

The surface finish specification is in conformity with DIN ISO 1302 (Ra-values in µm)

Execution of welding work according to DIN EN 25817.  
for butt welds: weld strength group C  
for fillet welds: weld strength group B

Allowable deviations for dimensions without tolerance specification:  
For welding constructions according to DIN 8570 - BE.  
For parts produced by cutting or non cutting shaping according to DIN ISO 2768 - mH.

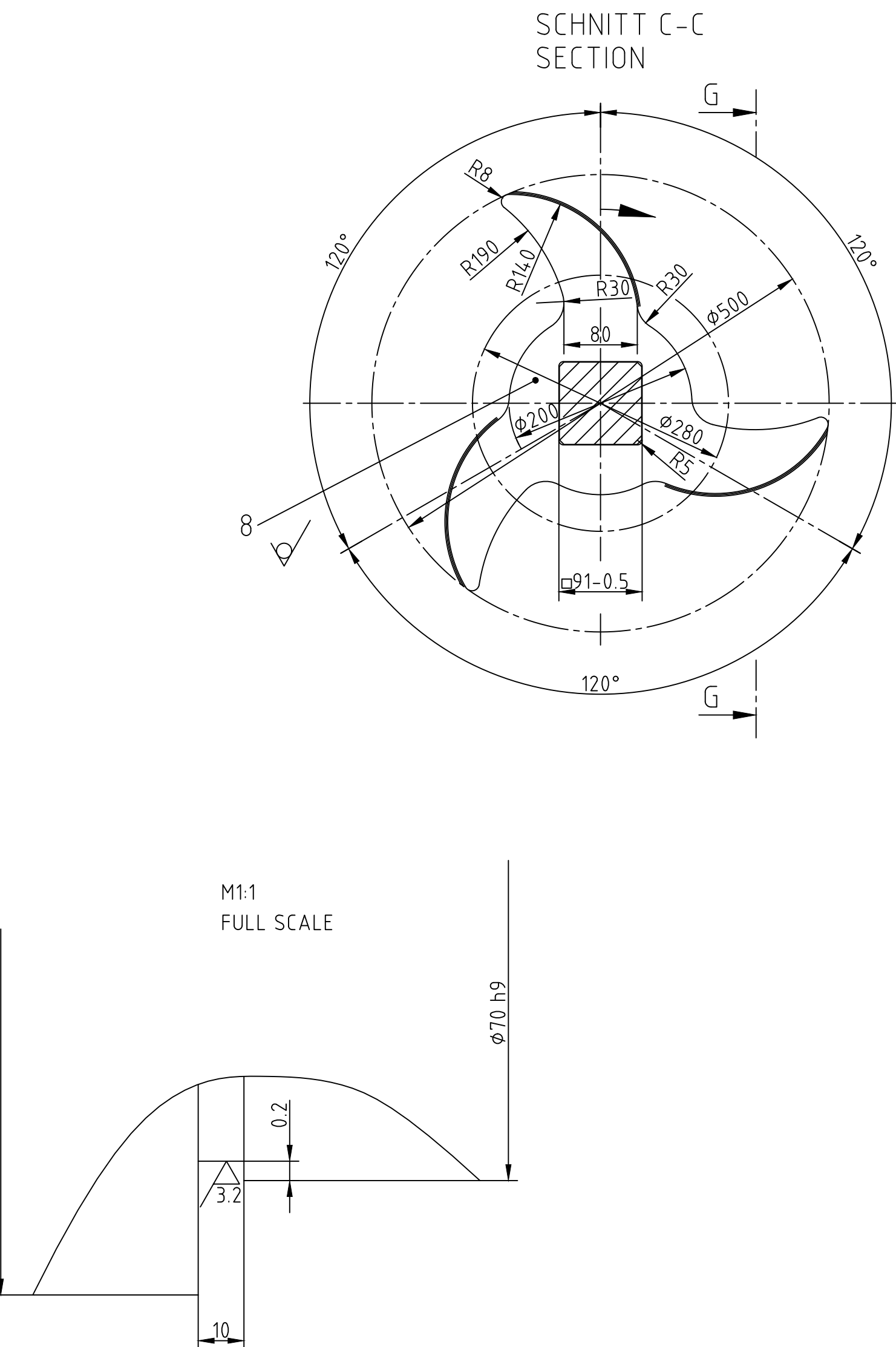
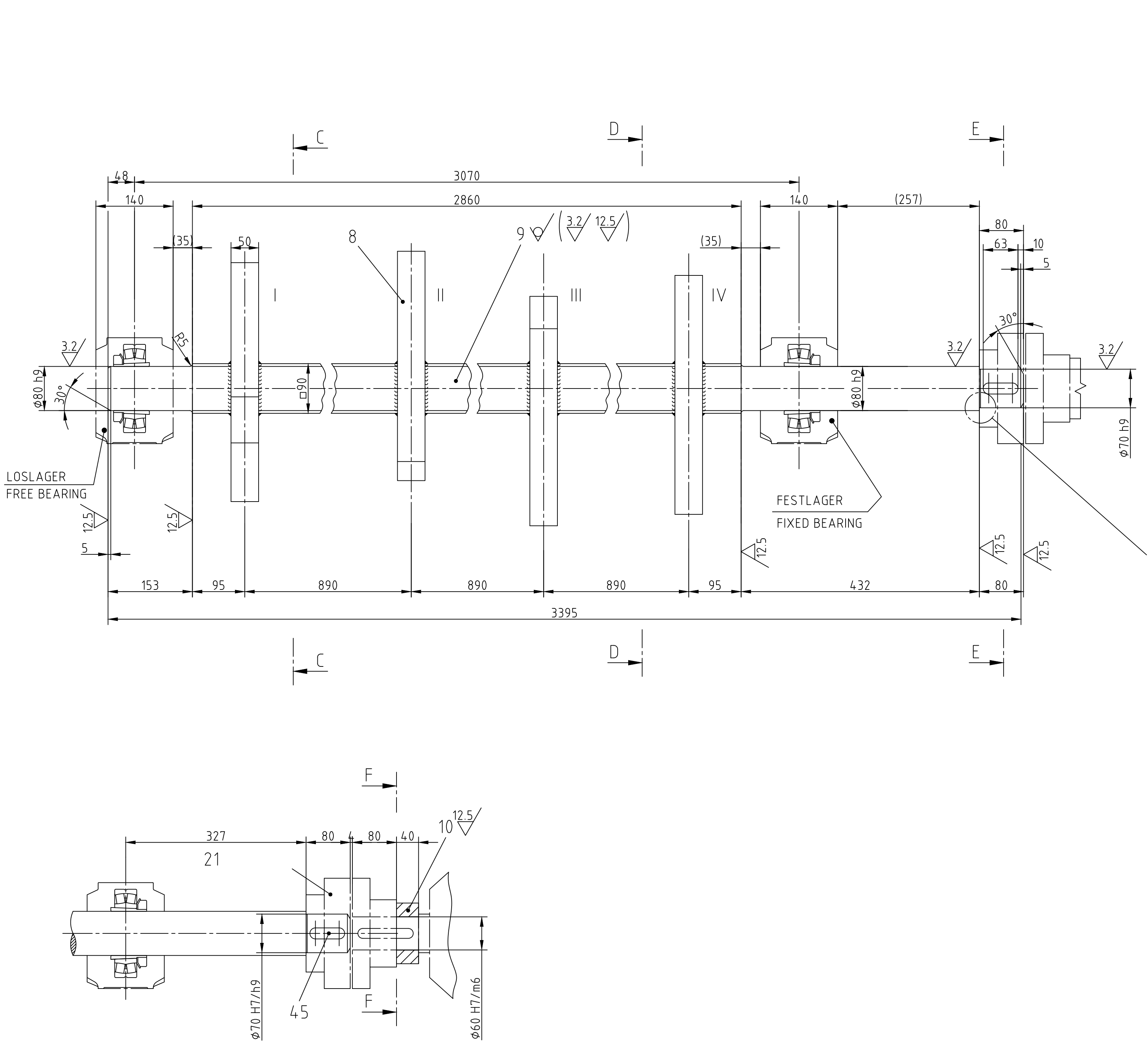
All welded seams except the rips shall be continuous.  
Unless specified otherwise in the drawing, the weld seam thickness shall be 0,5-0,7  
time the thinner sheet thickness.

The corresponding specification must be adhered to.

All flanges without machining instructions shall be straightened after welding.  
Maximum deviation from plane surface ± 1 mm.

