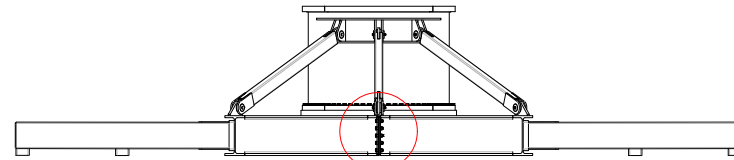


MIEJSCE MONTAZU I CIĘGNO PONUMEROWAC

Each rod has to be labeled to its place.

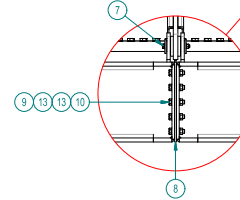


(1:20)

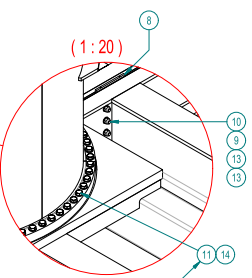
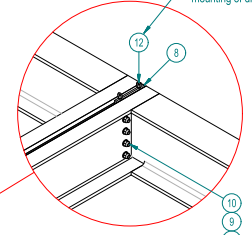
SRUBA OCZKOWA DO LATWIEJSZEGO MONTAZU

(1:20)

Lifting eyebolt for easier mounting of distance plate.

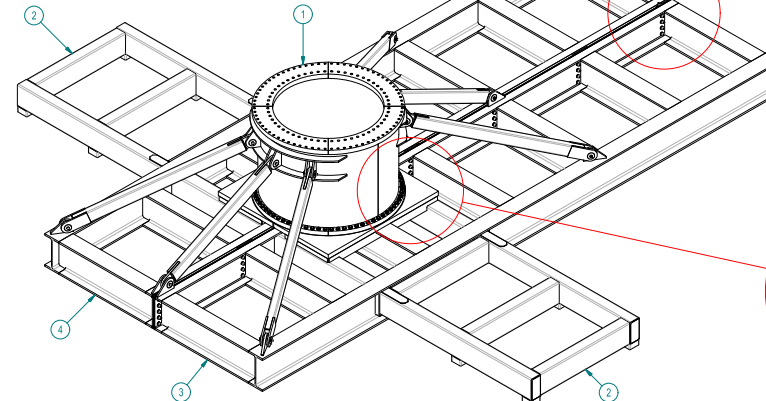
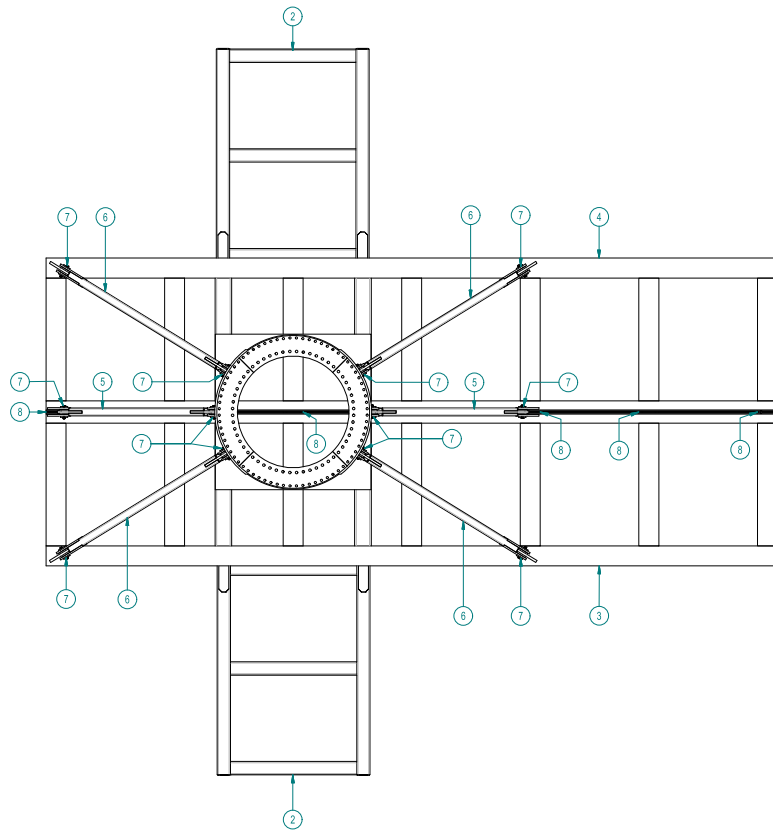


ISO (1:40)



Tightening torque = 1661Nm

MOMENT DOKREĆCENIA SRUB POZ 11



PRETENSION TORQUE TABLE (Nm)					
LUBRICANT IS TO BE APPLIED ON THREADS AND UNDER THE BOLT'S HEAD					
	8.8	10.9	12.9	A2-70	A2-70
M6	24	33	40	7.8	22
M8	41	55	70	15	44
M10	61	81	105	21	65
M12	81	114	138	27	78
M16	130	177	217	45	137
M20	205	241	249	72	204
M24	285	335	330	102	282
M30	410	480	470	147	417
M36	510	590	570	182	512

QTY	ITEM	DESCRIPTION	TECHNICAL DESCRIPTION	MATERIAL	PART No	VENDOR	MASS
12	11	WASHER	DN 6016 - A 31	PHOSPHON	15044731		0,08 kg
140	13	WASHER	DN 126 - A 30	PHOSPHON	15049832		0,04 kg
2	12	LIFTING EYEBOLT	DN 160 - 1615 x 17	CIS	15019192		11,7kg
72	11	HEX-HEAD BOLT	DN 601 - M16 x 140	10.9ZN	15019198		1,04 kg
70	10	HEX-HEAD BOLT	DN 601 - M17 x 140	8.8ZN	15019582		0,84 kg
70	9	HEX NUT	DN 604 - M27	8.8ZN	15014935		0,17 kg
7	8	DISTANCE PLATE	PLCS	INCOX	303224		23,45kg
12	7	BOLT	BOLT ASSEMBLY ROD	303423			7,39 kg
4	6	ROD	SUPPORT ROD 2	303363			180,60 kg
2	5	ROD	SUPPORT ROD 1	303361			155,70 kg
1	4	TEST FRAME	150 - 300TM TEST FRAME RIGHT SIDE	STEEL	303326		14452,57 kg
1	3	TEST FRAME	150 - 300TM TEST FRAME LEFT SIDE	STEEL	303323		14452,57 kg
2	2	TEST FRAME	150 - 300TM SIDE FRAME	STEEL	303321		1979,57 kg
1	1	TEST FRAME	150 - 300TM PROBEING	STEEL	303319		1381,20 kg

PARTS LIST

DATE: 11.07.2014	DRAWN: AJO	PROJECTION: 1st Angle	GENERAL TOLERANCES / SURFACE: WELDING NS-EN ISO 1300-RP / Sa 2.5 MACHINING NS-ISO 2768-mK / Ra 6.3
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TEST FRAME	FILE NAME	WEIGHT	SCALE	PAGE	SIZE:
150 - 300TM TEST FRAME ASSEMBLY ARRANGEMENT DRAWING	303312.lam	28113,0 kg	1:40	1/1	A1
DRAWING NUMBER	REVISION				
303312_A	-				