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Custom Castings

An alternative way of customizing is to cast a three dimensional logo onto existing designs.

A third method of customizing is to combine the two previous methods and add a unique logo to a newly created bench end, table, trash can holder, or other items. This method is commonly used and greatly enhances the common theme of a project.

Composition and Material: Aluminum Castings are made by the green sand mold method. Castings are cleaned by sand blasting and parting lines are then cleaned and deburred.

Aluminum Grades: Aluminum Association alloys 319, 356, and 514 are available on a certified basis. Other alloys can be cast upon request. A standard blended alloy is available for non-critical, non-certified applications.

Sizes: Castings range from 1"x 1"x 1" (0.1 lb.) to 48"x48"x2" (350 lbs.). Cores are used for horizontal holes and tight fit applications.

Finishes: The surface has an "as cast" texture. The surface can be sanded, ground, and polished with different grits and wire sizes. Castings are readily painted and coated via:
- Fluoropolymers
- Powder coats
- Paints
- Antiquing
- Electroplating

Limitations: Caution should be used in coastal applications where salt spray can cause electrolysis between dissimilar metals. Aluminum castings also provide poor anodizing characteristics.

Physical and Chemical Properties: Aluminum Association Chemical specifications certified as needed for specific applications. See Table 1.

Welding/Fabrication: Aluminum castings can be welded to other forms of aluminum (i.e., tubing, plate, sheet), but cannot be welded directly to steel. To overcome this limitation a steel tab or stub can be cast into the aluminum. That insert can then be welded to steel.

In addition to welding aluminum to aluminum, or steel inserts to steel, the castings can easily be drilled and threaded for bolt type attachments. Aluminum is easily sawed with a bandsaw and is easily machined.

Packaging and Shipping: Fiberboard drums and boxes from 100 lbs. to 300 lbs. Pallet boxes of 40"x48"x26" strapped to pallets for shipments of 800-1200 lbs. Shipping is via UPS and common carrier.

Maintenance: Surface Maintenance requirements are determined by the coating manufacturer. Aluminum will not rust and with a coherent contact coating it will not corrode, even in a sea coast environment.

Technical Services: A metallurgical engineer is on staff to answer any questions. Matchplate tooling is fabricated in-house. Local subcontractors have been educated to provide the proper drafts and dimensions for original wood carvings and master patterns.

| TABLE 1 |
|-----------------|-----------------|-----------------|
| SAND CASTING-AS CAST STRUCTURE (F-TEMPER) | ALUMINUM ALLOY |
| | 319 | 356 | 514 |
| Tensile Strength (1000 PSI) | 23.0 | 19.0 | 22.0 |
| Yield Strength (1000 PSI) | 13.0 | - | 9.0 |
| Major Alloys | Silicon | Copper | Magnesium |
| Elements | 6.0 | 7.0 | - |
| Nominal % | 3.5 | 0.3 | - |
| Characteristics (1 is Better) |
| Corrosion Resistance | 3 | 2 | 1 |
| Machinability | 3 | 3 | 1 |
| Polishing | 4 | 4 | 1 |
| Weldability | 2 | 1 | 3 |
| Cost | 1 | 2 | 4 |

Other alloys are available upon request.

Comments

A few comments for you about this catalog from the Management Group at Alloy Casting.

This Catalog comes to you as we celebrate our 50th year producing ornamental aluminum castings.

The catalog is arranged by topic and has been carefully put together to make it easy for you to find the items required in your business. We are proud to have included in this catalog over 350 items that have not been in our other catalogs. Many of these items are not only new to Alloy Casting but are new to the industry as well. Each new item has been labeled "NEW" under the product number. A review of these items could be of special interest to you.

Many of these new items have been custom created by fabricators and manufacturers as they have searched for something new to offer their customers. Alloy Casting has implemented these projects on a turn key basis. More information on our turn key abilities are discussed on page 5. We also have brochures entitled "Creativity that is Custom Cast" and, "Aluminum,. . Furniture's Alternative to Wood", that are available for your use. Just ask and we will send you copies.

We have prepared this catalog with you in mind. If you have any suggestions how we might make it easier and more profitable for you, please let us know.

We are proud to be known for our quality castings delivered in a prompt manner.

Jon McGraw

"Made in U. S. A."

American Foundry Society
American Fence Association
NOMMA
Texas Cast Metal Association
Construction Specifiers Institute
Bird of Paradise Picket casting #31 in a roof fence rail

**SECTION A-A DIAMOND CROSS SECTION.**

**THIS CASTING WILL NOT ACCEPT A STEEL CLIP.**

**BIRD OF PARIDISE**

**NEW**

**NEW**

**SEE PAGE NO 13 FOR THIS PIECE WITH HOLE IN LUG.**
Guardian style Castings

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<td>2223</td>
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<td>2222</td>
<td>DF</td>
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Picket casting #2 and #224 in a pool gate.

GUARDIAN PICKETS: FOR LARGER SLOT PICKETS SEE PAGE 12.

GUARDIAN CASTING

ALUMINUM CASTINGS

REVISION DATE: 01/18/95

GUARDIAN PICKETS: FOR LARGER SLOT PICKETS SEE PAGE 12.
<table>
<thead>
<tr>
<th>Item</th>
<th>Description</th>
<th>Height</th>
<th>Width</th>
<th>Thick</th>
<th>Weight</th>
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<tbody>
<tr>
<td>220</td>
<td>OLD 220B</td>
<td>3 1/2&quot;</td>
<td>25 1/2&quot;</td>
<td>3/4&quot;</td>
<td>1 6&quot;</td>
</tr>
<tr>
<td></td>
<td></td>
<td>8 9 CM</td>
<td>64 8 CM</td>
<td>1 9 CM</td>
<td>0 7 KGS</td>
</tr>
<tr>
<td>221</td>
<td>OLD 221F</td>
<td>3 1/2&quot;</td>
<td>25 1/2&quot;</td>
<td>3/4&quot;</td>
<td>1 6&quot;</td>
</tr>
<tr>
<td></td>
<td></td>
<td>8 9 CM</td>
<td>64 8 CM</td>
<td>1 9 CM</td>
<td>0 7 KGS</td>
</tr>
<tr>
<td>422</td>
<td>NEW</td>
<td>4 1/4&quot;</td>
<td>28 1/8&quot;</td>
<td>1&quot;</td>
<td>2 7&quot;</td>
</tr>
<tr>
<td></td>
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<td>10.8 CM</td>
<td>71.4 CM</td>
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<td>1.2 KGS</td>
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<td>Part Number</td>
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</tr>
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<td>33</td>
<td>4&quot;</td>
<td>2&quot;</td>
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<td>0.2 lbs</td>
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<td>333</td>
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<td>4 5/8&quot;</td>
<td>1/2&quot;</td>
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<tr>
<td>9430</td>
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<td>8 1/2&quot;</td>
<td>1/2&quot;</td>
<td>0.9 lbs</td>
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</tr>
<tr>
<td>9733</td>
<td>5 3/4&quot;</td>
<td>3 1/8&quot;</td>
<td>3/4&quot;</td>
<td>0.6 lbs</td>
<td></td>
</tr>
<tr>
<td>9826</td>
<td>6&quot;</td>
<td>3 1/2&quot;</td>
<td>7/8&quot;</td>
<td>0.7 lbs</td>
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<tr>
<td>9533</td>
<td>4&quot;</td>
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<td>3/8&quot;</td>
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<tr>
<td>2709</td>
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<td>3 1/2&quot;</td>
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<tr>
<td>2710</td>
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<td>2 1/2&quot;</td>
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<tr>
<td>1331</td>
<td>4 1/2&quot;</td>
<td>2 1/2&quot;</td>
<td>1/2&quot;</td>
<td>0.2 lbs</td>
<td></td>
</tr>
<tr>
<td>1333</td>
<td>7 1/4&quot;</td>
<td>3 1/2&quot;</td>
<td>1/2&quot;</td>
<td>0.3 lbs</td>
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</tr>
</tbody>
</table>
Picket castings #2 and #9 combined with spear point #8206 as a window guard.
**Section:**

**Picket Castings, With Holes in Lugs For Screw On Applications**

**2222**

- **NEW**
- **DF**
- **1/2"**

- **HEIGHT:** 15 7/8 IN
- **WIDTH:** 6 7/8 IN
- **THICK:** 3/4 IN
- **WEIGHT:** 1.0 LBS

- **HEIGHT:** 44.1 CM
- **WIDTH:** 20.0 CM
- **THICK:** 1.9 CM
- **WEIGHT:** 0.6 KGS

**1003**

- **NEW**
- **SF**
- **1/2"**

- **HEIGHT:** 13 3/4 IN
- **WIDTH:** 8 3/8 IN
- **THICK:** 3/4 IN
- **WEIGHT:** 1.0 LBS

- **HEIGHT:** 34.9 CM
- **WIDTH:** 20.0 CM
- **THICK:** 1.9 CM
- **WEIGHT:** 0.5 KGS

**4010**

- **OLD 10X4**
- **SF**
- **1/2"**

- **HEIGHT:** 3 3/4 IN
- **WIDTH:** 4 3/8 IN
- **THICK:** 3/4 IN
- **WEIGHT:** 0.3 LBS

- **HEIGHT:** 9.5 CM
- **WIDTH:** 10.8 CM
- **THICK:** 1.9 CM
- **WEIGHT:** 0.1 KGS

**4012**

- **OLD 12X4**
- **DF**
- **1/2"**

- **HEIGHT:** 16 5/8 IN
- **WIDTH:** 8 1/4 IN
- **THICK:** 3/4 IN
- **WEIGHT:** 2.1 LBS

- **HEIGHT:** 42.2 CM
- **WIDTH:** 21.0 CM
- **THICK:** 1.9 CM
- **WEIGHT:** 1.0 KGS

**1243**

- **OLD C243**
- **DF**
- **1/2"**

- **HEIGHT:** 15 IN
- **WIDTH:** 7 3/4 IN
- **THICK:** 3/4 IN
- **WEIGHT:** 2.1 LBS

- **HEIGHT:** 38.1 CM
- **WIDTH:** 19.7 CM
- **THICK:** 1.9 CM
- **WEIGHT:** 1.0 KGS

**2022**

- **OLD 22X2**
- **DF**
- **1/2"**

- **HEIGHT:** 13 1/4 IN
- **WIDTH:** 7 3/8 IN
- **THICK:** 3/4 IN
- **WEIGHT:** 1.5 LBS

- **HEIGHT:** 33.7 CM
- **WIDTH:** 18.7 CM
- **THICK:** 1.9 CM
- **WEIGHT:** 0.7 KGS

**1180**

- **NEW**
- **SF**
- **1/2"**

- **HEIGHT:** 15 7/8 IN
- **WIDTH:** 6 7/8 IN
- **THICK:** 3/4 IN
- **WEIGHT:** 2.1 LBS

- **HEIGHT:** 44.1 CM
- **WIDTH:** 20.0 CM
- **THICK:** 1.9 CM
- **WEIGHT:** 1.0 KGS

**1720**

- **SF**
- **1/2"**

- **NUMERICAL DRAWING**

- **Nominal Picket**

- **5 3/4 IN**

- **4 Circles are 5 1/8 IN outside diameter.**

- **Lugs Between Circles Have 1 5/8 IN Tapered Holes For Screw On Applications.**

- **HEIGHT:** 28 1/4 IN
- **WIDTH:** 5 1/8 IN
- **THICK:** 1/2 IN
- **WEIGHT:** 2.1 LBS

- **HEIGHT:** 71.8 CM
- **WIDTH:** 13.0 CM
- **THICK:** 1.3 CM
- **WEIGHT:** 1.0 KGS

**422**

- **NEW**
- **DF**
- **1/2"**

- **HEIGHT:** 4 1/4 IN
- **WIDTH:** 28 1/8 IN
- **THICK:** 1 IN
- **WEIGHT:** 2.7 LBS

- **HEIGHT:** 10.8 CM
- **WIDTH:** 71.4 CM
- **THICK:** 2.5 CM
- **WEIGHT:** 1.2 KGS

**426**

- **NEW**
- **DF**
- **1/2"**

- **HEIGHT:** 4 IN
- **WIDTH:** 28 5/8 IN
- **THICK:** 1 IN
- **WEIGHT:** 2.0 LBS

- **HEIGHT:** 25.8 CM
- **WIDTH:** 72.7 CM
- **THICK:** 2.5 CM
- **WEIGHT:** 0.9 KGS

**NOTE:** All items on this page have holes in their lugs for screw-on applications.

**SCALE:** 1 inch = 1 foot unless noted.

**REVISION DATE:** 01/18/95
### Security Doors: Scroll Friezes

<table>
<thead>
<tr>
<th>Style</th>
<th>Measurements</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1022</td>
<td>5 x 31 1/2</td>
<td>For the mail slot, outside face is 3 1/4 x 10 inches, inside face is 2 x 8 1/2 inches.</td>
</tr>
<tr>
<td>446</td>
<td>5 1/8 x 9 7/8</td>
<td>Short frieze to put in each side of mail slot.</td>
</tr>
<tr>
<td>432</td>
<td>5 1/4 x 29 1/8</td>
<td></td>
</tr>
<tr>
<td>438</td>
<td>5 1/4 x 31 1/2</td>
<td></td>
</tr>
<tr>
<td>433</td>
<td>5 1/4 x 25 1/4</td>
<td></td>
</tr>
<tr>
<td>538</td>
<td>5 1/2 x 25 1/4</td>
<td></td>
</tr>
</tbody>
</table>

Short bird #448 and scroll frieze #231 in a very popular security door design.

Oak doo panel #245, oak corners #215 and #216, and oak frieze #236 in a common security door design.
<table>
<thead>
<tr>
<th>Item</th>
<th>Description</th>
<th>Dimensions</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>426</td>
<td>New Acorn Friezes</td>
<td>4 X 28 5/8</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>455</td>
<td>New Short Frieze</td>
<td>4 X 10</td>
<td></td>
</tr>
<tr>
<td>463</td>
<td>New Acorn Friezes</td>
<td>4 1/8 X 29 3/4</td>
<td></td>
</tr>
<tr>
<td>235</td>
<td>New Acorn Friezes</td>
<td>4 3/4 X 31 5/8</td>
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<td>236</td>
<td>New Acorn Friezes</td>
<td>4 7/8 X 33 1/4</td>
<td></td>
</tr>
<tr>
<td>464</td>
<td>New Acorn Friezes</td>
<td>4 7/8 X 30 1/8</td>
<td></td>
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<tr>
<td>1027</td>
<td>New Acorn Friezes</td>
<td>5 X 31 1/2</td>
<td></td>
</tr>
<tr>
<td>445</td>
<td>New Short Frieze</td>
<td>5 X 9 7/8</td>
<td></td>
</tr>
<tr>
<td>239</td>
<td>New Acorn Friezes</td>
<td>5 1/4 X 31 1/2</td>
<td></td>
</tr>
<tr>
<td>539</td>
<td>New Acorn Friezes</td>
<td>5 1/2 X 31 3/8</td>
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### Traditional Oak Castings

<table>
<thead>
<tr>
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<th>Description</th>
<th>Dimensions</th>
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<tbody>
<tr>
<td>12</td>
<td>DF</td>
<td>Height: 16 5/8 in (=42.2) cm, Width: 8 1/4 in (=21.0) cm, Thickness: 7/8 in (=2.2) cm, Weight: 2.6 lbs (=1.2) kgs</td>
</tr>
<tr>
<td>2012</td>
<td>SBO</td>
<td>Height: 16 5/8 in (=42.2) cm, Width: 8 in (=20.3) cm, Thickness: 7/8 in (=2.2) cm, Weight: 2.1 lbs (=1.0) kgs</td>
</tr>
<tr>
<td>3012</td>
<td>DF</td>
<td>Height: 16 5/8 in (=42.2) cm, Width: 8 1/4 in (=21.0) cm, Thickness: 3/4 in (=1.9) cm, Weight: 2.6 lbs (=1.2) kgs</td>
</tr>
<tr>
<td>4012</td>
<td>SBO</td>
<td>Height: 16 5/8 in (=42.2) cm, Width: 8 in (=20.3) cm, Thickness: 3/4 in (=1.9) cm, Weight: 2.1 lbs (=1.0) kgs</td>
</tr>
<tr>
<td>1201</td>
<td>SF</td>
<td>Height: 3 1/8 in (=7.9) cm, Width: 8 in (=20.3) cm, Thickness: 3/4 in (=1.9) cm, Weight: 0.4 lbs (=0.2) kgs</td>
</tr>
<tr>
<td>2201</td>
<td>DF</td>
<td>Height: 3 1/8 in (=7.9) cm, Width: 8 in (=20.3) cm, Thickness: 3/4 in (=1.9) cm, Weight: 0.4 lbs (=0.2) kgs</td>
</tr>
<tr>
<td>3201</td>
<td>SF</td>
<td>Height: 3 1/8 in (=7.9) cm, Width: 8 in (=20.3) cm, Thickness: 3/4 in (=1.9) cm, Weight: 0.4 lbs (=0.2) kgs</td>
</tr>
<tr>
<td>206</td>
<td>SF</td>
<td>Height: 5 1/4 in (=13.3) cm, Width: 23 3/4 in (=60.3) cm, Thickness: 1 in (=2.5) cm, Weight: 1.5 lbs (=0.7) kgs</td>
</tr>
<tr>
<td>200</td>
<td>DF</td>
<td>Height: 28 in (=71.1) cm, Width: 11 3/8 in (=28.9) cm, Thickness: 7/8 in (=2.2) cm, Weight: 4.3 lbs (=2.0) kgs</td>
</tr>
<tr>
<td>241</td>
<td>DF</td>
<td>Height: 33 1/4 in (=84.5) cm, Width: 7 1/2 in (=19.0) cm, Thickness: 7/8 in (=2.2) cm, Weight: 4.0 lbs (=1.8) kgs</td>
</tr>
<tr>
<td>243</td>
<td>DF</td>
<td>Height: 33 1/4 in (=84.5) cm, Width: 7 1/4 in (=19.7) cm, Thickness: 3/4 in (=1.9) cm, Weight: 4.8 lbs (=2.2) kgs</td>
</tr>
<tr>
<td>245</td>
<td>New</td>
<td>Height: 33 1/4 in (=84.5) cm, Width: 10 in (=25.4) cm, Thickness: 7/8 in (=2.2) cm, Weight: 5.2 lbs (=2.4) kgs</td>
</tr>
</tbody>
</table>

**Scale:** 1 inch = 1 foot unless noted.

**Revision Date:** 12/09/94

Toll Free (800) 527-1318
(972) 286-2368
Fax: (972) 557-4727
Oak panel design #200 with corner #208 and frieze #206 as a porch enhancement.
Section:
Oak Castings

Oak Castings

Toll Free (800) 527-1318
(972) 286-2368
Fax: (972) 557-4727

SCALE: 1 INCH = 1 FOOT UNLESS NOTED

<table>
<thead>
<tr>
<th>Style</th>
<th>Description</th>
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<tbody>
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<td>OLD 282B</td>
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<tr>
<td>283</td>
<td>OLD 283B</td>
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<tr>
<td>264</td>
<td>OLD 264BL</td>
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<tr>
<td>265</td>
<td>OLD 264BR</td>
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<tr>
<td>280</td>
<td>DF</td>
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<tr>
<td>244</td>
<td>DF</td>
</tr>
<tr>
<td>270</td>
<td>DF</td>
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<tr>
<td>271</td>
<td>OLD 271BNB</td>
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<tr>
<td>285</td>
<td>OLD 285F</td>
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</table>

REVISION DATE: 12/08/94

SCALE: 1 INCH = 1 FOOT UNLESS NOTED
Toll Free (800) 527-1318
(972) 286-2368
Fax: (972) 557-4727

Section:

Birds Of Paradise

REVISION DATE: 03/28/95

SCALE: 1 INCH = 1 FOOT UNLESS NOTED
### Birds Of Paradise

**Section:**

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<td>16 1/4</td>
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<td>5.2</td>
<td>2.4</td>
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<td>21 3/8</td>
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<td>17 3/4</td>
<td>21 1/2</td>
<td>1</td>
<td>5.8</td>
<td>2.6</td>
</tr>
</tbody>
</table>

*Height in cm, width in cm, thickness in cm, weight in lbs and kg.*

**NOT TO SCALE:**

- Height 21 1/4 in, width 54.3 cm, thickness 1 in, weight 2.1 kg
- Height 22 1/2 in, width 55.9 cm, thickness 1 in, weight 2.4 kg
- Height 21 1/4 in, width 54.3 cm, thickness 1 in, weight 2.1 kg
- Height 21 in, width 21 in, thickness 1 in, weight 2.6 kg
- Height 17 3/4 in, width 21 1/2 in, thickness 1 in, weight 2.6 kg

**Scale:** 1 inch = 1 foot unless noted.

**Revision Date:** 01/30/95

**Contact Information:**

- Toll Free (800) 527-1318
- (972) 286-2368
- Fax: (972) 557-4727
620 DF

- Height: 23 3/4 in (60.3 cm)
- Width: 8 1/4 in (21.0 cm)
- Thickness: 3/4 in (1.9 cm)
- Weight: 2.8 lbs (1.3 kg)

1622 DF

- Height: 29 1/2 in (74.9 cm)
- Width: 7 1/2 in (19.0 cm)
- Thickness: 3/4 in (1.9 cm)
- Weight: 3.6 lbs (1.6 kg)

622 DF

- Height: 22 in (55.9 cm)
- Width: 7 1/2 in (19.0 cm)
- Thickness: 3/4 in (1.9 cm)
- Weight: 2.5 lbs (1.1 kg)

621 DF

- Height: 27 3/4 in (70.5 cm)
- Width: 11 1/4 in (28.6 cm)
- Thickness: 3/4 in (1.9 cm)
- Weight: 4.2 lbs (1.9 kg)

610 SBO

- Height: 27 1/4 in (69.2 cm)
- Width: 12 in (30.5 cm)
- Thickness: 1 in (2.5 cm)
- Weight: 6.6 lbs (3.0 kg)

611 DF

- Height: 27 7/8 in (70.8 cm)
- Width: 6 3/4 in (17.1 cm)
- Thickness: 1 in (2.5 cm)
- Weight: 2.9 lbs (1.3 kg)

600 DF

- Height: 23 3/4 in (59.1 cm)
- Width: 9 in (22.9 cm)
- Thickness: 1 in (2.5 cm)
- Weight: 3.8 lbs (1.7 kg)

619 DF

- Height: 26 3/4 in (67.9 cm)
- Width: 10 3/4 in (27.3 cm)
- Thickness: 3/4 in (1.9 cm)
- Weight: 3.9 lbs (1.8 kg)

REVISED DATE: 12/20/94

SCALE: 1 INCH = 1 FOOT UNLESS NOTED
| Section: Roses
| --- | --- |

<table>
<thead>
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<td>1.6 LBS</td>
<td>0.7 KGS</td>
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<td>3/4 IN</td>
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<td>11.4 CM</td>
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<tr>
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<tr>
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<tr>
<td>Weight</td>
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<td>1.6 KGS</td>
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**NOTE:** SCALE IS 1 INCH = 6 INCHES

**SCALE:** 1 INCH = 1 FOOT UNLESS NOTED

**Revision Date:** 12/20/94
**Section:** Roses

**624**
OLD 624BNB

<table>
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<td>1.5 KGS</td>
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**627**
OLD 627B

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<td>3.3 LBS</td>
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**601**
OLD 601BNB

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**602**
NEW

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Section: Grapes

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<td>1.8 cm</td>
<td>3.9 lbs</td>
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<td>19.1 cm</td>
<td>11.1 cm</td>
<td>2.8 cm</td>
<td>30 lbs</td>
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557  DF  NEW

314  DF  NEW

Grapes

REVISION DATE: 01/19/95

SCALE: 1 INCH = 1 FOOT UNLESS NOTED
Passion flower panel #100 and corner #105 as porch columns.
GREEK KEY

750 SBO

HEIGHT 28 IN 71.1 CM
WIDTH 11 IN 27.9 CM
THICK 1 IN 2.5 CM
WEIGHT 5.0 LBS 2.3 KGS

752 DF

HEIGHT 9 IN 22.9 CM
WIDTH 5 1/8 IN 11.7 CM
THICK 1/2 IN 1.3 CM
WEIGHT 0.6 LBS 0.3 KGS

759 DF

HEIGHT 13 1/4 IN 33.7 CM
WIDTH 5 1/8 IN 15.2 CM
THICK 1/2 IN 1.3 CM
WEIGHT 1.3 LBS 0.6 KGS

767 DF

HEIGHT 24 1/4 IN 61.6 CM
WIDTH 10 1/2 IN 26.7 CM
THICK 5/8 IN 1.6 CM
WEIGHT 4.7 LBS 2.1 KGS

REVOLUTION DATE: 01/19/95

SCALE: 1 INCH = 1 FOOT UNLESS NOTED
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<tr>
<td>WIDTH 8 IN</td>
<td>26.7 CM</td>
<td></td>
</tr>
<tr>
<td>THICK 1 1/2 IN</td>
<td>3.8 CM</td>
<td></td>
</tr>
<tr>
<td>WEIGHT 5.2 LBS</td>
<td>2.7 KGS</td>
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</tr>
<tr>
<td>WIDTH 9 5/8 IN</td>
<td>24.4 CM</td>
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<tr>
<td>THICK 5/8 IN</td>
<td>1.6 CM</td>
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<tr>
<td>WEIGHT 2.2 LBS</td>
<td>1.0 KGS</td>
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<table>
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<td>WIDTH 9 5/8 IN</td>
<td>24.4 CM</td>
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<td>THICK 5/8 IN</td>
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<tr>
<td>WEIGHT 4.8 LBS</td>
<td>2.2 KGS</td>
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<tr>
<td>THICK 1 1/8 IN</td>
<td>2.9 CM</td>
<td></td>
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<td>1.7 KGS</td>
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<tr>
<td>WEIGHT 2.1 LBS</td>
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<td>THICK 7/8 IN</td>
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<td>WEIGHT 7.5 LBS</td>
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<td>WIDTH 11 3/4 IN</td>
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<tr>
<td>THICK 1 IN</td>
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<tr>
<td>WEIGHT 5.1 LBS</td>
<td>2.3 KGS</td>
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<td>THICK 7/8 IN</td>
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<td>WEIGHT 2.2 LBS</td>
<td>1.0 KGS</td>
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<tr>
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REVISIO N DATE: 01/1995

SCALE: 1 INCH = 1 FOOT UNLESS NOTED
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**HEIGH**  | **WIDTH**  | **THICK**  | **WEIGHT**  |
-------|------------|------------|-------------|
18.5  | 19.25      | 7/8        | 2.6         |
       | 47.0 CM    | 48.9 CM    | 3.2 KGS     |

REVISION DATE: 01/26/95  SCALE: 1 INCH = 1 FOOT UNLESS NOTED
**Section:**

Circles and Ovals

---

**1720**

**DF**

NEW

NOMINAL PICKET

5 3/4 IN.