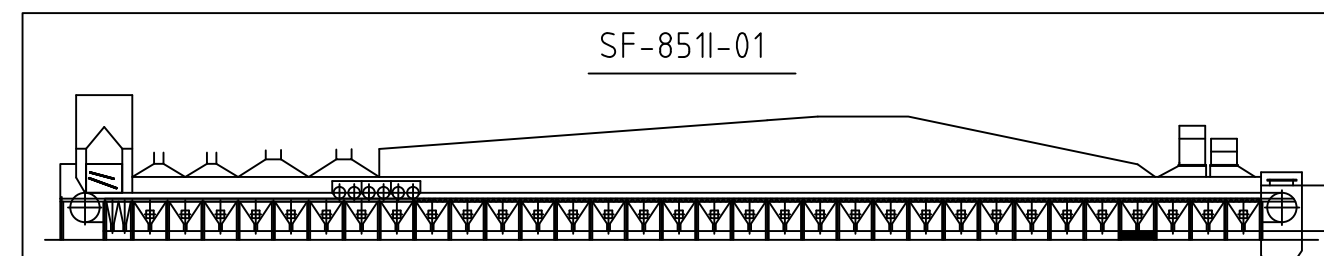
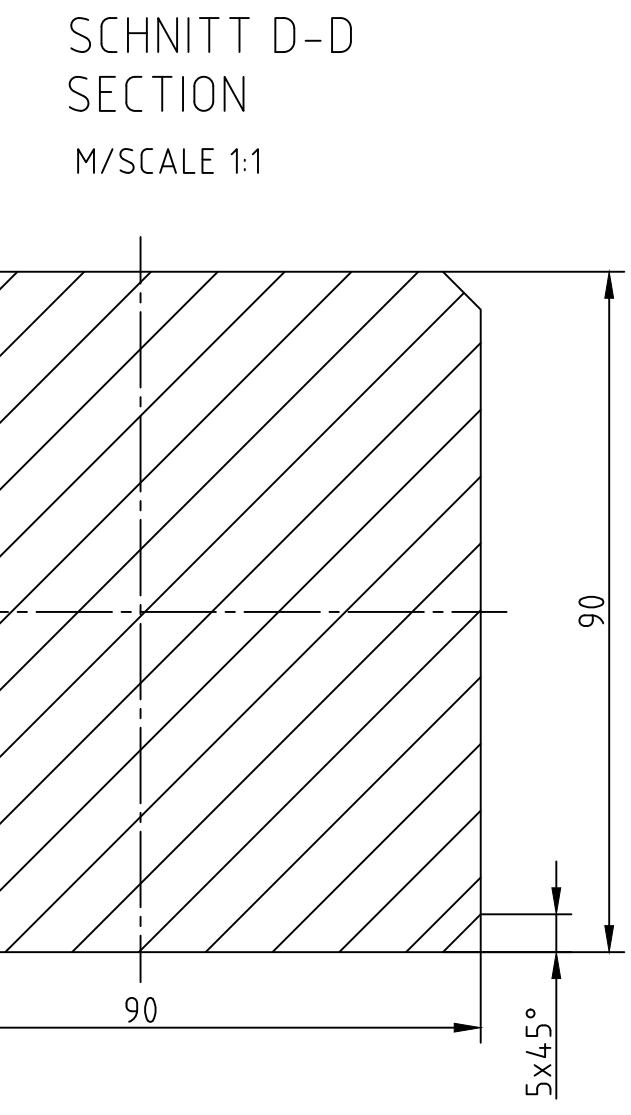
