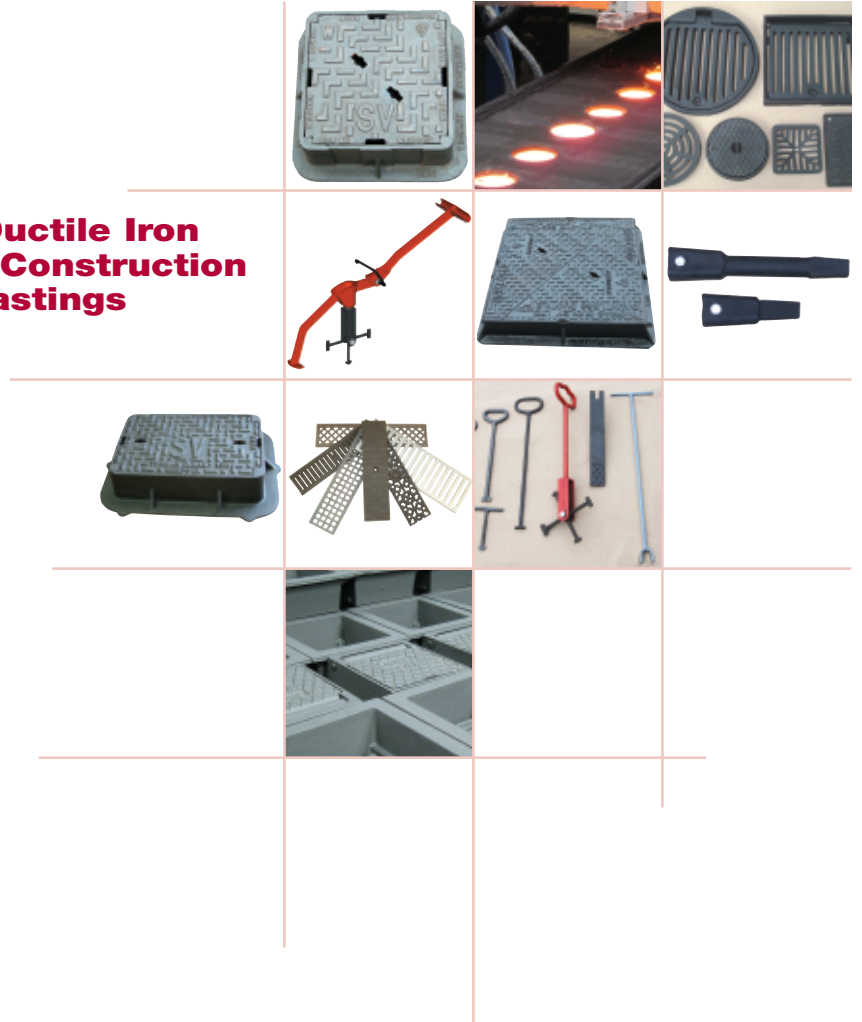


**Grey and Ductile Iron
 Utility and Construction
 Industry Castings**



Reliable, cost-effective, UK based manufacturing



At Thomas Dudley, we understand the need for organisations operating in the utility and construction industries to work with trusted suppliers.

As such, we provide a reliable, cost-effective, UK based source of manufacture for high quality grey and ductile iron castings.

We have been manufacturing castings since 1920 and call upon unrivalled expertise to engineer innovative, value-adding products.

Outstanding service

Our success has been built upon a unique ability to deliver an outstanding service by working closely in partnership with customers.

We can also provide the complete engineering service to design and develop new products on behalf of customers.

In addition, we can choose from 6 automated moulding lines including a new Disamatic facility and airset capabilities to provide the perfect production platform.