CIRCLES ARE 5 1/8 IN. OUTSIDE DIAMETER.

LUGS BETWEEN CIRCLES HAVE 1/2" TAPERED DOWN TO 1/8" DIAMETER HOLE FOR SCREW ON APPLICATIONS.

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<td>27 1/2</td>
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<td>178</td>
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<table>
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<td>11.4</td>
<td>29</td>
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<tr>
<td>4</td>
<td>10.2</td>
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<td>24.3</td>
</tr>
<tr>
<td>3 1/2</td>
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<th>IN</th>
<th>CM</th>
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<td>4.1</td>
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<th>KGS</th>
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<td>0.9</td>
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---

**833**

**SBO**

NEW

HEIGHT 29 1/2 IN 76.2 CM

WIDTH 4 3/8 IN 11.4 CM

THICK 1 IN 2.5 CM

WEIGHT 3.9 LBS 1.7 KGS

---

**534**

**FB**

NEW

HEIGHT 30 3/4 IN 78.1 CM

WIDTH 5 1/8 IN 13 CM

THICK 3/4 IN 1.9 CM

WEIGHT 3.8 LBS 1.7 KGS

---

**535**

**FB**

NEW

HEIGHT 34 1/8 IN 86.7 CM

WIDTH 8 IN 20.3 CM

THICK 3/4 IN 1.9 CM

WEIGHT 4.4 LBS 2.0 KGS

---

**836**

**FB**

NEW

HEIGHT 27 IN 68.6 CM

WIDTH 13 3/8 IN 34.6 CM

THICK 1/2 IN 1.3 CM

WEIGHT 2.4 LBS 1.1 KGS

---

**836**

**FB**

NEW

CIRCLES /RINGS

NO SCALE

STANDARD PLACEMENT OF CLIPS IS 2 AT 180 DEGREES APART.

TYPICAL CROSS SECTION

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<th>CATALOG NUMBER</th>
<th>OLD NUMBER</th>
<th>DIAMETER</th>
<th>INCHES</th>
<th>CENTIMETERS</th>
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<th>POUNDS</th>
<th>KILIGRAMS</th>
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<tr>
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<td>11</td>
<td>27.9</td>
<td>70.8</td>
<td>0.88</td>
<td>0.40</td>
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<td>7130</td>
<td>710X300</td>
<td>3</td>
<td>7.6</td>
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<td>0.20</td>
<td>0.09</td>
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<tr>
<td>7140</td>
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<td>7144</td>
<td>710X450</td>
<td>4 1/4</td>
<td>11.4</td>
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<td>0.14</td>
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<tr>
<td>7180</td>
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<td>8</td>
<td>20.3</td>
<td>51.1</td>
<td>0.63</td>
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</tbody>
</table>

---

**9272**

**DF**

NEW

HEIGHT 35 1/8 IN 89.2 CM

WIDTH 8 3/8 IN 20.6 CM

THICK 5/8 IN 1.6 CM

WEIGHT 6.5 LBS 3.0 KGS

---

NOTE: MORE CIRCLES WITH STARS ARE ON PAGE 70.

Scales: 1 INCH = 1 FOOT UNLESS NOTED

REVISED DATE: 12/21/94
Section: Circles And Ovals

**839**
- **DF**

**840**
- **DF**

**841**
- **DF**
  - **OLD 841F**

**9263**
- **SF**

**9331**
- **NEW**

**9237**
- **NEW**

**7121**
- **NEW**

- **DF**

---

**Rev: 01/30/95**

NOTE: MORE CIRCLES WITH STARS ARE SHOWN ON PAGE 70.

SCALE: 2 INCHES = 1 FOOT

CIRCLE HAS A NOMINAL CROSS SECTION OF 3/4 INCH BY 3/4 INCH
NOTE: THE CIRCLES ON THIS PAGE FIT INTO THE BENCH END ARM RESTS, SEE PAGE 95.
Panel section #813 grouped as a window screen.
# Mixed Castings

## 550 DF
- **Height**: 28 5/8 in (72.7 cm)
- **Width**: 10 in (25.4 cm)
- **Thick**: 3/4 in (1.9 cm)
- **Weight**: 4.5 lbs (1.8 kgs)

## 2550 DF
- **Height**: 27 1/4 in (69.2 cm)
- **Width**: 9 1/2 in (24.1 cm)
- **Thick**: 3/4 in (1.9 cm)
- **Weight**: 4.8 lbs (2.2 kgs)

## 553 DF
- **Height**: 27 in (68.6 cm)
- **Width**: 9 in (22.8 cm)
- **Thick**: 1 in (2.5 cm)
- **Weight**: 4.4 lbs (1.8 kgs)

## 552 DF
- **Height**: 19 5/8 in (49.8 cm)
- **Width**: 5 5/8 in (14.3 cm)
- **Thick**: 7/8 in (2.2 cm)
- **Weight**: 2.5 lbs (1.1 kgs)

## 801 DF
- **Height**: 27 3/4 in (70.5 cm)
- **Width**: 8 1/8 in (20.6 cm)
- **Thick**: 1/2 in (1.3 cm)
- **Weight**: 2.2 lbs (1.0 kgs)

## 1803 DF
- **Height**: 27 1/4 in (70.5 cm)
- **Width**: 19 5/8 in (49.8 cm)
- **Thick**: 5/8 in (1.3 cm)
- **Weight**: 2.2 lbs (1.0 kgs)

## 804 DF
- **Height**: 29 3/4 in (75.6 cm)
- **Width**: 7 in (17.8 cm)
- **Thick**: 1/2 in (1.3 cm)
- **Weight**: 2.1 lbs (1.0 kgs)

## 800 DF
- **Height**: 28 5/8 in (72.7 cm)
- **Width**: 8 3/8 in (21.5 cm)
- **Thick**: 1/2 in (1.3 cm)
- **Weight**: 2.5 lbs (1.1 kgs)

---

**Scale:** 1 inch = 1 foot unless noted.
Panel casting #705 group as a window screen/window guard.
### Mixed Castings

<table>
<thead>
<tr>
<th>Style</th>
<th>Material</th>
<th>Height</th>
<th>Width</th>
<th>Thickness</th>
<th>Weight</th>
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<tbody>
<tr>
<td>500</td>
<td>DF</td>
<td>25 1/2</td>
<td>16.5</td>
<td>1 1/4</td>
<td>5.9 LBS</td>
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<tr>
<td>981</td>
<td>DF</td>
<td>27 1/4</td>
<td>16.5</td>
<td>3/4</td>
<td>5.9 LBS</td>
</tr>
<tr>
<td>501</td>
<td>OLD 501B</td>
<td>14 3/4</td>
<td>37.5</td>
<td>1</td>
<td>3.2 LBS</td>
</tr>
<tr>
<td>502</td>
<td>OLD 502F</td>
<td>6</td>
<td>15.2</td>
<td>1</td>
<td>3.4 LBS</td>
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<tr>
<td>503</td>
<td>OLD 503F</td>
<td>9 7/8</td>
<td>15.2</td>
<td>1 1/8</td>
<td>4.1 LBS</td>
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<td>640</td>
<td>NEW</td>
<td>27 1/4</td>
<td>70.5</td>
<td>3/4</td>
<td>5.2 LBS</td>
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<tr>
<td>641</td>
<td>NEW</td>
<td>16</td>
<td>40.6</td>
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<td>3.8 LBS</td>
</tr>
</tbody>
</table>

---

**Scale:** 1 IN = 1 FOOT UNLESS NOTED

**Revision Date:** 03/09/95

**Toll Free (800) 527-1318**

**Fax:** (972) 557-4727

**Alloy Casting**

**Aluminum Castings**
Picket castings #2 and #9 combined with spear point #8206 and panel #769 as a security divider.

**768**
*SF*
*OLD 768SF*
- **Height:** 22 1/8 IN, 56.2 CM
- **Width:** 7 3/4 IN, 19.7 CM
- **Thickness:** 1/2 IN, 1.3 CM
- **Weight:** 2.2 LBS, 1.9 KGS

**769**
*DF*
*OLD 768DF*
- **Height:** 22 1/8 IN, 56.2 CM
- **Width:** 7 3/4 IN, 19.7 CM
- **Thickness:** 3/4 IN, 1.9 CM
- **Weight:** 4.0 LBS, 1.8 KGS

**908**
*SF*
*OLD 908SF*
- **Height:** 30 IN, 76.2 CM
- **Width:** 8 IN, 20.3 CM
- **Thickness:** 1/2 IN, 1.3 CM
- **Weight:** 3.3 LBS, 1.5 KGS

**909**
*DF*
*OLD 908DF*
- **Height:** 30 IN, 76.2 CM
- **Width:** 8 IN, 20.3 CM
- **Thickness:** 7/8 IN, 2.2 CM
- **Weight:** 6.5 LBS, 3.3 KGS

**818**
*SF*
*NEW*
- **Height:** 24 IN, 61.0 CM
- **Width:** 9 IN, 22.9 CM
- **Thickness:** 1/2 IN, 1.3 CM
- **Weight:** 5.0 LBS, 2.3 KGS

**1818**
*DF*
*NEW*
- **Height:** 24 IN, 61.0 CM
- **Width:** 9 IN, 22.9 CM
- **Thickness:** 1/2 IN, 2.2 CM
- **Weight:** 5.0 LBS, 2.3 KGS

**Miscellaneous Castings**
Section:
Miscellaneous Castings

<table>
<thead>
<tr>
<th>Reference</th>
<th>Description</th>
<th>Height</th>
<th>Width</th>
<th>Thick</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>900</td>
<td>SBO</td>
<td>28 1/2</td>
<td>11 1/8</td>
<td>3/8</td>
<td>5.1 lbs</td>
</tr>
<tr>
<td>9294</td>
<td>DF</td>
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<td>5</td>
<td>3/4</td>
<td>3.6 lbs</td>
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<tr>
<td>887</td>
<td>DF</td>
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<td>6 5/8</td>
<td>3/4</td>
<td>3.4 lbs</td>
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<tr>
<td>901</td>
<td>DF</td>
<td>24 1/4</td>
<td>7 3/4</td>
<td>3/4</td>
<td>2.5 lbs</td>
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<tr>
<td>950</td>
<td>DF</td>
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<td>11 1/8</td>
<td>3/8</td>
<td>5.1 lbs</td>
</tr>
<tr>
<td>951</td>
<td>DF</td>
<td>13 3/4</td>
<td>7 5/8</td>
<td>3/4</td>
<td>3.6 lbs</td>
</tr>
<tr>
<td>955</td>
<td>SF</td>
<td>26 1/2</td>
<td>7 5/8</td>
<td>3/4</td>
<td>3.8 lbs</td>
</tr>
<tr>
<td>820</td>
<td>DF</td>
<td>28</td>
<td>10</td>
<td>1</td>
<td>4.4 lbs</td>
</tr>
</tbody>
</table>

ENDS ARE 3/4 INCHES IN DIAMETER.

REVISION DATE: 01/30/95

SCALE: 1 INCH = 1 FOOT UNLESS NOTED
### Mixed Castings

**930**  
**NEW**  
**DF**  
**SAFE 4" SAFE**  
- **Height**: 29 in (72.7 cm)  
- **Width**: 14 in (35.6 cm)  
- **Thick**: 3/4 in (1.9 cm)  
- **Weight**: 4.5 lbs (2.5 kg)  

**932**  
**NEW**  
**DF**  
- **Height**: 28.58 in (72.7 cm)  
- **Width**: 14 in (35.6 cm)  
- **Thick**: 5/8 in (1.6 cm)  
- **Weight**: 5.2 lbs (2.4 kg)  

**931**  
**NEW**  
**DF**  
- **Height**: 29 1/2 in (74.9 cm)  
- **Width**: 14 in (35.6 cm)  
- **Thick**: 5/8 in (1.6 cm)  
- **Weight**: 4.9 lbs (2.2 kg)  

**934**  
**NEW**  
**DF**  
- **Height**: 29 1/2 in (74.9 cm)  
- **Width**: 14 1/4 in (35.6 cm)  
- **Thick**: 5/8 in (1.6 cm)  
- **Weight**: 4.6 lbs (2.1 kg)  

**970**  
**SBO**  
- **Height**: 27 1/2 in (69.8 cm)  
- **Width**: 12 3/8 in (31.4 cm)  
- **Thick**: 1 in (2.5 cm)  
- **Weight**: 5.5 lbs (2.5 kg)  

**985**  
**SBO**  
- **Height**: 28 1/2 in (72.4 cm)  
- **Width**: 11 1/4 in (28.6 cm)  
- **Thick**: 7/8 in (2.2 cm)  
- **Weight**: 8.3 lbs (3.7 kg)  

**9232**  
**NEW**  
**DF**  
- **Height**: 25 1/4 in (64.1 cm)  
- **Width**: 9 in (22.9 cm)  
- **Thick**: 1 in (2.5 cm)  
- **Weight**: 3.6 lbs (1.6 kg)  

**957**  
**NEW**  
**DF**  
- **Height**: 25 1/4 in (64.1 cm)  
- **Width**: 9 in (22.9 cm)  
- **Thick**: 1 in (2.5 cm)  
- **Weight**: 3.6 lbs (1.6 kg)  

**SECTION:** Toll Free (800) 527-1318  
(972) 286-2368  
Fax: (972) 557-4727  

**SCALE:** 1 INCH = 1 FOOT UNLESS NOTED

**REVISION DATE:** 12/23/94
Mixed Castings

Panel #1070 and corners #591 combined as a designed fence section.

Revision Date: 12/23/94
Scale: 1 inch = 1 foot unless noted
### Mixed Castings

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<td>878 DF NEW</td>
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<td>63.5 CM</td>
<td>28.6 CM</td>
<td>1.3 CM</td>
<td>3.6 LBS</td>
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<td>879 DF NEW</td>
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<td>60.0 CM</td>
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<td>1.2 CM</td>
<td>3.7 KGS</td>
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<tr>
<td>880 DF NEW</td>
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<td>66.0 CM</td>
<td>27.6 CM</td>
<td>1.5 CM</td>
<td>3.7 KGS</td>
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<tr>
<td>874 DF NEW</td>
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<td>60.0 CM</td>
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<td>1.9 CM</td>
<td>3.7 KGS</td>
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<td>42.9 CM</td>
<td>38.4 CM</td>
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<td>3.7 KGS</td>
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<td>9285 DF NEW</td>
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<td>73.7 CM</td>
<td>33.7 CM</td>
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<td>3.7 KGS</td>
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</table>

**REVISION DATE:** 01/30/95

**SCALE:** 1 INCH = 1 FOOT UNLESS NOTED

**MATCHING PIECES. THESE CAN BE PUT END TO END FOR EXTRA LENGTH, OR BE USED AS INDIVIDUAL PIECES.**
### LAMB UNDER WILLOW

**826** DF

<table>
<thead>
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<th>Height</th>
<th>Width</th>
<th>Thick</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>17 1/4 IN</td>
<td>5 1/4 IN</td>
<td>2.5 CM</td>
<td>2.6 LBS 1.2 KGS</td>
</tr>
</tbody>
</table>

### LAMB UNDER WILLOW

**1836** DF

<table>
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<th>Height</th>
<th>Width</th>
<th>Thick</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>35 3/4 IN</td>
<td>11 IN</td>
<td>2.5 CM</td>
<td>17.0 LBS 7.7 KGS</td>
</tr>
</tbody>
</table>

### LAMB UNDER WILLOW

**1830** DF

<table>
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<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>31 3/4 IN</td>
<td>10 1/2 IN</td>
<td>2.5 CM</td>
<td>15.0 LBS 6.8 KGS</td>
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</tbody>
</table>

### LAMB UNDER WILLOW

**1822** DF

<table>
<thead>
<tr>
<th>Height</th>
<th>Width</th>
<th>Thick</th>
<th>Weight</th>
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</thead>
<tbody>
<tr>
<td>32 3/8 IN</td>
<td>10 1/2 IN</td>
<td>3.8 CM</td>
<td>16.0 LBS 7.3 KGS</td>
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### LAMB UNDER WILLOW

**9264** DF

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<th>Height</th>
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<th>Weight</th>
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<tbody>
<tr>
<td>12 1/4 IN</td>
<td>12 1/4 IN</td>
<td>4.8 CM</td>
<td>103.2 CM</td>
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### LAMB UNDER WILLOW

**9269** DF

<table>
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<th>Width</th>
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<tbody>
<tr>
<td>30 IN</td>
<td>9 1/2 IN</td>
<td>2.5 CM</td>
<td>4.5 KGS</td>
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</table>

### LAMB UNDER WILLOW

**1829** DF

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<th>Width</th>
<th>Thick</th>
<th>Weight</th>
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</thead>
<tbody>
<tr>
<td>30 DEG</td>
<td>22 DEG</td>
<td>30 DEG</td>
<td>22 DEG</td>
</tr>
</tbody>
</table>

| 32 3/8 | 82.2 | 10 1/2 | 26.7 |
| 1 1/2 | 3.8 |
| 15.0 | 6.8 |
| 35 3/4 | 90.8 |
| 11 | 27.9 |
| 1 | 3.8 |
| 17.0 | 7.3 |
| 17 1/4 | 43.8 |
| 5 1/4 | 13.3 |
| 1 | 2.5 |
| 17.0 | 7.3 |

### Church railings using lamb-under-willow heavy duty castings #1822, #1830, and #1836.

**Church railings**

- Using lamb-under-willow heavy duty castings #1822, #1830, and #1836.

**Scale:** 1 inch = 1 foot unless noted
**Ballisters**

**Section:** Ballisters

**REVISED DATE:** 01/20/95

**SCALE:** 1 INCH = 1 FOOT UNLESS NOTED

---

**9193 NEW**
- Bar ends are 3/4 in. square.
- Height: 42 in., Width: 1 1/2 in., Thickness: 1 1/2 in., Weight: 2.8 lbs.
- Height: 106.7 cm, Width: 3.8 cm, Thickness: 3.8 cm, Weight: 1.3 kgs.

**150 NEW**
- Bar ends are 3/4 in. diameter.
- Height: 101.6 cm, Width: 7.0 cm, Thickness: 7.0 cm, Weight: 1.6 kgs.

**151 NEW**
- Top end is 3/4 in. square.
- Bottom end is 1 1/2 in. square.
- Height: 40 in., Width: 1 1/2 in., Thickness: 1 1/2 in., Weight: 4.0 lbs.
- Height: 101.6 cm, Width: 7.0 cm, Thickness: 7.0 cm, Weight: 1.8 kgs.

**152 NEW**
- Bar ends are 1 in. diameter.
- Height: 40 3/8 in., Width: 1 7/8 in., Thickness: 1 7/8 in., Weight: 3.8 lbs.
- Height: 103.2 cm, Width: 4.8 cm, Thickness: 4.8 cm, Weight: 3.8 kgs.

---

**9208 NEW**
- Center is 1 7/8 in. diameter.
- Height: 40 1/4 in., Width: 1 1/2 in., Thickness: 1 1/2 in., Weight: 4.1 lbs.
- Height: 102.2 cm, Width: 3.8 cm, Thickness: 3.8 cm, Weight: 1.9 kgs.

**9209 NEW**
- Center is 1 1/2 in. diameter.
- Height: 40 1/4 in., Width: 1 7/8 in., Thickness: 1 7/8 in., Weight: 4.2 lbs.
- Height: 102.2 cm, Width: 4.8 cm, Thickness: 4.8 cm, Weight: 1.9 kgs.

**9238 NEW**
- Top end is 3/4 in. diameter.
- Bottom end is 1 1/2 in. square.
- Height: 40 1/4 in., Width: 1 1/2 in., Thickness: 1 1/2 in., Weight: 5.2 lbs.
- Height: 102.2 cm, Width: 3.8 cm, Thickness: 3.8 cm, Weight: 2.3 kgs.

**9288 NEW**
- Top end is 3/4 in. diameter.
- Bottom end is 1 1/2 in. square.
- Height: 43 in., Width: 1 1/2 in., Thickness: 2 in., Weight: 6.1 lbs.
- Height: 109.2 cm, Width: 3.8 cm, Thickness: 5.1 cm, Weight: 2.8 kgs.
TWO PIECES REQUIRED FOR EACH ASSEMBLY. HOLE IS 1.6" I.D. DIA. PIECE FITS OVER NOMINAL 1 1/4 SCHED 40 PIPE.

**9258**

NEW

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Height (IN)</th>
<th>Height (CM)</th>
<th>Width (IN)</th>
<th>Width (CM)</th>
<th>Thickness (IN)</th>
<th>Thickness (CM)</th>
<th>Weight (LBS)</th>
<th>Weight (KGS)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 1/4&quot;</td>
<td>31</td>
<td>78.7</td>
<td>4 1/4</td>
<td>10.8</td>
<td>2 1/8</td>
<td>5.4</td>
<td>10.2</td>
<td>4.7</td>
</tr>
</tbody>
</table>

26 1/2 INCHES LONG

HOLE IS 2 3/8 DIAMETER.

PIECE FITS OVER A 2 INCH PIPE.

**990**

NEW

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Height (IN)</th>
<th>Height (CM)</th>
<th>Width (IN)</th>
<th>Width (CM)</th>
<th>Thickness (IN)</th>
<th>Thickness (CM)</th>
<th>Weight (LBS)</th>
<th>Weight (KGS)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2&quot;</td>
<td>26 1/2</td>
<td>67.3</td>
<td>6 1/2</td>
<td>16.5</td>
<td>6 1/2</td>
<td>16.5</td>
<td>16.0</td>
<td>7.3</td>
</tr>
</tbody>
</table>

28 1/2 INCHES LONG

HOLE IS 2 3/8 DIAMETER.

PIECE FITS OVER A 2 INCH PIPE.

**998**

NEW

<table>
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<tr>
<th>Diameter</th>
<th>Height (IN)</th>
<th>Height (CM)</th>
<th>Width (IN)</th>
<th>Width (CM)</th>
<th>Thickness (IN)</th>
<th>Thickness (CM)</th>
<th>Weight (LBS)</th>
<th>Weight (KGS)</th>
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<tbody>
<tr>
<td>2&quot;</td>
<td>28 1/2</td>
<td>72.4</td>
<td>6 1/2</td>
<td>16.5</td>
<td>6 1/2</td>
<td>16.5</td>
<td>17.0</td>
<td>7.7</td>
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</table>

**9250**

NEW

STEEPLE

ALL HORIZONTAL CROSS SECTIONS OF THIS PIECE ARE CIRCLES.

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Height (IN)</th>
<th>Height (CM)</th>
<th>Width (IN)</th>
<th>Width (CM)</th>
<th>Thickness (IN)</th>
<th>Thickness (CM)</th>
<th>Weight (LBS)</th>
<th>Weight (KGS)</th>
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</thead>
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<tr>
<td>2&quot;</td>
<td>26 1/4</td>
<td>66.7</td>
<td>7</td>
<td>17.8</td>
<td>6 1/2</td>
<td>16.5</td>
<td>2.3</td>
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</table>

END DIAMETERS ARE 1 1/4 INCHES.

CENTER AND MAX DIAMETER IS 1 1/4 INCHES.