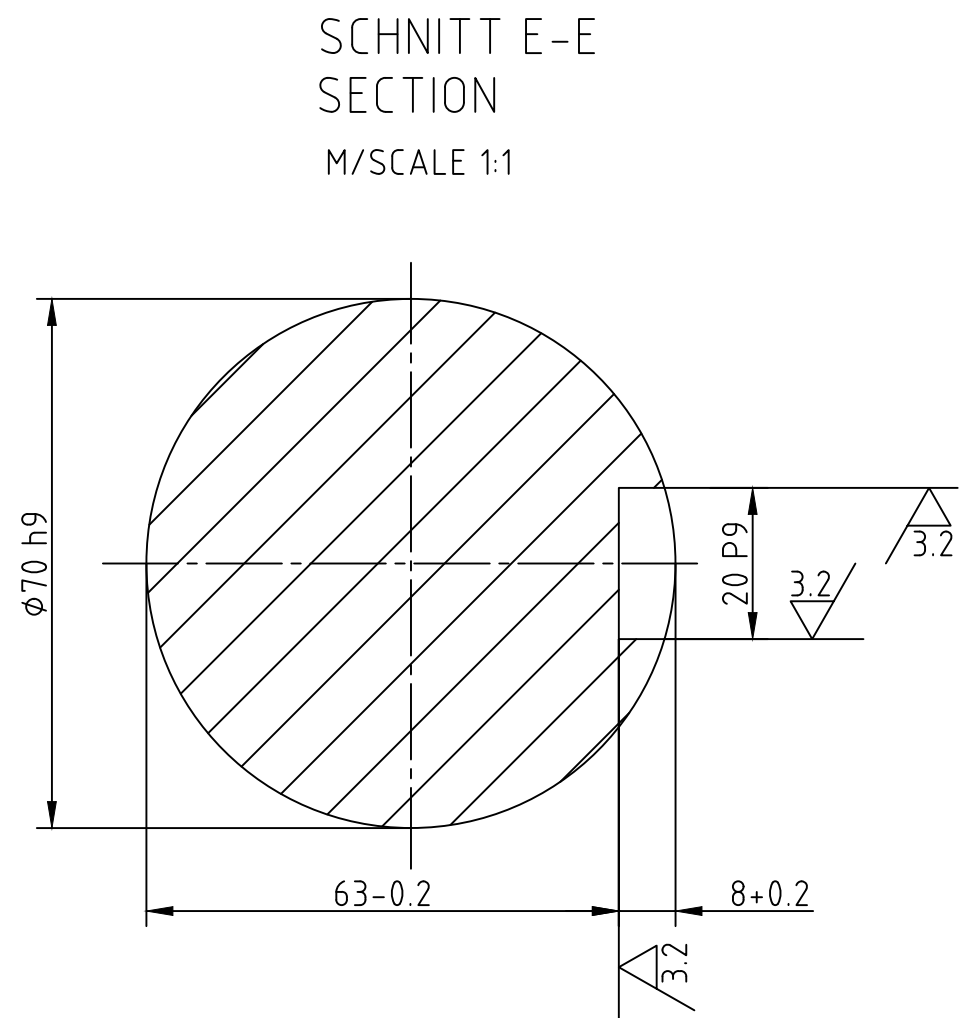
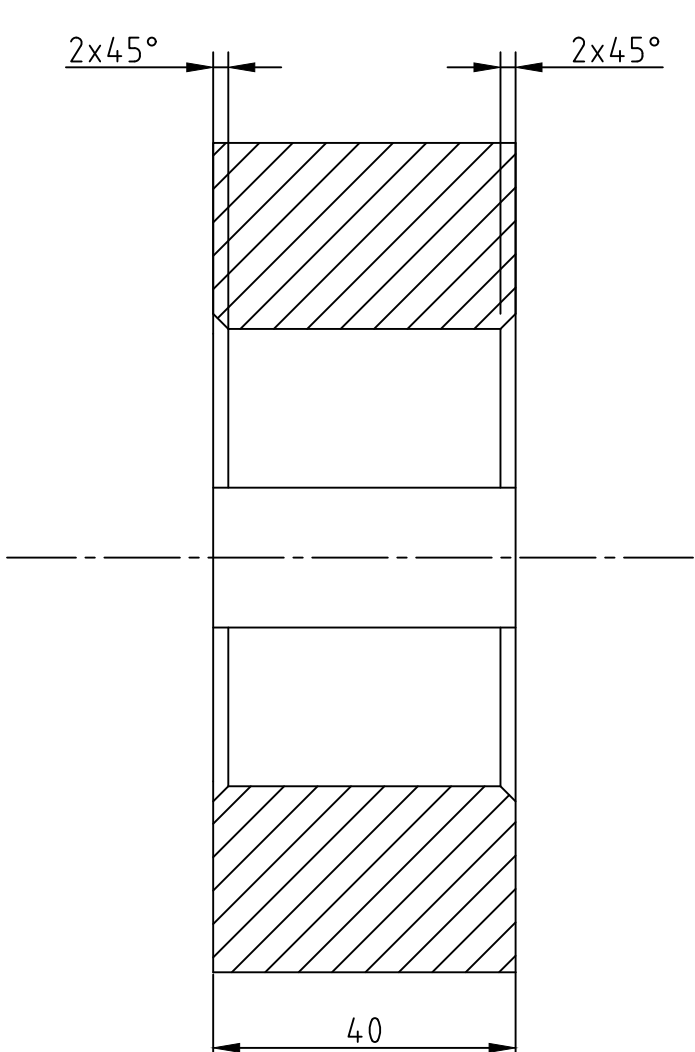