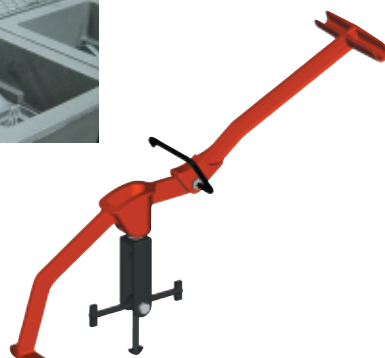
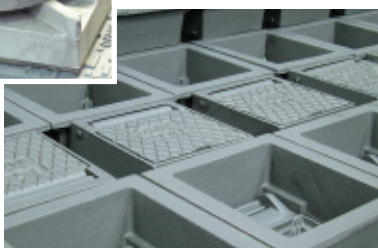
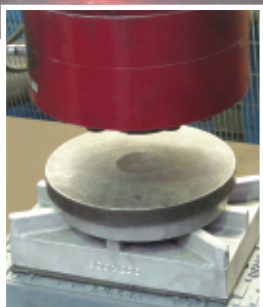
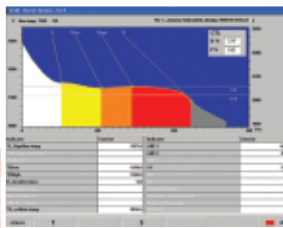
Assured quality

Thomas Dudley offers assured product quality.

We manufacture in the UK and are a quality accredited organisation. Best practice methodologies are employed throughout our foundry and are underpinned by stringent quality procedures and Six Sigma.

Our Advanced Thermal Analysis System (ATAS) enables us to carefully monitor and control melt quality to consistently ensure the integrity of our grey and ductile iron.

Rigorous post production testing is also undertaken.



Effective

Security of supply

Thomas Dudley offers an extremely secure source of supply from our Black Country foundry in the heart of the West Midlands.

Employing around 400 people and generating revenues exceeding £30 million, the Thomas Dudley Group is established, successful and financially robust.

When customers choose to work with us therefore, they do so with the assurance of knowing they have selected a manufacturing partner who will support them long into the future.

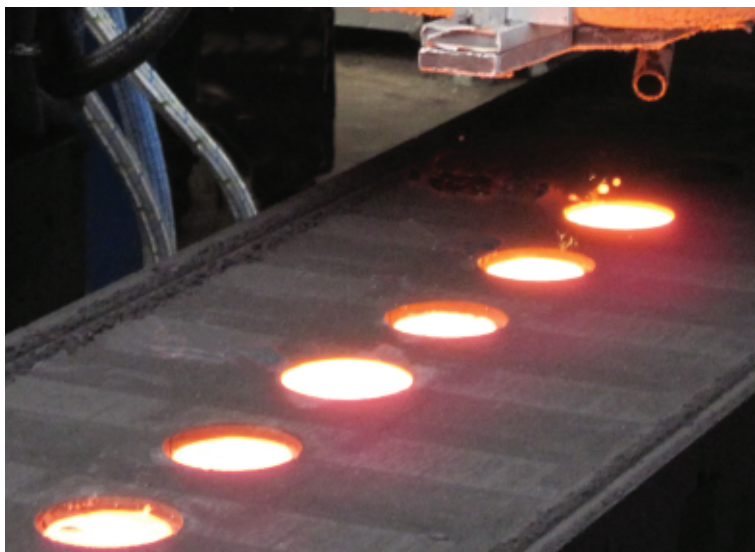
We also invest heavily in technology and as such, are able to continually improve, adapt and evolve with the businesses of our customers.

Cost-effective casting solutions

Thomas Dudley has the expertise to engineer competitive, value for money solutions.

In addition to selecting the most cost-effective method of manufacture, we call upon extensive on site logistical capabilities to produce castings in large volumes and store them on behalf of customers.

Proactively stock controlling these products, we can then deliver in smaller batches, to support contract or tender deadlines.



