

1

2

3

4

5

6

496 ±0.5

PŘEKLAD

dne: 10 -01- 2018

PROVEDLA  
JANA PROKEŠOVÁNote:  
Grind overlaying welding  
seams on this surfacePOZNÁMKA:  
NA TOMTO PLOCHU SEBROUSIT  
PŘESAHUJÍCÍ SVÁRY DO ROVINY

174.5

a 3 1 x 3

a 3 1 x 3

a 3 1 x 3

a 3 1 x 3

a 3 1 x 3

(160)

712

no welding on lower side  
SPODNÍ STRANA NENÍ SVÁŘENÁ

B-B

A-A

R

Obecná skupina pro hodnocení  
Poloha referenčních značek svařence  
Postup při svařování WPS  
Specifikace postupu svařování WPS  
Test specifikace  
Požadavky na výrobce

02

|  |               |
|--|---------------|
| General Assessment groups                | EN ISO 5817-C |
| Position for welder reference markers    | SM            |
| Welding procedure specification WPS      | 50988839001   |
| Stud welding procedure specification WPS | 50988839006   |
| Specification test                       | 50988839800   |
| Requirements to manufacturers            | WN 10570-1    |

02 DIN 50979-ZnFe12/Fn/T2

before tacking the roller  
PŘED STAHOVÁNÍM DÍLU ROLLE- 6 -02- 2018  
ARCHIV2  
2M/18/00036

|                                   |                                      |   |           |                |               |
|-----------------------------------|--------------------------------------|---|-----------|----------------|---------------|
| First angle projection            | 02                                   | change the coatings to Cr(VI)-free coatings | T92691    |                |               |
|                                   |                                      | welding sticker updated                     |           |                |               |
|                                   |                                      | OMĚNA POVRCHOVÉ ÚPRAVY                      |           |                |               |
|                                   |                                      | AKTUALIZOVÁNÍ SVÁŘOVACÍ RÁMEČEK             |           |                |               |
| General tolerance (GT) in mm      | Index                                | alteration                                  | Change no | Fit            | Toler.        |
| Size range                        | PPAP -                               |   |           |                |               |
| ≤ 30                              | ≤ 120                                | ≤ 400                                       | ≤ 1000    |                |               |
| GT coarse                         | Inspection dim.                      | Aux.dim. ( )                                |           |                |               |
| L 1 2 3 4                         | Drawn                                | Date  | Name      | Blank no:      | Weight: in kg |
| 1 2 4 6                           | Checked                              | 07.07.2017                                  |           |                | 6.1           |
| Lengths (L) and angle (L/Δ) = ±GT | Auth'd                               | 20.07.2017                                  |           | Title: assy.   | Prod.         |
|                                   | M.check                              | 24.07.2017                                  |           | rail           | Scale         |
|                                   |                                      |   |           |                | 1:2           |
| Tolerance Symbols ISO 1101        |                                      |   |           | Drawing number | Sheet: 1 of 1 |
| ○ roundness = 1/2σ-Tol.           |                                      |   |           | 55044200615    |               |
| □ straightness/flatness = AT      |                                      |   |           |                |               |
| ⊙ concentricity/run out = AT      |                                      |   |           |                |               |
| ≡ symmetry = AT                   |                                      |   |           |                |               |
| // parallelism = AT               |                                      |   |           |                |               |
| ⊕ position = AT                   |                                      |   |           |                |               |
| Languages: DE:EN                  | Confidential document                |   |           | Repl.          | Orig.         |
|                                   | Refer to protection notice ISO 18018 |   |           |                |               |

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