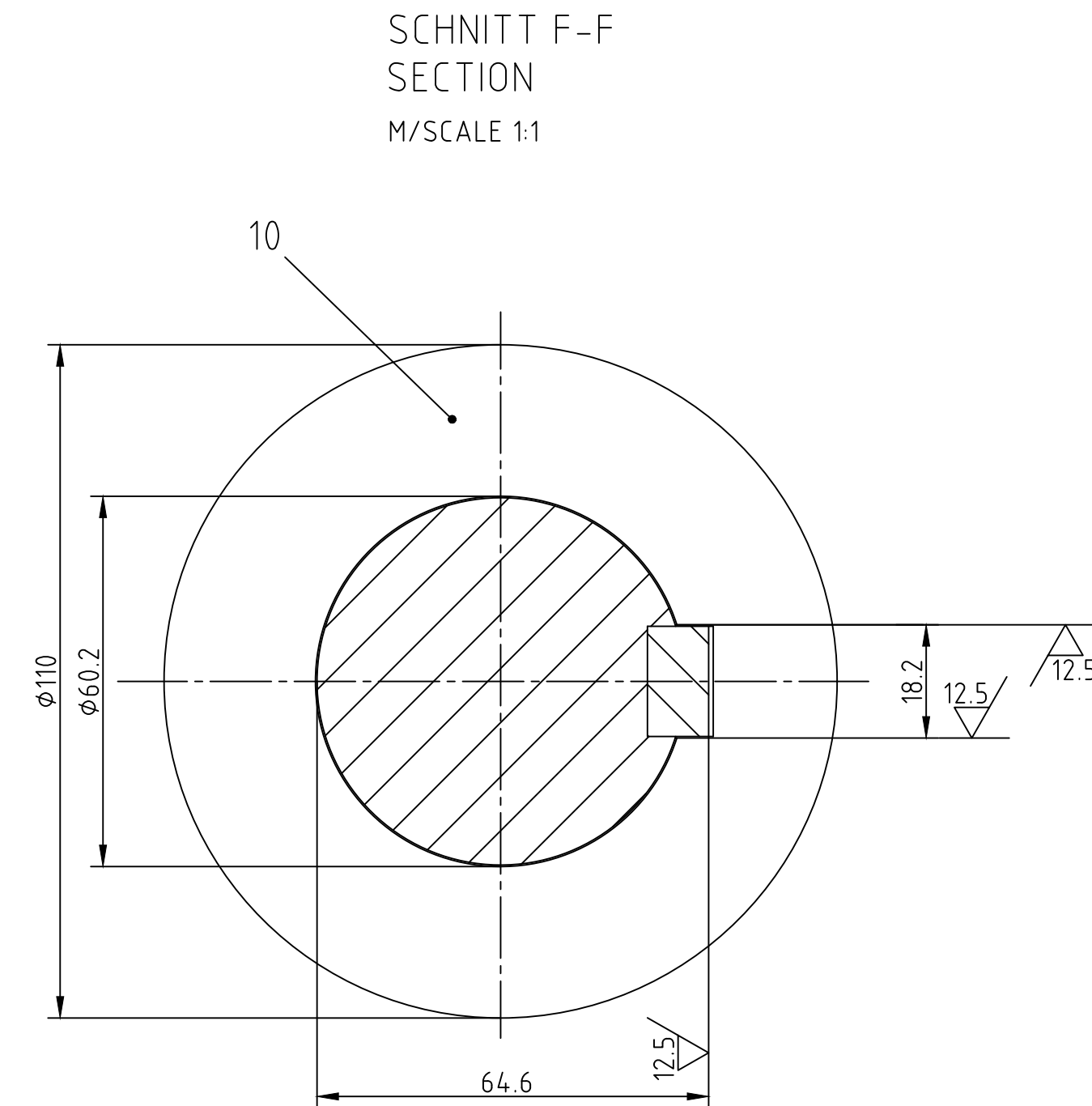
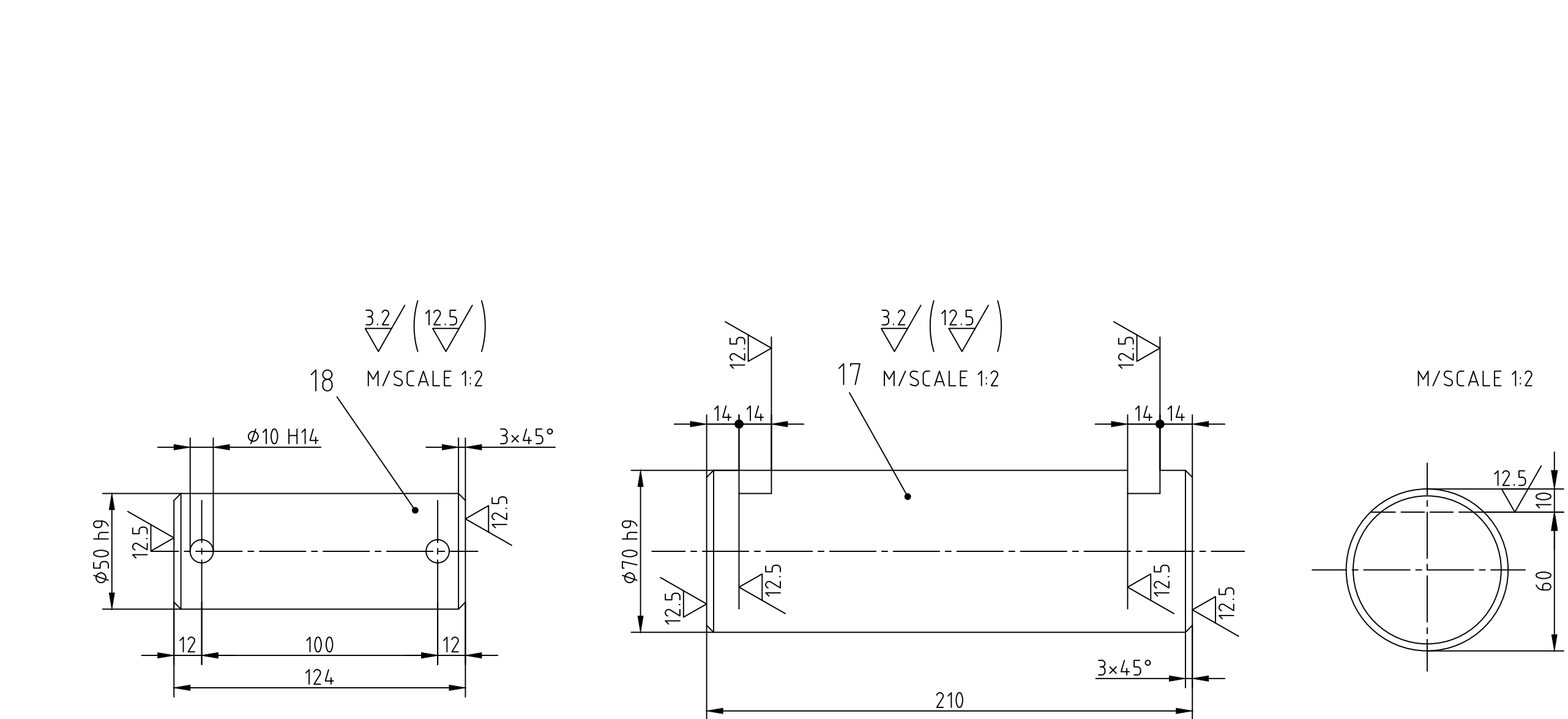
