



Joint Ring Solutions



Built to last. Designed to perform.

- For wetcast applications
- 12" through 144" diameters

Heavy steel construction designed for strength, durability and performance

Afinitas is known for bringing together the top engineering and manufacturing expertise in the industry to build best-in-class precast forming systems. Our wide range of quality products are backed by knowledgeable and responsive customer sales and manufacturing team members who are there to assist you throughout the life of your form. And to that point, our forms are built to last. We combine heavy-duty steel with an innovative approach to manufacturing that will ensure we can help you take your business where you want to grow.

Wetcast formwork is a core competency of the Afinitas team. We have been trusted for decades to engineer forms for a wide variety of applications, including:

- Manhole Cone Forms
- Manhole Riser Forms
- Manhole Slab Top, Transition Slab, Base Slab Forms
- Box Forms
- Flared End Forms
- Battery Grade Ring Forms
- Manhole Joint Rings



Manhole Cone Form



Box Form



Grade Ring Form

 **Afinitas is your source**
for Wetcast Forming Systems.

Contact our team at
+1 641-394-4111
or email rfq@afinitas.com

Joint Ring Types

Joint rings, also known as gaskets or seals, are flexible circular components designed to create a watertight seal between sections of precast concrete pipe, manholes, and other structures. They fill the gaps and prevent infiltration or exfiltration of water. Our high quality joint rings contribute to the overall stability and strength of your precast products, ensuring the integrity of your underground infrastructure projects.



Groove Forming Pallets with Legs

- Used with manhole slab tops, cones, riser or pipe forming
- Available sizes range from 24" – 144"
(smaller diameter rings are available)



Tongue Forming Headers, Open Top with Form Tabs

- Used with manhole combination base/riser forming or pipe forming
- Available sizes range from 24" – 144"
(smaller diameter rings are available)



Tongue Forming Pallets with Lifting Eyes

- Used with manhole monolithic base forming
- Available sizes range from 24" – 144"
(smaller diameter rings are available)



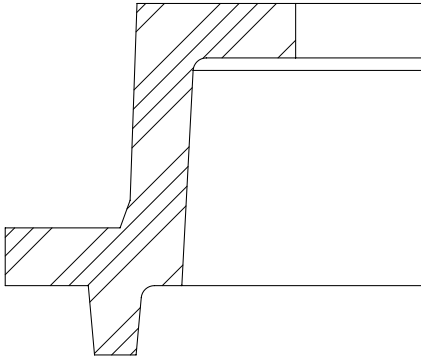
Tongue Forming Headers, Open Top with Form Hangers/Lifting Eyes

- Used with manhole - combination monolithic base/riser forming or pipe forming
- Available sizes range from 24" – 144"
(smaller diameter rings are available)

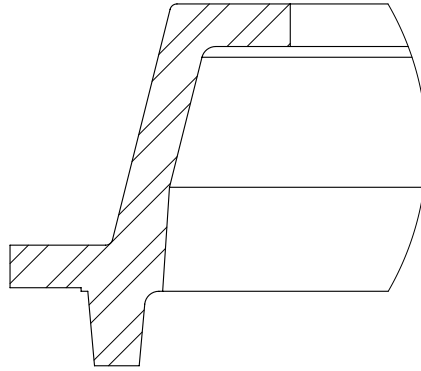


Joint Rings

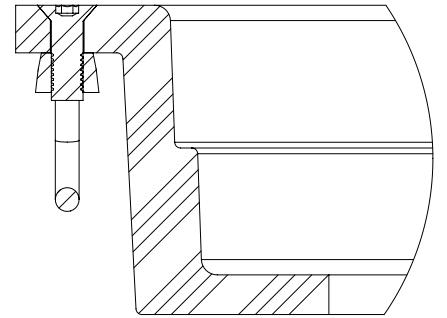
12" – 144" Diameter Round, Arch and Elliptical



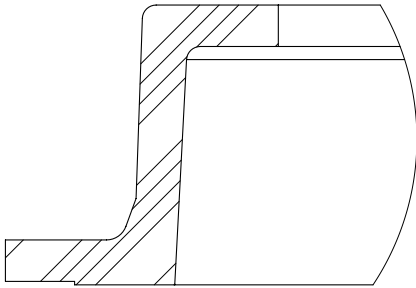
Single Offset Groove Forming
Pallet with Legs



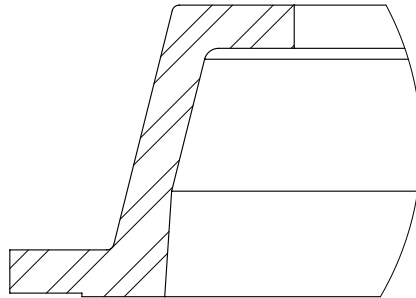
Mortar Joint Groove Forming
Pallet with Legs



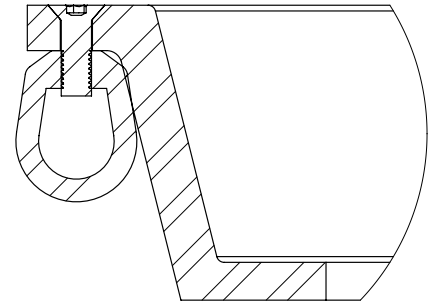
Single Offset Tongue Forming
Pallet with Lifting Eyes



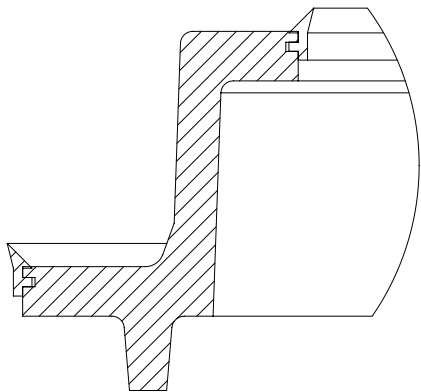
Single Offset Groove Forming
Pallet without Legs



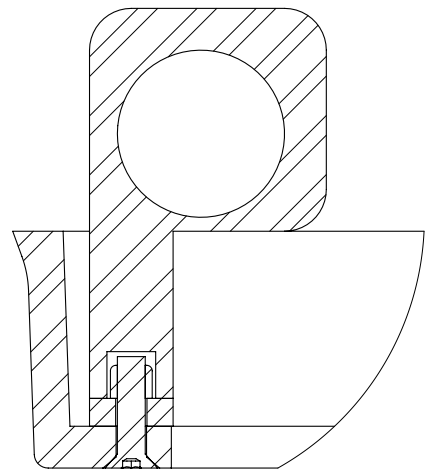
Mortar Joint Groove Forming
Pallet without Legs



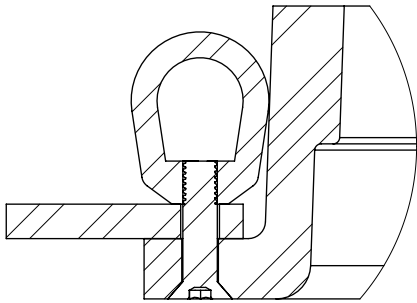
Mortar Joint Tongue Forming
Pallet with Lifting Eyes



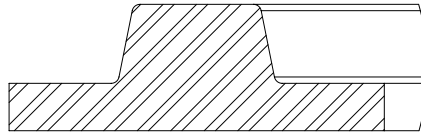
Single Offset Groove Forming
Pallet with Legs and ID/OD
Chamfer Seals



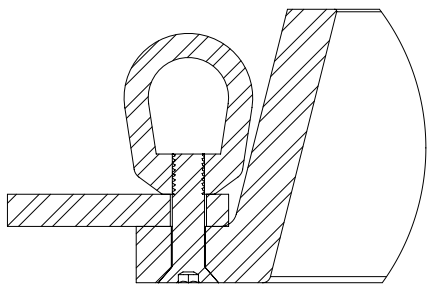
Single Offset Groove Forming
Header, Open Top with Lifting
Eyes and Core Tabs/Hangers



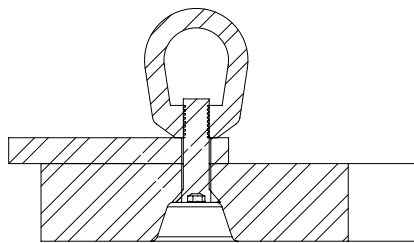
Single Offset Tongue Forming Header, Open Top with Lifting Eyes and Form Tabs



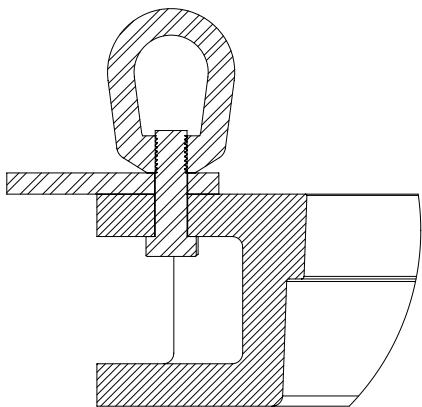
Key Lock Groove Forming Pallet



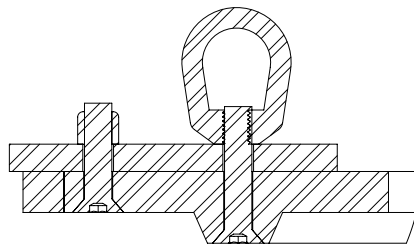
Mortar Joint Tongue Forming Header, Open Top with Lifting Eyes and Form Tabs



Key Lock Tongue Forming Header with Form Tabs and Lifting Eyes



Single Offset, Double Flange, Tongue Forming Header, Open Top with Lifting Eyes and Form Tabs (84\"/>