**9260**

NEW

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Height (IN)</th>
<th>Height (CM)</th>
<th>Width (IN)</th>
<th>Width (CM)</th>
<th>Thickness (IN)</th>
<th>Thickness (CM)</th>
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<th>Weight (KGS)</th>
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<tr>
<td>1 1/4&quot;</td>
<td>22 1/2</td>
<td>57.2</td>
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<td>2.9</td>
<td>1 1/8</td>
<td>2.9</td>
<td>11.1</td>
<td>5.0</td>
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</table>

REVISION DATE: 01/20/95

SCALE: 1 INCH = 1 FOOT UNLESS NOTED
<table>
<thead>
<tr>
<th>Style</th>
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<th>Description</th>
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</thead>
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<tr>
<td>8122</td>
<td>FB</td>
<td>NEW</td>
</tr>
<tr>
<td>8119</td>
<td>FB</td>
<td>OLD 19R</td>
</tr>
<tr>
<td>8117</td>
<td>SF</td>
<td>OLD 17R</td>
</tr>
<tr>
<td>8126</td>
<td>FB</td>
<td>NEW</td>
</tr>
<tr>
<td>8127</td>
<td>FB</td>
<td>NEW</td>
</tr>
<tr>
<td>8120</td>
<td>FB</td>
<td>OLD 20R</td>
</tr>
<tr>
<td>8128</td>
<td>FB</td>
<td>NEW</td>
</tr>
</tbody>
</table>

**Dimensions:**
- **Height:**
  - 2 3/4 IN (7.0 CM)
  - 11 5/8 IN (29.5 CM)
  - 2 1/8 IN (5.4 CM)
  - 2 3/4 IN (7.6 CM)
  - 3 3/4 IN (9.7 CM)
  - 11 1/4 IN (28.6 CM)
  - 2 1/8 IN (5.4 CM)
  - 2 3/4 IN (7.9 CM)
  - 3 1/8 IN (7.9 CM)
  - 2 3/4 IN (7.6 CM)
  - 3 1/8 IN (7.9 CM)
  - 3 1/2 IN (8.9 CM)
  - 3 1/8 IN (7.9 CM)
  - 2 1/2 IN (6.4 CM)
  - 1 7/8 IN (4.8 CM)
  - 3/16 IN (0.5 IN)
  - 0.03 IN (0.01 CM)

- **Width:**
  - 2 3/4 IN (7.0 CM)
  - 5 IN (12.7 CM)
  - 7 3/4 IN (9.7 CM)
  - 3 1/8 IN (7.9 CM)
  - 3 1/8 IN (7.9 CM)
  - 3 1/2 IN (8.9 CM)
  - 3 1/2 IN (8.9 CM)
  - 1 7/8 IN (4.8 CM)
  - 3/16 IN (0.5 IN)

- **Thickness:**
  - 1/4 IN (0.6 CM)
  - 1/4 IN (0.6 CM)
  - 1/4 IN (0.6 CM)
  - 1/4 IN (0.6 CM)
  - 1/4 IN (0.6 CM)
  - 1/4 IN (0.6 CM)
  - 1/4 IN (0.6 CM)

- **Weight:**
  - 0.1 LBS (0.4 KGS)
  - 0.1 LBS (0.4 KGS)
  - 0.1 LBS (0.4 KGS)
  - 0.1 LBS (0.4 KGS)

**Additional Information:**
- **Revision Date:** 01/20/95
- **Scale:** 3 INCHES = 1 FOOT UNLESS NOTED

**Notations:**
- FB: Fluer De Lis
- SF: Star Flower

**Contact Information:**
- Toll Free: (800) 527-1318
- Local: (972) 286-2368
- Fax: (972) 557-4727
<table>
<thead>
<tr>
<th>Number</th>
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<th>Width</th>
<th>Thickness</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
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<td>7 1/4&quot;</td>
<td>4 3/8&quot;</td>
<td>5/8&quot;</td>
<td>.5 lbs</td>
</tr>
<tr>
<td>8132</td>
<td>8 7/8&quot;</td>
<td>7 3/8&quot;</td>
<td>1/2&quot;</td>
<td>1.0 lbs</td>
</tr>
<tr>
<td>8188</td>
<td>7&quot;</td>
<td>4&quot;</td>
<td>3/8&quot;</td>
<td>.2 lbs</td>
</tr>
<tr>
<td>4421</td>
<td>4.5&quot;</td>
<td>3 7/8&quot;</td>
<td>1/4&quot;</td>
<td>.15 lbs</td>
</tr>
<tr>
<td>8149</td>
<td>1 7/8&quot; dia</td>
<td>1 7/8&quot; dia</td>
<td>1/4&quot;</td>
<td>.2 lbs</td>
</tr>
<tr>
<td>9069</td>
<td>2 3/8&quot; dia</td>
<td>2 3/8&quot; dia</td>
<td>3/8&quot;</td>
<td>.1 lbs</td>
</tr>
<tr>
<td>8137</td>
<td>3 1/8&quot; dia</td>
<td>3 1/8&quot; dia</td>
<td>3/8&quot;</td>
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<tr>
<td>8170</td>
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<td>3 1/8&quot; dia</td>
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</tr>
<tr>
<td>8144</td>
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<td>1/2&quot;</td>
<td>.4 lbs</td>
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<tr>
<td>8112</td>
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<td>4&quot;</td>
<td>1 1/8&quot;</td>
<td>.8 lbs</td>
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<td>Design</td>
<td>Height</td>
<td>Width</td>
<td>Thickness</td>
<td>Weight</td>
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<tr>
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<td>--------</td>
<td>-------</td>
<td>-----------</td>
<td>--------</td>
</tr>
<tr>
<td>8277</td>
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<tr>
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<td>6&quot; dia</td>
<td>1/2&quot;</td>
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<tr>
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<td>4 3/4&quot; dia</td>
<td>1/8&quot;</td>
<td>0.4 lbs</td>
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<tr>
<td>9495</td>
<td>10 1/2&quot; dia</td>
<td>10 1/2&quot; dia</td>
<td>1 1/2&quot;</td>
<td>5.5 lbs</td>
</tr>
<tr>
<td>8136/8139</td>
<td>3 1/2&quot; dia</td>
<td>3 1/2&quot; dia</td>
<td>3/4&quot;</td>
<td>0.8 lbs/pr</td>
</tr>
<tr>
<td>8138</td>
<td>7 3/4&quot;</td>
<td>7 3/4&quot;</td>
<td>7/8&quot;</td>
<td>4.8 lbs</td>
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<tr>
<td>9302</td>
<td>2 3/8&quot; dia</td>
<td>2 3/8&quot; dia</td>
<td>3/4&quot;</td>
<td>0.2 lbs</td>
</tr>
<tr>
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<td>6 1/4&quot;</td>
<td>8 1/4&quot;</td>
<td>1&quot;</td>
<td>1.4 lbs</td>
</tr>
<tr>
<td>8133</td>
<td>3 5/8&quot;</td>
<td>3 7/8&quot;</td>
<td>3/4&quot;</td>
<td>0.4 lbs</td>
</tr>
</tbody>
</table>

**NEW**

- **FLAT BACK**
- **HOLLOW BACK**
- **DOUBLE FACE**

**Button Rosette**

**Flower Rosette**

**Flat Back**

**Hollow Back**

**Double Face**

**Design Matches**

#848 & #849

**#849 & #849**

**#920 & #922**

**See Other Shells on Page 132**

**Matches Centers**

#920 & #922
NOTE: EACH PIECE HAS TWO TABS WITH A 1/8 INCH HOLE FOR SCREW ON APPLICATIONS.

---

**3730 FB**

- **Height:** 16 1/2 IN
- **Width:** 7 1/2 IN
- **Thickness:** 1 IN
- **Weight:** 1.2 LBS

---

**3731 FB**

- **Height:** 16 1/2 IN
- **Width:** 7 1/2 IN
- **Thickness:** 1 IN
- **Weight:** 1.2 LBS

---

**3732 FB**

- **Height:** 8 7/8 IN
- **Width:** 9 1/2 IN
- **Thickness:** 3/4 IN
- **Weight:** 0.5 LBS

---

**3733 FB**

- **Height:** 6 1/4 IN
- **Width:** 9 1/4 IN
- **Thickness:** 3/4 IN
- **Weight:** 0.4 LBS

---

**3727 SBO**

- **Height:** 12 1/4 IN
- **Width:** 7 1/2 IN
- **Thickness:** 1 1/4 IN
- **Weight:** 6.8 LBS

---

**3734 SBO**

- **Height:** 8 1/8 IN
- **Width:** 7 1/2 IN
- **Thickness:** 2 3/4 IN
- **Weight:** 0.9 LBS

---

**7732 FB**

- **Height:** 8 1/4 IN
- **Width:** 7 1/2 IN
- **Thickness:** 2 3/4 IN
- **Weight:** 2.9 LBS

---

**7737 FB**

- **Height:** 7 1/2 IN
- **Width:** 7 1/2 IN
- **Thickness:** 3/4 IN
- **Weight:** 2.2 LBS

---

**892 FB**

- **Height:** 14 1/4 IN
- **Width:** 12 1/8 IN
- **Thickness:** 5/8 IN
- **Weight:** 6.2 LBS

---

**LION HEAD**

- **Scale:** 6 INCHES = 1 FOOT

---

**Plaques**

**3730 NEW**

**3731 NEW**

**3732 NEW**

**3733 NEW**

**3727 NEW**

**3734 NEW**

**9281 NEW**

**7732 NEW**

**7737 NEW**

**3726 SBO**

**892 FB**

---

**Scale:** 1 INCH = 1 FOOT UNLESS NOTED
### 61 SBO
- **Height**: 7 in = 17.8 cm
- **Width**: 16 3/8 in = 41.6 cm
- **Thick**: 1 in = 2.5 cm
- **Weight**: 0.8 lbs = 0.4 kg

### 62 SBO
- **Height**: 5 1/2 in = 14.0 cm
- **Width**: 19 1/2 in = 49.5 cm
- **Thick**: 2 7/8 in = 7.3 cm
- **Weight**: 1.2 lbs = 0.6 kg

### 63 SBO
- **Height**: 9 1/4 in = 24.8 cm
- **Width**: 27 1/2 in = 69.8 cm
- **Thick**: 2 5/8 in = 6.7 cm
- **Weight**: 3.2 lbs = 1.4 kg

### 64 SBO
- **Height**: 5 5/8 in = 14.3 cm
- **Width**: 14.3 cm
- **Thick**: 1.6 cm
- **Weight**: 0.5 lbs = 0.2 kg

### 8412 DF
- **Height**: 5 5/8 in = 14.3 cm
- **Width**: 5 5/8 in = 14.3 cm
- **Thick**: 1.6 cm
- **Weight**: 0.5 lbs = 0.2 kg

### 8413 DF
- **Height**: 5 5/8 in = 14.3 cm
- **Width**: 5 5/8 in = 14.3 cm
- **Thick**: 1.6 cm
- **Weight**: 0.5 lbs = 0.2 kg

### 8412 NEW
- **Height**: 5 5/8 in = 14.3 cm
- **Width**: 5 5/8 in = 14.3 cm
- **Thick**: 1.6 cm
- **Weight**: 0.5 lbs = 0.2 kg

### 8413 NEW
- **Height**: 36 1/4 in = 92.1 cm
- **Width**: 39 1/2 in = 100.3 cm
- **Thick**: 2 in = 5.1 cm
- **Weight**: 32.4 lbs = 14.7 kg

---

**NOTE**: SCALE IS 1 INCH = 1 FOOT

**SCALE**: 3 INCHES = 1 FOOT UNLESS NOTED

---

**Plaques:**
- **Eagle Castings**

---

**Section:**
- Toll Free (800) 527-1318
- (972) 286-2368
- Fax: (972) 557-4727

---

**REVISION DATE:** 01/20/95

---

**Scale:** 3 INCHES = 1 FOOT UNLESS NOTED
<table>
<thead>
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<tr>
<td>7715</td>
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<td>21 1/4</td>
<td>1.9 CM</td>
<td>1.5 LBS</td>
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<td>1.6 CM</td>
<td>1.2 LBS</td>
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<tr>
<td>8412</td>
<td>DF</td>
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<td>1.3 CM</td>
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<tr>
<td>8413</td>
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<td>1.3 CM</td>
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<td>1.3 CM</td>
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<tr>
<td>2510</td>
<td>FB</td>
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<td>5 5/8</td>
<td>1.3 CM</td>
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<tr>
<td>2511</td>
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<td>5 5/8</td>
<td>1.3 CM</td>
<td>0.6 LBS</td>
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<tr>
<td>2518</td>
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<td>17 7/8</td>
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<td>1.1 LBS</td>
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<tr>
<td>8569</td>
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<td>21 1/4</td>
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**NOTE:** This item not to scale.

**SCALE:** 1 INCH = 1 FOOT UNLESS NOTED
<table>
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<tr>
<th>Number</th>
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<th>Width (CM)</th>
<th>Thickness (IN)</th>
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<tbody>
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<td>1.8</td>
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<td>3.9</td>
<td>1.8</td>
</tr>
</tbody>
</table>

**HORSES HEAD: TWO PIECES REQUIRED. FITS OVER A 2 INCH OUTSIDE DIAMETER TUBE. PIECES MAY BE WELDED TOGETHER.**

**DATA BELOW IS FOR EACH PIECE**

<table>
<thead>
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<th>Height (CM)</th>
<th>Width (IN)</th>
<th>Width (CM)</th>
<th>Thickness (IN)</th>
<th>Thickness (CM)</th>
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<th>Weight (KGS)</th>
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<td>30.8</td>
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<td>30.5</td>
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<td>1.8</td>
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Decorative Hinge Straps

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<td>3/16 IN</td>
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<tr>
<td>3715</td>
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<td>0.8 LBS</td>
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<tr>
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</tr>
<tr>
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<td>0.5 LBS</td>
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</tr>
<tr>
<td>3722</td>
<td>FB</td>
<td>2 1/4 IN</td>
<td>13 IN</td>
<td>3/16 IN</td>
<td>0.2 LBS</td>
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<td>FB</td>
<td>1 1/2 IN</td>
<td>9 3/4 IN</td>
<td>1/8 IN</td>
<td>0.1 LBS</td>
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REVISION DATE: 12/27/94

SCALE: 1 INCH = 1 FOOT UNLESS NOTED
**Section:**

**Star Castings**

<table>
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<tr>
<th>Catalog No</th>
<th>Dia. In</th>
<th>Dia. CM</th>
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<th>THCK CM</th>
<th>WT LBS</th>
<th>KGS</th>
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<td>713</td>
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**8121**

- **NEW**
- **FB**
- **HEIGHT**: 8 3/4 IN
- **WIDTH**: 9 1/8 IN
- **THICK**: 0.5 LBS
- **WEIGHT**: 2.5 LBS

**9244**

- **NEW**
- **FB**
- **HEIGHT**: 7 1/8 IN
- **WIDTH**: 7 IN
- **THICK**: 0.8 LBS
- **WEIGHT**: 4.3 LBS

**8108**

- **OLD 8R**
- **FB**
- **HEIGHT**: 7 1/2 IN
- **WIDTH**: 4 1/2 IN
- **THICK**: 0.2 LBS
- **WEIGHT**: 2.0 LBS

**8402**

- **NEW**
- **FB**
- **HEIGHT**: 5 5/8 IN
- **WIDTH**: 5 5/8 IN
- **THICK**: 0.8 LBS
- **WEIGHT**: 3.2 LBS

**711**

- **NEW**
- **11 5/8 IN. DIA**
- **FB**
- **CATALOG NO**: 711
- **DIA. IN**: 11 5/8
- **DIA. CM**: 29.5
- **THICK IN**: 1
- **THICK CM**: 2.5
- **WT LBS**: 4.3
- **KGS**: 2.0

**712**

- **NEW**
- **2 FT DIA**
- **FB**
- **HEIGHT**: 21 1/4 IN
- **WIDTH**: 21 1/4 IN
- **THICK**: 1/2 IN
- **WEIGHT**: 1.1 LBS

**713**

- **NEW**
- **3 FT DIA**
- **FB**
- **HEIGHT**: 28 5/8 IN
- **WIDTH**: 28 5/8 IN
- **THICK**: 1/2 IN
- **WEIGHT**: 5.2 LBS

**714**

- **NEW**
- **4 FT DIA**
- **FB**
- **HEIGHT**: 36 IN
- **WIDTH**: 36 IN
- **THICK**: 1 1/4 IN
- **WEIGHT**: 11.5 LBS

**9237**

- **NEW**
- **DF**
- **HEIGHT**: 6 3/4 IN
- **WIDTH**: 6 3/4 IN
- **THICK**: 1 1/4 IN
- **WEIGHT**: 2.3 LBS

**932**

- **NEW**
- **DF**
- **HEIGHT**: 28 5/8 IN
- **WIDTH**: 28 5/8 IN
- **THICK**: 5/8 IN
- **WEIGHT**: 5.2 LBS

Circle star #9237 and spear point #8211 custom designed and made for the White House Visitors center, Washington, D.C.

Revision Date: 12/27/94
NOTE: WHEN ORDERING ITEMS FROM THIS PAGE USE THE FIRST CATALOG NUMBERS TO INDICATE SIZE AND STYLE AND THE LAST LETTER TO INDICATE THE SPECIFIC LETTER DESIRED.

FOR EXAMPLE: TO ORDER A LETTER "G" THAT IS 10 INCHES TALL AND OLD ENGLISH DESIGN, TAKE THE BASE CATALOG NUMBER 560 AND ADD THE LETTER "G". THEN THE CATALOG NUMBER FOR THAT PIECE WOULD BE 560G.
NOTE: WHEN ORDERING ITEMS FROM THIS PAGE USE THE FIRST CATALOG NUMBERS TO INDICATE SIZE AND STYLE AND THE LAST NUMBER TO INDICATE THE SPECIFIC NUMBER DESIRED.

FOR EXAMPLE; TO ORDER A NUMBER "EIGHT" THAT IS 10 INCHES TALL, TAKE THE BASE NUMBER 548 AND ADD THE DIGIT 8. THEN THE CATALOG NUMBER FOR THAT PIECE WOULD BE 5488.
NOTE: WHEN ORDERING ITEMS FROM THIS PAGE USE THE FIRST CATALOG NUMBERS TO INDICATE SIZE AND STYLE AND THE LAST NUMBER TO INDICATE THE SPECIFIC NUMBER DESIRED.

FOR EXAMPLE; TO ORDER A NUMBER "EIGHT" THAT IS 3 INCHES TALL, TAKE THE BASE NUMBER 680 AND ADD THE DIGIT 8. THEN THE CATALOG NUMBER FOR THAT PIECE WOULD BE 6808.
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<thead>
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<th>Height</th>
<th>Width</th>
<th>Thick</th>
<th>Weight</th>
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<td>1&quot;</td>
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<td>0.1</td>
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<tr>
<td>8580</td>
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<tr>
<td>8582</td>
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<td>0.3</td>
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<tr>
<td>8590</td>
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<tr>
<td>8540</td>
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<tr>
<td>8533</td>
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<tr>
<td>134</td>
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<td>135</td>
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<td>0.3</td>
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<tr>
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<td>20.3</td>
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<td>0.6</td>
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</table>

HOLE IS 1 IN. DIAMETER. PROFILE MATCHES NUMBER 9218 FOUND ON PAGE 75.

HOLES ON FLANGE ARE 3/16 IN. DIAMETER.

HOLE IS 2 IN. DIAMETER.

HOLE IS 1 1/16 IN. DIAMETER.

HOLE IS 2 IN. DIAMETER. THIS PIECE WITH 133 MAY BE USED AS A PAIR. SEE SKETCH ON PAGE NO. 79.

NOTE: THIS PIECE NOT TO SCALE

HOLE IS 3 IN. DIAMETER. THIS PIECE WITH 138 MAY BE USED AS A PAIR. SEE SKETCH ON PAGE NO. 79.

NOTE: THIS PIECE NOT TO SCALE

INSIDE HOLE IS 4 IN. DIAMETER.

SCALE: 3 INCHES = 1 FOOT UNLESS NOTED

REVISION DATE: 01/21/95
NEW
V TYPE 1/2"

HOLE IS 1/2” X 1/2” SQUARE / FLAT BOTTOM

8451
HEIGHT: 2"
WIDTH: 2"
THICK: 1/2"
WEIGHT: .1 lbs

NEW
A TYPE 1/2"

HOLE IS 1/2” X 1/2” SQUARE

4803
HEIGHT: 2 3/8"
WIDTH: 1 1/4"
THICK: 7/8"
WEIGHT: .1 lbs

NEW
A TYPE 1/2"

HOLE IS 1/2” X 1/2” SQUARE

8450
HEIGHT: 1 3/4"
WIDTH: 1 3/4"
THICK: 1"
WEIGHT: .1 lbs

NEW
S TYPE 5/8"

HOLE IS 5/8” X 5/8” SQUARE

1632
HEIGHT: 1 1/2"
WIDTH: 1 1/2"
THICK: 1"
WEIGHT: .1 lbs

NEW
A TYPE 3/4"

HOLE IS 3/4” X 3/4” SQUARE

8906
HEIGHT: 3 1/2"
WIDTH: 2 1/2"
THICK: 1/2"
WEIGHT: .2 lbs

NEW
A TYPE 3/4"

HOLE IS 3/4” X 3/4” SQUARE

8460
HEIGHT: 2"
WIDTH: 3 7/8"
THICK: 1"
WEIGHT: .2 lbs

FLANGES
SQUARE HOLE 1/2”, 5/8” & 3/4”

HOLE IS 1/2” X 1/2” SQUARE / FLAT BOTTOM
HOLE IS 1/2” X 1/2” SQUARE
HOLE IS 1/2” X 1/2” SQUARE
HOLE IS 5/8” X 5/8” SQUARE
HOLE IS 5/8” X 5/8” SQUARE
HOLE IS 3/4” X 3/4” SQUARE
HOLE IS 3/4” X 3/4” SQUARE
A type tight at top
S type straight walls
V type tight at bottom
| NEW | V TYPE | 1" | 8610 | HEIGHT: 3"  
|     | WIDTH: 3"  
|     | THICK: 1"  
|     | WEIGHT: 0.3 lbs |  
| NEW | A TYPE | 1" | 8421 | HEIGHT: 3 3/4"  
|     | WIDTH: 1 3/4"  
|     | THICK: 1 3/8"  
|     | WEIGHT: .2 lbs |  
| NEW | A TYPE | 1" | 9218 | HEIGHT: 2 1/2"  
|     | WIDTH: 2 1/2"  
|     | THICK: 7/8"  
|     | WEIGHT: .2 lbs |  
| NEW | A TYPE | 1" | 2023 | HEIGHT: 3 3/4"  
|     | WIDTH: 1 3/4"  
|     | THICK: 1 1/4"  
|     | WEIGHT: .2 lbs |  
| NEW | A TYPE | 1" | 8430 | HEIGHT: 2 3/8"  
|     | WIDTH: 2 3/8"  
|     | THICK: 1"  
|     | WEIGHT: .1 lbs |  
| NEW | V TYPE | 1" | 8470 | HEIGHT: 2 3/4"  
|     | WIDTH: 2 3/4"  
|     | THICK: 1"  
|     | WEIGHT: .2 lbs |  
| NEW | A TYPE | 1" | 8471 | HEIGHT: 2 5/8"  
|     | WIDTH: 2 5/8"  
|     | THICK: 1/2"  
|     | WEIGHT: .1 lbs |  
| NEW | V TYPE | 1" | 8425 | HEIGHT: 3 5/8"  
|     | WIDTH: 3 5/8"  
|     | THICK: 2"  
|     | WEIGHT: .3 lbs |  
| NEW | A TYPE | 1" | 8420 | HEIGHT: 2 3/4"  
|     | WIDTH: 1 3/4"  
|     | THICK: 1 1/4"  
|     | WEIGHT: .2 lbs |  
| NEW | A TYPE | 1" | 8426 | HEIGHT: 2 3/4"  
|     | WIDTH: 1 3/4"  
|     | THICK: 1 1/4"  
|     | WEIGHT: |
FLANGES
SQUARE HOLE 1 1/4"

NEW
DRIVE IN SHOE FOR 1" SQUARE

TOP IS 5/8" SQUARE

8424
HEIGHT: 2"
WIDTH: 1 1/8"
THICK: 1 1/4"
WEIGHT: .1 lbs

NEW
DRIVE IN SHOE FOR 1" SQUARE

TOP IS 3/4" SQUARE

8423
HEIGHT: 2 5/8"
WIDTH: 2 5/8"
THICK: 1 1/2"
WEIGHT: .1 lbs

NEW
A TYPE 1 1/4"

HOLE IS 1 1/4" X 1 1/4" SQUARE

8480
HEIGHT: 3"
WIDTH: 3"
THICK: 1 1/4"
WEIGHT: .3 lbs

NEW
V TYPE 1 1/4"

HOLE IS 1 1/4" X 1 1/4" SQUARE

8489
HEIGHT: 4 3/4"
WIDTH: 2 5/8"
THICK: 1 1/4"
WEIGHT: .35 lbs

NEW
V TYPE 1 1/4"

HOLE IS 1 1/4" X 1 1/4" SQUARE

8487
HEIGHT: 1 1/4"
WIDTH: 3"
THICK: 3"
WEIGHT: .3 lbs

NEW
V TYPE 1 1/4"

HOLE IS 1 1/4" X 1 1/4" SQUARE

8481
HEIGHT: 3 1/4"
WIDTH: 3 1/4"
THICK: 1/4"
WEIGHT: .1 lbs

A type tight at top
S type straight walls
V type tight at bottom
<table>
<thead>
<tr>
<th>Model</th>
<th>Height</th>
<th>Width</th>
<th>Thickness</th>
<th>Weight</th>
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<td>4 7/8&quot;</td>
<td>2&quot;</td>
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</tr>
<tr>
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<td>4&quot;</td>
<td>2&quot;</td>
<td>.9 lbs</td>
</tr>
<tr>
<td>1423</td>
<td>6&quot;</td>
<td>4&quot;</td>
<td>1 5/8&quot;</td>
<td>.6 lbs</td>
</tr>
<tr>
<td>137</td>
<td>5 1/2&quot;</td>
<td>4 1/2&quot;</td>
<td>1 1/2&quot;</td>
<td>.55 lbs</td>
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</tbody>
</table>

**NEW**

- **A Type 2 1/2"**
  - Hole is 2 1/2" x 2 1/2" square

- **V Type 2 1/2"**
  - Hole is 2 1/2" x 2 1/2" square

- **V Type 3"**
  - Hole is 3 1/4" x 3 1/4" square

**NEW**

- **V Type 3"**
  - Hole is 3 1/4" x 3 1/4" square

- **V Type 3"**
  - Hole is 3" x 3" square

**Square Holes**:

- Hole is 2 1/2" x 2 1/2" square
- Hole is 3 1/4" x 3 1/4" square
- Hole is 3" x 3" square
NEW V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 3 5/8"
WIDTH: 2 3/8"
THICK: 1"
WEIGHT: .15 lbs

NEW V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 3 1/8"
WIDTH: 3"
THICK: 1"
WEIGHT: .3 lbs

NEW V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 3"
WIDTH: 4 1/2"
THICK: 1"
WEIGHT: .3 lbs

NEW V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 4 3/8"
WIDTH: 3 1/8"
THICK: 1 1/2"
WEIGHT: .45 lbs

NEW A TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 3 3/8"
WIDTH: 3 1/4"
THICK: 1 1/4"
WEIGHT: .3 lbs

NEW V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 3 5/8"
WIDTH: 3 3/8"
THICK: 1 3/8"
WEIGHT: .4 lbs

NEW V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 4 5/8"
WIDTH: 3 1/4"
THICK: 1 3/8"
WEIGHT: .4 lbs

NEW V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 2 3/8"
WIDTH: 2 1/2"
THICK: 1"
WEIGHT: .15 lbs

NEW V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 3 1/4"
WIDTH: 3 1/2"
THICK: 1"
WEIGHT: .25 lbs

NEW V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 6 1/8"
WIDTH: 2 7/8"
THICK: 1 1/2"
WEIGHT: .4 lbs

NEW V TYPE DOUBLE FACE

1 1/2" HIGH

9702 V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 4 3/8"
WIDTH: 3 1/8"
THICK: 1 1/2"
WEIGHT: .45 lbs

NEW V TYPE DOUBLE FACE

1 7/16" HIGH

8047 V TYPE

SEE PROFILES OF OPENINGS ON PAGE 75H

HEIGHT 4 1/2"
WIDTH: 3 1/2"
THICK: 1 7/16"
WEIGHT: .4 lbs

NEW V TYPE DOUBLE FACE

2" HIGH
Toll Free (800) 527-1318
(972) 286-2368
Fax: (972) 557-4727

Section: Finials

**8006**
**NEW**
**3/4”**

**TOP VIEW**
SIDE VIEW
STUB IS 1/2 INCH LONG AND 5/8 INCH SQUARE. SEAT IS ONE INCH SQUARE.
SCALE: 1/2 INCH = 1 INCH.
HEIGHT 1 IN 2.5 CM
WIDTH 1 IN 2.5 CM
THICK 1 IN 2.5 CM
WEIGHT 0.095 LBS 0.04 KG

**8002**
**OLD 3F**
**1”**

**TOP VIEW**
SIDE VIEW
STUB IS 3/4 INCH LONG AND 7/8 INCH SQUARE. IT FITS INTO A 1 INCH SQUARE 16 GAGE TUBING.
SCALE: 1/2 INCH = 1 INCH.
HEIGHT 1 1/2 IN 3.8 CM
WIDTH 1 1/2 IN 3.8 CM
THICK 1 1/2 IN 2.9 CM
WEIGHT 0.1 LG 0.06 KG

**9267**
**NEW**
**1”**

**TOP VIEW**
SIDE VIEW
STUB IS 3/4 INCH LONG AND 7/8 INCH SQUARE. IT FITS INTO A 1 INCH SQUARE 16 GAGE TUBING.
SCALE: 1/2 INCH = 1 INCH.
HEIGHT 1 1/4 IN 3.2 CM
WIDTH 1 1/4 IN 3.2 CM
THICK 1 1/4 IN 3.2 CM
WEIGHT 0.2 LBS 0.09 KG

**7726**
**NEW**
**2”**

**TOP VIEW**
SIDE VIEW
STUB IS 5/8 INCH LONG AND 7/8 INCH SQUARE. IT FITS INTO A 1 INCH SQUARE 16 GAGE TUBING.
SCALE: 1/2 INCH = 1 INCH.
HEIGHT 2 IN 5.7 CM
WIDTH 2 IN 5.7 CM
THICK 1 3/8 IN 3.5 CM
WEIGHT 0.5 LBS 0.2 KG

**8020**
**NEW**
**1”**

SIDE VIEW. USED AS A LAMBS TOUCHGE PIECE.
STUB IS 1/2 INCH SQUARE BY 3/8 INCH LONG. SEAT IS 1/4 INCH SQUARE.
HEIGHT 5 IN 12.7 CM
WIDTH 2 IN 5.0 CM
THICK 1 1/4 IN 2.9 CM
WEIGHT 0.84 LBS 0.37 KG

**8022**
**NEW**
**1 1/2”**

SIDE VIEW. USED AS A LAMBS TOUCHGE PIECE.
STUB IS 1 1/2 INCH SQUARE BY 7/8 INCH LONG. SEAT IS 1 1/4 INCH SQUARE.
HEIGHT 5 5/8 IN 14.3 CM
WIDTH 3 5/8 IN 9.3 CM
THICK 1 1/4 IN 2.9 CM
WEIGHT 0.55 LBS 0.25 KG

**8024**
**NEW**
**1 1/4”**

SIDE VIEW. USED AS A LAMBS TOUCHGE PIECE.
STUB IS 1 INCH SQUARE BY 7/8 INCH LONG. SEAT IS 1 1/2 INCH SQUARE.
HEIGHT 5 5/8 IN 14.3 CM
WIDTH 4 5/8 IN 11.3 CM
THICK 1 3/4 IN 4.4 CM
WEIGHT 0.5 LBS 0.23 KG

**132**
**FB**
HAND RAIL END CAP

**TOP VIEW**
SIDE VIEW
THIS PIECE IS 1/2 FULL SIZE.
HEIGHT 1 1/8 IN 2.9 CM
WIDTH 1 IN 2.5 CM
THICK 1/2 IN 1.3 CM
WEIGHT 0.07 LBS 0.03 KG

**133**
**FB**
HAND RAIL END CAP

**TOP VIEW**
SIDE VIEW
THIS PIECE IS 1/2 FULL SIZE.
HEIGHT 1 IN 2.5 CM
WIDTH 3 5/8 IN 9.3 CM
THICK 1/2 IN 1.3 CM
WEIGHT 0.11 LBS 0.05 KG

Revision Date: 01/2005

Scale: 5 Inches = 1 Foot unless noted.