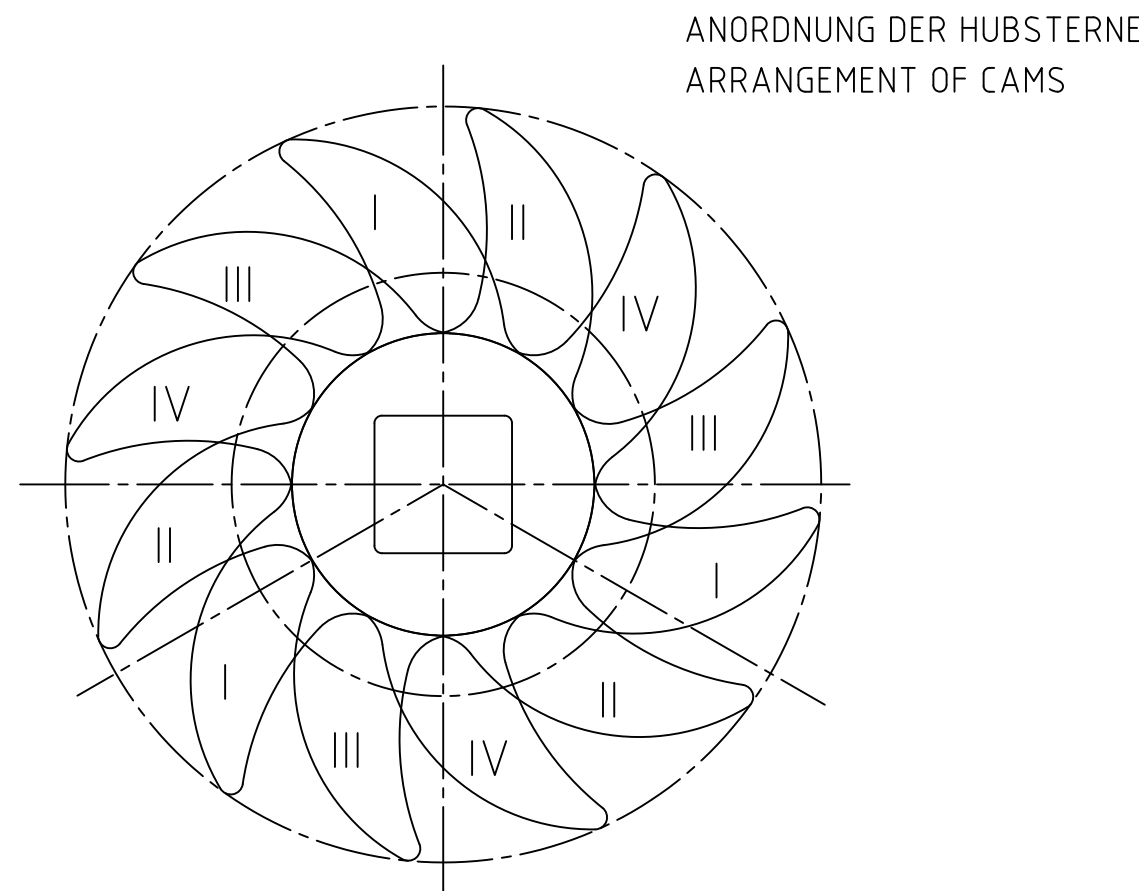
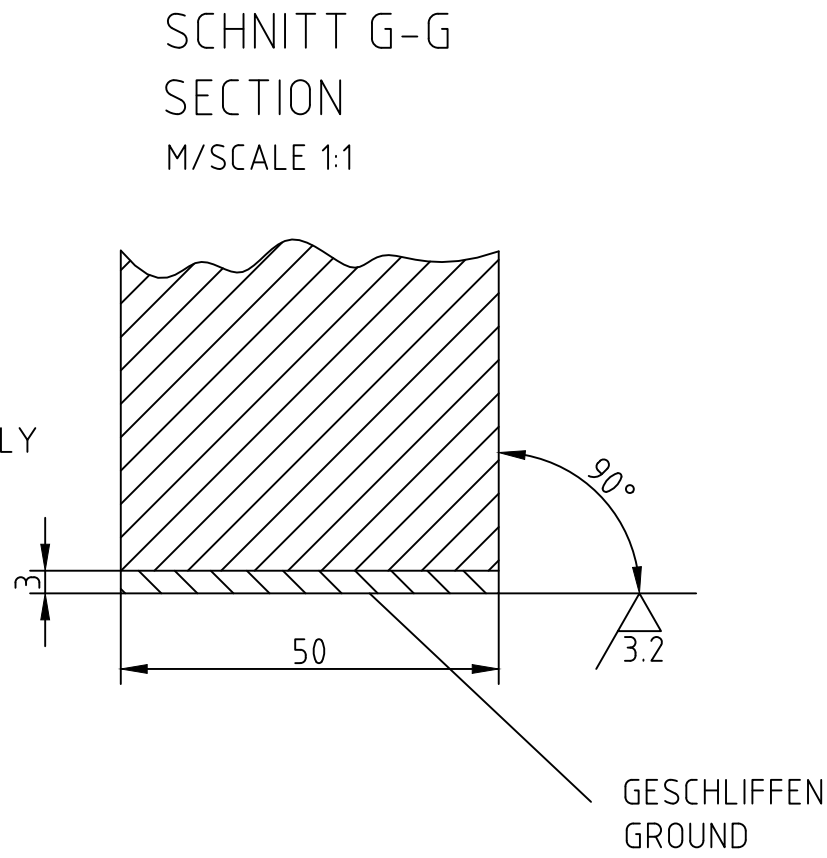
All items be bolted together shall be drilled with the same jig or on CNC- machine  
tool.