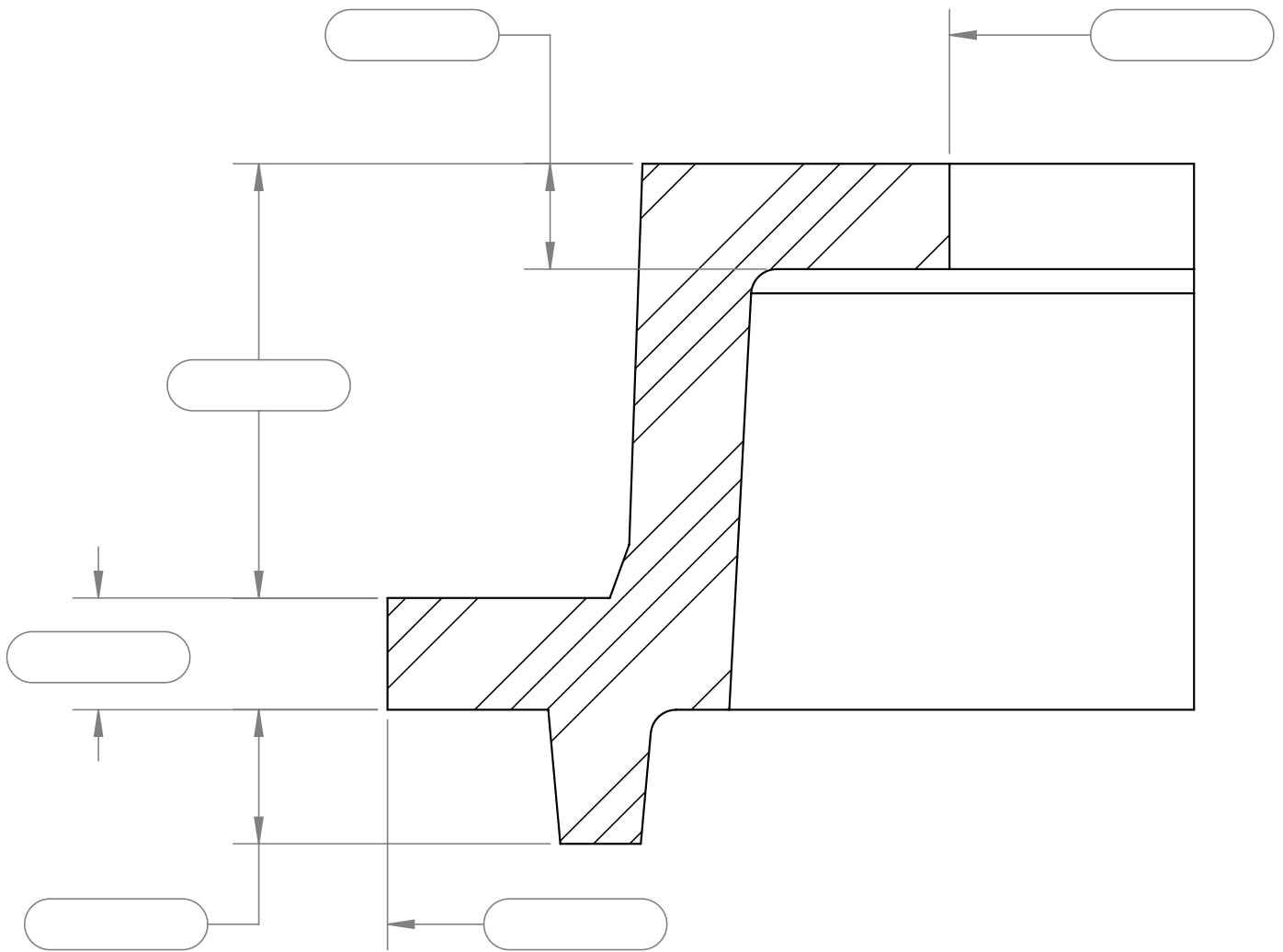


Key Lock Groove Forming Header with Form Tabs and Lifting Eyes

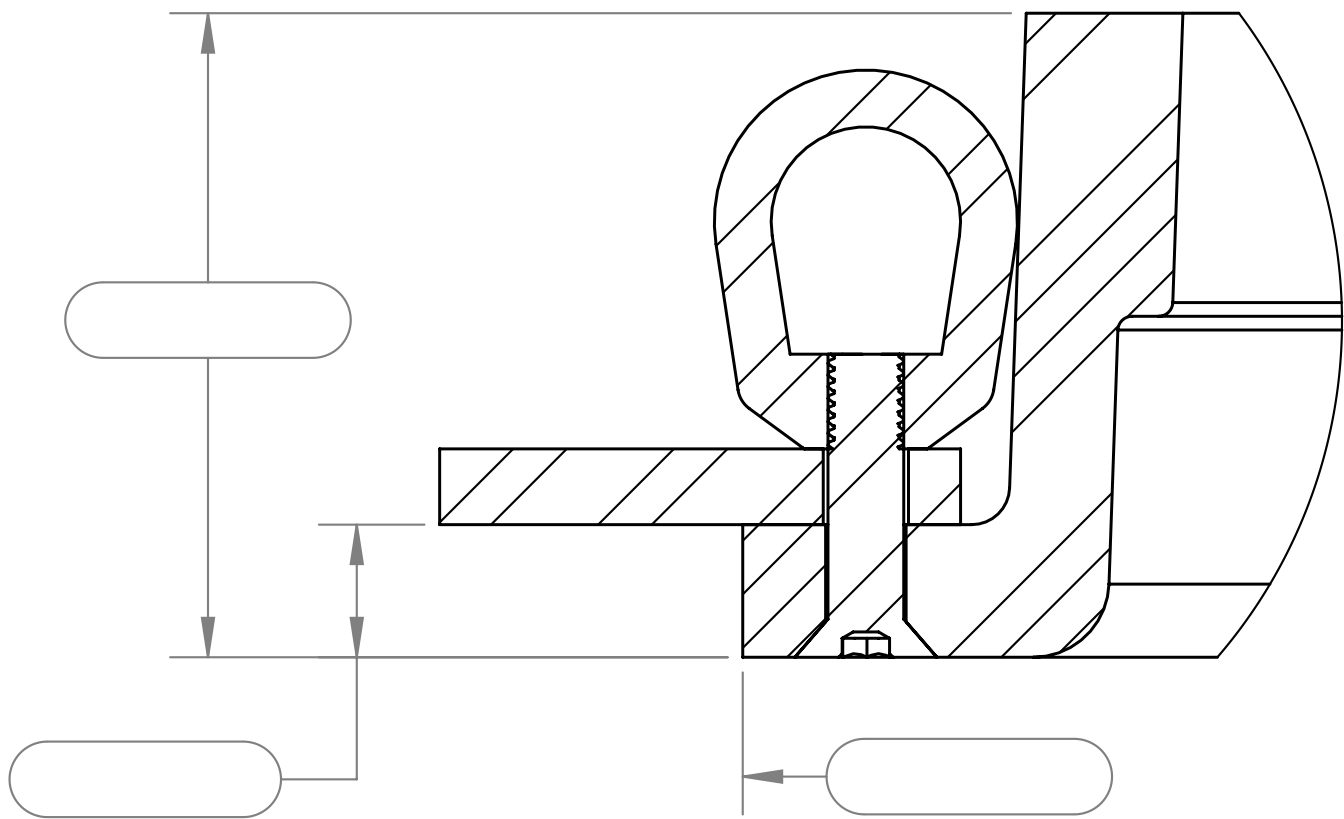


Joint Rings

Fill In The Blank Worksheets



Groove Forming Pallet with Legs

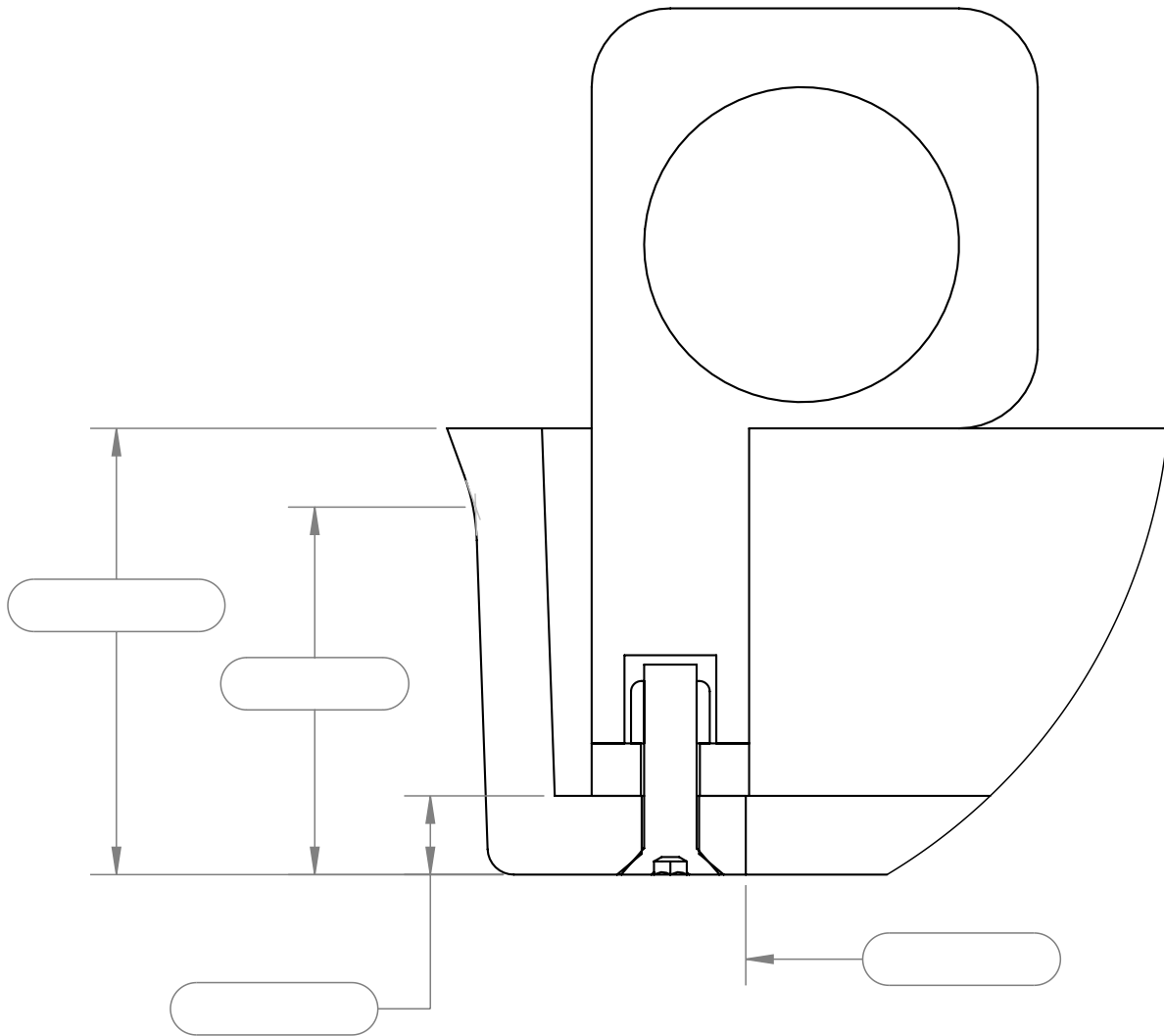


Tongue Forming Header, Open Top with Form Tabs and Lifting Eyes

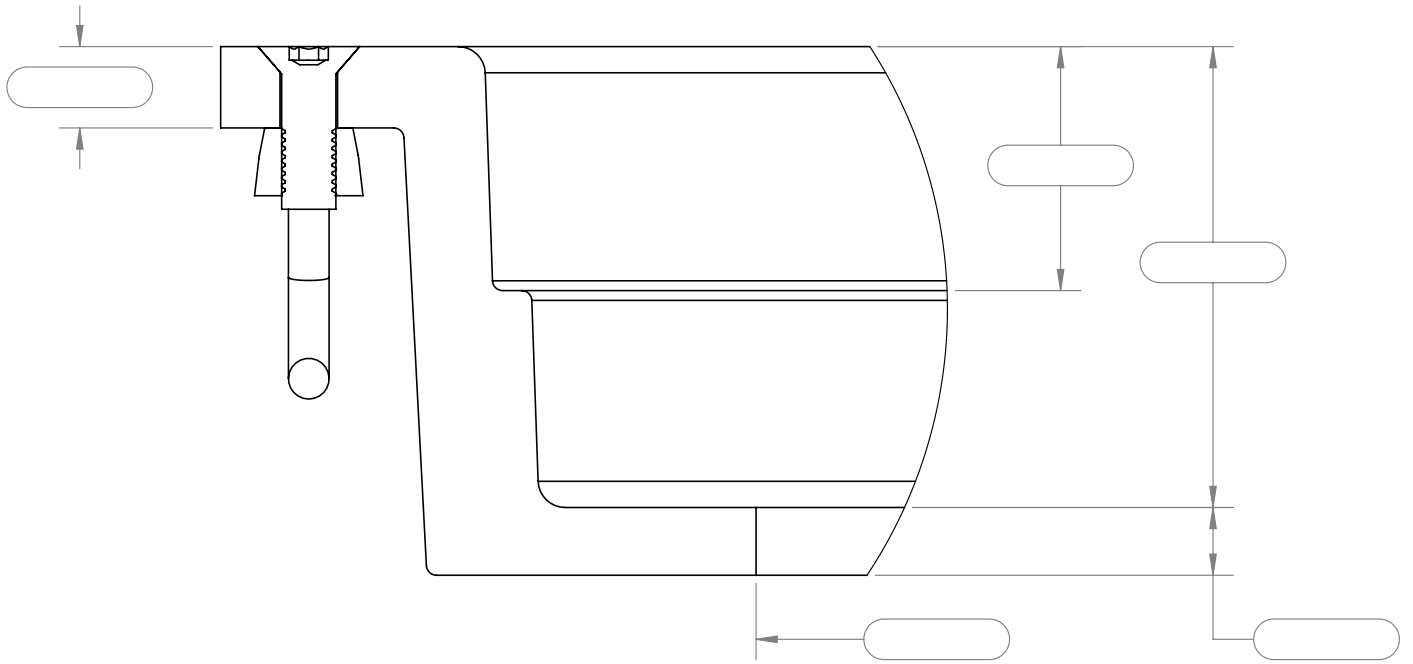


Joint Rings

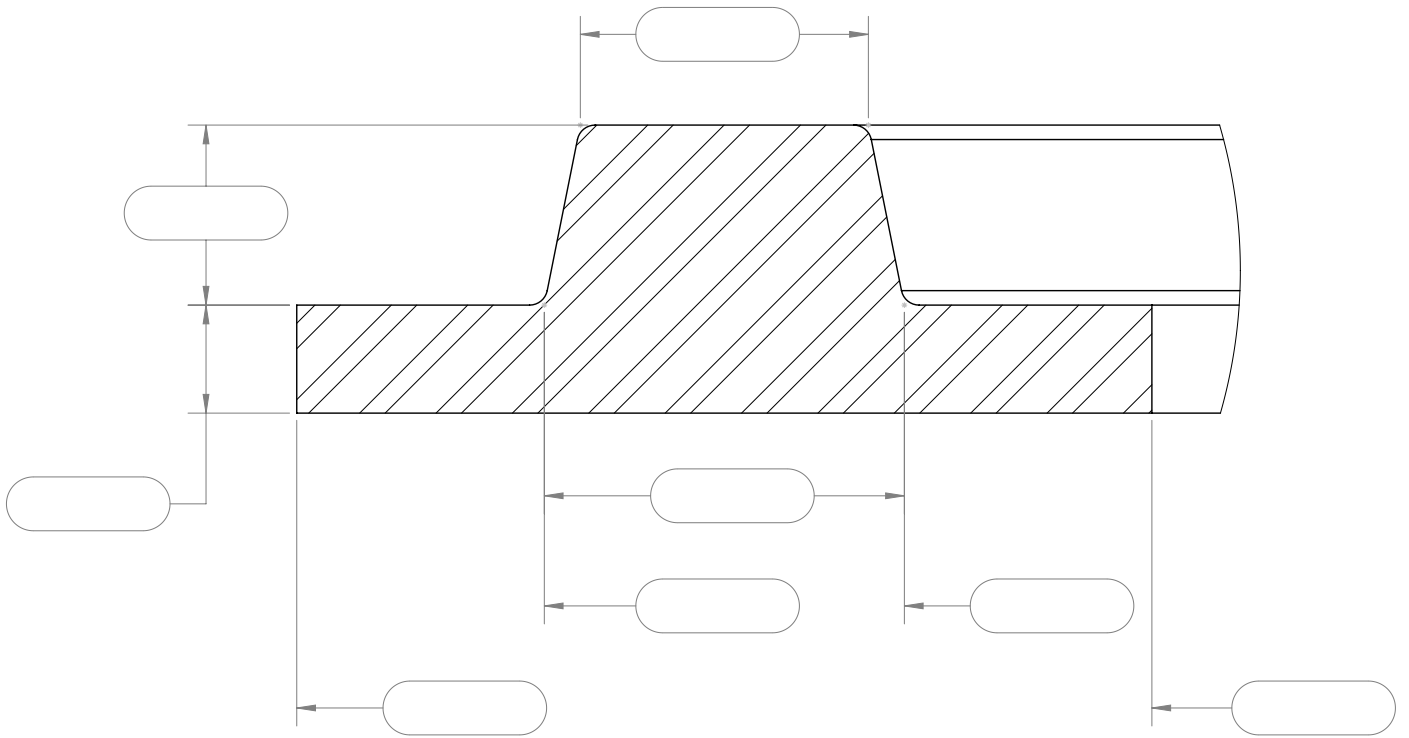
Fill In The Blank Worksheets



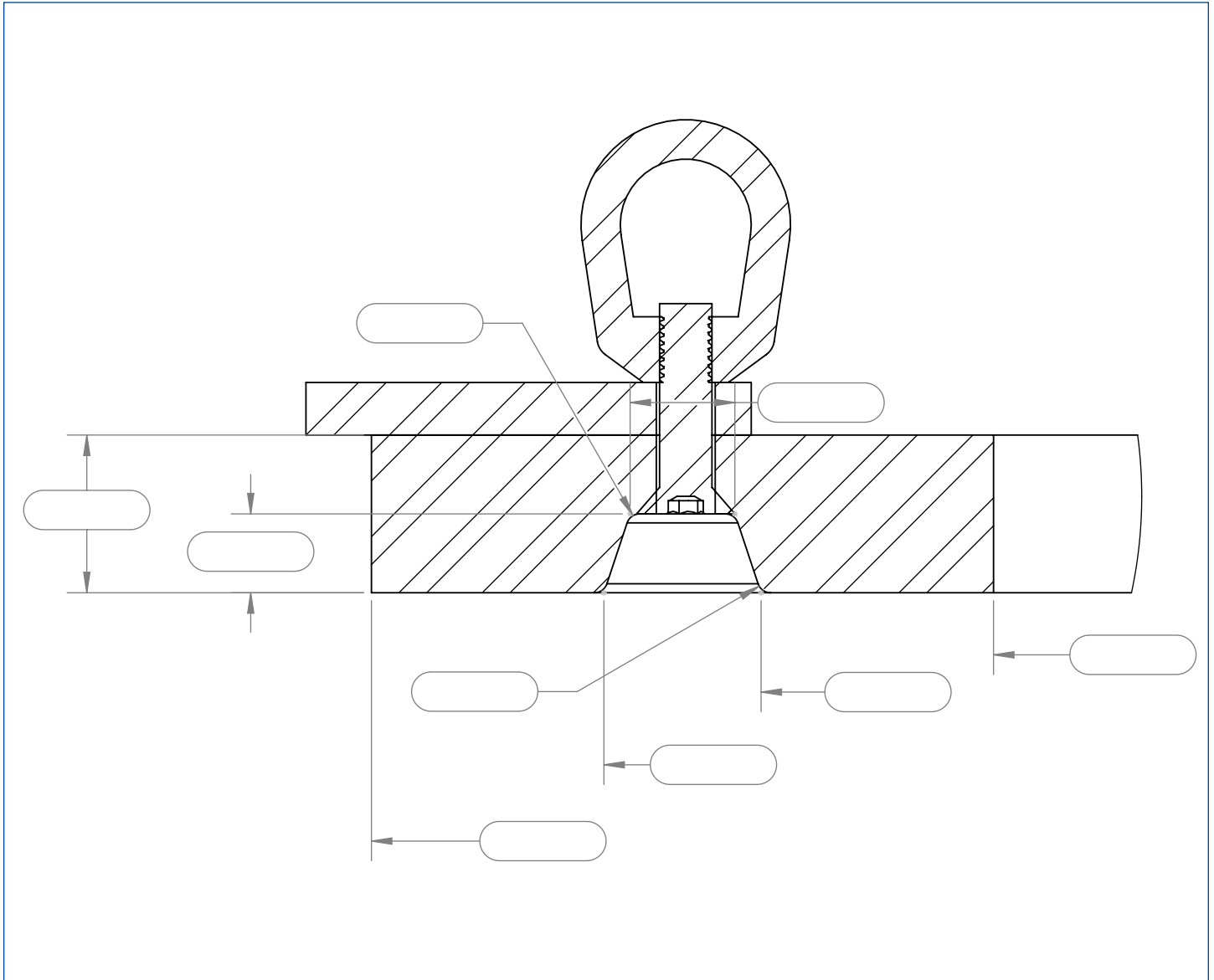
Groove Forming Header, Open Top with Core Tabs-Lifting Eyes