77
Colonial Flanges

**134**

- **Height**: 4 1/2 in (12.1 cm)
- **Width**: 4 in (10.2 cm)
- **Thickness**: 1 1/4 in (3.2 cm)
- **Weight**: 0.6 lbs (0.2 kg)

Hole is 2 in. diameter. This piece with No. 137 may be used as a pair. See sketch to right.

**137**

- **Height**: 4 1/2 in (11.4 cm)
- **Width**: 5 5/8 in (14.3 cm)
- **Thickness**: 1 1/2 in (3.8 cm)
- **Weight**: 0.6 lbs (0.3 kg)

Hole is 3 in. square. This piece with No. 134 may be used as a pair. See sketch to right.

**135**

- **Height**: 5 3/4 in (14.6 cm)
- **Width**: 5 3/4 in (14.6 cm)
- **Thickness**: 1 3/8 in (3.5 cm)
- **Weight**: 1.1 lbs (0.5 kg)

Hole is 3 in. diameter. This piece with No. 138 may be used as a pair. See sketch to right.

**138**

- **Height**: 4 1/2 in (14.0 cm)
- **Width**: 6 3/4 in (17.1 cm)
- **Thickness**: 4 1/2 in (3.5 cm)
- **Weight**: 0.9 lbs (0.4 kg)

Hole is 4 in. square. This piece with No. 135 may be used as a pair. See sketch to right.

**8512**

- **Height**: 5 1/8 in (13.0 cm)
- **Width**: 5 1/8 in (13.0 cm)
- **Thickness**: 1 in (2.5 cm)
- **Weight**: 0.8 lbs (0.4 kg)

Hole is 3 3/4 in. square. Boss is 3/4 inch deep.

**Note:** This area not to scale.

**Colonial Flange Assembly**

(Using No. 135 and No. 138)

**New**

**Pipe or tubing to be supplied by customer.**

**SQUARE TUBING TO BE SUPPLIED BY CUSTOMER.**

**REVISION DATE: 01/23/95**

**SCALE: 3 INCHES = 1 FOOT UNLESS NOTED.**
<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Weight (lbs)</th>
<th>Weight (kgs)</th>
<th>Thickness (in)</th>
<th>Thickness (cm)</th>
<th>Width (in)</th>
<th>Width (cm)</th>
<th>Height (in)</th>
<th>Height (cm)</th>
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<tbody>
<tr>
<td>8262</td>
<td>1/2&quot; SEAT: 1 1/8 IN SQUARE, STUB SQUARE, 1 3/16 LONG</td>
<td>.3</td>
<td>.1</td>
<td>1 1/8</td>
<td>2.9</td>
<td>4</td>
<td>10.2</td>
<td>7</td>
<td>17.8</td>
</tr>
<tr>
<td>8212</td>
<td>5/8&quot; SEAT: 1 1/8 IN SQUARE, BOTTOM SQUARE, 1 3/4 LONG</td>
<td>.2</td>
<td>.1</td>
<td>1 1/8</td>
<td>2.9</td>
<td>4</td>
<td>10.2</td>
<td>7</td>
<td>17.8</td>
</tr>
<tr>
<td>7731</td>
<td>5/8&quot; STUB: 1/2 IN DIAMETER, 1 3/4 SQUARE, 1 3/4 LONG</td>
<td>.3</td>
<td>.1</td>
<td>1 1/8</td>
<td>2.9</td>
<td>4</td>
<td>10.2</td>
<td>7</td>
<td>17.8</td>
</tr>
<tr>
<td>8214</td>
<td>5/8&quot; SEAT: 1/2 IN SQUARE, STUB SQUARE, 1 3/16 LONG</td>
<td>.3</td>
<td>.1</td>
<td>1 1/8</td>
<td>2.9</td>
<td>4</td>
<td>10.2</td>
<td>7</td>
<td>17.8</td>
</tr>
<tr>
<td>8201</td>
<td>3/4&quot; SEAT: 1 IN SQUARE, STUB SQUARE, 3/4 LONG</td>
<td>.2</td>
<td>.1</td>
<td>1 1/8</td>
<td>2.9</td>
<td>4</td>
<td>10.2</td>
<td>7</td>
<td>17.8</td>
</tr>
<tr>
<td>7727</td>
<td>1&quot; STUB: 5/8 SQUARE, 7/8 LONG</td>
<td>.6</td>
<td>.3</td>
<td>2 3/4</td>
<td>7.0</td>
<td>7</td>
<td>17.8</td>
<td>10 3/8</td>
<td>26.4</td>
</tr>
<tr>
<td>8208</td>
<td>1&quot; SEAT: 1/2 SQUARE, STUB SQUARE, 7/8 LONG</td>
<td>.2</td>
<td>.1</td>
<td>1 1/8</td>
<td>2.9</td>
<td>4</td>
<td>10.2</td>
<td>7</td>
<td>17.8</td>
</tr>
<tr>
<td>8268</td>
<td>1&quot; FOR 1/8 WALL</td>
<td>.1</td>
<td>.07</td>
<td>1 1/8</td>
<td>2.9</td>
<td>4</td>
<td>10.2</td>
<td>7</td>
<td>17.8</td>
</tr>
<tr>
<td>8261</td>
<td>1&quot; SEAT: 1 1/2 SQUARE, STUB SQUARE, 1 1/2 LONG</td>
<td>.1</td>
<td>.06</td>
<td>1 1/2</td>
<td>3.8</td>
<td>1 1/2</td>
<td>3.8</td>
<td>7</td>
<td>17.8</td>
</tr>
<tr>
<td>9275</td>
<td>1&quot; DRIVE IN STUB: 3/4 SQUARE, 2 3/8 LONG</td>
<td>.01</td>
<td>.05</td>
<td>1.2</td>
<td>3.0</td>
<td>1.2</td>
<td>3.0</td>
<td>4.8</td>
<td>12.2</td>
</tr>
</tbody>
</table>

**Scale:** 3 INCHES = 1 FOOT UNLESS NOTED
<table>
<thead>
<tr>
<th>Model No.</th>
<th>Type</th>
<th>Height</th>
<th>Width</th>
<th>Thick</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>7718</td>
<td>NEW</td>
<td>3/4&quot;</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>8209</td>
<td>NEW</td>
<td>1&quot;</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>8211</td>
<td>NEW</td>
<td>1&quot;</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>7760</td>
<td>NEW</td>
<td>1 1/2&quot;</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Stubs**

- **7718**
  - New
  - Stub is 3/4 inch long by 3/8 inch square
  - Seat is 1 inch diameter

- **8209**
  - New
  - Seat is 1 inch in diameter. Stub is 3/4 inch in diameter and 2 3/4 inches long

- **8211**
  - New
  - This piece was used with catalog number 9237 (as shown on page 47) at the visitor's center, The White House, Washington, D.C.
  - Seat is 3/8 inch in diameter, stub is 3/4 inch diameter and 1 1/2 inches long

- **7760**
  - New
  - Stub is 1 1/4 inches square by 3/4 inch long. Seat is 1 5/8 inches square.

**Measurements**

- **7718**
  - Height: 1 1/2 in, Width: 2 3/4 in, Thick: 1 3/4 in, Weight: 0.7 lbs

- **8209**
  - Height: 11 1/2 in, Width: 2 3/4 in, Thick: 1 3/4 in, Weight: 0.3 lbs

- **8211**
  - Height: 10 3/4 in, Width: 3 1/2 in, Thick: 1 1/2 in, Weight: 0.5 lbs

- **7760**
  - Height: 4 7/8 in, Width: 1 3/4 in, Thick: 1 3/4 in, Weight: 0.4 lbs

**Notes**

- Seat is 7/8 inch in diameter. Stub is 3/4 inch diameter and 1 1/2 inches long.
- Seat is 1 1/2 inch long by 5/8 inch square. Seat is 1 inch diameter. Stub is 3/4 inch diameter and 2 3/4 inches long.
ALLOY CASTING
Aluminum

Toll Free (800) 527-1318
(972) 286-2368
Fax (972) 557-4727

SPEARS
SLIP OVER TYPE

INQUIRY

8238
HEIGHT 4 5/8"
WIDTH: 1 1/8"
THICK: 1 1/8"
WEIGHT: .2 lbs

8203
HEIGHT 4 1/4"
WIDTH: 2 1/4"
THICK: 7/8"
WEIGHT: .3 lbs

8204
HEIGHT 4 1/2"
WIDTH: 2"
THICK: 7/8"
WEIGHT: .2 lbs

8205
HEIGHT 6 1/4"
WIDTH: 3 3/4"
THICK: 1"
WEIGHT: .4 lbs

8206
HEIGHT 4 5/8"
WIDTH: 1 1/8"
THICK: 1 1/4"
WEIGHT: .2 lbs

8207
HEIGHT 4 3/8"
WIDTH: 1 1/4"
THICK: 1 1/4"
WEIGHT: .1 lbs

8213
HEIGHT 4 1/4"
WIDTH: 2"
THICK: 1"
WEIGHT: .3 lbs

8256
HEIGHT 4 1/4"
WIDTH: 1 1/2"
THICK: 1 1/4"
WEIGHT: .2 lbs

634
HEIGHT 4 1/8"
WIDTH: 1 1/8"
THICK: 1 1/8"
WEIGHT: .2 lbs

8264
HEIGHT 6"
WIDTH: 1 7/8"
THICK: 1 7/8"
WEIGHT: .4 lbs

8223
HEIGHT 4"
WIDTH: 2 1/8"
THICK: 1 1/8"
WEIGHT: .2 lbs

8215
HEIGHT 5 3/8"
WIDTH: 2 3/4"
THICK: 1 3/8"
WEIGHT: .3 lbs
Spear point #8206, circle #7144 and ball finial #8001 in an aluminum fence section.
Spear point #8206, collar #0143, and diamond pattern #530 in a short wall fence top.
<table>
<thead>
<tr>
<th>Model</th>
<th>Height</th>
<th>Width</th>
<th>Thickness</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>3407</td>
<td>1 3/4&quot;</td>
<td>1 1/8&quot;</td>
<td>1 1/8&quot;</td>
<td>0.2 lbs</td>
</tr>
<tr>
<td>3410</td>
<td>2 3/8&quot;</td>
<td>1 1/2&quot;</td>
<td>1 1/2&quot;</td>
<td>0.2 lbs</td>
</tr>
<tr>
<td>3415</td>
<td>2 5/8&quot;</td>
<td>2&quot;</td>
<td>2&quot;</td>
<td>0.7 lbs</td>
</tr>
<tr>
<td>3420</td>
<td>3 3/4&quot;</td>
<td>2 1/2&quot;</td>
<td>2 1/2&quot;</td>
<td>0.6 lbs</td>
</tr>
<tr>
<td>3425</td>
<td>4&quot;</td>
<td>3&quot;</td>
<td>3&quot;</td>
<td>0.8 lbs</td>
</tr>
<tr>
<td>3430</td>
<td>4 3/4&quot;</td>
<td>3 5/8&quot;</td>
<td>3 5/8&quot;</td>
<td>1.5 lbs</td>
</tr>
<tr>
<td>3440</td>
<td>5 1/8&quot;</td>
<td>4 3/8&quot;</td>
<td>4 3/8&quot;</td>
<td>2.2 lbs</td>
</tr>
<tr>
<td>3441</td>
<td>6&quot;</td>
<td>4 5/8&quot;</td>
<td>4 5/8&quot;</td>
<td>2.3 lbs</td>
</tr>
<tr>
<td>3450</td>
<td>8 1/2&quot;</td>
<td>6 1/2&quot;</td>
<td>6 1/2&quot;</td>
<td>4.0 lbs</td>
</tr>
<tr>
<td>3460</td>
<td>18&quot;</td>
<td>18&quot;</td>
<td>1/2&quot; wall</td>
<td>30.00 lbs</td>
</tr>
</tbody>
</table>

**NOTE:** On most ball caps, the tube enters the cap approximately 5/8 inch and forms a loose fit.
<table>
<thead>
<tr>
<th>Model</th>
<th>Height</th>
<th>Width</th>
<th>Thickness</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>8001</td>
<td>1 7/8&quot;</td>
<td>1 1/4&quot;</td>
<td>1 1/4&quot;</td>
<td>0.2 lbs</td>
</tr>
<tr>
<td>8003</td>
<td>1 7/8&quot;</td>
<td>3/4&quot;</td>
<td>3/4&quot;</td>
<td>.06 lbs</td>
</tr>
<tr>
<td>7717</td>
<td>2 3/8&quot;</td>
<td>1 1/4&quot;</td>
<td>1 1/4&quot;</td>
<td>0.2 lbs</td>
</tr>
<tr>
<td>7792</td>
<td>3 1/2&quot;</td>
<td>1 5/8&quot;</td>
<td>1 5/8&quot;</td>
<td>0.5 lbs</td>
</tr>
<tr>
<td>7759</td>
<td>2 5/8&quot;</td>
<td>1 5/8&quot;</td>
<td>1 5/8&quot;</td>
<td>0.4 lbs</td>
</tr>
<tr>
<td>1409</td>
<td>2 3/4&quot;</td>
<td>1 1/2&quot;</td>
<td>1 1/2&quot;</td>
<td>1.0 lbs</td>
</tr>
<tr>
<td>8005</td>
<td>4&quot;</td>
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<td>2 1/4&quot;</td>
<td>0.6 lbs</td>
</tr>
<tr>
<td>8057</td>
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<td>1 3/4&quot;</td>
<td>1 3/4&quot;</td>
<td>0.4 lbs</td>
</tr>
<tr>
<td>8054</td>
<td>2 7/8&quot;</td>
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<td>1 1/2&quot;</td>
<td>0.4 lbs</td>
</tr>
<tr>
<td>8055</td>
<td>2 3/4&quot;</td>
<td>2 1/8&quot;</td>
<td>2 1/8&quot;</td>
<td>0.6 lbs</td>
</tr>
<tr>
<td>8040</td>
<td>2 3/4&quot;</td>
<td>2 1/4&quot;</td>
<td>2 1/4&quot;</td>
<td>0.6 lbs</td>
</tr>
<tr>
<td>9072</td>
<td>3 3/4&quot;</td>
<td>2 1/4&quot;</td>
<td>2 1/4&quot;</td>
<td>0.4 lbs</td>
</tr>
</tbody>
</table>
**BALL FINIALS**

<table>
<thead>
<tr>
<th>NEW</th>
<th>N E W</th>
<th>NEW</th>
</tr>
</thead>
<tbody>
<tr>
<td>DOUBLE FACE</td>
<td>DOUBLE FACE</td>
<td>DOUBLE FACE</td>
</tr>
<tr>
<td><img src="image1" alt="Image 66x561 to 151x640" /></td>
<td><img src="image2" alt="Image 197x562 to 274x653" /></td>
<td><img src="image3" alt="Image 91x519" /></td>
</tr>
</tbody>
</table>
| PIECE HAS A BASE 2 7/8” DIA BALL IS 3” DIA | PIECE HAS A BASE 1 1/2” DIA BALL IS 2 1/4” DIA | PIECE HAS A BASE 3 3/4” |}

**8033**

| HEIGHT | 3 3/4” |
| WIDTH: | 3”     |
| THICK: | 3”     |
| WEIGHT:| 1.8    |

**8075**

| HEIGHT | 2 3/4” |
| WIDTH: | 2 1/4” |
| THICK: | 2 1/4” |
| WEIGHT:| 0.6    |

**NEW DOUBLE FACE PIECE**

- **PIECE HAS A BASE 2 7/8” DIA** BALL IS 3” DIA
- **PIECE HAS A BASE 1 1/2” DIA** BALL IS 2 1/4” DIA
- **PIECE HAS A BASE 3 3/4”**

**NEW DOUBLE FACE PIECE**

- **PIECE HAS A BASE 2 7/8” DIA** BALL IS 3” DIA
- **PIECE HAS A BASE 1 1/2” DIA** BALL IS 2 1/4” DIA
- **PIECE HAS A BASE 3 3/4”**
Trivits

8304 DF
NEW
HEIGHT 8 5/8 IN 21.9 CM
WIDTH 3 1/2 IN 14.0 CM
THICK 1 IN 2.5 CM
WEIGHT 0.4 LBS 0.2 KGS

8305 DF
NEW
HEIGHT 8 3/8 IN 21.3 CM
WIDTH 3 1/4 IN 13.3 CM
THICK 1 1/8 IN 2.9 CM
WEIGHT 0.4 LBS 0.2 KGS

8306 DF
NEW
HEIGHT 8 IN 21.9 CM
WIDTH 3 3/8 IN 8.6 CM
THICK 1 1/8 IN 2.9 CM
WEIGHT 0.4 LBS 0.2 KGS

8307 DF
NEW
HEIGHT 9 IN 22.9 CM
WIDTH 4 IN 10.2 CM
THICK 1 1/8 IN 2.9 CM
WEIGHT 0.4 LBS 0.2 KGS

8309 DF
NEW
HEIGHT 8 3/4 IN 22.2 CM
WIDTH 3 1/2 IN 10.5 CM
THICK 1 1 IN 2.5 CM
WEIGHT 0.3 LBS 0.2 KGS

8310 DF
NEW
HEIGHT 8 1/2 IN 21.6 CM
WIDTH 5 IN 12.7 CM
THICK 1 1/4 IN 3.2 CM
WEIGHT 0.4 LBS 0.2 KGS

8311 DF
NEW
HEIGHT 8 3/8 IN 21.3 CM
WIDTH 3 5/8 IN 9.2 CM
THICK 1 1/8 IN 2.9 CM
WEIGHT 0.2 LBS 0.1 KGS

8314 DF
NEW
HEIGHT 8 7/8 IN 22.5 CM
WIDTH 5 1/2 IN 14.0 CM
THICK 1 1/8 IN 2.9 CM
WEIGHT 0.4 LBS 0.2 KGS

8316 DF
NEW
HEIGHT 8 3/4 IN 22.2 CM
WIDTH 3 1/2 IN 8.9 CM
THICK 1 1/8 IN 2.5 CM
WEIGHT 0.3 LBS 0.1 KGS

8317 DF
NEW
HEIGHT 8 5/8 IN 21.9 CM
WIDTH 5 1/2 IN 14.0 CM
THICK 1 1/8 IN 2.9 CM
WEIGHT 0.4 LBS 0.2 KGS

8319 DF
NEW
HEIGHT 6 1/2 IN 16.5 CM
WIDTH 6 1/2 IN 16.5 CM
THICK 1/2 IN 3.3 CM
WEIGHT 0.2 LBS 0.1 KGS

SCALE: 3 INCHES = 1 FOOT UNLESS NOTED

REVISION DATE: 12/30/94
Alloy Casting

Aluminum Castings

Toll Free (800) 527-1318
(972) 286-2368
Fax: (972) 557-4727

Section:

Roof Crestings
And Marquees

9243
NEW

HEIGHT 32 3/4 IN
WIDTH 12 5/8 IN
THICK 3/4 IN
WEIGHT 9.6 LBS

835
NEW

HEIGHT 15 1/8 IN
WIDTH 17 3/4 IN
THICK 3/8 IN
WEIGHT 2.3 LBS

9247
NEW

NOTE: THIS IS A "MARQUEE" CASTING
HEIGHT 15 7/8 IN
WIDTH 19 IN
THICK 3/4 IN
WEIGHT 8.8 LBS

8562
NEW

HEIGHT 18 IN
WIDTH 18 1/8 IN
THICK 1/4 IN
WEIGHT 2.2 LBS

8561
NEW

HEIGHT 20 1/2 IN
WIDTH 16 3/4 IN
THICK 1/4 IN
WEIGHT 1.1 LBS

454
NEW

HEIGHT 19 5/8 IN
WIDTH 16 1/4 IN
THICK 1 7/8 IN
WEIGHT 1.9 LBS ET.

452
NEW

HEIGHT 18 1/2 IN
WIDTH 5 5/8 IN
THICK 2 IN
WEIGHT 1.9 LBS EST.

8356
NEW

HEIGHT 19 5/8 IN
WIDTH 16 1/4 IN
THICK 1 7/8 IN
WEIGHT 1.9 LBS ET.

9134
NEW

NOTE: THIS IS A "MARQUEE" CASTING
HEIGHT 18 IN
WIDTH 13 IN
THICK 1 1/4 IN
WEIGHT 8.0 LBS

NOTE: ALL "MARQUEE" CASTINGS "NEST" AS SHOWN.

