6 All heated chamber will be insulated and will be wire brush finished for energy saving

5.7 Hydro forming will be used to form the edges in place of conventional impact Bending

PACKAGING

Each and every equipments would be protected before transportation to avoid scratches and distortion to maintain fabrication standards Equipments would be transported only in open deck transport.

Thanks & Regards

Ms.RV KITCHEN EQUIPMENTS