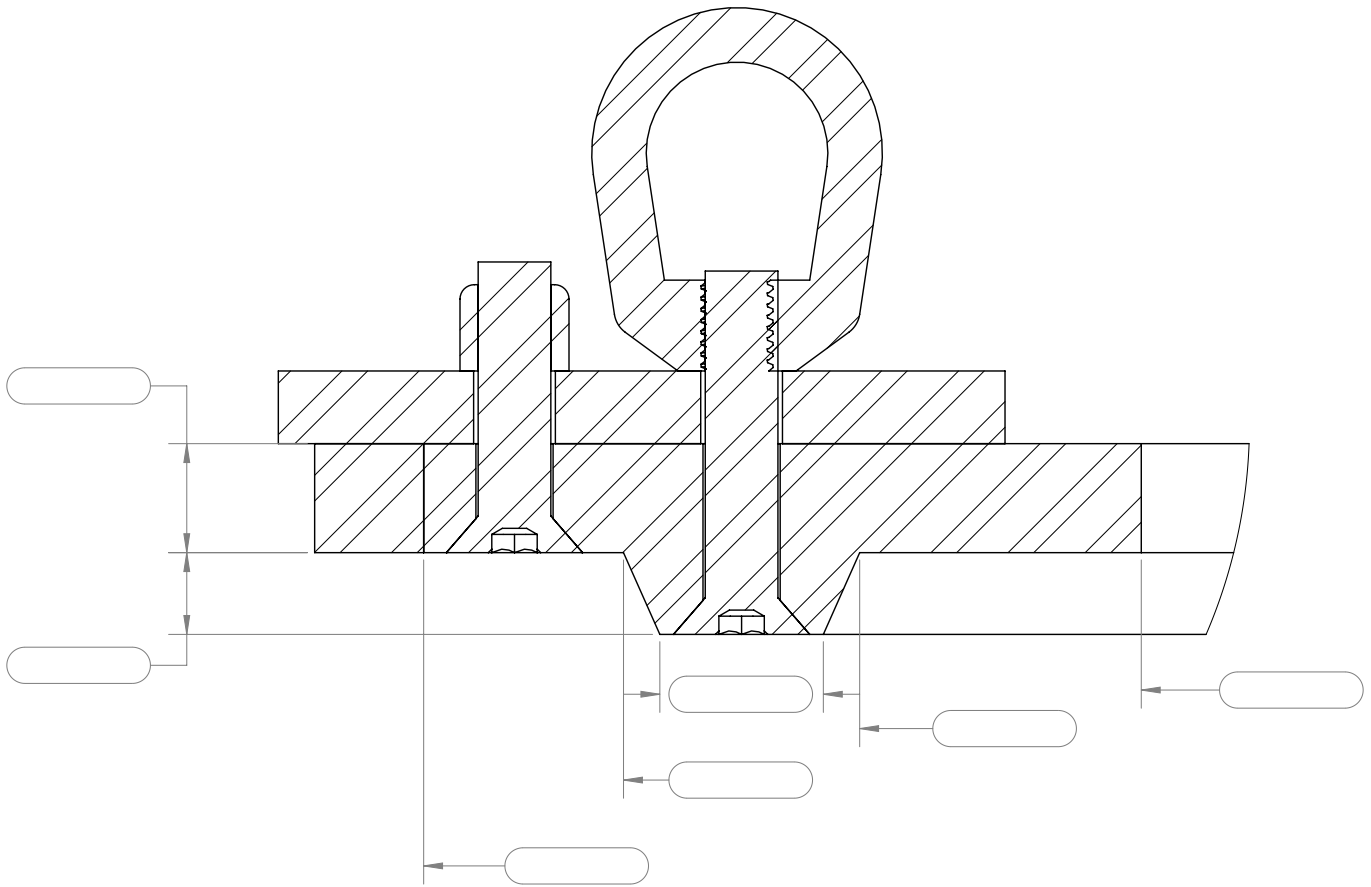
Tongue Forming Pallet with Lifting Eyes



Groove Forming Pallet



Tongue Forming Header with Lifting Eyes



Groove Forming Header with Form Tabs and Lifting Eyes

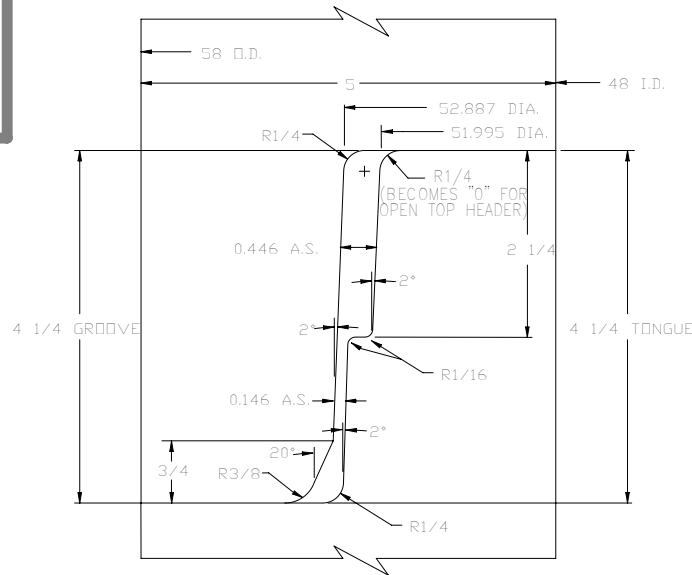


QT/TSS JOINT 48"


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48" QT/TSS
HK 165/185
JOINT DETAIL

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FAB		MACHINING		CUTTING									GENERAL TOLERANCES EXCEPT AS NOTED			
FRACTIONAL		DECIMAL		ANGULAR DEG												
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°												

QT/TSS Joint 48"



QT/TSS JOINT 60"

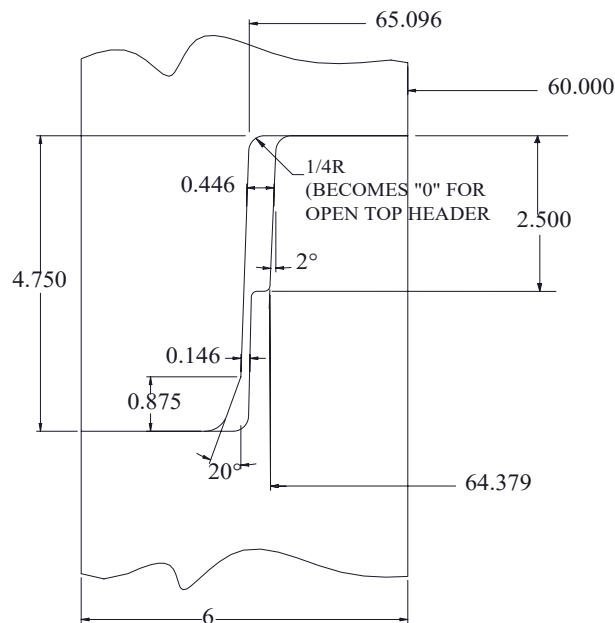
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60" QT/TSS
HK 165/185
JOINT DETAIL

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FAB		MACHINING		CUTTING											GENERAL TOLERANCES EXCEPT AS NOTED			
FRACTIONAL		DECIMAL		ANGULAR DEG														
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°				SHEET: 1 OF 1		SCALE: 1:1		SIZE A		DWG. NO: PD-60P-0095				

QT/TSS Joint 60"



QT/TSS JOINT 72"

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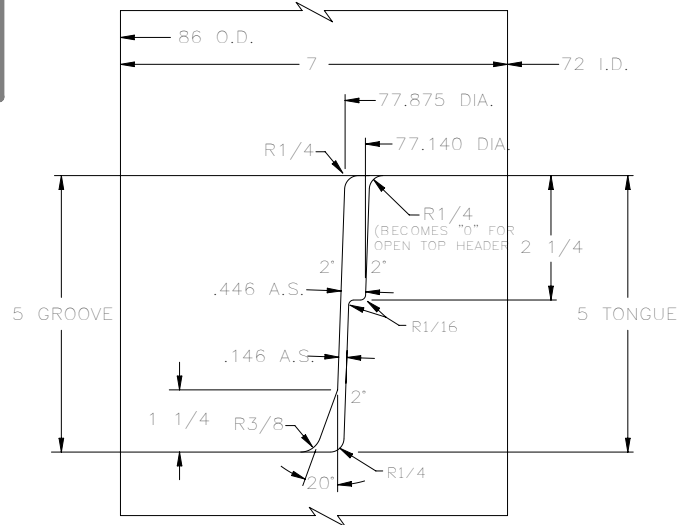
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72 QT/TSS
HK 165/185
JOINT DETAIL

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GENERAL TOLERANCES EXCEPT AS NOTED											72" QT/HK 165/185 TSS				
FRACTIONAL		DECIMAL		ANGULAR DEG							7" WALL				
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°											

QT/TSS Joint 72"



QT/HK165-HK185 JOINT 48"

DRAWING APPROVAL

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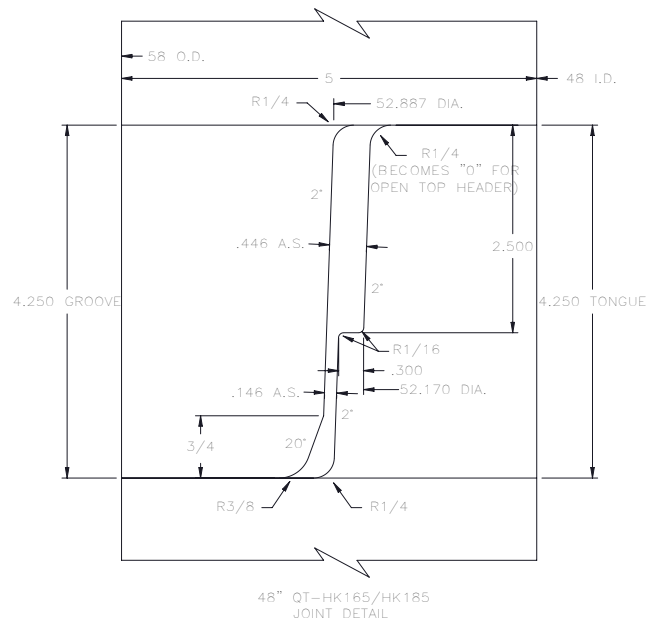
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WELDING		MACH		DRILL		SHAPING		CUTTING		<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY:</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div> <div>SHEET: 1 OF 1</div> <div>QTY:</div> <div>SCALE: 1:1</div> <div>SIZE A</div> <div>DWG NO: PD-48P-0159</div> <div>REV.</div>					
FAB		MACHINING				CUTTING					<div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div> <div>928 WEST MILWAUKEE 1701 MOLER ROAD</div> <div>NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207</div>				
GENERAL TOLERANCES EXCEPT AS NOTED															
FRACTIONAL		DECIMAL				ANGULAR DEG									
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005				± 1.0°									

QT/HK165-HK185 JOINT 48"



QT/HK165-HK185 JOINT 60"

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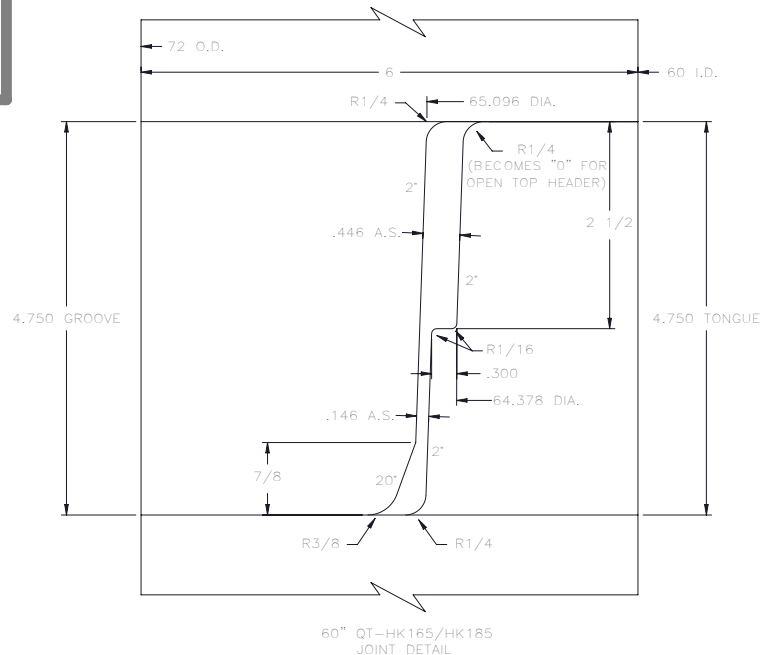
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FRACTIONAL		DECIMAL		ANGULAR DEG																				
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°																				