|         |           |                  |                  |
|---------|-----------|------------------|------------------|
| 20      | P9        | -0.022<br>-0.074 | 19.978<br>19.926 |
| Ø60     | m6        | -0.030<br>-0.011 | 60.030<br>60.011 |
| Ø80     | h9        | 0<br>-0.074      | 80.000<br>79.926 |
| Ø50     | h9        | 0<br>-0.062      | 50.000<br>49.938 |
| Ø70     | h9        | 0<br>-0.074      | 70.000<br>69.926 |
| Ø60     | H7        | +0.030<br>0      | 60.030<br>60.000 |
| Ø70     | H7        | +0.030<br>0      | 70.030<br>70.000 |
| Ø10     | H14       | +0.360<br>0      | 10.360<br>10.000 |
| Maß     | Passung   |                  |                  |
| Measure | Tolerance |                  |                  |



PANZERAUFTRAGS-  
SCHWEISSUNG  
HAERTE ca 55±5 HRC  
ELEKTRODE z.B. GRIDUR F-43  
bzw E10-55z nach DIN 8555

TYPE OF ELEKTRODE: GRIDUR F-43 RESPECTIVELY  
E10-55z ACC. TO DIN 8555  
HARDNESS - HRC 55±5  
HARD FACE  
WELDING



|                                                                         |                                                      |  |
|-------------------------------------------------------------------------|------------------------------------------------------|--|
| Reference Drawings / Documents<br>Dazugehoerige Zeichnungen / Dokumente |                                                      |  |
| Drawing / Document No.:<br>Zeichnungs / Dokumenten Nummer               | Title<br>Benennung                                   |  |
| I 76376-01-00781                                                        | Zusammenstellung Roststab - Reinigungsvorrichtung    |  |
| 8511-27-5260                                                            | GRATE BAR RAPPING DEVICE ARRANGEMENT                 |  |
| I 76376-01-00783                                                        | Roststab - Reinigungsvorrichtung, Einzelheit Blatt 2 |  |
| 8511-27-5262                                                            | GRATE BAR RAPPING DEVICE, DETAILS SHEET 2            |  |
| I 76376-01-00784                                                        | Roststab - Reinigungsvorrichtung, Einzelheit Blatt 3 |  |
| 8511-27-5263                                                            | GRATE BAR RAPPING DEVICE, DETAILS SHEET 3            |  |

|                                                                                            |          |          |                                                                                                                                            |                                    |                                          |            |
|--------------------------------------------------------------------------------------------|----------|----------|--------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------|------------------------------------------|------------|
| 1                                                                                          | 26.04.06 | E        | R.F.                                                                                                                                       | HOFF                               | CERTIFIED                                |            |
| 0                                                                                          | 06.04.06 | B        | SCHN                                                                                                                                       | HOFF                               | FIRST ISSUE                              |            |
| REV.                                                                                       | DATA     | TIPO     | POR                                                                                                                                        | SOLICIT.                           | DESCRIÇÃO                                |            |
| REVISÕES                                                                                   |          |          |                                                                                                                                            |                                    |                                          |            |
| TIPO DE EMISSÃO                                                                            |          |          | (A) PRELIMINAR<br>(B) PARA APROVAÇÃO<br>(C) PARA CONHECIMENTO                                                                              |                                    | (D) CONFORME CONSTRUÍDO<br>(E) CANCELADO |            |
|  CVRD |          |          | COMPLEXO DE TUBARÃO                                                                                                                        |                                    |                                          |            |
| DEP. ENGENHARIA                                                                            |          |          | PELLETIZING PLANT VIII<br>INDURATING MACHINE 4m WIDE; 768m2<br>GRATE BAR RAPPING DEVICE<br>DETAILS, SHEET 1<br>DESIGN DRAWING FOR MACHINES |                                    |                                          |            |
| GACRP                                                                                      |          |          |                                                                                                                                            |                                    |                                          |            |
| RESPONSÁVEL                                                                                |          | DATA     |                                                                                                                                            | ESCALA                             |                                          | REV.       |
| PROJ.                                                                                      | SCHN     | 06.04.06 |                                                                                                                                            | N° CVRD =<br>8511-27-5261          |                                          | 1          |
| DES.                                                                                       | SCHN     | 06.04.06 |                                                                                                                                            | N. OUTORUMPU :<br>I 76373-01-00782 |                                          | FOLHA<br>1 |
| VER.                                                                                       | DEP      | 06.04.06 |                                                                                                                                            | N. EPO :<br>C-MM-3513B-DG0261      |                                          |            |
| APROV.                                                                                     | HOFF     | 06.04.06 |                                                                                                                                            |                                    |                                          |            |