REVISED DATE: 12/30/94

SCALE: 1 INCH = 1 FOOT UNLESS NOTED
### Section: Shelf Brackets And Decorative Items

<table>
<thead>
<tr>
<th>Item</th>
<th>Type</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>71</td>
<td>DF</td>
<td>[Image] Height: 10 in (25.4 cm), Width: 6 3/4 in (17.1 cm), Thickness: 1 3/8 in (3.5 cm), Weight: 0.5 lbs (0.2 kgs)</td>
</tr>
<tr>
<td>72</td>
<td>DF</td>
<td>[Image] Height: 5 3/4 in (14.6 cm), Width: 7 1/2 in (19.0 cm), Thickness: 7/8 in (2.2 cm), Weight: 0.3 lbs (0.2 kgs)</td>
</tr>
<tr>
<td>73</td>
<td>DF</td>
<td>[Image] Height: 6 1/4 in (15.9 cm), Width: 5 1/2 in (14.0 cm), Thickness: 11/16 in (1.7 cm), Weight: 0.3 lbs (0.2 kgs)</td>
</tr>
<tr>
<td>590</td>
<td>DF</td>
<td>[Image] Height: 9 in (22.9 cm), Width: 9 in (22.9 cm), Thickness: 3/4 in (1.9 cm), Weight: 0.5 lbs (0.2 kgs)</td>
</tr>
</tbody>
</table>

### Additional Items:

<table>
<thead>
<tr>
<th>Item</th>
<th>Type</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>9154</td>
<td>NEW</td>
<td>[Image] Rams Head, Scale: 1 inch = 4 inches, Height: 5 in (12.7 cm), Width: 4 3/8 in (11.1 cm), Thickness: 2 3/4 in (7.0 cm), Weight: 1.1 lbs (0.5 kgs), NOTE: Top view, piece fits around a corner.</td>
</tr>
<tr>
<td>9184</td>
<td>FB</td>
<td>[Image] Griffin, Height: 4 3/4 in (12.3 cm), Width: 11 1/2 in (29.2 cm), Thickness: 1 1/4 in (0.6 cm), Weight: 0.6 lbs (0.3 kgs)</td>
</tr>
<tr>
<td>7768</td>
<td>WINGED LADY</td>
<td>[Image] Winged Lady, Front View, Height: 11 in (27.9 cm), Width: 5 1/2 in (14.0 cm), Thickness: 1 1/8 in (2.2 cm), Weight: 1.6 lbs (0.7 kgs)</td>
</tr>
<tr>
<td>9113</td>
<td>DF</td>
<td>[Image] Set, Scale: 1 inch = 4 inches, Height: 4 3/8 in (6.0 cm), Width: 2 in (5.1 cm), Thickness: 1 1/8 in (2.9 cm), Weight: 0.3 lbs (0.1 kgs)</td>
</tr>
<tr>
<td>9202</td>
<td>NEW</td>
<td>[Image] Piece has 4 mounting bosses on the back side, Height: 13 1/8 in (33.3 cm), Width: 23 in (58.4 cm), Thickness: 1 1/2 in (3.8 cm), Weight: 4.3 lbs (2.0 kgs)</td>
</tr>
<tr>
<td>191</td>
<td>DF</td>
<td>[Image] Picture Frame, Scale: 1 inch = 1 foot, Height: 14 3/4 in (37.5 cm), Width: 10 in (25.4 cm), Thickness: 3/8 in (1.6 cm), Weight: 0.6 lbs (0.3 kgs)</td>
</tr>
</tbody>
</table>

**Notice:** Scale 1 inch = 1 foot unless noted.
Cocktail table with polished seashell #3725 and table legs 9255.
### Assemblies: Flower Pot

#### 110 DF
- **New**
- **Top View**
- **Side View**
- **Scale:** 1 inch = 4 inches
- **Height:** 2 3/8 in (6.0 cm)
- **Width:** 3 1/4 in (8.3 cm)
- **Thickness:** 2 3/4 in (7.0 cm)
- **Weight:** 0.3 lbs (0.1 kgs)

#### 111 DF
- **New**
- **Top View**
- **Side View**
- **Scale:** 1 inch = 4 inches
- **Height:** 5 1/2 in (14.0 cm)
- **Width:** 6 1/2 in (16.5 cm)
- **Thickness:** 1 1/2 in (3.8 cm)
- **Weight:** 0.3 lbs (0.1 kgs)

#### 112 DF
- **New**
- **Top View**
- **Side View**
- **Scale:** 1 inch = 4 inches
- **Height:** 3 in (7.6 cm)
- **Width:** 4 1/2 in (11.4 cm)
- **Thickness:** 3 5/8 in (9.2 cm)
- **Weight:** 0.4 lbs (0.2 kgs)

#### 113 DF
- **New**
- **Top View**
- **Side View**
- **Scale:** 1 inch = 4 inches
- **Height:** 6 3/4 in (17.1 cm)
- **Width:** 7 1/2 in (19.1 cm)
- **Thickness:** 5/8 in (1.6 cm)
- **Weight:** 0.3 lbs (0.2 kgs)

#### 114 DF
- **New**
- **Top View**
- **Side View**
- **Scale:** 1 inch = 4 inches
- **Height:** 4 1/2 in (11.4 cm)
- **Width:** 5 1/8 in (13.0 cm)
- **Thickness:** 4 in (10.1 cm)
- **Weight:** 1.0 lbs (0.4 kgs)

#### 115 DF
- **New**
- **Top View**
- **Side View**
- **Scale:** 1 inch = 4 inches
- **Height:** 10 1/2 in (26.7 cm)
- **Width:** 9 1/8 in (23.2 cm)
- **Thickness:** 5/8 in (1.6 cm)
- **Weight:** 1.0 lbs (0.4 kgs)

#### 90 FB
- **New**
- **Top View**
- **Side View**
- **Scale:** 1 inch = 4 inches
- **Height:** 13 in (33.0 cm)
- **Width:** 6 1/4 in (15.9 cm)
- **Thickness:** 3/8 in (1.0 cm)
- **Weight:** 1.2 lbs (0.5 kgs)

#### 83 DF
- **New**
- **Top View**
- **Side View**
- **Scale:** 1 inch = 4 inches
- **Height:** 11 1/8 in (28.3 cm)
- **Width:** 6 3/4 in (17.1 cm)
- **Thickness:** 3 1/4 in (8.3 cm)
- **Weight:** 1.1 lbs (0.5 kgs)

#### 116 DF
- **New**
- **Top View**
- **Side View**
- **Scale:** 1 inch = 4 inches
- **Height:** 4 5/8 in (28.3 cm)
- **Width:** 6 1/4 in (15.9 cm)
- **Thickness:** 5 1/2 in (14.0 cm)
- **Weight:** 1.2 lbs (0.5 kgs)

---

**Revision Date:** 02/02/95
7701, 7712 AND 7735 WILL MAKE A BELLS ASSEMBLY IF DESIRED.

7712
CLAPPER FOR BELL

SCALE: 1 INCH = 1 FOOT

HEIGHT 4 1/2 IN 11.4 CM
WIDTH 5 7/8 IN 14.9 CM
THICK 5 7/8 IN 14.9 CM
WEIGHT 1.2 LBS 0.6 KGS

THIS PIECE MAY BE USED AS PART OF A BELL ASSEMBLY, OR A WALL HANGING BRACKET OR ONE PART OF A GUN RACK.

7735, SET

- INSCRIPTION: “GROW OLD ALONG WITH ME THE BEST IS YET TO BE”

FOR THIS SUN DIAL FACE USE 7742 AS A POINTER.

HEIGHT 10 IN 25.4 CM
WIDTH 10 IN 25.4 CM
THICK 3/8 IN 1.0 CM
WEIGHT 1.2 LBS 0.6 KGS

7730, SET

- INSCRIPTION: “HOURS FLY FLOWERS BLOOM AND DIE OLD DAYS OLD WAYS PASS LOVE STAYS”

USE SUN DIAL FACE 7730 WITH THIS POINTER.

SCALE: 3 INCHES = 1 FOOT

HEIGHT 4 1/4 IN 10.8 CM
WIDTH 4 1/4 IN 10.8 CM
THICK 3/8 IN 0.9 CM
WEIGHT 1.5 LBS 0.7 KGS

7794, SET

USE SUN DIAL FACE 7755 WITH THIS POINTER.

SCALE: 3 INCHES = 1 FOOT

HEIGHT 3 1/4 IN 8.3 CM
WIDTH 4 1/4 IN 10.8 CM
THICK 1/2 IN 1.3 CM
WEIGHT 0.3 LBS 0.14 KGS

7755, FB

- INSCRIPTION: “GROW OLD ALONG WITH ME THE BEST IS YET TO BE”

USE SUN DIAL FACE 7755 WITH THIS POINTER.

SCALE: 3 INCHES = 1 FOOT

HEIGHT 3 1/4 IN 8.3 CM
WIDTH 4 1/4 IN 10.8 CM
THICK 1/2 IN 1.3 CM
WEIGHT 0.3 LBS 0.14 KGS

7707, SET

7750, NEW

SUN DIAL FACE USE 7707 AS A POINTER.

HEIGHT 7 1/2 IN 19.0 CM
WIDTH 7 1/2 IN 19.0 CM
THICK 1/4 IN 0.6 CM
WEIGHT 0.6 LBS 0.3 KGS

USE SUN DIAL FACE 7750 WITH THIS POINTER.

SCALE: 3 INCHES = 1 FOOT

HEIGHT 3 1/4 IN 8.3 CM
WIDTH 4 1/4 IN 10.8 CM
THICK 1/2 IN 1.3 CM
WEIGHT 0.1 LBS 0.04 KGS

7707, NEW

- INSCRIPTION: “HOURS FLY FLOWERS BLOOM AND DIE OLD DAYS OLD WAYS PASS LOVE STAYS”

USE SUN DIAL FACE 7707 WITH THIS POINTER.

SCALE: 1 INCH = 1 FOOT UNLESS NOTED

REVISED DATE 12/30/94
<table>
<thead>
<tr>
<th>Part Number</th>
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<th>Height</th>
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<th>Thickness</th>
<th>Weight</th>
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<tr>
<td>3744</td>
<td>Wind Vane Directional Arm</td>
<td>3/8 in</td>
<td>13/8 in</td>
<td>1 1/4 in</td>
<td>0.5 lbs</td>
</tr>
<tr>
<td>3745</td>
<td>Wind Vane Directional Arm</td>
<td>3/8 in</td>
<td>13/8 in</td>
<td>1 1/4 in</td>
<td>0.5 lbs</td>
</tr>
<tr>
<td>3746</td>
<td>Wind Vane Post</td>
<td>2 1/2 in</td>
<td>23 1/2 in</td>
<td>1 1/4 in</td>
<td>0.9 lbs</td>
</tr>
<tr>
<td>3747</td>
<td>Foot Scraper</td>
<td>9 5/8 in</td>
<td>21 0 in</td>
<td>2 3/8 in</td>
<td>1.5 lbs</td>
</tr>
<tr>
<td>81</td>
<td>Foot Scraper</td>
<td>3/8 in</td>
<td>12 0 in</td>
<td>1 1/4 in</td>
<td>0.5 lbs</td>
</tr>
</tbody>
</table>

**Hand Call:**
Toll Free (800) 527-1318
(972) 286-2368
Fax: (972) 557-4727
The flexibility of the green sand casting system used at ALLOY CASTING allows freedom in designing special items for your customers. On this page are examples of how you may use this freedom to specialize Bench Ends unique to you or your customer. Shown are several interchangeable symbols that represent some of the various designs that can be used. Each insert is 5 5/8 inches in diameter. Additionally your designs can be inlaid into floor grates, tree grates, baluster columns, trash containers, security windows and many other systems as your needs might dictate. Let us help develop your ideas. See page 43 for other standard circles that fit into the arm of this bench end piece.

Benches include two ends with your choice of circles (see note above) welded into the arms (which are powder coated) 10 wooden slats that are nominally 46 inches long, 20 stainless steel carriage bolts powder coated to match bench arms. Wood for the bench ends are pre drilled for easy assembly. Prices may vary because of the volatility of the price of wood. Instructions for assembly are provided. Tools required for assembly are a small hammer and a 9/16 inch wrench.
ALUMINUM LOCKBOXES
ALLOY 5052 - 1/8 INCH THICK
LOCKSET HOLES ARE 2 1/8 INCHES IN DIAMETER FOR 2 3/8 INCHES BACK SET
BOXES COME WITH STAINLESS STEEL SCREWS FOR STRIKE PLATE

**WELDABLE ONE HOLE - WITH GUARD**

<table>
<thead>
<tr>
<th>CATALOG NO.</th>
<th>1182</th>
<th>1183</th>
<th>1184</th>
<th>1188</th>
</tr>
</thead>
<tbody>
<tr>
<td>THICKNESS</td>
<td>1 1/4 IN</td>
<td>3.2 CM</td>
<td>1 3/8 IN</td>
<td>3.5 CM</td>
</tr>
<tr>
<td>HEIGHT</td>
<td>3 3/8 IN</td>
<td>17.2 CM</td>
<td>3 3/8 IN</td>
<td>17.2 CM</td>
</tr>
<tr>
<td>WIDTH</td>
<td>4 1/4 IN</td>
<td>10.8 CM</td>
<td>4 1/4 IN</td>
<td>10.8 CM</td>
</tr>
<tr>
<td>WEIGHT</td>
<td>0.4 LB</td>
<td>0.19 KG</td>
<td>0.4 LB</td>
<td>0.20 KG</td>
</tr>
</tbody>
</table>

**WELDABLE TWO HOLE - WITH GUARD**

<table>
<thead>
<tr>
<th>CATALOG NO.</th>
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<th>1284</th>
<th>1286</th>
<th>1288</th>
</tr>
</thead>
<tbody>
<tr>
<td>THICKNESS</td>
<td>1 3/8 IN</td>
<td>3.5 CM</td>
<td>1 1/2 IN</td>
<td>3.8 CM</td>
</tr>
<tr>
<td>HEIGHT</td>
<td>6 7/8 IN</td>
<td>18.3 CM</td>
<td>6 7/8 IN</td>
<td>18.3 CM</td>
</tr>
<tr>
<td>WIDTH</td>
<td>4 1/4 IN</td>
<td>10.8 CM</td>
<td>4 1/4 IN</td>
<td>10.8 CM</td>
</tr>
<tr>
<td>WEIGHT</td>
<td>0.9 LB</td>
<td>0.39 KG</td>
<td>0.9 LB</td>
<td>0.39 KG</td>
</tr>
</tbody>
</table>
### ALUMINUM LOCKBOXES

**ALLOY 5052 - 1/8 INCH THICK**

Boxes come with stainless steel screws for strike plate.

#### BOLT ON - ONE HOLE - WITH GUARD

Can be used with prepainted tubing.

**Note:** On the 1385 (1 5/8 inch tubing) and the 1388 (2 inch tubing), lock sets with extra long tangs must be used.

<table>
<thead>
<tr>
<th>CATALOG NO.</th>
<th>1380</th>
<th>1385</th>
<th>1388</th>
</tr>
</thead>
<tbody>
<tr>
<td>TUBING</td>
<td>1&quot;</td>
<td>1 5/8&quot;</td>
<td>2&quot;</td>
</tr>
<tr>
<td>THICKNESS</td>
<td>1 1/4 IN 5.7 CM</td>
<td>1 7/8 IN 4.8 CM</td>
<td>2 IN 3.2 CM</td>
</tr>
<tr>
<td>HEIGHT</td>
<td>3 1/4 IN 7.2 CM</td>
<td>3 1/4 IN 8.3 CM</td>
<td>5 1/4 IN 8.3 CM</td>
</tr>
<tr>
<td>WIDTH</td>
<td>5 3/16 IN 11.1 CM</td>
<td>5 3/4 IN 14.6 CM</td>
<td>5 IN 13.5 CM</td>
</tr>
<tr>
<td>WEIGHT</td>
<td>0.3 LB 0.2 KG</td>
<td>0.4 LB 0.2 KG</td>
<td>0.4 LB 0.2 KG</td>
</tr>
<tr>
<td>HOLES</td>
<td>4 @ 1/4 IN DIAM.</td>
<td>4 @ 1/4 IN DIAM.</td>
<td>4 @ 13/64 IN SQUARE</td>
</tr>
<tr>
<td>BACKSET</td>
<td>2 3/8</td>
<td>2 3/4</td>
<td>2 3/8</td>
</tr>
</tbody>
</table>

**Note:** The 1388 lock box fits over standard 2 inch aluminum tubing. Holes on the side of the lockbox are 13/64 inch square for use with 3/16 inch carriage bolts (4 places). 2 inch tubing must be cut out, 7/8 inch by 3 1/4 inches, to slip in (and over) the lock box.

#### BOLT ON - TWO HOLE - WITH GUARD

Can be used with prepainted tubing.

**Note:** On the 1485 (1 1/2 inch tubing), lock sets with extra long tangs must be used.

<table>
<thead>
<tr>
<th>CATALOG NO.</th>
<th>1480</th>
<th>1485</th>
</tr>
</thead>
<tbody>
<tr>
<td>TUBING</td>
<td>1&quot;</td>
<td>1 5/8&quot;</td>
</tr>
<tr>
<td>THICKNESS</td>
<td>1 1/4 IN 3.2 CM</td>
<td>1 7/8 IN 4.8 CM</td>
</tr>
<tr>
<td>HEIGHT</td>
<td>6 7/8 IN 17.5 CM</td>
<td>6 7/8 IN 17.5 CM</td>
</tr>
<tr>
<td>WIDTH</td>
<td>5 1/4 IN 13.3 CM</td>
<td>5 3/4 IN 14.6 CM</td>
</tr>
<tr>
<td>WEIGHT</td>
<td>0.7 LB 0.3 KG</td>
<td>0.8 LB 0.4 KG</td>
</tr>
<tr>
<td>HOLES</td>
<td>6 @ 1/4 IN DIAM.</td>
<td>6 2 1/4 IN DIAM.</td>
</tr>
<tr>
<td>BACKSET</td>
<td>2 3/8</td>
<td>2 3/4</td>
</tr>
</tbody>
</table>

**Note:** On the 1488 (1 1/2 inch tubing), lock sets with extra long tangs must be used.
ALL ALUMINUM HARDWARE
CAST ALUMINUM PLATES

1066  
NEW  
FB  

1091  
NEW  

Hinge assembled
Hinge dis-assembled

LIFT OFF HINGE, UNIVERSAL LEFT AND RIGHT HAND.

5/16 INCH DIAMETER STAINLESS STEEL PIN 3/4 INCH LONG, NON REMOVABLE.

1/8 INCH THICK STAINLESS STEEL WASHER.

Hinge is 3 5/32 INCHES TALL. HEIGHT, INCLUDING WELD TAB IS 5/8 INCHES. NOMINAL DIAMETER IS 1/2 INCH.

1098/1099  
NEW  

Hinge assembled
Hinge dis-assembled

LIFT OFF HINGE, LEFT HAND AND RIGHT HAND.

0.180 DIAMETER STAINLESS STEEL PIN, 1 INCH LONG, NON REMOVABLE.

RIGHT HAND LIFT OFF HINGE IS SHOWN (NO. 1099). LEFT HAND HINGE NOT SHOWN (NO. 1098). BOTH HINGES ARE 2 INCHES HIGH AND 1 3/4 INCHES WIDE BY 3/8 INCH HIGH.

1095  
NEW  

PIN IS 1/2" DIAMETER, GALVANIZED STEEL, REMOVABLE. LEAF IS 0.180 INCH THICK.

HEIGHT 5 IN 12.7 CM
WIDTH 4 3/4 IN 12.1 CM
THICK 1 IN 2.5 CM
WEIGHT 0.9 LB 0.43 KG

1093  
NEW  

PIN IS 5/32" DIAMETER, ALUMINUM, NON REMOVABLE. LEAF IS 0.090 INCH THICK.

HEIGHT 3 IN 7.6 CM
WIDTH 3 IN 7.6 CM
THICK 3/8 IN 1.0 CM
WEIGHT 0.1 LB 0.05 KG

1092  
NEW  

PIN IS 1/8" DIAMETER, ALUMINUM, NON REMOVABLE. LEAF IS 0.050 INCH THICK.

HEIGHT 2 IN 5.9 CM
WIDTH 2 IN 5.9 CM
THICK 1/4 IN 0.6 CM
WEIGHT 0.03 LB 0.005 KG

2080  
OLD H208 AL  

WELDABLE TAB

HEIGHT 2 5/8 IN 6.7 CM
WIDTH 2 IN 5.1 CM
THICK 1/4 IN 0.6 CM
WEIGHT 0.1 LB 0.05 KG

NOTE: ALL CORNER HOLES IN THE PLATES ARE TAPERED. (1/2 INCH DIAMETER AT THE TOP AND ARE 3/8 IN. DIAMETER AT THE BOTTOM).

SCALE: 3 INCHES = 1 FOOT

REVISED DATE: 01/24/95

Section:
Aluminum Hardware
**8016**
NEW
1 1/2"

**1400**
NEW
1"

**8298**
NEW
1/2"

**9298**
DF

---

**8030**
1"

**8031**
1"

**BASKET**

---

INQUIRY

---

INQUIRY

---

NOT AVAILABLE

---

STUB IS 1/2 INCH LONG BY 1 INCH SQUARE AND TAPERED. SEAT IS 1 3/4 INCHES SQUARE.

---

STUB IS 1/2 INCH LONG BY 1 INCH SQUARE AND TAPERED. SEAT IS 1 3/4 INCHES SQUARE.

---

STUB IS 1/2 INCH LONG BY 1 INCH SQUARE AND TAPERED. SEAT IS 1 3/4 INCHES SQUARE.

---

STUB IS 1/2 INCH LONG BY 1 INCH SQUARE AND TAPERED. SEAT IS 1 3/4 INCHES SQUARE.

---

STUB IS 1/2 INCH LONG BY 1 INCH SQUARE AND TAPERED. SEAT IS 1 3/4 INCHES SQUARE.

---

NOTE: THIS PIECE IN DEVELOPMENT. IF INTERESTED PLEASE CONTACT US BY PHONE.

---

NUMBER 9298 CASTINGS CAN BE "NESTED" BY SLIDING INDIVIDUAL PIECES ONTO A 3/4 INCH SQUARE TOP AND BOTTOM RAIL THROUGH 7/8 INCH SQUARE HOLES ON THE CAST PIECE.

---

CENTERLINE OF 3/4 INCH BAR

---

CENTERLINE OF 3/4 INCH BAR

---

CENTERLINE OF 3/4 INCH BAR

---

SCALE: 3 INCHES = 1 FOOT UNLESS NOTED

---

REVISED DATE: 02/28/95
Technical Definitions, Abbreviations and Symbols

Symbols:

\[ x \] Normally used in connection with picket castings to indicate the width of the bar ("x" inches) onto which the picket casting will fit.

\[ x \] Indicates the size of the hole in the casting and will fit onto a square bar of that size. The opening will be oversized. If the tubing or bar size designated is 1 inch square the hole will typically be 1/16 inch oversized.

\[ \circ \] Indicates the size of tubing into which the casting will fit. If the tubing size designated is 1 inch square the stub on the casting will be typically 7/8 inch square, tapered and will wedge into a 1 inch tube that has a nominal 16 gage wall thickness.

\[ \bigcirc \] Indicates the size of tubing into which the casting will fit. If the tubing size designated is 1 inch round the stub on the casting will be typically 7/8 inch round, tapered and will wedge into a 1 inch tube that has a nominal 16 gage wall thickness.

Definitions:

1. **Clips** -- Steel pieces (clips) are cast into the aluminum casting in order to be able to weld the casting to steel. The clips can be placed in the casting at almost any location and are of two basic arrangements.

   **Flat clips** -- Those clips that when the casting is placed on a flat surface the clips are parallel to the surface of the casting.

   ![Flat steel clip diagram](image)

   **Vertical Clips** -- Those clips called vertical clips or "pushed clips" or "ninety degree clips", and are clips that when the casting is placed on a flat surface the clips are vertical to the casting.

   ![Vertical steel clip diagram](image)

2. **Drafts** -- That slope on the vertical face of a pattern. A positive draft allows the pattern to be pulled cleanly from the sand in the mold.

   ![Positive angle, No angle, Negative angle](image)

   **Positive Draft**
   **Zero Draft**
   **Negative Draft -- "undercut"**

3. **Loose** -- When a casting is molded "loose" it is done without the support of a pattern board. Although the individual piece price is higher, a few items can be made at a lower per piece cost by avoiding the more expensive cost of permanent tooling. However pieces made by this method do not have a quality as good as those made with permanent tooling.

4. **Master Pattern** -- The original piece. A carving or sample from which the permanent production tooling will be created.
Technical Definitions, Abreviations and Symbols

(Continued)

Definitions

5. **Match Plate** -- The permanent production tooling which has been created from the master pattern.

6. **Nested** -- the nesting concept has two or more castings that have been designed to interlock on a bar to provide a continuous design when they are placed (nested) in a series.

7. **Parting Line** -- That line developed on the casting where the two halves of a sand mold come together. Normally the widest part of the casting's cross section.

8. **Stub** -- The stub is that part of a spear or finial that fits into a tube opening. The stub is most always tapered and contains drafts. i.e. the stub may be a tapered 7/8 inch square to fit into a 1 inch tubing that has 1/16 inch wall thickness.

Abreviations:

1. **lbs** -- Weight of the casting in pounds.

2. **Kgs** -- Weight of the casting in kilograms.

3. **in** -- Dimension of the casting in inches.

4. **cm** -- Dimension of the casting in centimeters.

5. **DF** -- Double face. Indicates that the casting has the similar type of surface and design on both sides of the piece.

6. **SF** -- Single face. Indicates that the casting may have some detail on the back side of the piece, but much less than the front side of the piece.

7. **FB** -- Flat back. Indicates that the casting is flat on the back side.

8. **SBO** -- Side Backed Out. Indicates that the casting has been lightened by "scooping" out the back side of the piece. The back side has no detail or design.
1. Payment Terms --
   Established accounts net 30 days.

   New accounts are shipped COD until a credit application has been submitted and approved. A credit application (faxable) is enclosed, see page 103. Credit evaluations can be made within a week. No statements will be sent. Please pay from invoice rendered.

2. Shipping --
   All merchandise is shipped FOB factory in Mesquite, Texas, with goods being at the transit risk of the purchaser. Shipping is via specified air carrier, common carrier, motor express, bus, or UPS.

3. Warranty --
   Material and workmanship of aluminum castings upon receipt. Castings received in an unacceptable condition will be replaced. Castings are made with substantial hand working in the forming and cleaning process. Because of this every casting is not exactly the same, and there will be minor differences between castings of the same design.

4. Damages/Shortages --
   All merchandise is shipped on pallets, pallet boxes, in fiber drums, boxes, or cardboard wrapped to reduce the impact of rough handling during shipment.

   Any claims for damages are the responsibility of the purchaser and must be filed against the carrier at the receiving end. Alloy Casting will assist at any time.

5. Returned Goods --
   No merchandise is to be returned without prior approval. A credit or check will be issued upon receipt of the goods at the factory in Mesquite, Texas. There is no restocking charge for standard inventory items.

6 Pricing --
   All prices will be subject to change without advance notice. Ask for price information at time of placing the order. All price commitments will be honored.

7. Minimum Order --
   There is no minimum order. All orders will receive immediate personal attention and will be shipped promptly.

8. Back Orders --
   All casting orders will be shipped complete. If an expedited order is required, a partial order will be shipped upon request.