QT/HK165-HK185 JOINT 60"



QT/HK165-HK185 JOINT

72"

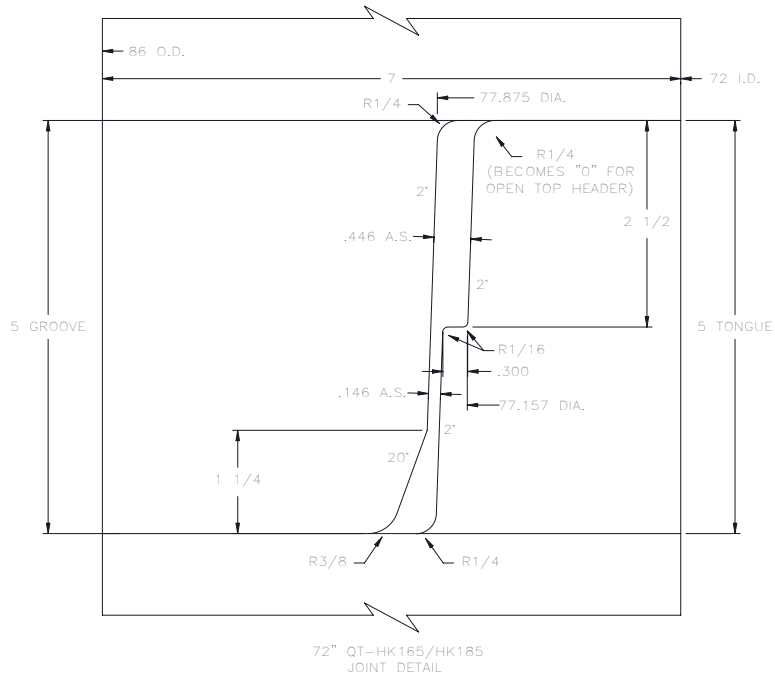
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GENERAL TOLERANCES EXCEPT AS NOTED							
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<div><div>AFINITAS</div><div>AFINITAS</div><div>FORMING SYSTEMS DIVISION</div><div>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659</div><div>1701 MOLER ROAD COLUMBUS, OHIO 43207</div></div> <div>72" QT-HK165/HK185</div> <div>7" WALL</div>							

QT/HK165-HK185 JOINT 72"



7R/HK165-HK185 JOINT 48"

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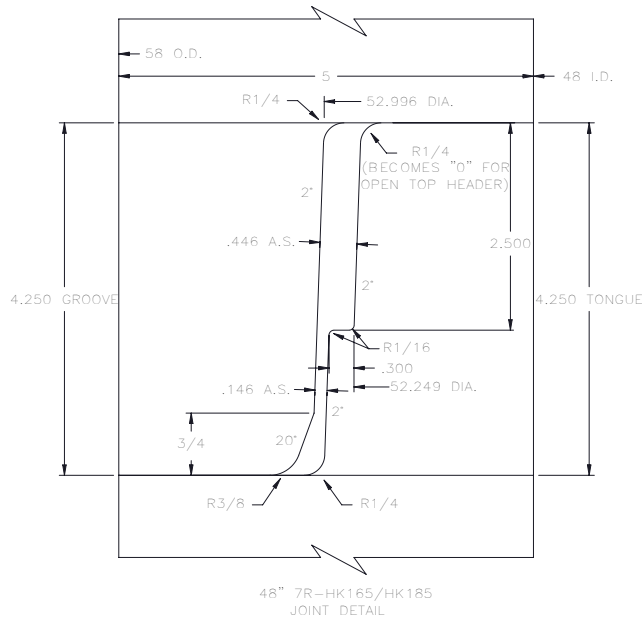
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WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY:</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div>	<div></div> <div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div> <div>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659</div> <div>1701 MOLER ROAD COLUMBUS, OHIO 43207</div>		48" 7R-HK165/HK185 5" WALL					
FAB		MACHINING		CUTTING										
GENERAL TOLERANCES EXCEPT AS NOTED														
FRACTIONAL		DECIMAL		ANGULAR DEG										
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°					SHEET: 1 OF 1		SCALE: 1:1	SIZE A	DWG NO: PD-48P-0158	REV.

7R/HK165-HK185 JOINT 48"



7R/HK165-HK185 JOINT 60"

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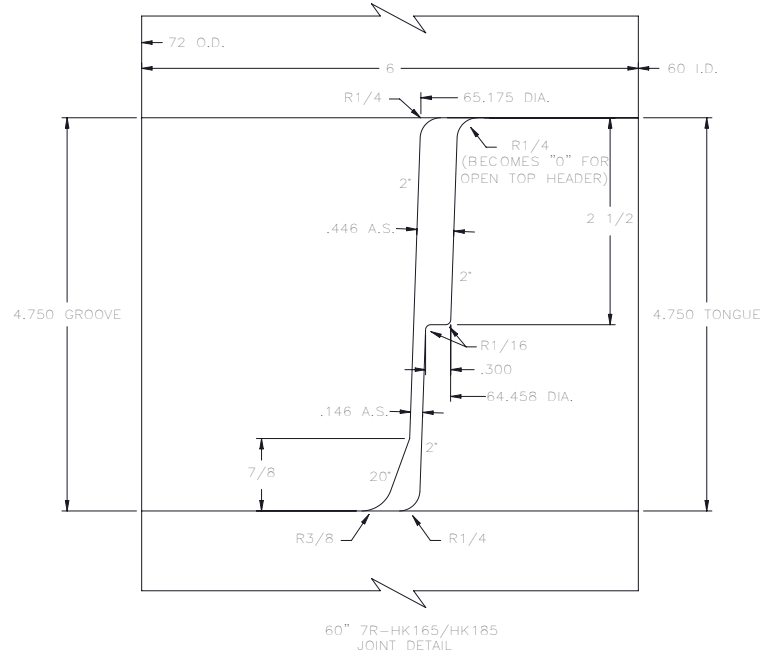
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WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED.</div> <div>DRAWN BY:</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div>	<div><div><div></div><div>AFINITAS</div></div><div>AFINITAS FORMING SYSTEMS DIVISION</div><div>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659</div><div>1701 MOLER ROAD COLUMBUS, OHIO 43207</div></div> <div>60" 7R-HK165/HK185</div> <div>6" WALL</div>		<div>SHEET: 1 OF 1</div> <div>QTY:</div> <div>SCALE: 1:1</div> <div>SIZE A</div> <div>DWG NO: PD-60P-0105</div> <div>REV.</div>		
FAB		MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED											
FRACTIONAL		DECIMAL		ANGULAR DEG							
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°							

7R/HK165-HK185 JOINT 60"



7R/HK165-HK185 JOINT 72"

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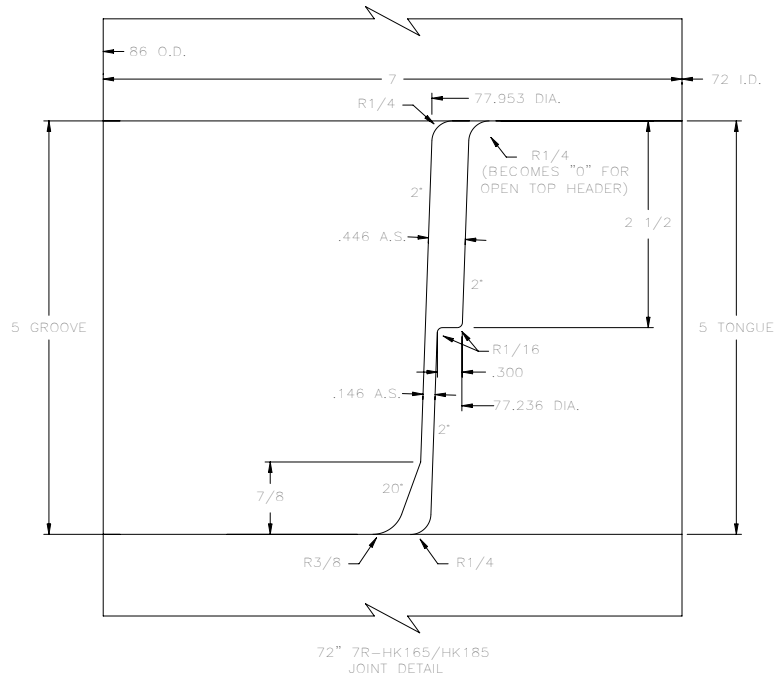
Company Name _____


Authorized Signature _____

Date _____

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REV.	ECR	CHANGE	BY	DATE
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WELDING	MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED.</div> <div>DRAWN BY:</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div>	<div><div>AFINITAS</div><div>AFINITAS FORMING SYSTEMS DIVISION</div><div>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659</div><div>1701 MOLER ROAD COLUMBUS, OHIO 43207</div></div>				
FAB	MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL		ANGULAR DEG							
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°			72" 7R-HK165/HK185				
						7" WALL				
						SHEET: 1 OF 1	SCALE: 1:1	SIZE A	DWG. NO: PD-72P-0114	REV.
						QTY:				

7R/HK165-HK185 JOINT 72"



7R/HK200L JOINT 84"

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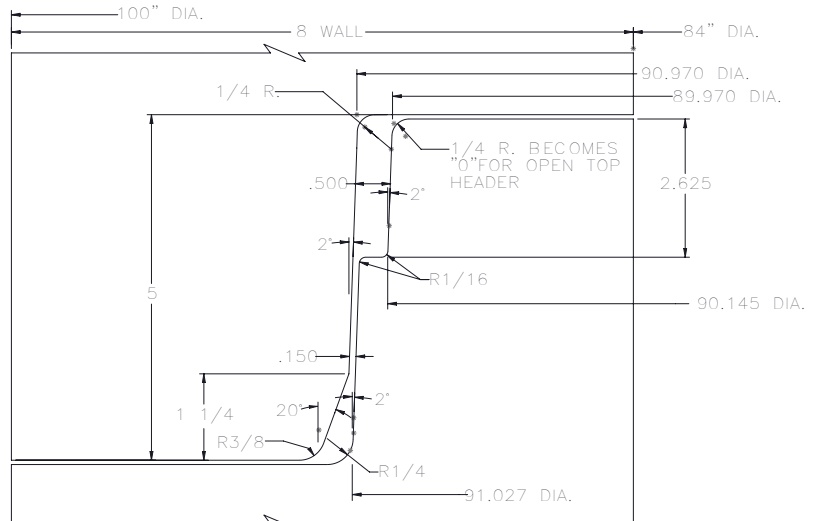
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Date _____

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REV.	ECR	CHANGE	BY	DATE
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84" 7R-HK200L
JOINT DETAIL

WELDING		MACH		DRILL		SHAPING		CUTTING		<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY:</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div> <div>SHEET: 1 OF 1</div> <div>QTY:</div> <div>SCALE: 1:1</div> <div>SIZE A</div> <div>DWG NO: 84 7R-HK200L</div> <div>REV.</div>	
FAB		MACHINING				CUTTING					<div></div> <div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div> <div>928 WEST MILWAUKEE</div> <div>NEW HAMPTON, IOWA 50659</div> <div>1701 MOLER ROAD</div> <div>COLUMBUS, OHIO 43207</div>
GENERAL TOLERANCES EXCEPT AS NOTED											
FRACTIONAL		DECIMAL				ANGULAR DEG					
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005				± 1.0°					

7R/HK200L JOINT 84"



7R/HK200L JOINT 96"

DRAWING APPROVAL

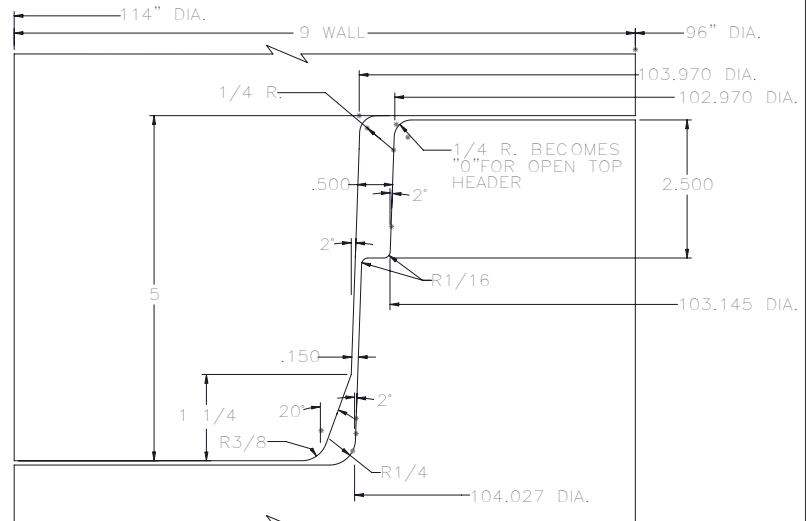
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REV.	ECR	CHANGE	BY	DATE



96" 7R-TSS 200L
JOINT DETAIL

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FAB	MACHINING		CUTTING			<div>96" - 7R/200L TSS</div> <div>8" WALL</div>				
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL		ANGULAR DEG							
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0 °							
					SHEET: 1 OF 1	SCALE: 1:1	SIZE A	DWG NO: 96-7R 200L TSS	REV.	