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Ductile iron manhole covers and frames

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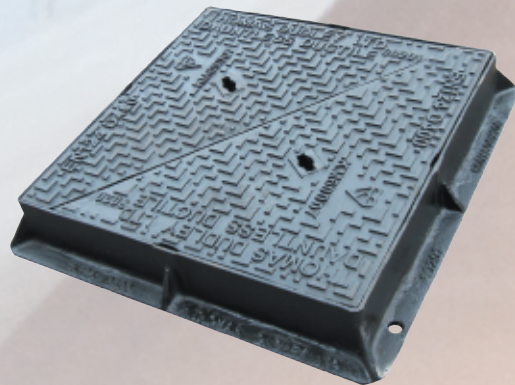
14-15

Other Dauntless castings for the utility and construction industries

16

Envirofacturing and Technical Specifications

Ductile iron manhole



Pattern Nos. 324837 and 324838

Product Description

- Ductile iron manhole frame with user-friendly two piece slide out cover
- Ductile iron conforms with BS 1563 500/7
- Manhole cover and frame conforms with BS EN 124 Grade 400
- Capable of bearing wheel loads of five tonnes in applications where vehicles only have occasional access

Special Features

- Features a slide out cover that can be easily removed by one man
- Incorporates two prising slots and two keyholes for balance when replacing the cover
- Cover can be badged as required subject to sufficient demand and incorporates a raised pattern to reduced the risk of slipping
- Supplied complete with an environmentally friendly black water based coating

All sizes are approximate

Pattern	Clear Opening	Size Over Base	Depth
324837	600 x 600mm	700 x 700mm	100mm
324838	675 x 675mm	775 x 775mm	100mm

covers and frames

Pattern Nos. 6560 and 6570

Product Description

6560 Pattern:

- Grade B ductile iron manhole cover with one piece slide out cover
- Complies with BS 5834 Part 3
- Capable of bearing wheel loads of five tonnes in areas to which vehicles only have occasional access



6570 Pattern:

- Grade A ductile iron manhole cover with two piece slide out cover
- Can be used with confidence in most applications (not recommended for where fast moving traffic is likely)



Special Features

- Both the 6560 and 6570 patterns feature a slide out cover that can easily be removed by one man
- The 6560 cover incorporates two prising slots and two keyholes for balance when replacing the cover
- The 6570 frame incorporates a two piece cover. Each piece has one prising slot and one key hole
- Covers can be badged as required subject to sufficient demand and incorporate a raised pattern to reduce the risk of slipping
- Supplied complete with an environmentally friendly black water based coating

All sizes are approximate

Pattern	Clear Opening	Size Over Base	Depth
6560	600 x 450mm	765 x 642mm	75mm
6570	600 x 450mm	810 x 665mm	100mm



Gripfix® Ductile Iron



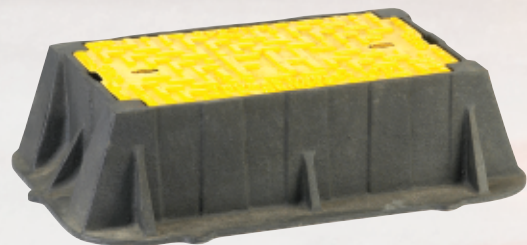
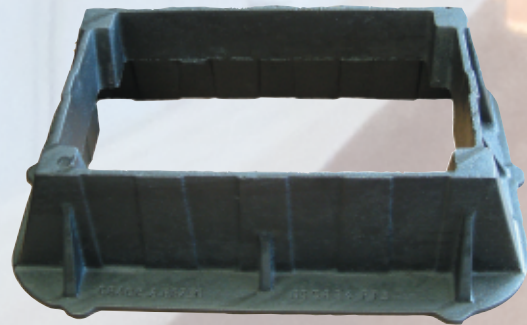
Pattern No. 6270

Product Description

- Ductile iron surface box. BS5834: Grade A, Grade B and D400 grades available
- Can be used with confidence in carriageways, verges and pavements
- Highways Agency HA 104/02 compliant
- Designed and manufactured in the UK