9. M S D S --
   Material Safety Data Sheets are available upon request.
"Quality Castings on Time"

Credit Application

Business Name________________________________________________________Partnership_______

Business Address______________________________________________________Proprietorship_____

_____________________________Phone (  )______________________________Corporation_______

Name of Key Officer or Principal___________________________________________

Home Address________________________________________________________________

Home Phone (  )_____________________________Driver's License__________________________

Number of years in Present Business________________

Bank Reference: Name of Bank_________________________________________________________

Address __________________________ __________________________ __________________________

Phone (  )_____________________________ __________________________ __________________________

Name of Bank Officer___________________________________________________

Trade References: (1) (2) (3) (4)

Company Name________________________ __________________________ __________________________

Address __________________________ __________________________ __________________________

________________________ __________________________ __________________________

Fax Number (  )__________ (  )__________ (  )__________ (  )__________

Person to Contact:

________________________ __________________________ __________________________

Date Applied____________________ Signature

103
### Alloy Casting

**Toll Free (800) 527-1318**

(972) 286-2368

Fax: (972) 557-4727

---

**ALUMINUM CASTINGS**

### Indital Aluminum Forgings

<table>
<thead>
<tr>
<th>Part</th>
<th>Height</th>
<th>Width</th>
<th>THICK</th>
<th>Weight</th>
</tr>
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<tbody>
<tr>
<td>2685</td>
<td>39 1/4&quot;</td>
<td>1 1/8&quot;</td>
<td>5/8&quot;</td>
<td>1.1 lbs (2.79 kgs)</td>
</tr>
<tr>
<td>2680</td>
<td>47 3/4&quot;</td>
<td>1 3/8&quot;</td>
<td>7/8&quot;</td>
<td>4.2 lbs (10.7 kgs)</td>
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<tr>
<td>2684</td>
<td>39 1/4&quot;</td>
<td>1 1/4&quot;</td>
<td>9/16&quot;</td>
<td>1 lbs (2.54 kgs)</td>
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<tr>
<td>2683</td>
<td>39 1/4&quot;</td>
<td>1 1/4&quot;</td>
<td>9/16&quot;</td>
<td>1.3 lbs (3.00 kgs)</td>
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<tr>
<td>2687</td>
<td>39 1/4&quot;</td>
<td>4 3/4&quot;</td>
<td>1 1/2&quot;</td>
<td>1.5 lbs (3.81 kgs)</td>
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</tbody>
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**ALL FORGINGS ON THIS PAGE ARE 9/16"**

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<tr>
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<th>THICK</th>
<th>Weight</th>
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<tbody>
<tr>
<td>2695</td>
<td>60&quot;</td>
<td>71/2&quot;</td>
<td>5/8&quot;</td>
<td>1.5 lbs (3.81 kgs)</td>
</tr>
<tr>
<td>2696</td>
<td>40&quot;</td>
<td>117/8&quot;</td>
<td>2 1/4&quot;</td>
<td>1.5 lbs (0.7 kgs)</td>
</tr>
<tr>
<td>2689</td>
<td>39 1/4&quot;</td>
<td>8 1/4&quot;</td>
<td>1 1/2&quot;</td>
<td>1.8 lbs (4.57 kgs)</td>
</tr>
<tr>
<td>2688</td>
<td>39 1/4&quot;</td>
<td>9 1/4&quot;</td>
<td>1&quot;</td>
<td>1.9 lbs (4.54 kgs)</td>
</tr>
<tr>
<td>2691</td>
<td>39 1/4&quot;</td>
<td>9 1/4&quot;</td>
<td>1 1/2&quot;</td>
<td>2 lbs (4.45 kgs)</td>
</tr>
</tbody>
</table>

Revision Date: 05/01/99
Toll Free (800) 527-1318
(972) 286-2368
Fax: (972) 557-4727

Alloy Casting
ALUMINUM CASTINGS

APPROXIMATE DIMENSIONS

NEW PRODUCTS

APPROXIMATE DIMENSIONS

Revision Date 05/01/99
<table>
<thead>
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<th>PART</th>
<th>PG.</th>
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<td>#4387........ 124</td>
<td>#7776........ 126</td>
<td>#9307........ 130</td>
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<td>#4399........ 127</td>
<td>#7806........ 132</td>
<td>#9319........ 125</td>
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<td>#4404........ 129</td>
<td>#7816........ 132</td>
<td>#9350........ 122,141</td>
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<td>#4405........ 121</td>
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<td>#9365........ 127</td>
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Product #930 and #939 in a deck rail
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123
NEW

DOUBLE FACE

7774
HEIGHT: 20"
WIDTH: 3" DIA
THICK: 3/4" DIA
WEIGHT: 3.80 lbs

9080
HEIGHT: 13 1/2"
WIDTH: 4 3/4" DIA
THICK: 4 3/4" DIA
WEIGHT: 10.50 lbs

4387
HEIGHT: 28 1/8"
WIDTH: 4 5/8" DIA
THICK: 1"
WEIGHT: 2.70 lbs

1902
HEIGHT: 35 1/2"
WIDTH: 6" DIA
THICK: 9/16" DIA
WEIGHT: 7.80 lbs

162
HEIGHT: 36"
WIDTH: 6"
THICK: 9/16" Dia
WEIGHT: 7.40 lbs

NEW

DOUBLE FACE

7774
COLLARS 1 1/2" DIA
HEIGHT: 40 1/4"
WIDTH: 1 1/4"
THICK: 1 1/4"
WEIGHT: 4.90 lbs

9299
15" FLUTED L
HEIGHT: 41"
WIDTH: 1 1/2"
THICK: 1 1/2"
WEIGHT: 7.0 lbs

4707
BAR 1/2 "SQ END, PINS 1/4" DIA
HEIGHT: 28 1/2"
WIDTH: 4 1/4"
THICK: 7/8"
WEIGHT: 0.80 lbs

4712
ENDS 1/4" X 1/2"
HEIGHT: 27 1/4"
WIDTH: 4 1/4"
THICK: 7/8"
WEIGHT: 0.80 lbs

162
COLLARS 1 1/2" DIA
HEIGHT: 3 1/2"
WIDTH: 2 3/4"
THICK: 3/4"
WEIGHT: 3.10 lbs
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</tr>
<tr>
<td><strong>1887</strong></td>
<td></td>
</tr>
<tr>
<td>HEIGHT: 31 1/2&quot;</td>
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</tr>
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</tr>
<tr>
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</tr>
<tr>
<td>WEIGHT: 2.9 lbs.</td>
<td></td>
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<tr>
<td>NEW</td>
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</tr>
<tr>
<td>CENTER COLLAR 1 1/4&quot; DIA END 9/16&quot; DIA</td>
<td></td>
</tr>
<tr>
<td><strong>2191</strong></td>
<td></td>
</tr>
<tr>
<td>HEIGHT: 44&quot;</td>
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</tr>
<tr>
<td>THICK: 1 1/4&quot;</td>
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<tr>
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<td></td>
</tr>
<tr>
<td>NEW</td>
<td>NOT TO SCALE</td>
</tr>
<tr>
<td>CENTER COLLAR 1 1/4&quot; DIA END 9/16&quot; DIA</td>
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<tr>
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<tr>
<td><strong>2193</strong></td>
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<tr>
<td>NEW</td>
<td>NOT TO SCALE DOUBLE FACE</td>
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<tr>
<td>DIAMOND SHAPED</td>
<td></td>
</tr>
<tr>
<td><strong>2241</strong></td>
<td></td>
</tr>
<tr>
<td>HEIGHT: 40 1/4&quot;</td>
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</tr>
<tr>
<td>WIDTH: 9&quot;</td>
<td></td>
</tr>
<tr>
<td>THICK: 1&quot;</td>
<td></td>
</tr>
<tr>
<td>WEIGHT: 1.5 lbs.</td>
<td></td>
</tr>
<tr>
<td>NEW</td>
<td>NOT TO SCALE DOUBLE FACE</td>
</tr>
<tr>
<td>DIAMOND SHAPED CTRS 16 3/8&quot; APART</td>
<td></td>
</tr>
<tr>
<td><strong>2242</strong></td>
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<tr>
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</tr>
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</tr>
<tr>
<td>THICK: 1&quot;</td>
<td></td>
</tr>
<tr>
<td>WEIGHT: 1.9 lbs.</td>
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</tr>
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</table>
NEW

8235
HEIGHT: 5 1/8"
WIDTH: 3 3/8"
THICK: 7/8"
WEIGHT: 0.2 lbs

8218
HEIGHT: 4 1/2"
WIDTH: 2 7/8"
THICK: 1"
WEIGHT: 0.3 lbs

8219
HEIGHT: 5 1/2"
WIDTH: 3 1/2"
THICK: 1"
WEIGHT: 0.3 lbs

8273
HEIGHT: 4 3/4"
WIDTH: 3 1/8"
THICK: 1 3/8"
WEIGHT: 0.3 lbs

NEW

8272
HEIGHT: 5 5/8"
WIDTH: 2 3/4"
THICK: 1 1/4"
WEIGHT: 0.5 lbs

8281
HEIGHT: 5"
WIDTH: 1 7/8"
THICK: 1 7/8"
WEIGHT: 1.10 lbs

8243
HEIGHT: 7"
WIDTH: 2"
THICK: 2"
WEIGHT: 0.7 lbs

8298
HEIGHT: 7 1/2"
WIDTH: 3 1/2"
THICK: 1 3/8"
WEIGHT: 0.5 lbs

NEW

8241
HEIGHT: 8"
WIDTH: 2 1/8"
THICK: 2 1/2"
WEIGHT: 1.10 lbs

8282
HEIGHT: 9 1/8"
WIDTH: 5"
THICK: 1 5/8"
WEIGHT: 1.10 lbs

8226
HEIGHT: 6"
WIDTH: 2 1/8"
THICK: 2 1/8"
WEIGHT: 0.7 lbs

8291
HEIGHT: 10 1/8"
WIDTH: 3 1/2"
THICK: 3 1/2"
WEIGHT: 3.2 lbs
NEW

DOUBLE FACE

2 PIECE HOLLOW POST

4434
HEIGHT: 8 3/4"
WIDTH: 14 1/4"
THICK: 5/8"
WEIGHT: 1.9 lbs

181
HEIGHT: 38"
WIDTH: 8 1/2"
THICK: 3"
WEIGHT: 1.6 lbs

82
HEIGHT: 11"
WIDTH: 8 1/2"
THICK: 3"
WEIGHT: 1.6 lbs

NEW

DOUBLE FACE

2 PIECE HOLLOW

4762/4768
HEIGHT: 9"
WIDTH: 10"
THICK: 2 3/8"
WEIGHT: 1.4 lbs

4787/4806
HEIGHT: 11 1/4"
WIDTH: 12"
THICK: 2 5/8"
WEIGHT: 2.1 lbs

4452
HEIGHT: 10 3/8"
WIDTH: 12 1/2"
THICK: 7/8"
WEIGHT: 1.5 lbs

NEW

HOLLOW BACK

1 PIECE

4473
HEIGHT: 17"
WIDTH: 7 3/4"
THICK: 3/4"
WEIGHT: 14 lbs

4788
HEIGHT: 10 1/2"
WIDTH: 16 1/4"
THICK: 3/4"
WEIGHT: 1.2 lbs

NEW

FLAT BACK

3738
HEIGHT: 9 1/2"
WIDTH: 12"
THICK: 1/2"
WEIGHT: 1.6 lbs

3735
HEIGHT: 13 1/4"
WIDTH: 16 3/4"
THICK: 3/4"
WEIGHT: 4 lbs

3741
HEIGHT: 18 1/2"
WIDTH: 38"
THICK: 1/2"
WEIGHT: 12 lbs

FLAT BACK

NEW

DOUBLE FACE

8" OCTAGONAL BASE OPENING BOTH SIDES 1 3/4" X 3 1/2"

HORSES HEAD, 2 PIECES REQUIRED. FITS OVER A 2" OUTSIDE DIAMETER TUBE. PIECES MAY BE WELDED TOGETHER.

2 PIECE HOLLOW

TOP 2 1/2" X 2 3/4" הודון 2 1/2" SQUARE

HORSES HEAD, 2 PIECES REQUIRED. FITS OVER A 2" OUTSIDE DIAMETER TUBE. PIECES MAY BE WELDED TOGETHER.

2 PIECE HOLLOW POST

1 PIECE

DOUBLE FACE

8" OCTAGONAL BASE OPENING BOTH SIDES 1 3/4" X 3 1/2"

HORSES HEAD, 2 PIECES REQUIRED. FITS OVER A 2" OUTSIDE DIAMETER TUBE. PIECES MAY BE WELDED TOGETHER.

2 PIECE HOLLOW POST

TOP 2 1/2" X 2 3/4" הודון 2 1/2" SQUARE

HORSES HEAD, 2 PIECES REQUIRED. FITS OVER A 2" OUTSIDE DIAMETER TUBE. PIECES MAY BE WELDED TOGETHER.
### Bamboo / Seashells

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<thead>
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<th>Style</th>
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<th>Thick</th>
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</thead>
<tbody>
<tr>
<td><strong>7806</strong></td>
<td>40&quot;</td>
<td>3/4&quot; DIA</td>
<td>3/4&quot; DIA</td>
<td>2.0 lbs</td>
</tr>
<tr>
<td><strong>7808</strong></td>
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<td>1&quot; DIA</td>
<td>1&quot; DIA</td>
<td>3.2 lbs</td>
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<tr>
<td><strong>7816</strong></td>
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<td>2&quot; DIA</td>
<td>2&quot; DIA</td>
<td>12.0 lbs</td>
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<tr>
<td><strong>9655</strong></td>
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<td>6&quot; DIA</td>
<td>1&quot;</td>
<td>1.8 lbs</td>
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<tr>
<td><strong>9291</strong></td>
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<td>6 1/2&quot;</td>
<td>5/8&quot;</td>
<td>0.5 lbs</td>
</tr>
<tr>
<td><strong>8165</strong></td>
<td>4&quot;</td>
<td>4&quot;</td>
<td>1/2&quot;</td>
<td>1.0 lbs</td>
</tr>
<tr>
<td><strong>8160</strong></td>
<td>10&quot;</td>
<td>10&quot;</td>
<td>1/2&quot;</td>
<td>21.0 lbs</td>
</tr>
</tbody>
</table>

**NEW**

- **DOUBLE FACE**
- **3/4"**
- **FLAT BACK**
- **15" DIA**
- **SAME DESIGN**
- **8166/INQUIRY**
- **IN DEVELOPMENT**

- **FLAT BACK**
- **3 5/8" DIA**
- **SAME DESIGN**
- **8164/INQUIRY**
- **IN DEVELOPMENT**

**TYPICAL DETAIL**

- **SEE BAMBOO RING #7373**
- **FLAT BACK**
- **4" 10" 15" DIA 3 5/8" DIA**

**IN DEVELOPMENT**

- **SAME DESIGN**
- **8160/INQUIRY**

---

**CONTACT**

Toll Free (800) 527-1318  
(972) 286-2368  
Fax (972) 557-4727  

Alloy Casting  
Aluminum
**NEW**

**DOUBLE FACE**

<table>
<thead>
<tr>
<th>939</th>
<th>3750</th>
<th>4721</th>
<th>4494</th>
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<td>HEIGHT: 15 3/4&quot;</td>
<td>HEIGHT: 14 1/2&quot;</td>
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<tr>
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<td>WIDTH: 13 1/2&quot;</td>
<td>WIDTH: 6&quot;</td>
<td>WIDTH: 6 1/4&quot;</td>
</tr>
<tr>
<td>THICK: 3/4&quot;</td>
<td>THICK: 1 1/2&quot;</td>
<td>THICK: 3/8&quot;</td>
<td>THICK: 5/8&quot;</td>
</tr>
<tr>
<td>WEIGHT: 9.2 lbs</td>
<td>WEIGHT: 7.3 lbs</td>
<td>WEIGHT: 0.8 lbs</td>
<td>WEIGHT: 0.7 lbs</td>
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**NEW**

**DOUBLE FACE**

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<td>WEIGHT: 2 lbs</td>
<td>WEIGHT: 2.5 lbs</td>
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**NEW**

**HOLLOW BACK**

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<tbody>
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<td>HEIGHT: 14&quot;</td>
</tr>
<tr>
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<td>WIDTH: 9&quot;</td>
<td>WIDTH: 13&quot;</td>
</tr>
<tr>
<td>THICK: 3/4&quot;</td>
<td>THICK: 1/2&quot;</td>
<td>THICK: 1/2&quot;</td>
</tr>
<tr>
<td>WEIGHT: 1.8 lbs</td>
<td>WEIGHT: 2.5 lbs</td>
<td>WEIGHT: 2 lbs</td>
</tr>
<tr>
<td><strong>NEW</strong></td>
<td><strong>NEW</strong></td>
<td></td>
</tr>
<tr>
<td>---------</td>
<td>---------</td>
<td></td>
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<tr>
<td><strong>DOUBLE FACE</strong></td>
<td><strong>DOUBLE FACE</strong></td>
<td></td>
</tr>
<tr>
<td><img src="image1.png" alt="Sea Horse" /></td>
<td><img src="image2.png" alt="Dolphin" /></td>
<td></td>
</tr>
<tr>
<td><strong>4722</strong></td>
<td><strong>9549</strong></td>
<td></td>
</tr>
<tr>
<td><strong>HEIGHT</strong> 24 1/2”</td>
<td><strong>HEIGHT</strong> 8 1/4” DIA</td>
<td></td>
</tr>
<tr>
<td><strong>WIDTH</strong> 6 3/4”</td>
<td><strong>WIDTH</strong> 8 1/4” DIA</td>
<td></td>
</tr>
<tr>
<td><strong>THICK</strong> 3/4”</td>
<td><strong>THICK</strong> 1/2”</td>
<td></td>
</tr>
<tr>
<td><strong>WEIGHT</strong> 2.7 lbs</td>
<td><strong>WEIGHT</strong> 1.4 lbs</td>
<td></td>
</tr>
</tbody>
</table>

**New Ring 5/8” Face**
Custom design possibilities. BIG TEX Panels Approximately 24” by 34”.
Exact size depends upon cross section and layout.

See page 114 for 2 piece split design possibilities #7791 and #7797
Automatic Rail and Gate drawing programs

- Compatible with Alloy Casting designs
- Develops all dimensions and cut lists.
- Only basic computer knowledge required

For more information visit us at www.fabcad.com or call: 1-800-255-9032 FABCAD.USA
Base Casting #951 Spear #2777 Crown Castings #801
Medallion Pieces Modified #1341

Base Castings #938 With #934 On Top

Corner Castings #9237 Large Spear #8209
Small Spear #2776 Center Medallions #713

Corner Brackets #1803 Top Snap-ons #2223
Small Snap-ons #4350 Spears #2779

Border Castings #7791 Center #7781

Border Castings #933 Center Medallion #892

Base Spines #9055 Small Snap-ons #10
Large Snap-on #3003 Spear #8264

Vertical Borders #960 Snap-ons #2058
“On March 2, 1836, Texas troops under Sam Houston won independence and shouted out “Remember the Alamo!” When we tried that here, the neighbors complained about the noise.”

These one-of-a-kind plaques, offered exclusively from Alloy Casting and the Hysterical Society of America are sure to cause a double take from everyone who sees them. Made of durable, rustproof aluminum, these hilarious plaques have unique historical facts mixed in with just the right amount of funny fiction. All plaques come ready to hang with an included mounting kit. Large plaques are approximately 8” by 15” and weigh two pounds. Small plaques are 4” by 9” and weigh a half of a pound.

AT THIS VERY LOCATION
ON APRIL 12, 1861
ABSOLUTELY NOTHING HAPPENED.

#1861
SMALL PLAQUE - 4” BY 9” / 0.5 LBS

TO ORDER OR FOR MORE INFORMATION CALL

1.800.527.4727

OR VISIT OUR WEB SITE AT WWW.ALLOYNET.COM

#91TX
LARGE PLAQUE V.1
8” BY 15” / 2 LBS

#92TX
LARGE PLAQUE V.2
8” BY 15” / 2 LBS

#91FL
LARGE PLAQUE
8” BY 15” / 2 LBS

#91NM
LARGE PLAQUE
8” BY 15” / 2 LBS
CHOSE FROM OVER 35 STATES WITH MORE TO BE ADDED SOON

ALABAMA  Part no. 91AL
In 1866, the first electric trolley streetcar the United States began in Alabama. If this building had been here, they could have borrowed an extension cord.

ARKANSAS  Part no. 91AK
On January 26, 1860, the famous U.S. Army General Douglas MacArthur was born in Little Rock. And, during all the years he lived, he never once visited here.

ARIZONA  Part no. 91AZ
On July 4, 1888, Juan Leivas roped and tied a steer at Prescott in America's first rodeo. With a mortgage like ours we know how the steer felt.

CALIFORNIA  Part no. 91CA
In 1849 the famous "Gold Rush" changed California forever. Prospectors, known as 49ers, poured into the territory. Today if you dig straight down at this Location don't hit the septic tank.

COLORADO  Part no. 91CO
In 1858 "Pikes Peak or Bust" was the cry As miners poured into the territory to Seek their fortune.

DELWARE  Part no. 91DE
On December 7, 1787 Delaware ratified the Constitution and became the first state admitted into the union. If this building had been here, we would have thrown a party.

FLORIDA  Part no. 91 FL
On March 3, 1845, Florida became the 27th state. The Seven Year War with the Seminole Indians had ended. Visitors arrived by railroads and steamships, and this building was not yet here.

GEORGIA  Part no. 91GA
In 1864, General W. T. Sherman burned Atlanta and began his march to the sea. Cotton was king "Gone With the Wind" was Georgia, and this ain't Tara.

IDAHO  Part no. 91 ID
In 1860, prospectors stumped into Idaho with the discovery of gold on Orofino Creek. To this date not a single nugget has been found at this site.

ILLINOIS  Part no. 91IL
In 1858, the Lincoln-Douglas debates identified how the issue of slavery was dividing the nation. Had they made their train connection in Chicago both would have had lunch here.

IOWA  Part no 91 IO
In the 1880s Iowa's farmers began raising hogs on home grown corn, forever changing the state's economy. So while eating here, please don't make a pig of yourself.

KANSAS  Part no. 91 KS
In the 1860's Bat Masterson and Wyatt Earp cleaned up the lawlessness in Dodge City and Abilene. Here you are more than welcome to clean up the kitchen.

KENTUCKY  Part no. 91 KY
In 1875, the first Kentucky Derby was run at Louisville, beginning a great tradition in American sports. At this "Old Kentucky Home" horses must wipe their feet before entering.

LOUISIANA  Part no. 91 LA
In 1803 Napoleon sold the entire Louisiana Territory for $15 million to the United States. That was a much better deal than we got on this property.

MAINE  Part no. 91 ME
In 1770, Burnham Tavern in Machias opened, offering, "Drink for the thirsty, Food for the Hungry, Lodging for the weary, and Good keeping for horses." That offer still applies here.

MASSACHUSETTS  Part no. 91MA
On April 18, 1775 Paul Revere made his famous ride to warn his fellow Patriots that the British were coming. Unlike here, we have no warning when visitors are coming.

MICHIGAN  Part no. 91 MI
On 1893 Henry Ford appeared in America's first practical automobile. If this building was here, Mr. Ford could have blocked the driveway and gotten America's first parking ticket.

MINNESOTA  Part no. 91 MN
In 1889, the Mayo Clinic, one of the world's leading medical centers, was established in Minnesota. If this building had been here, they still would not have made a house call.

MISSISSIPPI V1  Part no. 91 MS
In 1894, in Vicksburg, Joseph Biedenharn, a candy store owner, first bottled Coca-Cola. If we had been here then we could have bought a six-pack.

MISSISSIPPI V2  Part no. 92MS
Admitted as the 20th state on Dec. 10, 1817, the Civil War changed Mississippi Battles raged across the state, replacing the splendor and grace of the old south, and at this location nothing happened.

MISSOURI  Part no 91MO
In 1865, the notorious bandit, Jesse James began to terrorize this state. He never tried to rob the people in this building because it was not here.

NEBRASKA  Part no. 91NE
In 1883, Buffalo Bill's famous Wild West Show was organized at his ranch in North Platte, and this is definitely no a home where the buffalo roam.

NEVADA  Part no. 91 NV
In 1859, silver miners rushed into Nevada after hearing of the incredibly rich Comstock Lode. You are standing at the very location where nothing was found.

NEW HAMPSHIRE  Part no. 91NH
In 1777, hundreds of New Hampshire "Minute Men" hurried to Boston to fight the British. Here, no one has been in a hurry since.

NEW JERSEY  Part no. 91 NJ
3000 visitors came to Menlo Park in 1879 to witness Thomas Edison's demonstration of the electric light. Today, we would be happy with one visitor who could change a light bulb.

NEW MEXICO  Part no. 91NM
The Santa Fe Trail was established in 1821, opening a new route to New Mexico. Nowadays, we would be satisfied with a new route to the grocery store.

NEW YORK  Part no. 91 NY
In 1626, Peter Minuit purchased Manhattan Island for roughly $24 in trinkets. That was a much better deal than we got on this property.

OHIO  Part no. 91OH
In 1869, the first public weather forecasting service began in Cincinnati. When we watch the weather on TV here, the forecasting is no better than it was then.

OKLAHOMA  Part no. 91OK
On April 22, 1889, nearly 50,000 settlers poured into Oklahoma as the territory was opened to homesteaders. If this had been built "sooner" one might have settled here.

PENNSYLVANIA  Part no. 91PA
November 19, 1863, Abraham Lincoln, in his Gettysburg Address, spoke of the struggle of a nation torn apart by civil war, like the struggle here when it's time to clean the bathroom.

RHODE ISLAND  Part no. 91 RI
In 1854, this state contributed greatly to agriculture by the development of a new type of chicken called the "Rhode Island Red." And if you are not "chicken" stay for dinner.

SOUTH CAROLINA  Part no. 91SC
On November 24, 1786, South Carolina was the first state to sign the Constitution and became the first state of the United States. If this building had been here, Mr. Ford could have blocked the driveway and gotten America's first parking ticket.

TENNESSEE  Part no. 91TN
In the Mexican War 1845, citizens volunteered in such numbers that Tennessee is known as the volunteer state. Here, we can't get a volunteer to take out the garbage.

TEXAS V1  Part no. 91 TX
On April 21, 1836, Texas troops under Sam Houston won independence, as they shouted out "Remember the Alamo." When we tried that here, the neighbors complained about the noise.

TEXAS V2  Part no. 92 TX
On March 2, 1836, Texas declared her independence from Mexico, wild Comanches roamed the plains, Rangers protected frontier settlements, and this building was not here yet.

UTAH  Part no. 91UT
On May 10, 1853, the first official act of the new state was to legalise polygamy. Only 25 years later, the last nail was driven, completing this building.

VERMONT  Part no. 91VT
On March 4, 1791, after the American Revolution, Vermont became our 14th state. Pioneers on small farms began producing maple syrup and dairy products, and this building was not here yet.

VIRGINIA  Part no. 91 VA
Virginia, 1st of the 13 original colonies, contributed such dedicated statesman as Patrick Henry, George Washington, and Thomas Jefferson to the course of freedom. None of which slept here.