7R/HK200L JOINT 96"



7R/HK200L JOINT 120"

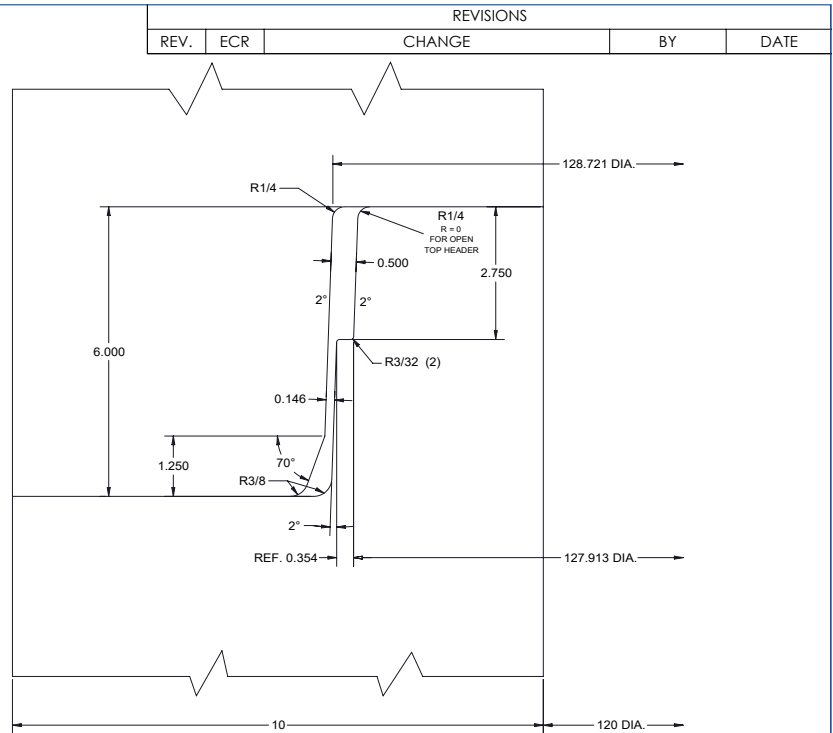
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FAB	MACHINING	CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED									
FRACTIONAL	DECIMAL	ANGULAR DEG							
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005	± 1.0 °							

7R/HK200L JOINT 120"



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Authorized Signature _____
Date _____

Technical drawing of a vertical pipe assembly. The drawing shows a vertical pipe with various dimensions and annotations. The total height of the assembly is 6.000. The top section has a diameter of 154.221 DIA. The bottom section has a diameter of 153.405 DIA. The total width of the assembly is 144 DIA. The drawing includes several radii: R1/4, R1/16 (2), R3/8, and R1/4. A note indicates that R1/4 becomes "0" for open top header. Other dimensions include 0.500, 2", 2.630, 0.150, 1.250, and 70°.

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FAB	MACHINING		CUTTING							144 Q7R HK200L-TSS 12" WALL		
GENERAL TOLERANCES EXCEPT AS NOTED												
FRACTIONAL	DECIMAL		ANGULAR DEG									
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°	DATE: WEIGHT: LBS JOB NO:		SHEET: 1 OF 1 QTY:	SCALE: 1:1	SIZE A	DWG NO: 144 Q7R HK-200L-TSS	REV.		

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7R/250-210-4G JOINT 48"

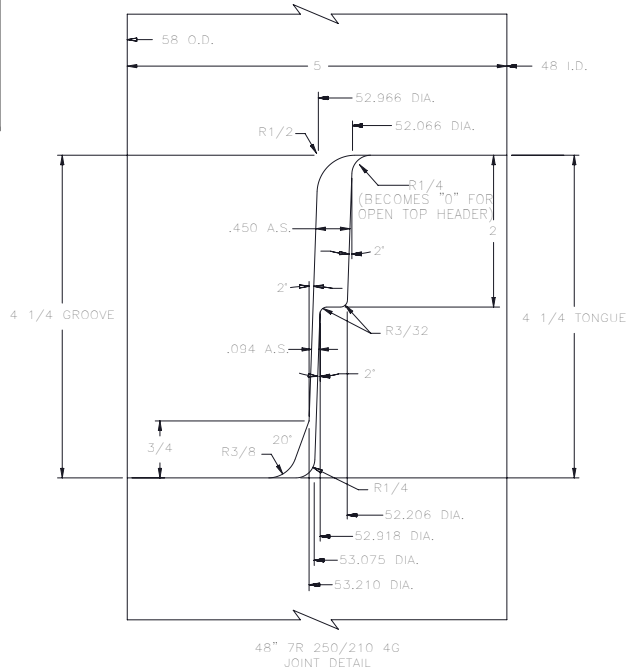
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FAB	MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL		ANGULAR DEG							
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°							
					48" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/2104G GASKET 5" WALL					
					SHEET: 1 OF 1		SCALE: 1:1	SIZE: A	DWG NO: PD-48P-0067	REV.
					QTY:					

7R/250-210-4G JOINT 48"



7R/250-210-4G JOINT 60"

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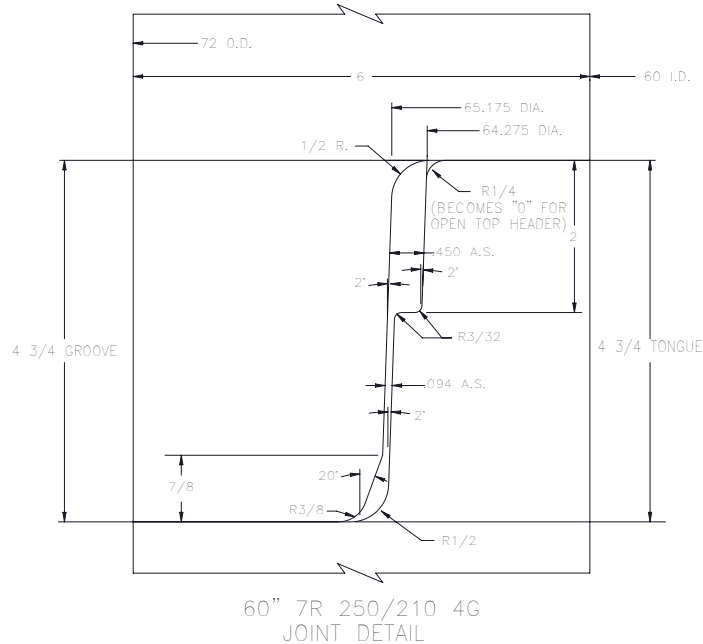
Company Name _____

Authorized Signature _____


Date _____

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WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY: 11/10/20</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div> <div>SHEET: 1 OF 1</div> <div>QTY:</div> <div>SCALE: 1:1</div> <div>SIZE A</div> <div>DWG NO: PD-60P-0055</div> <div>REV.</div>	
FAB		MACHINING		CUTTING			
GENERAL TOLERANCES EXCEPT AS NOTED							
FRACTIONAL		DECIMAL		ANGULAR DEG			
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°			

		AFINITAS FORMING SYSTEMS DIVISION	
928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659		1701 MOLER ROAD COLUMBUS, OHIO 43207	
60" SINGLE OFFSET JOINT - Q7R PRESS SEAL 250/210 4G GASKET 6" WALL			

7R/250-210-4G JOINT 60"



7R/250-210-4G JOINT 72"

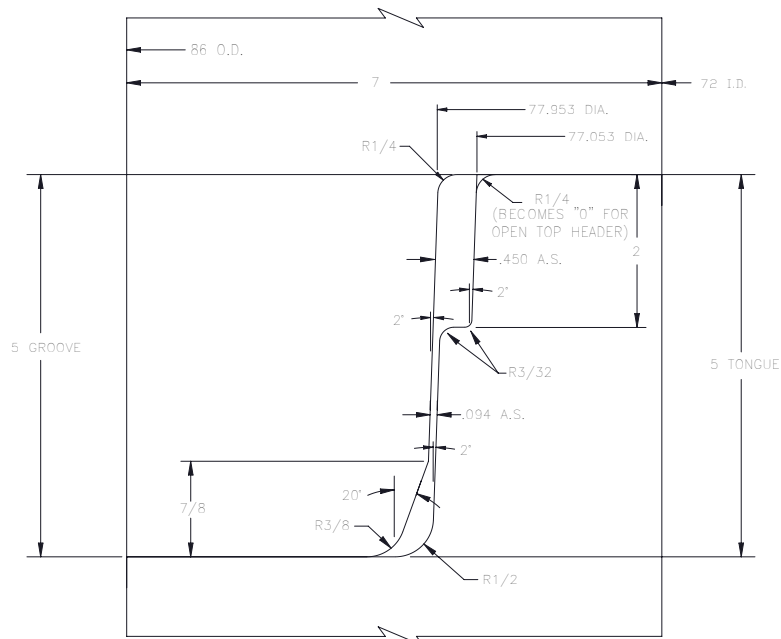
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72" 7R 250/210 4G
JOINT DETAIL

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FAB		MACHINING		CUTTING										
GENERAL TOLERANCES EXCEPT AS NOTED														
FRACTIONAL		DECIMAL		ANGULAR DEG										
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°										
						SHEET: 1 OF 1		SCALE: 1:1		SIZE: A		DWG NO: PD-72P-0019		

7R/250-210-4G JOINT 72"



7R/250-210-4G JOINT 84"

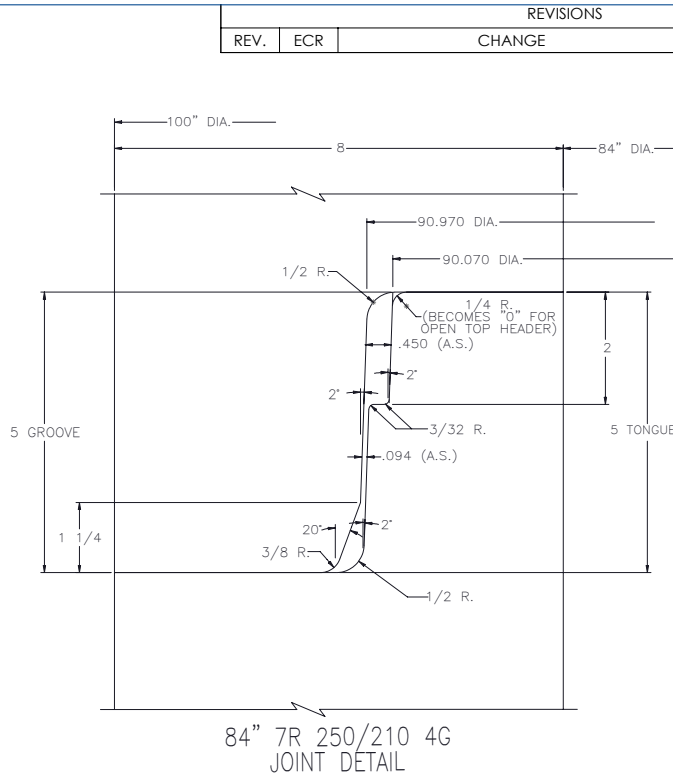
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FAB		MACHINING		CUTTING				<div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div>			
GENERAL TOLERANCES EXCEPT AS NOTED								928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659		1701 MOLER ROAD COLUMBUS, OHIO 43207	
FRACTIONAL		DECIMAL		ANGULAR DEG				84" SINGLE OFFSET JOINT -QR7 PRESS SEAL 250/210 4G GASKET 8" WALL			
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°							

7R/250-210-4G JOINT 84"

Joint Profile is NOT recommended for 84" diameter and larger (Recommend using the 7R/288-4G Joint)



7R/250-210-4G JOINT 96"

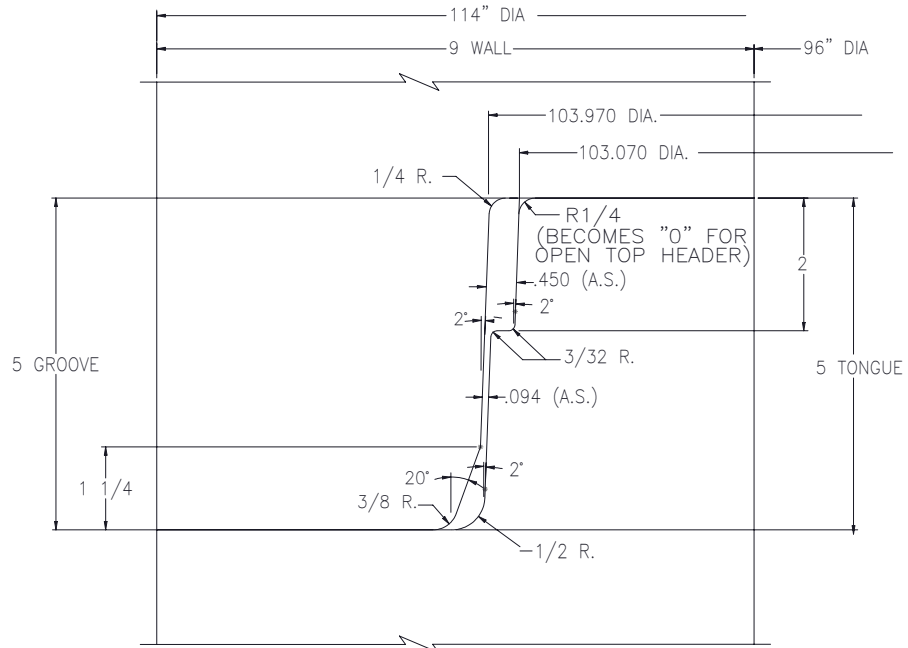
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96 QUINN 7R 250-4G
JOINT DETAIL

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FAB		MACHINING				CUTTING																											GENERAL TOLERANCES EXCEPT AS NOTED									
FRACTIONAL				DECIMAL				ANGULAR DEG																																		
X ± 1/16				X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005				± 1.0°																																		

7R/250-210-4G JOINT 96"

Joint Profile is NOT recommended for 84" diameter and larger (Recommend using the 7R/288-4G Joint)

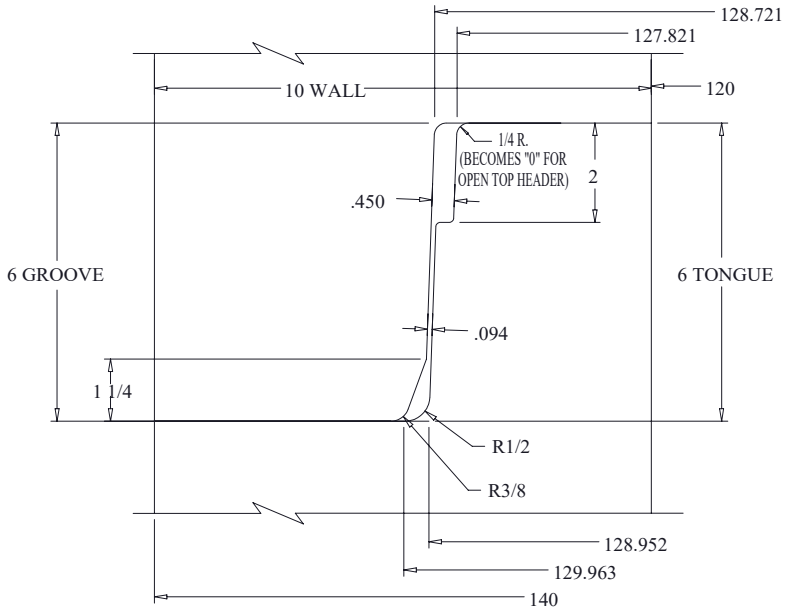


7R/250-210-4G JOINT 120"

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120 JOINT DETAIL
QUINN 7R / 250-4G