Special Features

- Incorporates a Gripfix® unique solid top non-rock, rattle free one piece ductile iron cover
- Cover supplied with prising slots and keyholes and in approved Fire Service Yellow if required
- Two prising slots allow easy clearance of the cover from either direction in emergencies
- Two keyholes facilitate balance and level lifting/replacement of the cover and prevent lopsided action and the possibility of trapped fingers
- Has solid flange to prevent ingress of backfill into the chamber
- FH covers available with direction indicator on the underside
- Supplied complete with an environmentally friendly black water based coating
- Lid incorporates a raised pattern to reduce the risk of slipping
- Cover badged as 'WATER', 'FH', 'SV', 'WO', 'METER' or 'AV' as standard. Can be badged as required, subject to sufficient demand



All sizes are approximate

Pattern	Clear Opening	Size Over Base	Depth
6270	380 x 230mm	508 x 356mm	100mm
6270	380 x 230mm	508 x 356mm	125mm

Surface Boxes

Pattern Nos. 135AN and 225AN

Product Description

- Ductile iron surface boxes. BS5834 Grade A, EN124:C250 and D400 grades available
- Can be used with confidence in carriageways, verges and pavements
- Highways Agency HA 104/02 compliant
- Designed and manufactured in the UK

Special Features

- Incorporates a Gripfix® unique solid top non-rock, rattle free one piece ductile iron cover
- Cover supplied with four prising slots
- 225AN cover has two keyholes to facilitate balance and level uplifting/replacement of the cover, preventing lopsided action and the possibility of trapped fingers
- Has solid flange to prevent ingress of backfill into the chamber
- Supplied complete with an environmentally friendly black water based coating
- Lid incorporates a raised pattern to reduce the risk of slipping
- Cover badged 'SV' as standard. Can be badged as required subject to sufficient demand

All sizes are approximate

Pattern	Clear Opening	Size Over Base	Depth
135AN	150 x 150mm	245 x 245mm	100mm
225AN	225 x 225mm	304 x 304mm	100mm

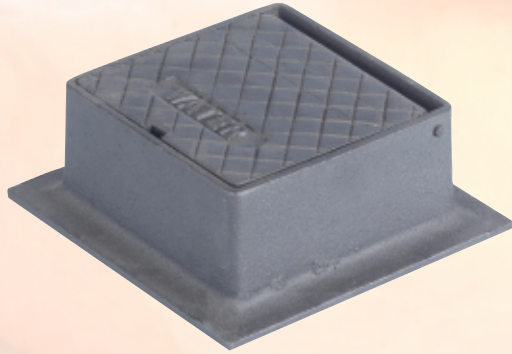
Pattern number 300AN featuring a non-rock, rattle free two piece cover is also available.

Pattern	Clear Opening	Size Over Base	Depth
300AN	300 x 300mm	380 x 380mm	100mm



Unique non-rock
cover

Grey Iron Stoptap Boxes



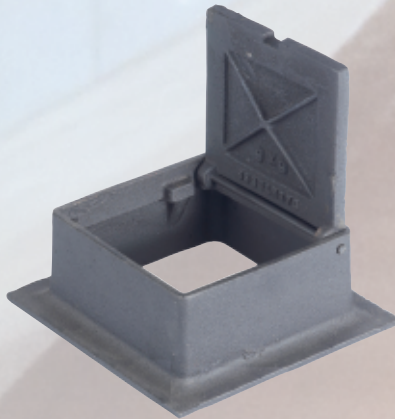
Pattern No. 6110

Product Description

- Traditional range of stoptap boxes
- For use in pedestrian areas and those subject to light hand traffic
- Designed and manufactured in the UK

Special Features

- Badged 'WATER' as standard but can be badged as required subject to sufficient demand
- Fitted with steel hinge pin. A brass hinge pin can be supplied as an optional extra
- Locking versions are fitted with turnbuckle locks manufactured from non-corrodible brass
- Lid incorporates a raised pattern to reduce the risk of slipping
- Prising slot is also included for easy opening
- Supplied complete with an environmentally friendly black water based coating
- *Can be supplied with locking lids as an optional extra



