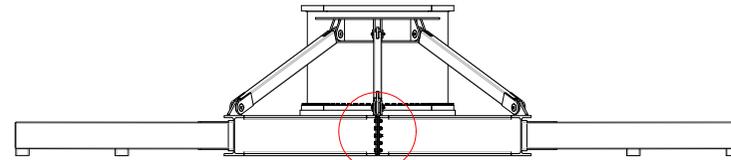


MIEJSCE MONTAZU I CIĘGNO PONUMEROWAC
Each rod has to be labeled to its place.

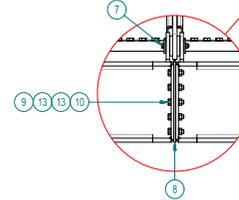


(1:20)

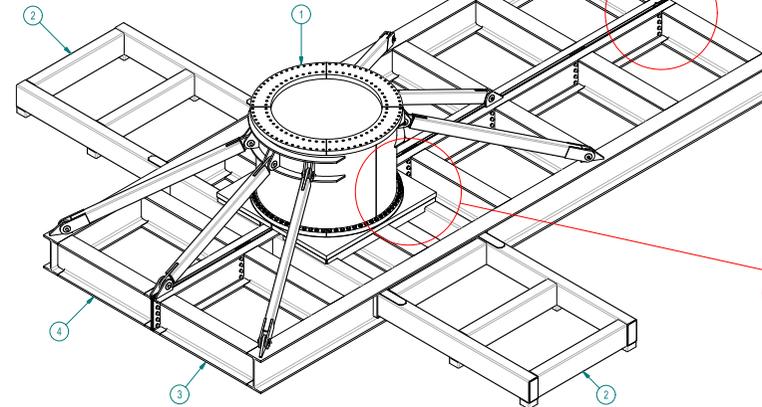
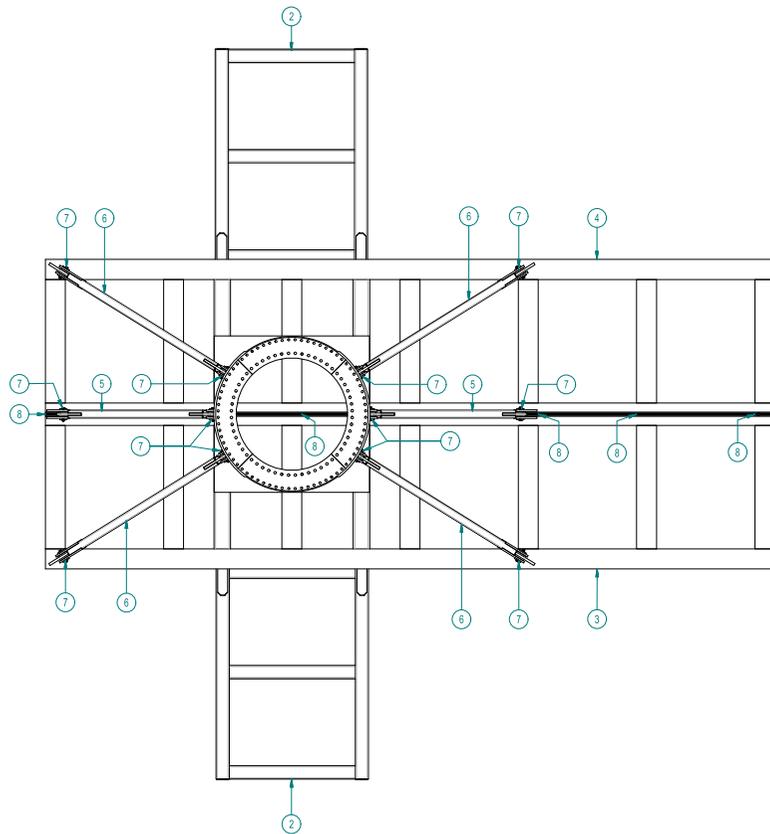
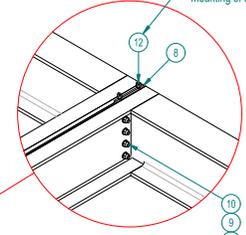
SRUBA OCZKOWA DO LATWIEJSZEGO MONTAZU

(1:20)

Lifting eyebolt for easier mounting of distance plate.



ISO (1:40)



(1:20)

Tightening torque = 1661Nm

MOMENT DOKREĆCENIA SRUB POZ 11

QTY	ITEM	DESCRIPTION	TECHNICAL DESCRIPTION	MATERIAL	PART No	VENDOR	MASS
12	11	WASHER	DN 6016 - A 31	PHOSPHEN	15044731		0,08 kg
140	13	WASHER	DN 126 - A 38	PHOSPHEN	15049832		0,04 kg
2	12	LIFTING EYEBOLT	DN 160 - 1615 x 17	CIS	15019192		61,7kg
72	11	HEX-HEAD BOLT	DN 6011 - M16 x 140	16.9ZN	15019198		1,04 kg
70	10	HEX-HEAD BOLT	DN 6011 - M17 x 110	8.8ZN	15009882		0,84 kg
70	9	HEX NUT	DN 604 - M27	8.8ZN	15014935		0,17 kg
7	8	DISTANCE PLATE	PLCS	INCOE	303324		23,46kg
12	7	BOLT	BOLT ASSEMBLY ROD		303403		7,36 kg
4	6	ROD	SUPPORT ROD 2	STEEL	303363		180,60 kg
2	5	ROD	SUPPORT ROD 1	STEEL	303361		155,70 kg
1	4	TEST FRAME	150 - 300TM TEST FRAME RIGHT SIDE	STEEL	303326		8462,57 kg
1	3	TEST FRAME	150 - 300TM TEST FRAME LEFT SIDE	STEEL	303323		8462,57 kg
2	2	TEST FRAME	150 - 300TM SIDE FRAME	STEEL	303321		1979,57 kg
1	1	TEST FRAME	150 - 300TM PROBEING	STEEL	303319		3881,20 kg

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
M10	41	65	79	15	44
M12	61	114	138	27	76
M16	107	217	271	65	167
M20	355	541	649	157	384
M24	655	935	1120	220	629
M30	1310	1840	2210		
M36	2260	3210	3950		

DATE:	DRAWN:	PROJECTION:	GENERAL TOLERANCES / SURFACE:
11.07.2014	AJO		
DATE:	CHECK:	WELDING:	MACHINING:
		NS-EN ISO 1301-RP / Sa 2.5	NS - ISO 2768-mK / Ra 6.3

TEST FRAME	DRAWING NUMBER	REVISION
150 - 300TM TEST FRAME ASSEMBLY ARRANGEMENT DRAWING	303312_A	-

REFERENCE	FILE NAME	WEIGHT	SCALE	PAGE	SIZE:
	303312.lam	28113,0 kg	1:40	1/1	A1