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FAB		MACHINING				CUTTING													
GENERAL TOLERANCES EXCEPT AS NOTED																			
FRACTIONAL		DECIMAL				ANGULAR DEG													
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005				± 1.0°													

7R/250-210-4G JOINT 120"

Joint Profile is NOT recommended for 84" diameter and larger (Recommend using the 7R/288-4G Joint)



7R/288-4G JOINT 84"

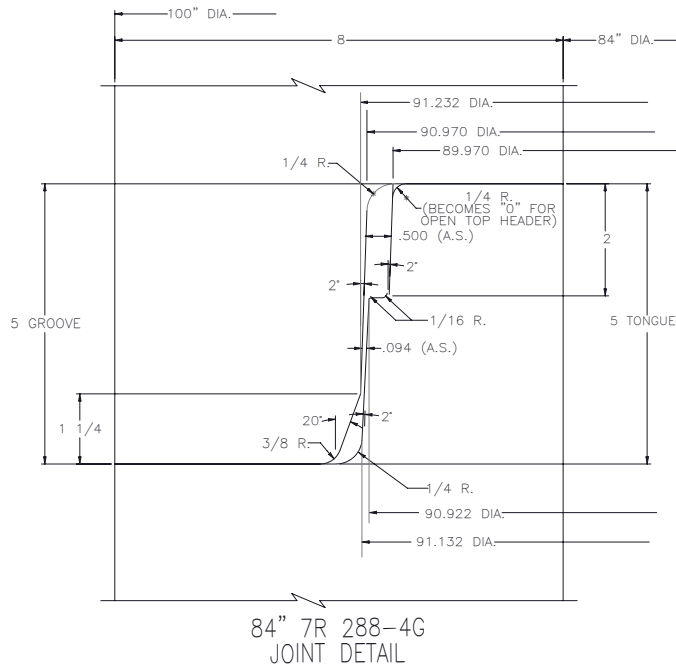
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WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED. DRAWN BY: DATE: WEIGHT: LBS JOB NO:</div>		<div><div>AFINITAS</div><div>FORMING SYSTEMS DIVISION</div><div>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659</div><div>1701 MOLER ROAD COLUMBUS, OHIO 43207</div></div>		<div>84" 7R 288-4G</div> <div>8" WALL</div>		<div>REV.</div>			
FAB		MACHINING		CUTTING											
GENERAL TOLERANCES EXCEPT AS NOTED															
FRACTIONAL		DECIMAL		ANGULAR DEG											
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°											
						SHEET: 1 OF 1		SCALE: 1:1		SIZE A		DWG NO: PD-84P-0041			
						QTY:									

7R/288-4G JOINT 84"

NOTICE! Recommended joint to use for 84" diameter and larger!



7R/288-4G JOINT 96"

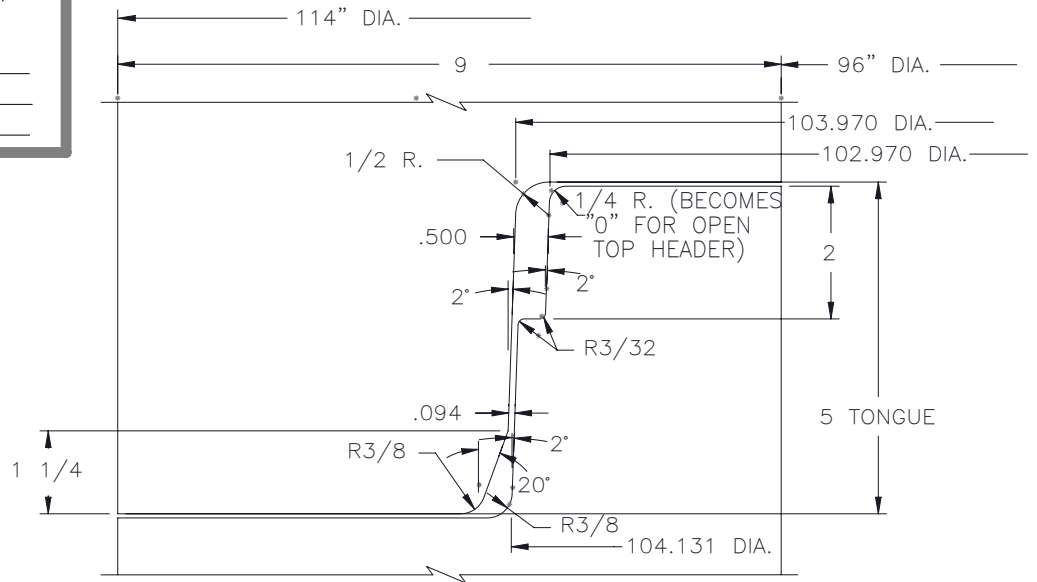
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JOINT DETAIL

QUINN 7R / PRESS SEAL 288-4G

WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY:</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div>		<div><div><div></div></div><div>AFINITAS</div></div> <div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div> <div>928 WEST MILWAUKEE</div> <div>NEW HAMPTON, IOWA 50659</div> <div>1701 MOLER ROAD</div> <div>COLUMBUS, OHIO 43207</div>		<div>96" QUINN 7R / PRESS SEAL 288-4G</div> <div>9" WALL</div>			REV.	
FAB		MACHINING		CUTTING										
GENERAL TOLERANCES EXCEPT AS NOTED														
FRACTIONAL		DECIMAL		ANGULAR DEG										
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°										
						SHEET: 1 OF 1		SCALE: 1:1		SIZE A		DWG NO: PD-96P-0062		
						QTY:								

7R/288-4G JOINT 96"

NOTICE! Recommended joint to use for 84" diameter and larger!



7R/288-4G JOINT 120"

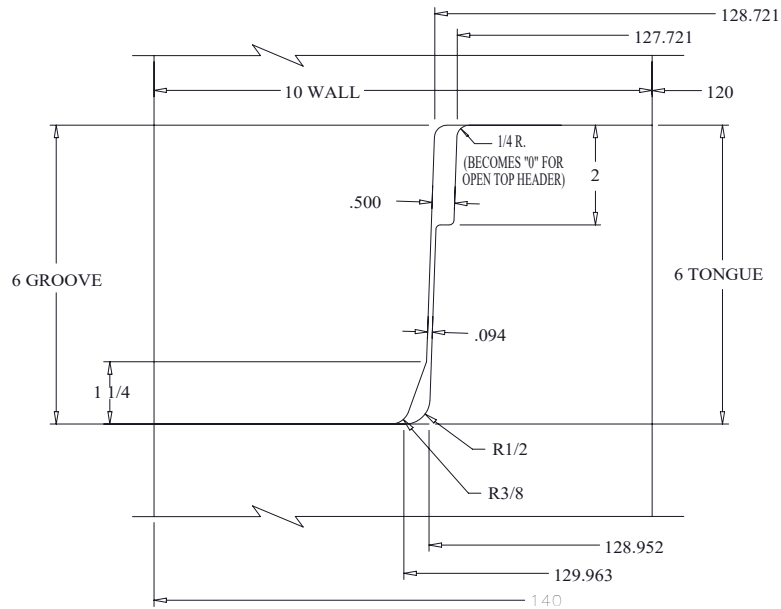
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120 JOINT DETAIL
Q7R / 288-4G

WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY:</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div>	<div>AFINITAS</div> <div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div> <div>928 WEST MILWAUKEE</div> <div>NEW HAMPTON, IOWA 50659</div> <div>1701 MOLER ROAD</div> <div>COLUMBUS, OHIO 43207</div>		<div>120" Q7R/288 4G</div> <div>10" WALL</div>		SHEET:	1 OF 1	SCALE:	1:1	SIZE	A	DWG NO:	PD-120P-0024	REV.
GENERAL TOLERANCES EXCEPT AS NOTED																			
FRACTIONAL		DECIMAL		ANGULAR DEG															
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°															

7R/288-4G JOINT 120"

NOTICE! Recommended joint to use for 84" diameter and larger!



7R/288-4G JOINT 144"

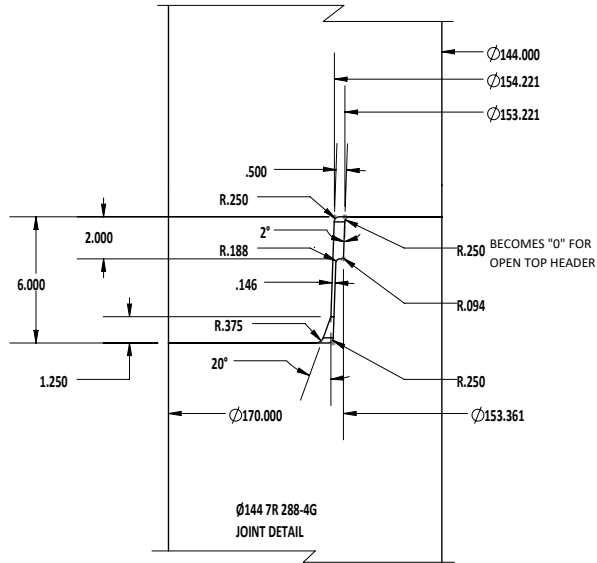
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WELDING		MACH		DRILL		SHAPING		CUTTING		<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED.</div> <div>DRAWN BY:</div> <div>DATE:</div> <div>WEIGHT: 217777.82 LBS</div> <div>JOB NO:</div> <div><div><div><div></div><div>AFINITAS</div></div><div>AFINITAS FORMING SYSTEMS DIVISION</div><div>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659</div><div>1701 MOLER ROAD COLUMBUS, OHIO 43207</div></div></div> <div>144-7R-288-4G</div> <div>13" WALL</div> <div><div>SHEET: 1 OF 1</div><div>QTY:</div></div> <div><div>SCALE: 1:64</div><div>SIZE A</div></div> <div><div>DWG NO: 144-7R-288-4GDETAIL</div><div>REV.</div></div>				
FAB		MACHINING				CUTTING								
GENERAL TOLERANCES EXCEPT AS NOTED														
FRACTIONAL		DECIMAL			ANGULAR DEG									
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005			± 1.0°									

7R/288-4G JOINT 144"

NOTICE! Recommended joint to use for 84" diameter and larger!



SHORT S/O JOINT 48"

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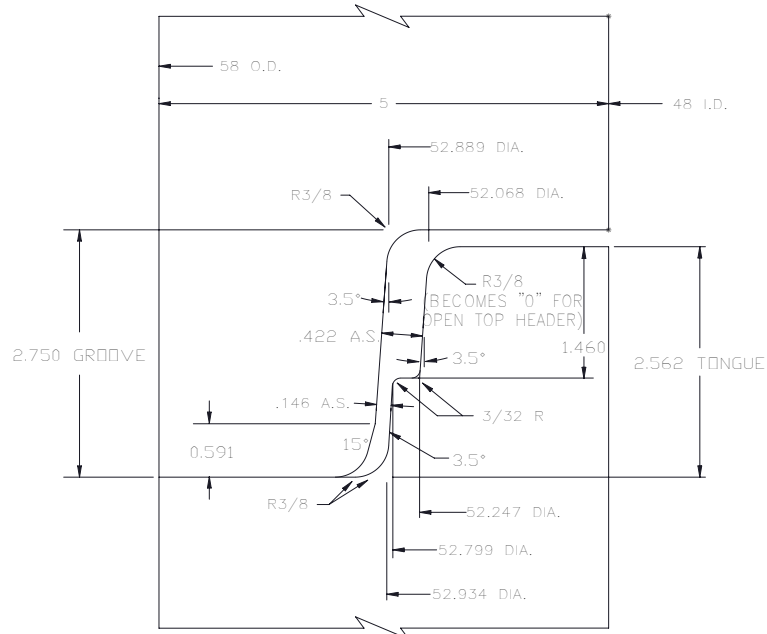
Company Name _____

Authorized Signature _____

Date _____

REVISIONS

REV.	ECR	CHANGE	BY	DATE
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48" F-114 SJ
JOINT DETAIL

WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY:</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div>	<div><div><div></div></div><div>AFINITAS</div></div> <div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div> <div>928 WEST MILWAUKEE 1701 MOLER ROAD</div> <div>NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207</div>		<div>48" SHORT S/O JOINT</div> <div>5" WALL</div>				<div>SHEET: 1 OF 1</div> <div>QTY:</div> <div>SCALE: 1:1</div> <div>SIZE A</div> <div>DWG NO: PD-48P-0138</div> <div>REV.</div>	
FAB		MACHINING		CUTTING										
GENERAL TOLERANCES EXCEPT AS NOTED														
FRACTIONAL		DECIMAL		ANGULAR DEG										
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°										

SHORT S/O JOINT 48"



SHORT S/O JOINT 60"

DRAWING APPROVAL

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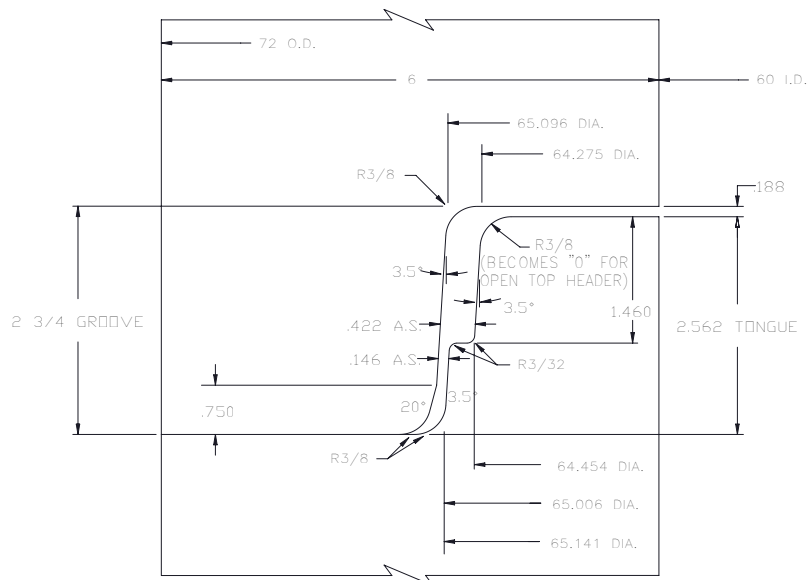
Company Name _____

Authorized Signature _____


Date _____

REVISIONS

REV.	ECR	CHANGE	BY	DATE
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60" F-114 SJ
JOINT DETAIL

