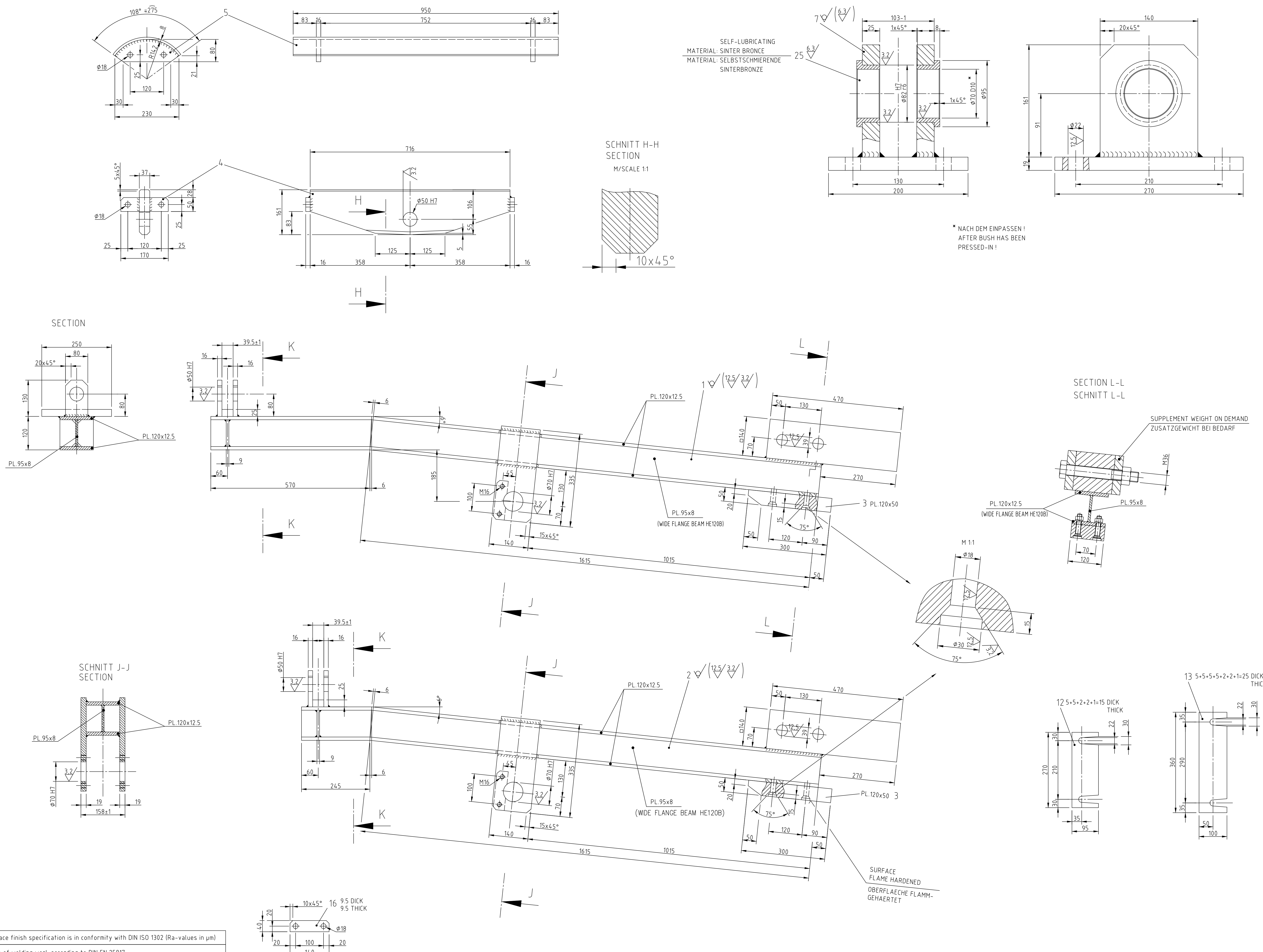




The surface finish specification is in conformity with DIN ISO 1302 (Ra-values in µm)

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.

Ø82	r6	+0.073	82.073
Ø50	H7	+0.051	50.051
Ø82	H7	+0.035	82.035
Ø70	H7	+0.035	70.035
Ø70	D10	+0.030	70.030
Measure	Tolerance		
Maß	Passung		

Reference Drawings / Documents Dazugehörige Zeichnungen / Dokumente	
Drawing / Document No.: Zeichnungs / Dokumenten Nummer	Title Benennung
176376-01-00781	Zusammenstellung Roststab - Reinigungsvorrichtung
8511-27-5260	GRATE BAR RAPPING DEVICE ARRANGEMENT
176376-01-00782	Roststab - Reinigungsvorrichtung, Einzelheit Blatt 1
8511-27-5261	GRATE BAR RAPPING DEVICE, DETAILS SHEET 1
176376-01-00784	Roststab - Reinigungsvorrichtung, Einzelheit Blatt 3
8511-27-5263	GRATE BAR RAPPING DEVICE, DETAILS SHEET 3

* SELBSTSCHMIERENDE SINTERBRONZE
SELF-LUBRICATING SINTER BRONZE

1	26.04.06	E	R.F.	HOFF	CERTIFIED
0	06.04.06	B	SCHM	HOFF	FIRST ISSUE
REV.	DATA	TIPO	POR	SOLICIT.	DESCRIÇÃO
REVISÕES					
TIPO DE EMISSÃO					
(A) PRELIMINAR	(B) PARA APROVAÇÃO	(C) PARA COTAÇÃO	(D) PARA COTAÇÃO	(E) PARA COTAÇÃO	(F) CONFORME CONHECIMENTO
(G) PARA COTAÇÃO	(H) PARA COTAÇÃO	(I) PARA COTAÇÃO	(J) PARA COTAÇÃO	(K) PARA COTAÇÃO	(L) PARA COTAÇÃO
CVRD					
COMPLEXO DE TUBARÃO					
DEP. ENGENHARIA					
GAGRP					
RESPONSÁVEL					
PROJ.	SCHN	06.04.06	ESCALA	1:1	REV. 1
DES.	SCHN	06.04.06	1:1	8511-27-5262	FOLHA 1
VER.	DEP	06.04.06	N.º DE PROJ.	176373-01-00783	
APROV.	HOFF	06.04.06	N.º DE PROJ.	C-MM-3513B-DG0262	