









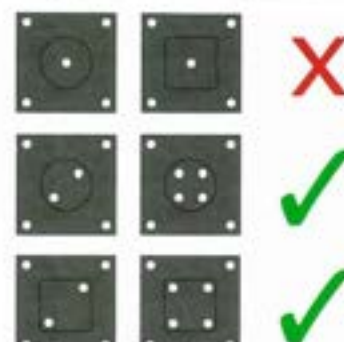


VENTING & DRAINAGE

The purpose of this information sheet is to provide specific guidance targeted at areas within the fabrication process that will lead to improvements in the finished product. It is our aim to educate and provide awareness to our customers, that will save time and money, by correcting potential design flaws. Considering where to put suitable venting and drainage holes prior to fabrication will lead to the best finish on any galvanized and powder-coated surface.



			Number and location of holes or slots at each end of the hollow section										
			1 hole	1 hole	2 holes	2 holes	2 slots at corners	4 holes	4 slots at corners	4 holes of 15 mm x 1 central hole	4 holes of 15 mm x 1 central hole	4 holes of 25 mm x 1 central hole	
Section cross-sectional shape and dimensions (mm)													
Round	Square	Rectangular	Diameter of the hole (mm)				Size of Slot (mm)	Diameter of hole (mm)		Size of Slot (mm)		Diameter of central hole (mm)	
15	15	—	10	10	—	—	—	—	—	—	—	—	—
20	20	30 x 15	10	10	—	—	—	—	—	—	—	—	—
30	30	60 x 30	12	12	10	10	—	—	—	—	—	—	—
40	40	60 x 30	14	14	12	12	10	—	—	—	—	—	—
50	50	80 x 40	16	16	12	12	13	10	10	—	—	—	—
60	60	80 x 40	20	20	12	12	16	10	10	12	—	—	—
80	80	100 x 60	25	25	16	16	20	12	12	15	—	—	—
100	100	120 x 80	30	30	20	20	25	14	14	20	—	—	—
120	120	160 x 80	36	36	25	25	30	20	20	25	—	—	—
150	150	200 x 120	45	45	30	30	40	25	25	30	30	—	—
200	200	280 x 140	60	60	40	40	50	30	30	35	50	40	—
300	300	300 x 250	—	—	60	60	75	40	40	50	60	70	70
400	400	400 x 350	—	—	80	80	100	50	50	75	100	100	100
500	500	500 x 500	—	—	100	100	120	75	60	90	140	120	130
600	600	700 x 400	—	—	120	110	150	90	75	110	150	150	160



Good hole size and placement around the inside circumference of any hollow section enables the item to be hung at almost any angle and provides excellent drainage which in turn leads to superior quality. It is a common mistake just to have one hole in the center of a base or cap plate, this will trap liquid and necessitates more holes for correct drainage. The amount, position and size of the holes required for hollow sections are shown in the chart above. Further information regarding design for galvanizing is available in **BS EN ISO 14713 - 2020 part 2 - Zinc Coatings - Guidelines and recommendations for the protection against corrosion of iron and steel in structures**

Remember as the volume of the item increases then so does the size and/or quantity of holes required!! Unfortunately the drilling of any additional holes is charged extra and may delay the turnaround on your order.

Should you wish any further information please do not hesitate to contact one of our experts on Elgin – 01343 548855 or Cumbernauld – 01236 731444 or alternatively email any enquiries direct to our technical team at design@higalv.co.uk