All sizes are approximate



Slip resistant pattern

Lid	Clear Opening	Over Top of Frame (mm)	Over Top of Frame (")	Size Over Base	Depth
*Hinged	102 x 95mm	114 x 114mm	(4½ x 4½")	152 x 152mm	76mm
*Hinged	102 x 102mm	127 x 127mm	(5 x 5")	152 x 152mm	102mm
Swivel	127mm diameter	147 x 147mm	(5¾ x 5¾")	180 x 180mm	80mm
Hinged & locking	140 x 114mm	152 x 152mm	(6 x 6")	180 x 180mm	76mm
Hinged	140 x 114mm	152 x 152mm	(6 x 6")	210mm diameter	76mm
Hinged & locking	140 x 114mm	152 x 152mm	(6 x 6")	210mm diameter	76mm
Hinged & locking	140 x 114mm	152 x 152mm	(6 x 6")	180mm diameter	76mm
Hinged	203 x 190mm	229 x 229mm	(9 x 9")	276 x 276mm	76mm
Hinged & locking	203 x 190mm	229 x 229mm	(9 x 9")	276 x 276mm	76mm
Hinged	267 x 241mm	305 x 305mm	(12 x 12")	394 x 394mm	102mm
Hinged & locking	267 x 241mm	305 x 305mm	(12 x 12")	394 x 394mm	102mm

Locking Stoptap Box

Pattern Nos. 6413

Product Description

- Grade B lockable stoptap box with ductile iron lid
- Complies with BS 5834 Part 2
- Ideal for use where there may be the potential for tampering
- Designed and manufactured in the UK

Special Features

- Fitted with a tamper resistant locking lid
- The turnbuckle lock is manufactured from non-corrodible brass
- Lid incorporates a raised pattern to reduce the risk of slipping
- Supplied complete with an environmentally friendly black water based coating
- A prising slot is also included for easy opening
- Key to operate lock is available as an optional extra

All sizes are approximate

Clear Opening	Over Top of Frame	Size Over Base	Depth
100mm	142 x 114mm	176 x 150mm	75mm



Tamper resistant locking lid

Cast Iron Surface Boxes



Non-corrodible
brass hinge pin



Pattern No. 6153/190

Product Description

- Fit on to most plastic top hats including the Waterfit Plain Top Hat
- All the patterns are designed and manufactured in the UK and comply with BS5834 Part 2
- Capable of bearing wheel loads of five tonnes in areas to which vehicles only have occasional access

Special Features

- Badged 'WATER' as standard but can be badged as required subject to sufficient demand
- Fitted with non-corrodible brass hinge pins
- Lid incorporates a raised pattern to reduce the risk of slipping, and a prising slot
- Supplied complete with an environmentally friendly black water based protective coating
- Lockable options and alternative sizes available
- Lids can be supplied with a hole for a touch read pad

All sizes are approximate

Lid	Clear Opening	Over Top of Frame	Size Over Base	Depth
6153/190	180mm	210 x 200mm	272 x 272mm	75mm

for Meter Box Chambers

Pattern Nos. 6150/135, 6150/150 & 6150/180

Product Description

6150/135 Pattern:

- Round spigot fits outside of a 6" nominal bore plastic guard pipe

6150/150 Pattern:

- Round spigot fits inside a 200mm nominal base plastic guard pipe or outside a 6" nominal bore pipe

6150/180 Pattern:

