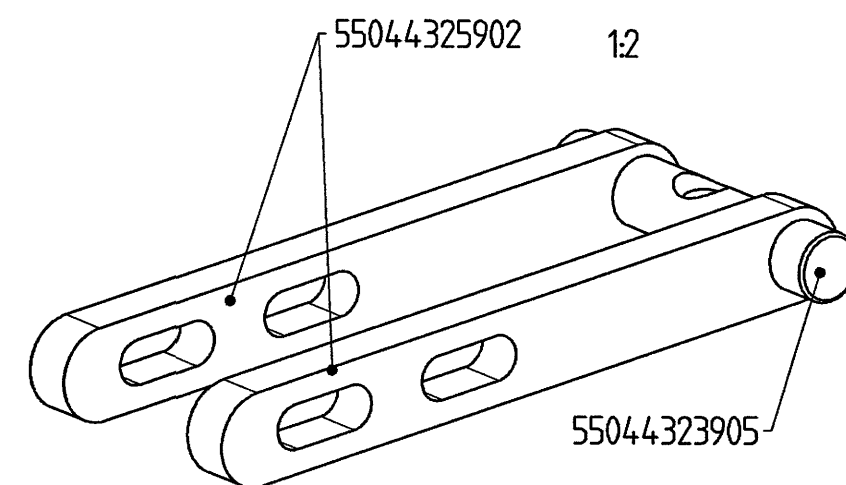


PŘEKLAD

dne: 10 -01- 2018

*P*ROVEDLA
JANA PROKEŠOVÁ



- 6 -02- 2018

ARCHIV





2 LM/18/00036

② DIN 50979 - ZnFe12/Fn/T2

02

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

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

First angle projection			02	change the coatings to Cr(VI)-free coatings	T92691																			
				updated weld sticke																				
				ZMĚNA POVRCHOVÉ ÚPRAVY																				
				AKTUALIZOVÁN SVAROVACÍ RÁMEČEK																				
General tolerance (GT) in mm Size range			Index	alteration	Change no	Fit	Toler.																	
<table><tr><td></td><td>></td><td>30</td><td>></td><td>120</td><td>></td><td>400</td><td>></td><td>1000</td></tr><tr><td>≤</td><td>30</td><td>≤</td><td>120</td><td>≤</td><td>400</td><td>≤</td><td>1000</td></tr></table>				>	30	>	120	>	400	>	1000	≤	30	≤	120	≤	400	≤	1000	PPAP -	Material:			Weight: in kg 1.325
				>	30	>	120	>	400	>	1000													
≤	30	≤	120	≤	400	≤	1000																	
Inspection dim.  Aux.dim. ()			Blank no:																					
GT fine			Date	Name	Title: assy.			Prod.																
<table><tr><td>L</td><td>0,2</td><td>0,5</td><td>0,8</td><td>2</td><td>4</td></tr><tr><td>Δ</td><td>0,1</td><td>0,2</td><td>0,4</td><td>1</td><td>2</td></tr></table>			L	0,2	0,5	0,8	2		4	Δ	0,1	0,2	0,4	1	2	Drawn	11.04.2017	ZP.Zheng	guide					
L	0,2	0,5	0,8	2	4																			
Δ	0,1	0,2	0,4	1	2																			
Lengths (L) and angle (∠)= ±GT			Checked	20.06.2017	M.Bolbrinker	Scale 1:2																		
			Auth'd	20.07.2017	S.Bornefeld																			
Tolerance Symbols ISO 1101 ○ roundness = 1/2ø-Tol. —□ straightness/flatness = AT ◎/ concentricity/run out = AT ≡ symmetry = AT // parallelism = AT ⊕ position = AT			M.check	24.07.2017	C. Weise	Sheet: 1 of: 1																		
Languages: DE;EN			 STILL GmbH Hamburg			Drawing number 55044201702																		
			Confidential document			Repl.																		
			Refer to protection notice ISO 16016			Orig.																		

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