WEST VIRGINIA  Part no. 91 WV
In 1869, the famous abolitionist, John Brown and his followers raided the arsenal at Harper's Ferry. Here, we like to raid the refrigerator.
“Quality castings on time”

Other castings in AlloMet upon request. Call for pricing.

<table>
<thead>
<tr>
<th>SQUARE HOLE SIZE</th>
<th>PART NO. AL 535/</th>
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<tr>
<td>6&quot;</td>
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</tr>
</tbody>
</table>

Eliminate your powder coat flaking problems.
**Sign and Mail Box**

**Alloy Casting**

Aluminum

Toll Free (800) 527-1318  •  Fax 972.557.4727

Local 972.286.2368  •  Alloynet.com

“Quality castings on time”

Many more decorative pieces in full line catalog!
STATE OF TEXAS
CERTIFICATE OF RESALE, LEASING OR RENTING TANGIBLE PERSONAL PROPERTY *

I HEREBY CERTIFY: That I hold Texas Limited Sales Tax Permit No.__________________ issued pursuant to the Limited Sales, Excise and Use Tax Law, and that the tangible personal property described below or which is shown in the attached order of invoice which is made a part hereof, which I will purchase from Alloy Casting INC. 3900 S. Peachtree Rd. Mesquite, TX 75180  (972)-286-2368 will be resold, rented or leased by me in the form of tangible personal property; however, if I make any use of the tangible personal property other than retention, demonstration or display while holding it for sale, lease or rental in the regular course of business, the use shall be taxable to me as of the time when the tangible personal property is first so used, and the sales price of the tangible personal property to me shall be deemed the measure of the tax. Description of the property to be purchased: Aluminum Castings / Hardware

Executed this the ____________ day of ___________________________, 19______.

Purchaser __________________________ (company or organization)

By __________________________ Title _________________________

(signature)

Address ________________________________

City/ Zip code __________________________

* The form must contain the signature and must bear the name and address of the purchaser; it must indicate the number of the permit, if any, issued to the purchaser. It must indicate the general character of the tangible personal property sold, leased or rented by the purchaser in the regular course of business.
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<tr>
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**INDIVIDUAL OR 3 PIECE SET**

- **FLAT BACK**
- **DOUBLE FACE**
- **1/2" SLOT**

**NEW ASSORTED DESIGNS**

- OPENING 7 3/4" BY 15 1/2"W BY 1 1/4" BELOW SEAT
- OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT
- OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT
- OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT
- OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT
- OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT

**2 VIEWS**

- **OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT**
- **OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT**
- **OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT**
- **OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT**
- **OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT**
- **OPENING OVAL 10" BY 18"W BY 3 3/4" BELOW SEAT**

**DOUBLE FACE**

- **3/4" SQUARE COLLAR**
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<td>Width</td>
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<td>Weight</td>
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# NEW ASSORTED DESIGNS

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RO MAN SERIES
ALL ITEMS 4" SAFE

#0936 DOUBLE FACE
29 1/8 L  
13 1/2 W  
5/8 t  
6.3 lbs

#0931 DOUBLE FACE
29 1/2 L  
14 W  
5/8 t  
4.9 lbs

#0932 DOUBLE FACE
28 5/8 L  
14 W  
5/8 t  
5.2 lbs

#0939 DOUBLE FACE
29 1/8 L  
13 1/2 W  
3/4 t  
9.20 lbs

#2946 DOUBLE FACE
45 3/4 L  
3 W  
5/8 t  
1.50 lbs

#2934 DOUBLE FACE
34 L  
13 3/4 W  
5/8 t  
4.9 lbs  
for 36" rail

#2937 DOUBLE FACE
37 L  
9 1/2 W  
5/8 t  
3.5 lbs  
for 42" rail
#0930 DOUBLE FACE
29 L
14 W
5/8 t
4.5 lbs

#0934 DOUBLE FACE
29 1/2 L
14 1/4 W
5/8 t
4.6 lbs

#0927 DOUBLE FACE
27 L
9 1/4 W
5/8 t
3.10 lbs
27° pitch 23” vertical

#0928 DOUBLE FACE
sizes estimated
33 1/2 L
8 3/4 W
5/8 t
3.5 lbs
34° pitch 28” vertical

#0937 DOUBLE FACE
37 L
8 W
5/8 t
3.3 lbs
45° pitch 29 1/2” vertical

#0938 DOUBLE FACE
3 1/4 L
41 1/4 W
5/8 t
4.5 lbs

#2938 DOUBLE FACE
4 1/4 L
40 1/8 W
5/8 t
3.5 lbs
Many catalog items can be made in Bendable metal for design applications. Call to discuss.
LEAVES

- #9741 double face
  - H= 3 3/8
  - W= 1 7/8
  - T= 3/16
  - WT=.15 LBS
- #9742 double face
  - H= 4 1/2"
  - W=4"
  - T= 1/2
  - WT=.15 LBS
  - 1/2" deep
- #9743 double face
  - H=8 3/4
  - W=2 1/2"
  - T= 5/8 DEEP
  - WT=.20 LBS
- #9482 double face
  - H= 6 1/2" each
  - W= 5 3/4" each
  - WT=.2 lbs. each
  - 2" deep
  - each cast leaf pair
- #9483 double face
  - H=5" each
  - W=5/34" each
  - WT=.151lbs each
  - 1 1/2" deep
  - each cast leaf pair

BATWING
- 1" thick
- In strong Marine Grade aluminum
- #1240 1241
  - 1" thick
  - 6 1/4  h
  - 1 3/4 dia base
  - .40 lb

TASSELS
- #1908 double face
  - 4 1/2 h
  - 1 3/4 dia base
  - .40 lb

SHOES
- #8417
  - Double Face H= 21/8"
  - W= 6 5/8"
  - WT=.9lb.
  - 3"deep
  - 1 X 2" square

BOATING
- #1424
  - L 6 5/8
  - W 8 1/2
  - WT=.20 LBS
- #4791
  - L 7 3/4
  - W 8 3/4
  - WT=.50LBS
#1457 with 1458
#1457
New Double Collar
39” high
1 1/4 dia.
1.6 lbs
Double Face ends 7/16 square

#1458
Single Collar
see catalog

#2161 with 2162
#2162
New Double Collar
40 3/4 high
1 3/8 dia.
1.9 lbs
Double Face ends 3/8 dia.

#2161
Single Collar
see catalog

#3765
light weight hollow seashell
goes together back to back
20 5/8 high
19 wide
3 thick
13 lbs
SOLID Seashell #3725
See catalog pg 64

Goes together back to back

#3782
26 1/2 high
27 wide
1/2 thick
14 lb
flat back

#3783 mirror image

#3792
31 1/4 high
13 1/2 wide
1/2 thick
5 lb
flat back

#3793 mirror image

#3782/3792 combo
2 piece palm tree
45” tall

#3783/3793 combo
2 piece palm tree
45” tall
### STARS, RINGS & BALLS

**ALLOY CASTING**
Aluminum

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<td>#7150</td>
</tr>
<tr>
<td>4 7/8</td>
<td>1/2</td>
<td>#7147 *</td>
</tr>
<tr>
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<td></td>
<td>#7144</td>
</tr>
<tr>
<td>4</td>
<td></td>
<td>#7140</td>
</tr>
<tr>
<td>3 7/8</td>
<td></td>
<td>#7137</td>
</tr>
<tr>
<td>3 7/8</td>
<td>DF</td>
<td>#2137</td>
</tr>
<tr>
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<td>DF</td>
<td>#9775</td>
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<td>DF</td>
<td>#9334</td>
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<tr>
<td>3 1/2</td>
<td></td>
<td>#7134</td>
</tr>
<tr>
<td>3</td>
<td></td>
<td>#7130</td>
</tr>
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* IN DEVELOPMENT

DF=Double Face

<table>
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<th>PART #</th>
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<tr>
<td>36</td>
<td>#0713</td>
</tr>
<tr>
<td>24</td>
<td>#0712</td>
</tr>
<tr>
<td>11 5/8</td>
<td>#0711</td>
</tr>
<tr>
<td>11 5/8</td>
<td>DF #8443</td>
</tr>
<tr>
<td>6 3/4</td>
<td>DF #9237</td>
</tr>
<tr>
<td>5 5/8</td>
<td>DF #8442</td>
</tr>
<tr>
<td>5</td>
<td>#9618</td>
</tr>
<tr>
<td>3 1/2</td>
<td>#9734</td>
</tr>
</tbody>
</table>
DIPTYCH * DESIGNS

* Diptych - a set of two side-by-side panels bearing pictures of art or carvings

The leaf patterns have been designed to incorporate a 3/4" picket spacing.
BALL CAPS & COLLARS

Alloy Castings Inc
3900 South Peachtree Road
Mesquite TX 75180

Toll Free (800) 527-1318
(972) 286-2368
Fax (972) 557-4727

ALLOY CASTING
Aluminum

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BALL CAP #3460
6” Ball Cap

POST CAPS
Very new 5” 3305
Also available
New 6” 3306
New 8” 3308

Lo Profile Collars
1/2 sq. 7284 (old 7782)
5/8 sq. 7285 (NEW larger)
5/8 sq. 7765 (smaller old)
3/4 sq. 7286 (old 7786)
1 sq. 7288 New

#3305
5” Post Caps

NEW DESIGN
#1843
3/4 COLLAR

#7286
New 3/4 square collar
NEW PRODUCTS  SCREW ON COLLARS

-Reduce Clean-Up Labor Costs-

Set screws on opposite side of collar to give double bite.
Visually hidden from above
Set screws 1/4-20 use 1/8” hex tool
Various lengths
(over 3/16L) to match
as close as possible to surface

Full Collar Side Views
#2140 1” and #2143 3/4”

Lo Profile Side View
#2286 3/4”

Front Face View

Perfect for
Mechanical Rail

Other
SCREW ON COLLARS
AVAILABLE
For 1/2 ” square and
5/8” square
42" RAILING

TRADITIONAL GUARDIAN CASTING
NOW AVAILABLE AS 2pc for 42' HIGH rail #4202
-DOUBLE FACE-
4’ safe with touching adjacent pickets

REDUCE FABRICATION COST
PRODUCTS NOW AVAILABLE

Drop In panels with Big Foot for 42” high rail
Top rail/castings/bottom rail
No cost of intermediate rail meets 4” code with side pickets
Castings nominal dimensions:
8-10” wide x 39 1/2 high x 3/4” thick

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**Hollow tube Aluminum Balusters**

1/16” wall 35” long

**#1981**
35 L
1 1/4 dia
.8 lbs
1/16 wall
1 1/4 end dia

**#1982**
35 L
1 1/4 dia
.8 lbs
1/16 wall
1 1/4 end dia

**#1983**
35 L
1 1/8 dia
.8 lbs
1/16 wall
5/8 end dia

Similar designs as solid aluminum
Castings #9055 and #9056
Page 113 of our catalog
We are now Cad/Cam capable
For new patterns and tooling

Fast- accurate- simple

Email your 3D digital model files in STP
We can quickly and economically transform your data
Into workable patterns and tooling

We can also provide 2D or 3D digital models
From sketches or engineering drawings
Which you can preview
Before the part is fabricated

Compatible with most 3D modeling software including
AutoCAD/ Turbocad/ PlasmaCad/ Rhino/ Solid Works

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Mesquite TX 75180

If you would like to be removed from this FAX list please call 1-800-527-1318
CIRCUMSCRIBED DESIGNS
Frame 5/8 thick with 5/8 face

<table>
<thead>
<tr>
<th>Style #</th>
<th>Dimensions</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>#9281</td>
<td>10 3/4 H, 10 3/4 W, 7/8 T</td>
<td>4.70 lbs, 4.71</td>
</tr>
<tr>
<td>#2290</td>
<td>10 3/8 H, 10 3/8 W, 5/8 T</td>
<td>2.4 lbs</td>
</tr>
<tr>
<td>#2291</td>
<td>10 3/8 H, 10 3/8 W, 5/8 T</td>
<td>3.4 lbs</td>
</tr>
<tr>
<td>#2292</td>
<td>10 3/8 H, 10 3/8 W, 5/8 T</td>
<td>3.5 lbs</td>
</tr>
<tr>
<td>#2293</td>
<td>10 3/8 H, 10 3/8 W, 5/8 T</td>
<td>3.4 lbs</td>
</tr>
<tr>
<td>#2294</td>
<td>10 3/8 H, 10 3/8 W, 1 1/4 T</td>
<td>4.8 lbs</td>
</tr>
<tr>
<td>#2295</td>
<td>10 3/8 H, 10 3/8 W, 5/8 T</td>
<td>3.5 lbs</td>
</tr>
<tr>
<td>#2296</td>
<td>10 3/8 H, 10 3/8 W, 5/8 T</td>
<td>2.9 lbs</td>
</tr>
</tbody>
</table>

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Mesquite TX 75180

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Alloy Castings Inc
1-800-527-1318
3900 South Peachtree Road
Mesquite TX 75180
# New Collars

## For 5/8” and 3/4”

<table>
<thead>
<tr>
<th></th>
<th>5/8 SQUARE</th>
<th>5/8 ROUND</th>
<th>3/4 SQUARE</th>
<th>3/4 ROUND</th>
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</thead>
<tbody>
<tr>
<td>3 3/4 DIA H</td>
<td>1855</td>
<td>1825</td>
<td>1445</td>
<td>1395</td>
</tr>
<tr>
<td>3 3/4 DIA W</td>
<td>1854</td>
<td>1824</td>
<td>1444</td>
<td>1394</td>
</tr>
<tr>
<td>1 3/4 T</td>
<td>1857</td>
<td>1827</td>
<td>1447</td>
<td>1397</td>
</tr>
<tr>
<td>1.10 lbs</td>
<td>1858</td>
<td>1828</td>
<td>1448</td>
<td>1398</td>
</tr>
<tr>
<td>Double Face</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2 5/8 DIA H</td>
<td>1859</td>
<td>1829</td>
<td>1449</td>
<td>1399</td>
</tr>
<tr>
<td>2 5/8 DIA W</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 1/4 T</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>.40 lbs</td>
<td></td>
<td></td>
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</tr>
<tr>
<td>Double Face</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3 1/2 H</td>
<td></td>
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<td></td>
<td></td>
</tr>
<tr>
<td>3 1/2 W</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.00 lbs</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Double Face</td>
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<td></td>
</tr>
<tr>
<td>3 1/2 DIA H</td>
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<td></td>
</tr>
<tr>
<td>3 1/2 DIA W</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2.0 T</td>
<td></td>
<td></td>
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<td></td>
</tr>
<tr>
<td>1.50 lbs</td>
<td></td>
<td></td>
<td></td>
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</tr>
<tr>
<td>Double Face</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>6 7/8 H</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5 1/4 W</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2 1/4 T</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.3 lbs</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Double Face</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

## All Casting Can Be Made in Marine Grade Aluminum

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Alloy Castings Inc  
3900 South Peachtree Road  
Mesquite TX 75180
**Lattice Collars**

**Easy and Quick Set Ups**

Square and Round Holes
One direction hole through, 
Other direction hole partially through

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Hole Type</th>
<th>Weight</th>
<th>Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 5/8 DIA H</td>
<td>2 5/8 DIA W</td>
<td>1 1/4 T</td>
<td>.35 lbs</td>
</tr>
<tr>
<td>3 3/4 DIA H</td>
<td>3 3/4 DIA W</td>
<td>1 3/4 T</td>
<td>1 lb</td>
</tr>
<tr>
<td>3 1/2 H</td>
<td>3 1/2 W</td>
<td>2 1/4 T</td>
<td>1. lbs</td>
</tr>
<tr>
<td>3 1/2 DIA H</td>
<td>3 1/2 DIA W</td>
<td>2 T</td>
<td>1.4 lbs</td>
</tr>
</tbody>
</table>

Lattice Ball Collars
Square and Round Holes
One direction hole through, 
Other direction hole partially through

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Hole Type</th>
<th>Weight</th>
<th>Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/2 SQUARE</td>
<td>1/2 ROUND</td>
<td>2474</td>
<td>2464</td>
</tr>
<tr>
<td>5/8 SQUARE</td>
<td>5/8 ROUND</td>
<td>2475</td>
<td>2465</td>
</tr>
<tr>
<td>3/4 SQUARE</td>
<td>3/4 ROUND</td>
<td>2476</td>
<td>2466</td>
</tr>
<tr>
<td>1 &quot; SQUARE</td>
<td>1 &quot; ROUND</td>
<td>2478</td>
<td>2468</td>
</tr>
</tbody>
</table>

**ALL casting can be made in Marine Grade ALUMINUM**

See our web site: [www.alloynet.com](http://www.alloynet.com)

Alloy Castings Inc
3900 South Peachtree Road
Mesquite TX 75180
**ALL CAST LEAVES CAN BE MADE IN BENDABLE ALUMINUM FOR SMALL BENDS**

<table>
<thead>
<tr>
<th>#9482 DF</th>
<th>#9483 DF</th>
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<tbody>
<tr>
<td>NO DETAIL ON BACK</td>
<td>NO DETAIL ON BACK</td>
</tr>
<tr>
<td>6 1/2 H</td>
<td>5 1/4 H</td>
</tr>
<tr>
<td>5 1/2 W</td>
<td>5 1/4 W</td>
</tr>
<tr>
<td>3/16, 1 3/4 T</td>
<td>3/16, 1 1/2 T</td>
</tr>
<tr>
<td>.2 lbs</td>
<td>.15 lbs</td>
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<table>
<thead>
<tr>
<th>#2631 DF</th>
<th>#2632 DF</th>
<th>#2633 DF</th>
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<tbody>
<tr>
<td>6 L</td>
<td>8 1/2 L</td>
<td>10 1/2 L</td>
</tr>
<tr>
<td>1 1/2 W</td>
<td>3 W</td>
<td>2 3/4 W</td>
</tr>
<tr>
<td>1 3/8 T</td>
<td>2 T</td>
<td>2 T</td>
</tr>
<tr>
<td>.2 lbs</td>
<td>.4 lbs</td>
<td>.5 lbs</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>#9741 DF</th>
<th>#9742 DF</th>
<th>#9743 DF</th>
</tr>
</thead>
<tbody>
<tr>
<td>3/4 L</td>
<td>4 3/8 L</td>
<td>8 3/4 L</td>
</tr>
<tr>
<td>1 7/8 W</td>
<td>3 7/8 W</td>
<td>2 1/2 W</td>
</tr>
<tr>
<td>5/8 T</td>
<td>1/2 T</td>
<td>1/2 T</td>
</tr>
<tr>
<td>curved</td>
<td>curved</td>
<td>curved</td>
</tr>
<tr>
<td>.1 lbs</td>
<td>.2 lbs</td>
<td>.3 lbs</td>
</tr>
</tbody>
</table>

**ALL CASTING CAN BE MADE IN MARINE GRADE ALUMINUM**
ALL CAST LEAVES CAN BE MADE IN BENDABLE ALUMINUM FOR SLIGHT BENDS

CAST LEAVES

| #2331 | Flat Back | 6 3/8 L | 2 W | 3/16 T | .1 lbs |
| #2332 | Flat Back | 8 3/4 L | 4 W | 1/4 T | .5 lbs |
| #2333 | Flat Back | 10 3/8 L | 4 1/8 W | 1/4 T | .6 lbs |

FORGED LEAVES

| #2711 | 4 3/4 H | 2 W | 1/8 T | 0.10 lbs |
| #2712 | 4 3/4 H | 2 W | 1/8 T | 0.10 lbs |

STAMPED LEAVES

| #1271 | 5 1/2 H | 3 W | 1/16 T | 0.10 lbs |
| #1272 | 5 1/2 H | 3 W | 1/16 T | .10 lbs |
| #1276 | 9 H | 2/78 W | 1/16 T | 0.10 lbs |

ALL CASTING CAN BE MADE IN MARINE GRADE ALUMINUM

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Alloy Castings Inc
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Mesquite TX 75180
Understanding Custom Castings

While many variables come into play in determining costs, ultimately the project is a success if end user needs are met at an acceptable price.

By Jon P. McGraw
Alloy Casting Co.

This article originally printed in the 1992 November-December issue of Fabricator Magazine, an official publication of the National Ornamental & Miscellaneous Metals Association.

Custom designed aluminum casting can be produced in a wide range of sizes, weights, and shapes for any type of ornamental application. The front end cost of creating the master pattern and the production tooling are an important consideration to the project's total cost and can range from 3 percent to 90 percent of that total. These costs are typically overcome by the customer's desire for a product that is unique and aesthetically pleasing.

This article will outline some of the extremes that we have encountered in custom designed castings. We have completed jobs that range from 1 inch by 1 inch by 2 inches to 48 inches by 48 inches by 2 inches and from weights of .2 pounds to 250 pounds, and from 4 pieces to 10,000 pieces.

These jobs have had tooling charges of 3 percent to 90 percent of the total project cost. In all cases the casting was original and achieved the cost-beauty relationship the fabricator needed to please the customer.

Custom casting projects arrive at the foundry in many forms, including a sketch on an envelope, an engineered drawing, a miniature model, or a full scale model. In each case, the foundry was able to use wood carvers, pattern makers, and shop personnel to create the master patterns and production tooling.

Figure 1 shows some of the small items that we’ve custom produced. Typically these small aluminum castings are in the range of .2 to .5 pounds. The length of the production run heavily influences the cost of the individual item because the tooling cost must be amortized over the entire run. In these small items tooling costs have ranged from a low of 10 percent for a 10,000 piece run to a high of 90 percent for a 200 unit run. Figure 2 shows some of the unique long baluster castings. The lengths go up to 49 inches and weights range from 3 pounds to 5 pounds. Tooling charges have varied from 3 percent to 50 percent of the total project cost. The 3 percent tooling charge was a result of the fabricator providing a dimensionally correct master pattern for a large, 3,100 piece production run.

The items in figures 3 and 4 are mid-size castings with weights of 5 pounds to 20 pounds. The tooling charges were 5 percent to 8 percent of the total project. The low tooling charges are again related to the high production run of the Hawaiian hotel pineapple plaque in figure 4 and the simplicity of the contemporary plaque in figure 3. In both of these cases the foundry was provided with an engineering drawing. The wood carver used the drawings to provide an...
oversized dimensionally correct master pattern before the match plate maker created the production tooling.

The picture frame shown in figure 5 is 44 inches by 54 inches and weighs 42 pounds. The tooling charges are only 10 percent on this total project cost because the customer provided a master pattern that was single face and had the correct dimensions, drafts, smoothness, and tolerance.

The sea shell shown in figure 6 and figure 7 first came to the foundry as the 4-inch plaster miniature shown in figure 6. The wood carver used the plaster miniature to extrapolate the size to a 2 foot by 2 foot pattern and a 4 foot by 4 foot pattern. The final 2 foot casting weighed 50 pounds (figure 6) and the 4 foot casting weighed 250 pounds. The unit is shown here on location at a Florida bay front development (figure 7).

Another option in the quest for uniqueness and originality is to modify existing patterns. Figure 8 shows a common ornamental aluminum bench end customized to accept varying logos and symbols. Typically adjustments can be made by adding to (epoxy) or taking away (machining) existing patterns. Tooling charges for this approach are commonly on the low side because the starting master pattern is already available as a sample of the full size original casting. The concept of adding symbols or letters to existing patterns can give a fabricator a chance to sell a common theme to developers of malls, townhouses, or

FIGURE 6 shows the plaster miniature and the final product.

FIGURE 7 shows the complete shell, which was used in a beach front development in Florida.
parks. In this way, trash containers, park benches, tables, tree grates, and entry areas can easily have a common logo or symbol.

Table I is a summary of the technical data for the items pictured in this article. Each of these aluminum castings started as an original idea and was the creation of a homeowner, architect, or fabricator. In all cases the foundry's job was to help the fabricator implement each custom project to the cost-aesthetic satisfaction of the end user.

An earlier article I wrote in the May-June 1987 Fabricator discusses the technical aspects of “custom-designed aluminum casting patterns.” If you would like a reprint of the article, please contact Alloy Casting Co.

Alloy Casting Co. has been a nationwide member of NOMMA since 1974.

<table>
<thead>
<tr>
<th>FIG.</th>
<th>Item</th>
<th>Size (in.)</th>
<th>Wt. (lbs.)</th>
<th>Single/Double side</th>
<th>Adu. R. Pieces</th>
<th>%Tool Cost</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>3&quot; Fence Top</td>
<td>3x3x1</td>
<td>.25</td>
<td>DF</td>
<td>10,000</td>
<td>10</td>
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<tr>
<td>1</td>
<td>Round Collar</td>
<td>2 dia. x 1</td>
<td>.20</td>
<td>DF</td>
<td>200</td>
<td>90</td>
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<tr>
<td>1</td>
<td>Pyramid Spear</td>
<td>1x1x2</td>
<td>.20</td>
<td>DF</td>
<td>400</td>
<td>55</td>
</tr>
<tr>
<td>1</td>
<td>Square Collar</td>
<td>2 dia. x 1</td>
<td>.2</td>
<td>DF</td>
<td>200</td>
<td>90</td>
</tr>
<tr>
<td>2</td>
<td>49&quot; Sq.</td>
<td>1x1x49</td>
<td>4.5</td>
<td>DF</td>
<td>240</td>
<td>50</td>
</tr>
<tr>
<td>2</td>
<td>49&quot; Rd.</td>
<td>1x1x49</td>
<td>4.5</td>
<td>DF</td>
<td>240</td>
<td>50</td>
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<tr>
<td>2</td>
<td>Twist</td>
<td>1x1x42</td>
<td>2.75</td>
<td>DF</td>
<td>3,100</td>
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<td>3</td>
<td>30&quot; Sq. Rd.</td>
<td>1x1x39</td>
<td>3.5</td>
<td>DF</td>
<td>248</td>
<td>30</td>
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<td>3</td>
<td>Plaque</td>
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<td>19</td>
<td>SF</td>
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<tr>
<td>4</td>
<td>Pineapple</td>
<td>11x11x1</td>
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<td>DF</td>
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</tr>
<tr>
<td>5</td>
<td>Picture Frame</td>
<td>44x54x1</td>
<td>42</td>
<td>SF</td>
<td>600</td>
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</tr>
<tr>
<td>6</td>
<td>2&quot; Sea Shell</td>
<td>24x24x3</td>
<td>50</td>
<td>SF</td>
<td>65</td>
<td>70</td>
</tr>
<tr>
<td>7</td>
<td>4&quot; Sea Shell</td>
<td>48x48x2</td>
<td>250</td>
<td>DF</td>
<td>4</td>
<td>50</td>
</tr>
<tr>
<td>8</td>
<td>Bench End</td>
<td>26x30x1</td>
<td>19</td>
<td>DF</td>
<td>1,400</td>
<td>5</td>
</tr>
</tbody>
</table>

Source: Alloy Casting Co.