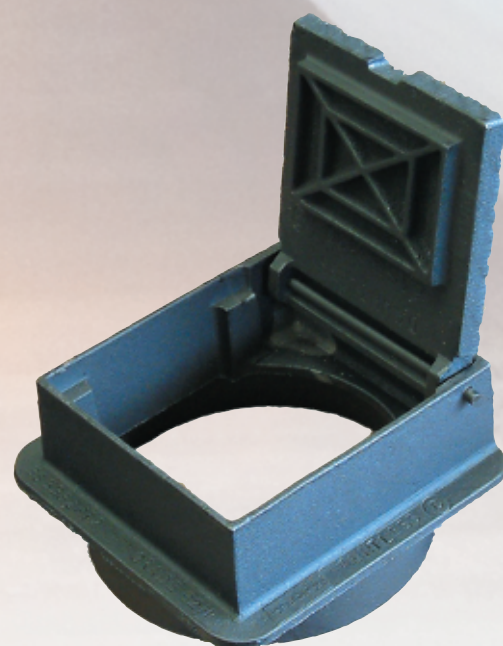
- Round spigot fits outside a 200mm nominal bore plastic guard pipe
- All patterns are designed and manufactured in the UK and comply with BS5834 Part 2
- Capable of bearing wheel loads of five tonnes in areas to which vehicles only have occasional access

Special Features

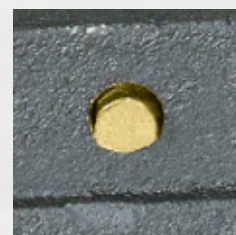
- Badged 'WATER' as standard but can be badged as required subject to sufficient demand
- Fitted with non-corrodible brass hinge pins
- Lid incorporates a raised pattern to reduce the risk of slipping, and a prising slot
- Supplied complete with an environmentally friendly black water based protective coating
- Lockable options and alternative sizes available
- Lids can be supplied with a hole for a touch read pad

All sizes are approximate

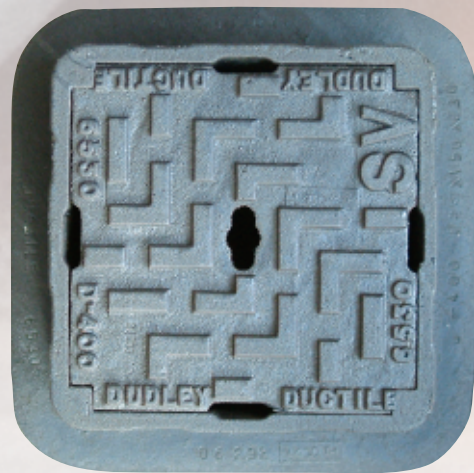
Lid	Clear Opening	Over Top of Frame	Size Over Base	Depth	
6150/135	135mm	170 x 153mm	188 x 188mm	Box - 60mm	Overall - 90mm
6150/150	150mm	180 x 160mm	200 x 200mm	Box - 60mm	Overall - 90mm
6150/180	180mm	220 x 220mm	238 x 238mm	Box - 60mm	Overall - 105mm



Non-corrodible
brass hinge pin



Ductile Iron Surface Box for Telescopic Spindles



Unique non-rock cover

Product Description

- Designed specifically for use with telescopic extension spindles
- BS5834 Grade A, EN124:C250 and D400 grades available
- Highways Agency HA 104/02 compliant
- Designed and manufactured in the UK

Special Features

- Incorporates a Gripfix® unique solid top non-rock, rattle free one piece ductile iron cover
- Four prising slots allow easy clearance of the cover from any direction in emergencies
- One keyhole provided
- Lid incorporates a raised pattern to reduce the risk of slipping
- Cover badged 'SV' as standard. Can be badged as required subject to sufficient demand
- Supplied with an environmentally friendly black water based coating

All sizes are approximate

Clear Opening	Over Top of Frame	Size Over Base	Depth
135 x 135mm	150 x 150mm	275 x 275mm	225mm



DUDLEY HydraFold

Folding Manhole Lifting Tool

Product Description

- Folding manhole lifting tool that has been designed with manual lifting best practice guidelines in mind
- Unique patented design allows manhole covers to be safely lifted whilst keeping a straight back and reducing the risk of injury

