



# L&M RADIATOR PTY LTD

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## **WORK SCOPE - CERTIFIED REBUILD**

### **STEELWORK** :

1. All steelwork is cleaned or sandblasted before inspection and then painted to customer requirements.
2. Any steelwork damaged or fatigued is repaired as required.
3. Any steelwork excessively corroded or unrepairable is replaced with new parts.
4. All radiator caps are replaced to guarantee original specification and achieve safety standards.
5. All rubber baffles are inspected to ensure serviceability and are replaced if required.
6. All filler necks are inspected for damage or wear and replaced as required.
7. Pressure release valves are removed, cleaned and replaced to guarantee original specification and achieve safety standards. Swing valve assemblies are inspected and replaced as required.

### **MESABI CORES** :

8. All tubes are removed from header plates and inspected.
9. Fin bonding to tubes is tested in accordance with original specifications.
10. Tubes are ultrasonically cleaned in a detergent based cleaning agent (non caustic) then tubes are steam cleaned both internally and externally.
11. Sample tubes are cut and split open then inspected for internal contaminants and build-up of silica dropout. All internal contamination will be cleaned or tubes replaced if they cannot be cleaned.
12. All tubes will be straightened, any fin damaged repaired and both tube ends will be lightly buffed maintaining seal surface integrity. All missing tube supports are replaced as required.

### **HEADER PLATES** :

13. All header plates are cleaned and inspected, we also rework as required.
14. Header plate sealing surfaces are cleaned and inspected to ensure the integrity of the material and prepare a good sealing surface.
15. All seal holes are wire buffed to remove any contamination.
16. All seals are replaced with genuine MESABI seals.

### **NEW PARTS REQUIRED :**

17. Any tubes not to MESABI specification are replaced. Only genuine MESABI original parts used.
18. New high tensile bolts, nuts and washers are used if required and all existing bolts re-torque on all MESABI rebuilds.
19. All gaskets are replaced with “non-asbestos” gasket material.
20. New overflow / vent hoses are fitted.

### **RE ASSEMBLY :**

21. Cores are assembled in MESABI jigs to ensure accurate and square assembly at all times. All tubes are installed utilising MESABI manufacturing assembly standards.
22. Core assemblies are assembled back into refurbished steelwork, utilising new gaskets, bolts, nuts and washers (MESABI rebuilds use Permatex as gasket sealing aid).
23. Units are tested as required to suit individual pressure relief valve settings, at all times adhering to strict MESABI QA test procedures.
24. After testing, the radiator assembly is dried before final painting. All steelwork is re-painted to customer's requirement.
25. Certified rebuilds are fully crated, palletised or placed on a purpose built shipping cradle or skid as required for return shipment to the customer. If received with original crate, pallets or shipping cradle will be repaired as required.

### **GENERAL :**

26. All QA procedures and records are strictly in accordance with the MESABI worldwide Quality Control Programme. L&M Radiator Pty Ltd is ISO 9001:2008 accredited.
27. A certified MESABI Rebuild Certificate for completed works is available on request.

**SIGNED BY :**



**RICHARD CHAPPELL**  
General Manager