WELDING	MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY: 11/10/20</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div>	<div></div> <div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div>		<div>928 WEST MILWAUKEE</div> <div>NEW HAMPTON, IOWA 50659</div> <div>1701 MOLER ROAD</div> <div>COLUMBUS, OHIO 43207</div>		
FAB	MACHINING		CUTTING							
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL	DECIMAL		ANGULAR DEG							
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°							
						SHEET: 1 OF 1	SCALE: 1:1	SIZE A	DWG NO: PD-60P-0102	REV.
						QTY:				

SHORT S/O JOINT 60"



SHORT S/O JOINT 72"

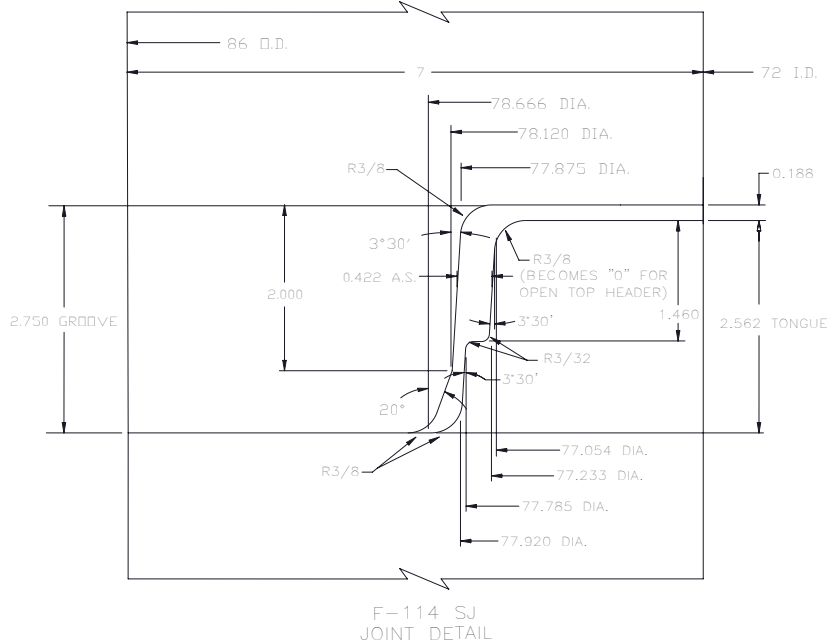
DRAWING APPROVAL


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WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY: 11/11/20</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div> <div>SHEET: 1 OF 1</div> <div>QTY:</div> <div>SCALE: 1:1</div> <div>SIZE A</div> <div>DWG NO: PD-72P-0042</div> <div>REV.</div>	<div></div> <div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div> <div>928 WEST MILWAUKEE 1701 MOLER ROAD</div> <div>NEW HAMPTON, IOWA 50659 COLUMBUS, OHIO 43207</div>		72" SHORT S/O JOINT 7" WALL							
FAB		MACHINING		CUTTING												
GENERAL TOLERANCES EXCEPT AS NOTED																
FRACTIONAL		DECIMAL		ANGULAR DEG												
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°												

SHORT S/O JOINT 72"



1M MORTAR JOINT 48"

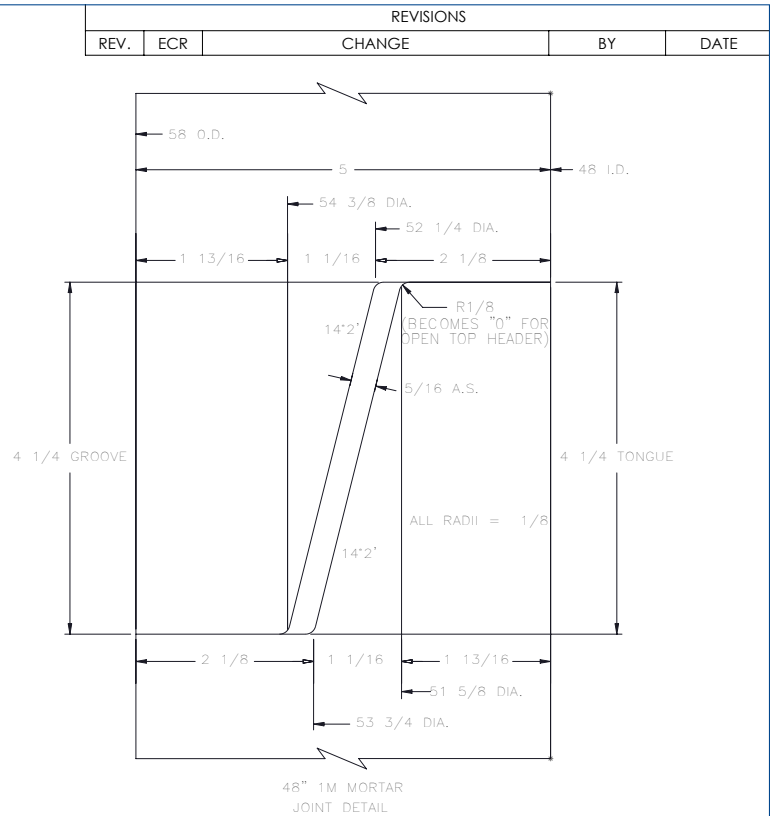
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WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY: 11/10/20</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>SHEET: 1 OF 1</div> <div>JOB NO:</div> <div>QTY:</div>		<div><div><div></div></div><div>AFINITAS</div></div> <div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div> <div>928 WEST MILWAUKEE</div> <div>NEW HAMPTON, IOWA 50659</div> <div>1701 MOLER ROAD</div> <div>COLUMBUS, OHIO 43207</div>		
FAB		MACHINING		CUTTING						
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL		DECIMAL		ANGULAR DEG		48" 1M MORTAR JOINT 5" WALL				
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°						
						SCALE: 1:1		SIZE: A	DWG NO: PD-48P-0157	REV.

1M MORTAR JOINT 48"



1M MORTAR JOINT 60"

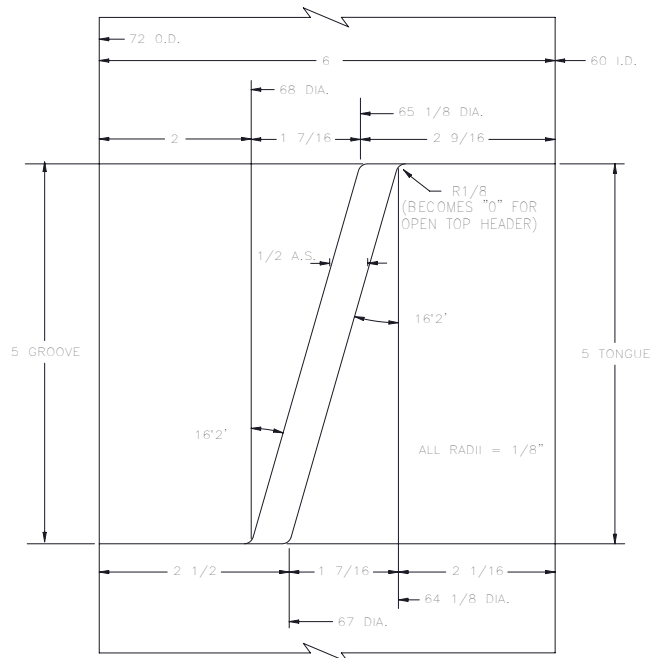
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60" 1M MORTAR
JOINT DETAIL

WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF NEW HAMPTON METAL FABRICATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF NEW HAMPTON METAL FABRICATION IS PROHIBITED.</div> <div>DRAWN BY: 11/10/20</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div>		<div><div><div></div><div>AFINITAS</div></div><div>AFINITAS FORMING SYSTEMS DIVISION</div><div>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659</div><div>1701 MOLER ROAD COLUMBUS, OHIO 43207</div></div>		60" 1M MORTAR JOINT 6" WALL			
FAB		MACHINING		CUTTING									
GENERAL TOLERANCES EXCEPT AS NOTED													
FRACTIONAL		DECIMAL		ANGULAR DEG									
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°				SHEET: 1 OF 1		SCALE: 1:1	SIZE: A	DWG NO: PD-60P-0103	REV.
								QTY:					

1M MORTAR JOINT 60"



1M MORTAR JOINT 72"

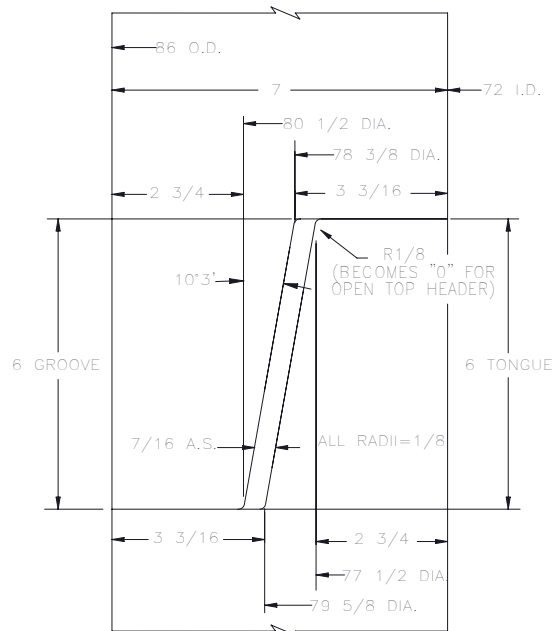
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72" 1M
MORTAR JOINT

WELDING		MACH	DRILL	SHAPING	CUTTING	<div><div><div><div></div><div></div><div></div></div><div>AFINITAS</div></div><div>AFINITAS FORMING SYSTEMS DIVISION</div><div>928 WEST MILWAUKEE NEW HAMPTON, IOWA 50659</div><div>1701 MOLER ROAD COLUMBUS, OHIO 43207</div></div> <div><div>72" MORTAR JOINT-Q1M</div><div>7" WALL</div></div>				
FAB		MACHINING		CUTTING						
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL		DECIMAL		ANGULAR DEG		<div><div>PROPRIETARY AND CONFIDENTIAL</div><div>THE INFORMATION CONTAINED</div><div>IN THIS DRAWING IS THE SOLE</div><div>PROPERTY OF NEW HAMPTON</div><div>METAL FABRICATION. ANY</div><div>REPRODUCTION IN PART OR AS</div><div>A WHOLE WITHOUT THE WRITTEN</div><div>PERMISSION OF NEW HAMPTON</div><div>METAL FABRICATION IS</div><div>PROHIBITED.</div><div>DRAWN BY: 11/10/20</div><div>DATE:</div><div>WEIGHT: LBS</div><div>JOB NO:</div><div>SHEET: 1 OF 1</div><div>QTY:</div><div>SCALE: 1:1</div><div>SIZE A</div><div>DWG NO: PD-72P-0095</div><div>REV.</div></div>				
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°						

1M MORTAR JOINT 72"

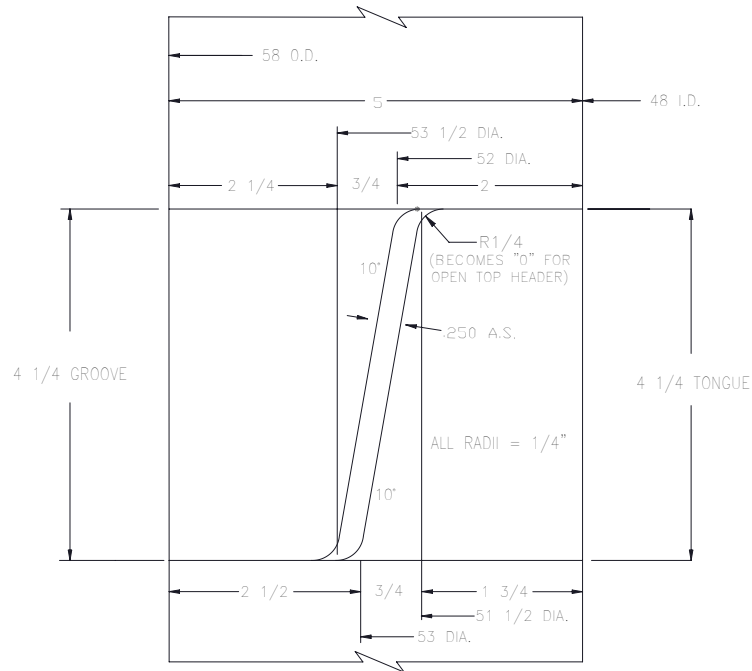


3M MORTAR JOINT 48"


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48" 3M MORTAR
JOINT DETAIL

WELDING		MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY: 11/10/20</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div>	<div></div> <div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div>		<div>928 WEST MILWAUKEE</div> <div>NEW HAMPTON, IOWA 50659</div> <div>1701 MOLER ROAD</div> <div>COLUMBUS, OHIO 43207</div>	
FAB		MACHINING		CUTTING						
GENERAL TOLERANCES EXCEPT AS NOTED										
FRACTIONAL		DECIMAL		ANGULAR DEG						
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°						
48: 3M MORTAR JOINT DETAIL							5" WALL			
SHEET: 1 OF 1		SCALE: 1:1		SIZE A		DWG NO: PD-48P-0152		REV.		
QTY:										

3M MORTAR JOINT 48"



3M MORTAR JOINT 60"

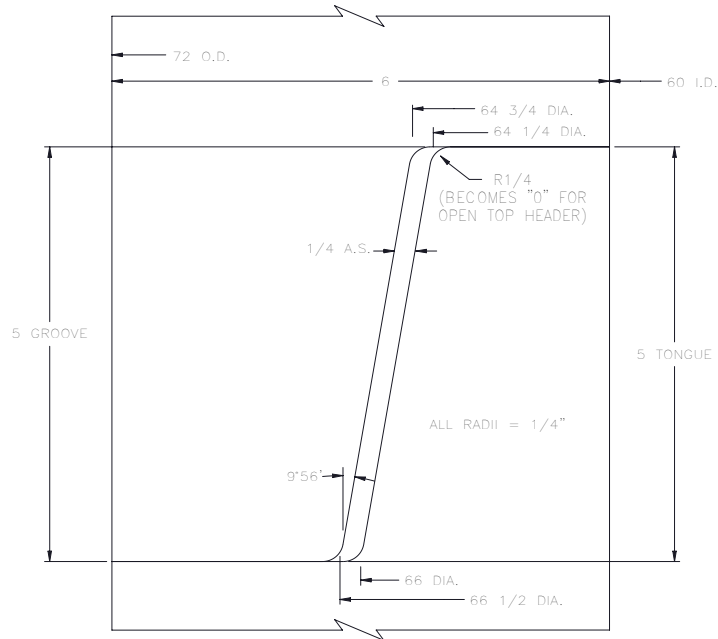
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60" 3M MORTAR
JOINT DETAIL