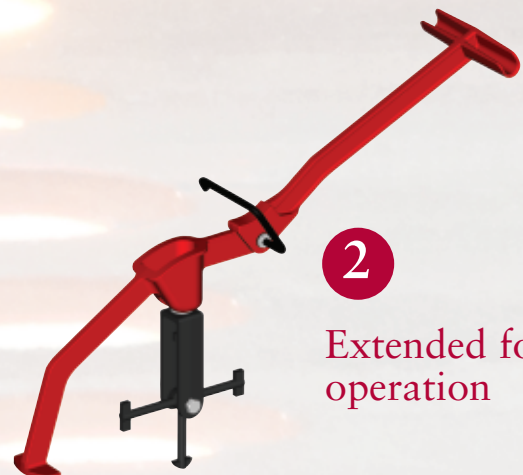
Special Features

- Lightweight with integral handle for easy carrying
- Four different key heads
- Useable with most types of cover
- Folds down to fit into car boots - ideal for taking on site
- Ductile iron strength
- Painted finish
- The Dudley Treadlift foot lever can be used in conjunction with the Hydrafold to help break the manhole cover seal



1

Folded for transportation



2

Extended for operation

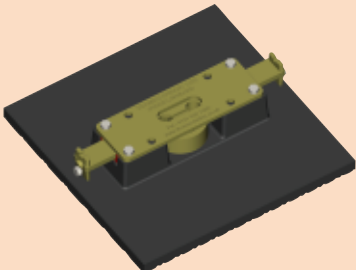
Other Dauntless castings for the utility and construction industries


The Dauntless range of construction industry castings is the largest in the UK.


In addition to the products detailed on pages 4 - 13 of this catalogue, we manufacture grey and ductile iron brackets, heating and ventilation products, airbricks, sash weights, floor plates, gratings and drainage products.

A small selection of these are shown below and right. If you cannot find what you are looking for, please contact our sales office on 0121 530 7000. We can also design and engineer bespoke iron castings – please enquire.

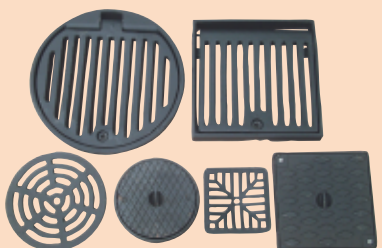
Valve Spindles	Description	Pattern	Sizes
	Valve extension spindles	-	100mm - 1000mm Please enquire

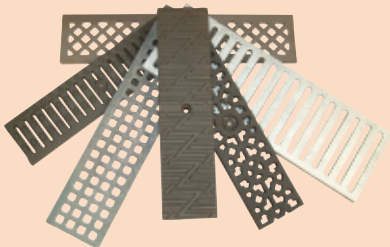
Replacement Lids	Description	Pattern	Sizes
	Locking replacement stoptap box lid	323555	225mm x 225mm

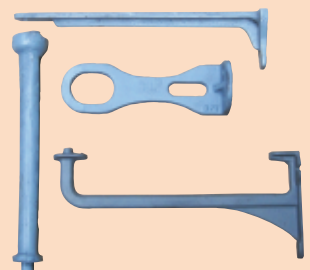
Lifting Tools and Keys	Description	Pattern	Sizes
	Ductile heavy duty lifting key Steel heavy duty lifting key Ductile medium duty lifting key Grey iron light duty lifting key Steel crutch end stopcock key Steel box end stopcock key Treadlift foot lever Hydra lifting tool short handle Hydra lifting tool long handle	HD1, HD3 HD2 M1 LD3, LD4 SC1 SC2 - - -	94mm and 300mm 442mm 125mm 71mm and 75mm 600mm, 750mm and 900mm 600mm, 750mm and 900mm - 530mm 630mm