FIGURE 8: A common bench end.
Once a fabricator provides a dimensional sketch for a custom casting much of the work is already done. From that point the foundry can provide a quote for a turnkey program that includes creating the master pattern, fabricating the tooling, and manufacturing the final product. The only part that should concern the fabricator is the creative concept and creating the sketch.

Like most custom projects, creating the sketch is the easy part. Selling, fabricating, and installing the job are always more involved.

One of the most encompassing projects that Alloy Casting has completed was a custom project for a blacksmith shop in West Palm Beach, Fla. The program included five custom castings of various sizes.

The owner of a Miami Beach, Fla. home was renovating a mansion to its original 1920s design. The source document for the design was a 1920s newspaper article containing a photograph of the house’s original exterior. The newspaper photograph was studied and the ornamental iron work was redrawn to a full-scale drawing, which included three of the five custom castings [Figure 1]. The castings were to be used on the exterior of the house as a window dressing and security bards, and in the interior of the house as a room divider.

The sketches were submitted to Alloy Casting for a quote. The quote was for a turnkey project that included five original wood patterns and carvings, four pattern boards, eight sets of castings, one 5/8 inch square core box, and a match plate. A match plate is a piece of production tooling that has the design of the casting embedded into it. When the foundry’s sand is pressed against the design an imprint is left in the sand. It is this imprint that gives the aluminum casting its artistic shape. The core box enables the foundry to make and bake hard sand pieces. These hard sand pieces (called “cores”) are then placed in the mold to block out areas of the casting where horizontal holes are needed.

The wood-carver began the project by carving the plaque face and the carved dragons. The full-sized drawing enabled the woodcarver to carve with confidence knowing that there would be no pattern modifications. The master patterns for the round collar (5/8 inch square hole) was created by a pattern maker and given to a match plate fabricator to make the production tooling.

The first phase of the project included only eight sets of castings. With such a small number of castings, four of the five original master patterns were mounted directly on wooden boards to save tooling expenses. Because the dragon faced both left and right, it was tooled to be double-faced. This allowed the same dragon to be used for both left and right applications. The collars and balusters were also double-faced. The face plaque was constructed on a single face pattern board in order to save carving duplication and expense. During the second phase
of the project, two single face plaques were placed back-to-back to create a two-sided design.

Figure 2 shows the tooling that evolved from the original carvings. The dragon is double faced and the sun faced plaque is flat black. Figure 3 shows the tall baluster and the round collars that were lathe turned and mounted to wood pattern boards to provide a double face casting. Figure 4 shows the square collar, its match plate, and the 5/8 inch core box. The square core print on the tooling enabled a 5/8 inch sand core to be cast into the casting. When the core was removed, the result was a 5/8 inch square hole. The collar could then be slipped on to a 5/8 inch square bar. Figure 5 shows the castings arranged per the original sketch and Figure 6 shows the actual installation on the Miami Beach home.

A custom project for one item typically takes from start of master pattern work to prototype casting about four to six weeks. The exact time depends on the intricacy of the master pattern carving. In the Miami Beach project, it took seven weeks to complete the five original casting designs.

A foundry is organized to handle custom projects. Wood carvers and pattern makers are trained to provide sufficient drafts to eliminate undercuts and to compensate for metal shrinkage. Foundries that handle all stages of custom casting production in-house, such as Alloy Casting, insure high quality tooling and prompt deliveries. Figure 6 shows the wood-carver working on a new pattern, while figure 7 shows Doug Thomas [left] examining the master with Juan Acosta, the match plate maker.

Most projects received by Alloy Casting are initiated by a fabricator with a sketch. When a sketch is used, the foundry quotes from this drawing after acceptance. The foundry then handles the project on a turnkey basis from master pattern through tooling fabrications, to final castings.

This article is the third in a series on custom castings. Earlier articles covered technical details (May/June 1987) and economics of master patterns and tooling (November/December 1992). Alloy Casting Co. has been a NOMMA nationwide supplier member since 1974.
FIGURE 8: The carver and match plate maker examine a master.

FIGURE 9: Both of these plaques are shown with their original sketches. The casting at the left is a full sized drawing for a bench end insert. At right, a 40 percent scale drawing was carved to actual size by the wood carver.

FIGURE 10: These two types of tops were created from two separate castings. The combination of two individual parts into one casting reduced fabrication costs. The item on the left is shown with matching floor flange. The left ball top is a combination decorative flange and a standard two inch ball top. The casting on the right combines a crown and a two-piece collar to form a single piece top.
Using Aluminum Castings For Restoration

When ordering custom castings for restoration projects, different quality levels are available.


This article originally printed in the 1998 September-October issue of Fabricator Magazine, an official publication of the National Ornamental & Miscellaneous Metals Association.

Custom castings are often requested during renovation and restoration projects. Often, new castings must be reproduced from old pieces taken from the job site, or even a drawing, old photo, or faded newspaper clippings. On a small scale these projects can be a homeowner needing 2-3 fence panels to repair a fence, or on a large scale the project can be a government agency restoring a turn-of-the-century post office.

Because of the age of the castings being reproduced, almost all of the designs are originals made in cast iron. The aluminum replacements are easily accepted by the fabricator and architects. Aluminum is more forgiving than cast iron. It is easily drilled and fabricated, lighter in weight, rust free, and simple to weld. If the project involves attaching aluminum castings to a steel frame, a steel clip, bolt, or stud can be placed in the aluminum casting during forming. This steel insert can then be welded to the steel framing.

There are some quality constraints with a restoration project. If the job calls for only a few new castings, the tooling charges may easily outweigh the cost of the individual pieces. On a small project, for example, our foundry can reproduce directly from the older casting sample by forming the mold around the “loose” sample. In this case the detail in the new piece will be no better than the detail in the old casting, and in many cases worse. By producing the new casting loose there is no toling to hold the sample rigid in the production equipment. This lack of rigidity causes floating, which sometimes reduces the quality. There is also a loss of crispness in the detail and an accumulation of defects. Think of this method as using a photocopier, where you must make a copy of a copy. Each time a “copy of a copy” is made, the defects accumulate. As details become blurry and blotches occur, some of these defects can be eliminated by using an old sample to make new tooling or by re detailing to create an epoxy look-a-like.

The reproduced castings will also be 2 percent smaller than the original. When the 2 percent shrinkage is a problem, the issue can be circumvented by lengthening the sample casting or by adding epoxy where needed.

A typical renovation project, where no samples were available, is shown in Figures 1 and 2. The figures

FIGURE 1: This reproduction job started out with a full scale drawing of a three piece window crest

FIGURE 2: The drawing comes to life in a stunning aluminum casting
are of a window cresting for the renovation of a 1920s house in Miami, Fla. All ironwork on the house had been removed and destroyed by a succession of owners. But the new owner had a faded 1920s newspaper article and photo that depicted the house when new. This photo was used to make the full scale drawing in Figure 1, and reproduced as three new woodcarvings. The resulting castings are shown in Figure 2. It is a remarkable reproduction.

Figure 3 shows two cast iron panels from a Pennsylvania bridge renovation project where samples were available. The sample panels were cleaned up, epoxy was added to lengthen the required 2 percent, and new match plate tooling was fabricated. A 100 units of each design were required. Figure 4 is an example of the original bridge railing.

Figure 5 shows broken fence panels of an older home in Mississippi. Figure 6 is the fence broken into its three individual components. The samples came to us with many layers of paint and years of accumulated rust and debris. Twenty-four interlocking panels, 48 finials with a 7/8 square slot, and 6 textured end pieces were required for this project. The panels were for restoration of broken panels on the existing iron fence and a 2 section expansion of new fence. The samples were sandblasted, and new match plate double face tooling was fabricated. There are similar fence panels in existence, but none fit the home owners’ exact requirements. In this project it was verified several times with the home owner that the new casting would be aluminum, and her local installer could handle the fabrication of the two dissimilar metals.

The first casting on the left in Figure 7 shows an 8 inch cast iron stove leg with a hollow back. The other three castings are aluminum legs that have been cast loose, without the benefit of permanent tooling. Only one leg was required. But because reproducing in this manner sometimes gives questionable quality, we cast three legs and picked the best one to ship. Around the edges of the two right most castings, the rough edges can be seen. The selected casting, second from left, also looked this way, but it was extensively cleaned with chipping hammers, grinders, and files.

The two cast iron finials in Figure 8 were cast in Ohio during the late 1800s for a mansion in Passacoula, Miss. A current source for matching finials could not be found. Alloy Casting was sent a sample of each finial. An epoxy mold was made, and the resulting finial was detailed and mounted to a pattern board. To provide a compatible welding point between the aluminum finials and the steel frame, we provided a 2 inch long, 3/8 inch diameter smooth steel rod that was cast into the aluminum. The rod protruded out 1 inch. The fabricator’s job entailed redoing old broken fence sections and a driveway expansion. Over
1,000 finials were required.

Over the years Alloy Casting has done many restoration projects. Each project was unique. We once did aluminum pieces for a large scrolled iron chandelier with missing sections. It was fortunate that the lamp was not welded as it allowed the iron and aluminum replacement pieces to be interlaced and bolted together. The chandelier (no photos available) now sits in a restored mansion in Ohio with few people knowing its blend of old and new technology.

In 1992 the Hill Country Courthouse in Texas was gutted by fire. Two years later we were requested by a local Waco, Texas, fabricator to reproduce the window walk roof cresting for the courthouse. The source material for the product included old photos, old drawings, and a partial piece of heavily burned cast iron. There were five pieces to the project that entailed a combination of four wooden pattern boards and one aluminum match plate. The exterior of the building was the first phase in the renovating project, and the new aluminum roof crestings were visually equal to the old cast iron pieces.

The diversity of projects that fall under the renovation and restoration category is endless. Every project from homeowner’s fencing to bridges, to building facings to theater stairs, to roof cresting, has been completed with aluminum castings. We have even had inquiries to do aluminum castings for antique cars. Anything is possible.

The key items to consider for reproduction are the quality of the sample item submitted as a pattern and the trade off between the number of casting required and the amount of tooling investment needed to maintain quality.

Alloy Casting has been a NOMMA member since 1974. This article is the fifth in an ongoing series on custom castings. For a complete collection, call Alloy Casting at 800-527-1318.
Choosing The Right Alloy For The Right Custom Casting

The properties of aluminum alloys vary greatly. When specifying a custom casting, it's important to select the best alloy for your particular need.

By J on P. McGraw
Alloy Casting Co.

When choosing the alloy for an aluminum casting, it's important to select a type that provides the best detail and weldability, while at the same time having good foundry characteristics. A good aluminum alloy should contain silicon for high detail retention and flowability, and it should not contain elements detrimental to weldability, such as nickel. Nickel is harmful because of its high melting temperature.

Other properties to consider when choosing an alloy are strength, good corrosion resistance, and bend-ability. The projects described in this article show the advantages of matching the best alloy for a particular need. Table 1 summarizes the chemical compositions described in these scenarios.

Castings That Bend

Fabricators in the trade desire to make jobs look good. And, it sometimes helps if they also look unusual. One way to achieve this combination is for the castings to have the ability to bend into unusual shapes. Most casting have metal combinations that are stiff and difficult to bend, but it is possible to find highly bendable alloys.

On the other hand, the casting in Figure 2 has a more consistent cross section of 3/8 inches by 11/4 inches, and we were able to achieve a much larger bend of 10 inches in a 27 inch length.

The most dramatic bends have been obtained in a leaf design, 4-1/2 inches by 40 inches, with a consistent 3/16 inch thickness, shown in Figure 3. These leaves were specially designed and a special alloy was chosen to provide maximum bending ability.

Good bending results can be obtained at room temperatures, and you can feel the casting stiffen as the hardening takes place. The twisting and compound bends of the leaves were obtained by heating the casting, bending, and reheating as necessary. It is a trial and error process, but it's possible to make some very dramatic shapes.
Weldability

Most aluminum castings provided by foundries to the ornamental trade are provided in the ‘as cast’ condition (temper F). These castings are readily weldable and no special cautions are necessary.

The casting alloy is normally in the 300 series, which provides good castability for the foundry and good detail retention and weldability for the fabricator.

In those cases where there is a special application for high strength and/or corrosion resistance, extra care is necessary in selecting a welding rod. It's also important to remember that a casting given a special heat treatment cannot be welded without destroying the special treatment in the area affected by the weld. When welding, the fusion that occurs changes the microstructure of the metal and transforms the area back to an “as cast” condition.

Corrosion Resistance

Alloys that have good corrosion resistance show poor casting characteristics for the foundry and poor weldability to the fabricator. Figure 4 is a handrail panel that was made from alloy 514 (4 percent magnesium) and was used in a sea coast application. Alloy 514 exhibits good corrosion resistance properties.

On the other hand, alloy 535 (7 percent magnesium) shows a higher strength and a superior corrosion resistance because of its higher magnesium and lower and tighter specifications on trace metals. Alloy 514 was specified for the job, but for the same money 535 could have been used. This is a situation where the specifier did not take full advantage of available options. These two alloys are from the same family as the sheet and plate used for marine applications.

Those metals that strengthen aluminum the most, like copper and zinc, are the most detrimental to the corrosion resistance of aluminum.

Strength/Heat Treatment

Those alloys exhibiting high strength are normally poor in other characteristics. Alloy 713 (7 percent zinc, 1 percent copper) was chosen for the chair leg piece shown in Figure 5. Alloy 713 has high strength in the “as cast” temper and needs no heat treatment for maximum properties. The alloy, however, pours like molasses, has high shrinkage, and tends to lose detail. Fortunately, the rectangular leg cross section of 5/8 inches by 1 inch is plain and simple and showed shrinkage only in the hidden back side of the legs.

Another alloy commonly used in the “as cast” temper is alloy 319 (7 percent silicon and 3 percent copper). In this alloy, silicon has replaced the zinc and imparted more flowability and detail retention. The strength loss through the elimination of the zinc is partially compensated by an increase in copper. Figure 6 shows some castings that have been cast in alloy 319 for good machinability. The holed clutch housing is designed to break under certain conditions and alloy 319 imparts a consistent microstructure for that predictable breaking.

Alloy 356 (7 percent silicon, 1/4 percent magnesium) is the aluminum foundryman's all purpose workhorse. It has good detail retention and pours well. It is the most commonly used alloy and is specified in either the ‘as cast’ or heat treated condition. The ‘as cast’ condition strength levels of 19,000 p.s.i. (pounds per square inch) can be raised 34,000 p.s.i in the T-6 temper. T-6 temper is soaking at 1,000 degrees F for 12 hours followed by an aging treatment of 310 degrees F for 3 to 5 hours. This strengthening occurs because of a hardening process caused by the 1/4 percent magnesium.
The heat treatment has a powerful influence on properties but can increase the casting cost by 20 to 40 percent.

Figure 7 shows some industrial tire spreaders that were cast in alloy 356 and tempered to T-6. The extra strength was a requirement. Because the heat treatment improves the metal's 'as cast' microstructure, any subsequent welding destroys the heat treatment's benefits.

Because of its reasonable cost and high strength, alloy 713 would always be chosen if strength and cost were the only criteria, but because of other needs like corrosion resistance, weldability, detail retention and castability, alloy 356 and the other alloys are more frequently specified.

Polishing

Some alloys polish better than others. The high strength alloy 713 has a good luster, but for my personal preference and use, I have chosen alloy 514 (4 percent magnesium) to impart a beautiful polish and high luster to the seashell cocktail table in Figure 8. The seashell and legs of this table are now four years old and have the same shine as they did when they were first professionally polished.

Summary

The job requirements for most ornamental work can be handled with decorative castings made from common everyday alloys. But for that special job requiring a unique set of physical characteristics, it is good to know what other alloys are available that can provide those unique properties. Strength, corrosion resistance, weldability, luster and benability can all be modified with an alloy that gives the right blend of unique properties.

This article is part of an ongoing series on custom castings. Alloy Casting has been a NOMMA member since 1974.
Prepare to Powder Coat
and Put Off the White Stuff

Six preliminary steps can help fight off long
And short-term corrosion.

By Jon P. McGraw
Alloy Casting Co.

This article originally printed in the 2002 July-August issue of Fabricator Magazine, an official publication of the National Ornamental & Miscellaneous Metals Association.

Powder coating aluminum castings can sometimes be a problem. Immediate problems appear when the powder coat bubbles because of gas evolution from the casting during the heating cycle. Long-term problems happen when white corrosion develops under the coating, and flaking and peeling starts. Even though powder coating is a sophisticated process, these two problems do occur. Fighting off their occurrence is possible by taking correct preliminary steps. Preventative action can mean the use of a better base metal, preheating to degas the casting, extensive chemical cleaning, proper acidic etching rinsing with deionized water, and adequate powder curing. A lack of attention to any one of these steps can mean a rough surface and/or a coating that eventually will flake.

One: Use a Better Base Metal

When most aluminum castings are placed in a seacoast environment they demonstrate white corrosion. This corrosion is caused by salt air penetrating the coating and allowing a galvanic battery action between the aluminum and the dissimilar metals in the aluminum. These dissimilar metals are mainly copper.

In the above example, the ball cap with the dull white corrosion was made with a standard aluminum casting alloy. The ring shown was made with a marine-grade alloy and shows no corrosion. It has retained its metallic shiny surface. Both samples were placed together in a chlorine corrosive environment.

FYI

In THIS ARTICLE . . .

• An industry supplier of aluminum castings and aluminum hardware lists six ways to avoid two problems that occur when powder coating aluminum
• Short term problem, like bubbling, result from gas evolution during the heat cycle.
• Long term problems, like flaking and peeling, stem from white corrosion setting in between the coating and the base metal.

For more info call Jon McGraw at (800) 527-1318

These samples were placed in a severe chlorine atmosphere to replicate a corrosive environment. The sample on the right is a typical casting showing a white-chalky surface. The center powder coated sample shows corrosion that has penetrated from the inside out of a typical casting. The marine-grade ball aluminum cap on the left shows no corrosion. Even with two saw cuts that were put through the coating and into the ball prior to the corrosive environment, the marine-grade metal did not corrode under the powder coat nor did the coating flake off.
and zinc. The cause of the problem can be eliminated by using a marine-grade aluminum alloy having magnesium as a major component. Even under the most severe conditions, the marine-grade alloy stays shiny and coherent under the powder coat and eliminates white corrosion.

**Two: Degas the Metal**

The second step for excellent powder coating of aluminum castings is to run a preheat cycle to degas the metal. The preheating expels the contained hydrogen that was entrapped as a natural result of the casting process. Aluminum sand mold castings are made in a mixture of sand, clay and approximately 4 percent water. The impact of the molten aluminum on the damp sand creates steam of which a portion is absorbed into the casting as hydrogen. During the powder coat heating cycle, the hydrogen is expelled and shows up as a bubbly surface. This problem can be eliminated by first using a preheat cycle that is 50% to 100% higher that the normal powder curing temperature and for a time cycle 30 to 100 percent as long as the powder curing time. A good degassing cycle will eliminate unsightly bubbles.

The proper selection of a marine-grade alloy and degassing can greatly reduce problems with powder coating on aluminum castings. But even with those actions, there are two more essential steps that need to be taken: good cleaning and good surface etching.

**Three and Four: Cleaning and Etching**

Good cleaning entails alkaline decontaminating to remove organic oils, waxes and lubricants, and acidic cleaners to remove inorganic rust, scale, welding smut and to etch the surface. Contaminates and moisture left on the surface will detract from powder adhesion and give a poor coating life.

**Five: Deionized Water Rinsing**

After acidic etching the surface must be rinsed to remove contaminants and rinsed sufficiently to give a “water breakfree” cascade off the surface. Deionized water is the best media for this procedure.

After rinsing, the casting should be dried and free of powder or streaking on the surface. A powdery film indicates poor rinsing or old, heavily contaminated cleaning fluids.

**Six: Curing**

Proper curing of the powder coat is also critical for good longevity. A weak, soft coating will not stand up to the elements. As indicated above it takes several correct steps to enhance the life of powder coating. A misstep in any one can cause flaking.

I have seen castings on a gate application where the coating on cast aluminum spear finals was in excellent shape but only 24 inches lower on the same picket the cast aluminum collars were badly corroded with the powder coat flaking off. It was difficult to determine which of the many initial steps had been adequate for the finial but inadequate for the collar. Note the photographs on this page showing actual job applications where the powder coat process proved to be inadequate.

Other reports from the field suggest that imported aluminum castings exhibit much more out-gassing and corrosion than domestic castings. This is probably due to higher levels of dissimilar metals and
contaminates and lower quality foundry practices at foreign shops.

The important steps for powder coating are the same important steps for other coatings as well, be that fluoropolymers, wet paints, or hybrid combinations.

A good powder coating system is a sophisticated process. There are many sequential steps that must happen correctly in order to obtain good results. These detailed steps are highly technical and more than can be covered in this short article. So the next time you send a job with aluminum castings “out to be powder coated” and worry about the results, think of the many steps that are essential to providing a smooth, long lasting coating. Reduce those worries and insure good results by taking preventative action. Make sure the job is not returned.
The survey says, . . .

"Marine grade castings!"

A pictorial survey of eight case studies suggests that using marine grade castings and a modified powder coating application to avoid degassing results in long lasting beautiful aluminum castings, even in harsh salt water environments.

By Jon McGraw
Alloy Casting Co. Inc.

There are many steps necessary to providing a good, hard, coherent coating to aluminum castings. These steps include proper cleaning and rinsing, degassing, and proper curing of the coating. However, even if these steps are followed and the powder coater does the best possible job, sufficient evidence from on-site inspections and field reports suggests that another step is necessary on your part: using marine grade base material. The marine grade approach offers added protection that makes your job look better for a longer period of time. And that reduces call backs, which makes all of us happier.

The rapid flaking and peeling of coatings from aluminum castings in a severe weather environment or the normal long term slow deterioration in a mild environment can be resisted with the proper selection of marine grade base metal because marine grade aluminum castings resist corrosion and improve coating performance.

For your information

Poor finish: Non-marine grade castings and sub-par powder coating application (page 30).
Better finish: Marine grade castings and sub-par powder coating application (page 32).
Best finish: Marine grade castings and good powder coating application including a modified degassing pre-bake cycle (page 34).
Contact: Jon McGraw, Alloy Casting Co. Inc., Ph: (800) 527-1318.
This scroll casting is not marine grade. It shows severe white corrosion after only 18 months in its ocean environment in Sarasota, FL. No coating remains.

This 12-year-old aluminum furniture in Dallas, TX, is also not marine grade. Even though it is not in a harsh marine environment, its powder coat is peeling and corrosion appears.

Corrosion on aluminum

Flaking and peeling occur on regular aluminum because air penetrates through the coating and corrodes the base metal. The devastation of the coating can occur rapidly when the job site is next to the ocean. Or it can take a much longer period of time in a more temperate climate. Either way, however, the castings will eventually show signs of corrosion. The scroll casting pictured at the top of this page has been on the ocean only 18 months and shows almost complete disintegration; whereas the aluminum furniture (pictured below it, bottom of page 29) is located in the more moderate environment of Dallas, TX. In this less harsh environment the aluminum held off significant corrosion for 10 years. The furniture has now been in the weather 12 years.

Poor: Corrosion on non-marine grade castings with sub-par powder coating application

Typical corrosion of non-marine aluminum castings is shown at left. The ball cap has been near the ocean for four years and shows the corrosion on the corner edges where only a thin layer of coating might have been applied. This edge with a thin coating enables the salt air to penetrate here first and begin the corrosion peeling action. The root cause of the white chalk aluminum corrosion is the residual amounts of copper that create a galvanic reaction with the aluminum base material.

Better: Corrosion on marine grade casting with poor powder coating application

Even the use of virgin metal with the correct marine grade chemistry, however, cannot cure the faults of a poor coating application. Pictured at the top of page 32 is a handrail installed near the ocean in Palm Beach, FL. For eight years the castings have been directly exposed to the wind and spray of the ocean. However, they are still shiny and coherent. This shiny and coherent surface indicates no galvanic corrosion has occurred as the marine metal has successfully resisted the salt air. But because of the
poor powder coating application, the net effect is still a poor looking rail. Compare this picture at left with the non-marine grade aluminum castings that have been on the ocean only 18 months (top of page 29). Marine grade castings on the ocean eight years with no corrosion pictured at left show the value of the proper base metal. Again, however, even the marine grade metal could do nothing to improve the original poor powder coating.

**Best:** Corrosion on marine grade castings with good coating application

A recent on-site survey of many copper-free marine grade castings that have been on the ocean between one and 3½ years shows the excellent results of combining marine grade castings with good powder coating applications. Shown below and on page 34, the castings are coherent and show no signs of corrosion or flaking.

When I visited one fabricator in Jupiter, FL and asked to visit job sites that have had marine grade metal for
This marine grade and well powder coated spear and ball cap located just 100 yards from the ocean is in excellent, coherent condition after 3½ years.

This marine grade large, heavy seashell aluminum casting adorning an exterior fence located between the Intracoastal Waterway and the Atlantic ocean shows a coherent coating in excellent condition after two years.

several years, he said, “I don’t know where they are. I only know I have had no call backs because of poor performance.”

**Caution: Avoid out gassing during the powder coat cycle when using marine grade castings**

The above comment shows the overall value of using marine grade aluminum. However, the value of marine grade castings can be undermined if certain precautions are not taken to prevent out gassing during the powder coat cycle. The chemistry of the marine grade metal demands the foundry pour at a higher temperature into the sand molds. This higher temperature in contact with the moisture inherent in the sand causes more than a normal amount of steam. This moisture becomes trapped in the aluminum casting.

During the heating and curing powder coat cycle, the moisture is pushed out of the casting and causes a bulky surface in the powder coat. For this reason, it is recommended that the powder coater operate a de-gassing step. This includes (1) running a pre-bake de-gassing cycle at 50–100 degrees higher than normal, and (2) running the pre-bake cycle at least 100 percent longer than the normal powder coat curing time. On heavier aluminum castings a much longer pre-bake cycle may be necessary.