WELDING		MACH		DRILL		SHAPING		CUTTING		<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY: 11/10/20</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div>	<div></div> <div>AFINITAS</div>		<div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div> <div>928 WEST MILWAUKEE1701 MOLER ROAD</div> <div>NEW HAMPTON, IOWA 50659COLUMBUS, OHIO 43207</div>				
FAB		MACHINING		CUTTING													
GENERAL TOLERANCES EXCEPT AS NOTED																	
FRACTIONAL		DECIMAL			ANGULAR DEG			60" 3M MORTAR JOINT									
X ± 1/16		X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005			± 1.0°			6" WALL									
								SHEET: 1 OF 1		SCALE: 1:1		SIZE A		DWG NO: PD-60P-0058		REV.	
								QTY:									

3M MORTAR JOINT 60"



3M MORTAR JOINT 72"

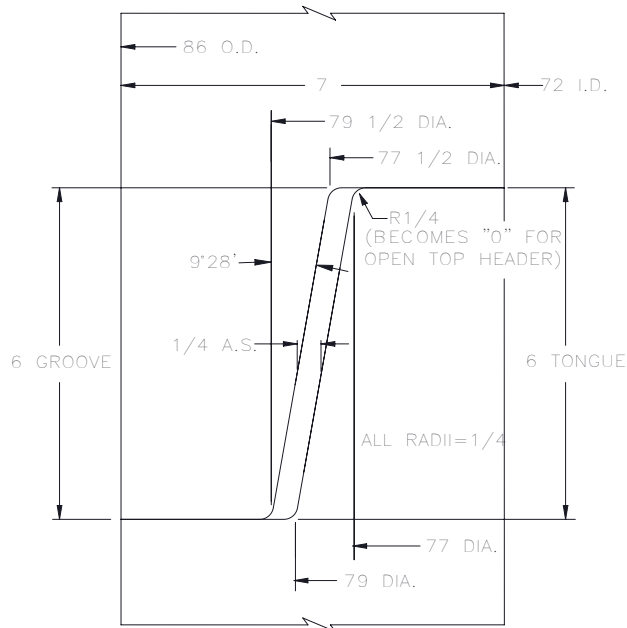
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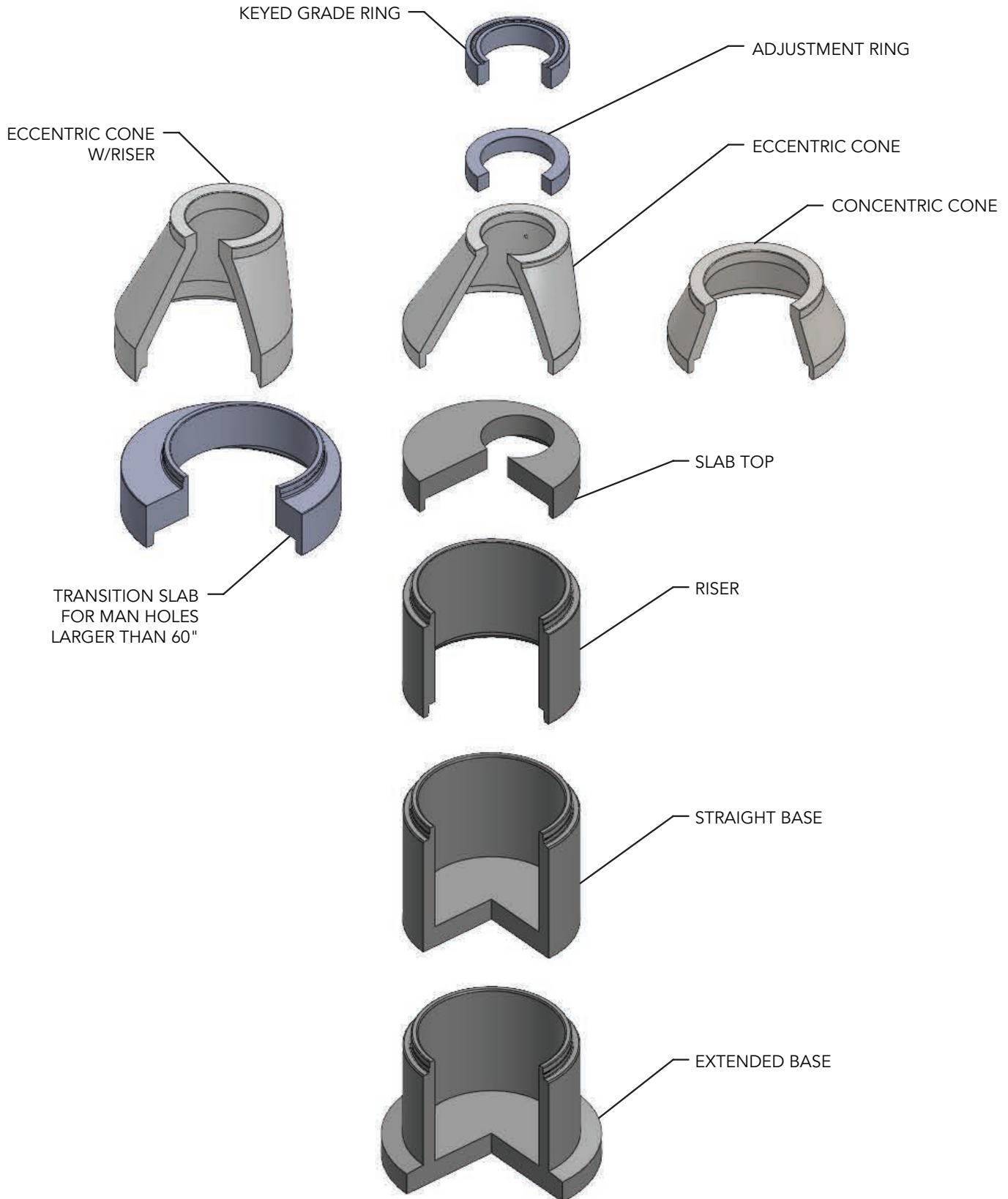
72" 3M
MORTAR JOINT

WELDING	MACH	DRILL	SHAPING	CUTTING	<div>PROPRIETARY AND CONFIDENTIAL</div> <div>THE INFORMATION CONTAINED</div> <div>IN THIS DRAWING IS THE SOLE</div> <div>PROPERTY OF NEW HAMPTON</div> <div>METAL FABRICATION. ANY</div> <div>REPRODUCTION IN PART OR AS</div> <div>A WHOLE WITHOUT THE WRITTEN</div> <div>PERMISSION OF NEW HAMPTON</div> <div>METAL FABRICATION IS</div> <div>PROHIBITED.</div> <div>DRAWN BY: 11/10/20</div> <div>DATE:</div> <div>WEIGHT: LBS</div> <div>JOB NO:</div> <div>SHEET: 1 OF 1</div> <div>QTY:</div> <div>SCALE: 1:1</div> <div>SIZE A</div> <div>DWG NO: PD-72P-0112</div> <div>REV.</div>	
FAB	MACHINING		CUTTING			<div></div> <div>AFINITAS</div> <div>FORMING SYSTEMS DIVISION</div>
GENERAL TOLERANCES EXCEPT AS NOTED						<div>928 WEST MILWAUKEE</div> <div>NEW HAMPTON, IOWA 50659</div> <div>1701 MOLER ROAD</div> <div>COLUMBUS, OHIO 43207</div>
FRACTIONAL	DECIMAL		ANGULAR DEG			<div>72" MORTAR JOINT-Q3M</div> <div>7" WALL</div>
X ± 1/16	X.X ± 0.030 X.XX ± 0.015 X.XXX ± 0.005		± 1.0°			

3M MORTAR JOINT 72"



Manhole Cone Stack-Up



Afinitas brings you the industry's best formwork and a whole lot more.

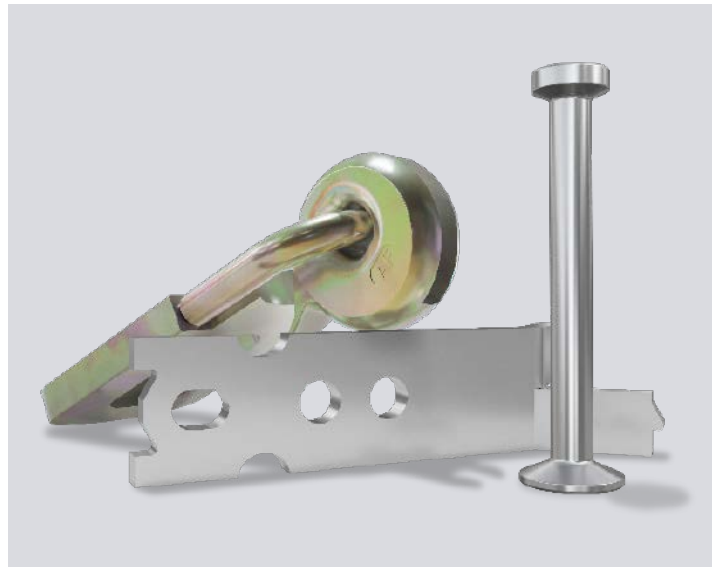
Afinitas is the premier platform of precast concrete infrastructure equipment and services.

With decades of experience in the pipe and precast concrete markets, we provide manufacturers around the world with the gold standard in precast concrete product production equipment, highly engineered drycast and wetcast forms and a wide variety of concrete accessories.

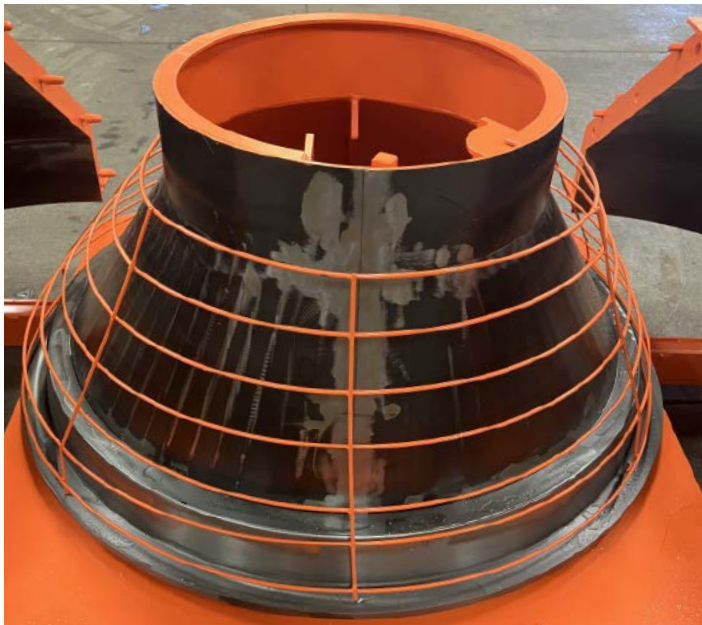
Our combined strengths mean more concrete machinery engineering resources, manufacturing know-how and pipe and precast concrete industry experience is ready to help you create the ideal production systems for your infrastructural concrete product needs.



SmartRoll™ Form Controller – Intelligent Safety Brake reduces form swinging up to 90%.



Lifting Anchors, Fixation Inserts and other precast accessories



Cone Cages



SmartJax®

Adjustable Magnetic Support Stand for Wetcast Pallets

Introducing SmartJax®*

A revolutionary way to firmly stool up pallets inside concrete forms

Our **patent-pending SmartJax®** adjustable support stand offers many advantages over existing pallet support systems:

Simply Genius! You will love the speed and convenience of having a single unit to support and secure your pallet. Stand and magnets all-in-one.

Safe – say goodbye to the splintering and unreliability of using wood pieces, PVC or hollow core concrete traditionally used as supports.

Strong – our stand is built to last as a heavy steel fabricated weldment.

Speedy – multiple hole locations in the support tube make pin-facilitated height adjustment quick and easy.

Product Highlights

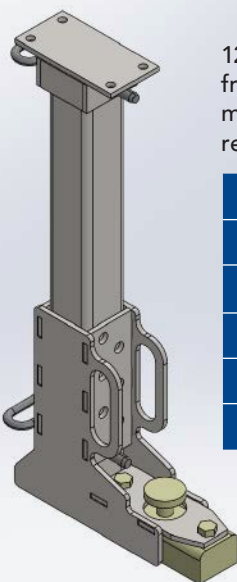
- 6000 pound capacity**
- 12" overall height with adjustment up to 18" tall in 1" increments, making it simple to size to your requirements
- 1000 pound on/off button base magnet for attachment to form sub-base
- Interchangeable leg tube heights



SmartJax® can be used on both box and round forms.



Adjusts to a wide variety of heights.



12" overall height with adjustment from 12" to 23" in 1" increments, making it simple to size to your requirements.

SJL 2	24" – 35"
SJL 3	36" – 47"
SJL 4	48" – 59"
SJL 5	60" – 71"
SJL 6	72" – 83"
SJL 7	84" – 95"

* Patent-pending.

** Depending on pallet design, a minimum of 3 to 4 SmartJax™ (or more) are to be used at all times to support a flat pallet, pallet support stool, joint forming pallet or any combination along with the concrete load.

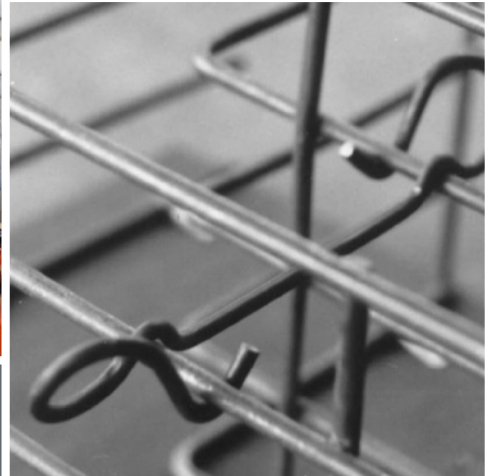


Joint Ring Solutions

Equipment & Automation



Concrete Accessories



Forming Systems



Intelligent Infrastructure Solutions
Visit www.afinitas.com to learn more.

Afinitas Forming Systems Division

Iowa

928 W Milwaukee
New Hampton, IA 50659

Phone: 641-394-4111

Fax: 641-394-4542

rfq@afinitas.com

Ohio

1701 Moler Road
Columbus, OH 43207

Phone: 614-444-2184

rfq@afinitas.com



Intelligent Infrastructure Solutions

Afinitas is a global, comprehensive and customer-oriented equipment, automation, forming and accessories platform for precast concrete and infrastructural products.

Afinitas Forming Systems Division:

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