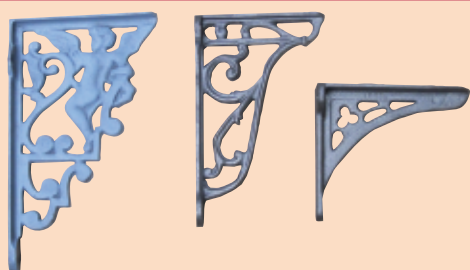
Tidal Flaps and Stoppers	Description	Pattern	Sizes
	Cast iron galvanised locking stopper	D453	140mm, 191mm and 267mm
	Cast iron galvanised tidal flap	D250	133mm, 184mm, 267mm and 330mm

Step Irons	Description	Pattern	Sizes
	Malleable iron galvanised step irons	D102	114mm and 229mm

Drainage Gratings	Description	Pattern	Sizes
	A comprehensive range of fulley grids, gratings and frames and sealing plates	-	Please enquire

Linear Drainage Gratings	Description	Pattern	Sizes
	Stillette Flat straight bar Forecourt Decorative Light duty Z tread	- - - - - -	123mm x 498mm 123mm x 498mm 123mm x 498mm 123mm x 498mm 123mm x 498mm 123mm x 498mm

Brackets	Description	Pattern	Sizes
	Towel rail brackets (shown left) A wide range of basin, sink and cistern brackets are also available – please enquire	D1001	165mm – 305mm

Decorative Brackets	Description	Pattern	Sizes
	Cupid bracket (shown left) Also available: Clover Bramble	D1094 D1091 D1093	161mm and 305mm 140mm and 165mm 140mm and 203mm



- We have attained BS EN ISO 14001, the recognised standard for environmental management systems
- We employ best practice and lean manufacturing principles throughout the organisation to maximise manufacturing efficiency
- We invest heavily in technology designed to reduce our emissions and energy consumption
- We manufacture in the UK and not overseas, helping to reduce the environmental cost and carbon footprint of transportation
- Our catalogues are printed on recycled paper by local printers
- We recycle our waste paper by shredding it on-site and re-use it for packing purposes

Technical Specifications (EN and Previous National Standards):

Minimum Tensile Strength		Grey Cast Iron					
N/mm ²	Tonf/in ²	BS EN 1561:1997	BS 1452 1961	BS 1452 1990	DIN 1691 1985	NF A32:101 1987	ANSI/ASTM A48-83
150	9.7	EN-GJL-150	10 12	150 180	GG-15	FGL-150	20A
200	13.0	200	14	220	20	200	25A 30A 35A
250	16.2	250	17	250	25	250	40A
300	19.4	300	20	300	30	300	45A
350	22.7	350	23	350	35	350	50A
Minimum Tensile Strength/Elongation %		Spheroidal Graphite (Nodular or Ductile) Cast Iron					
N/mm ²	Tonf/in ²	BS EN 1561:1997	BS 2789 1961	BS 2789 1985	DIN 1691 1985	NF A32-201 1987	ANSI/ASTM A536-84
350	22.7	EN-GJS-350-22	24/17	350/22		FGS370-17	
400	25.9	400-18		400/18	GGG-40	400-12	60-40-18 60-42-10
420	27.2		27/12	420/12			
450	29.1	450-10		450/10			65-45-12 70-50-05
500	32.4	500-7	32/7 37/2	500/7	50	500-7	80-55-06 80-60-03
600	38.8	600-3	42/2	600/3	60	600-3	100-70-03
700	45.3	700-2	47/2	700/2	70	700-2	
800	51.8	800-2		800/2	80	800-2	120-90-02
900	58.3	900-2		900/2			

Approximate equivalents only. E. & O.E.



Thomas Dudley Ltd.

P.O. Box 28, Birmingham New Road, Dudley, West Midlands DY1 4SN
 Tel: 0121 530 7000 (Sales) 0121 557 5411 Fax: 0121 557 5345
 E-mail: sales@thomasdudley.co.uk www.thomasdudley.co.uk

We are a quality assured company to:

