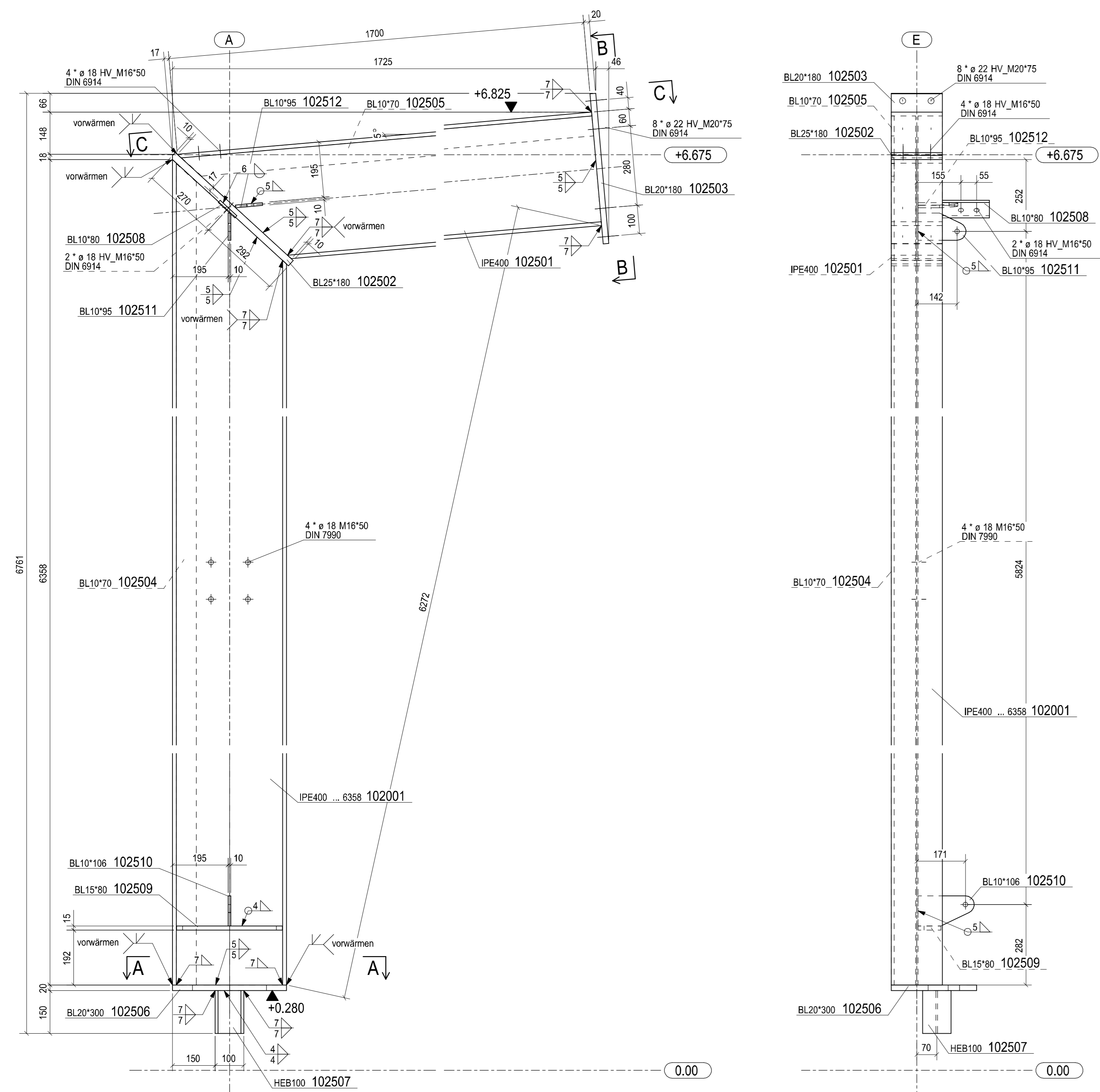
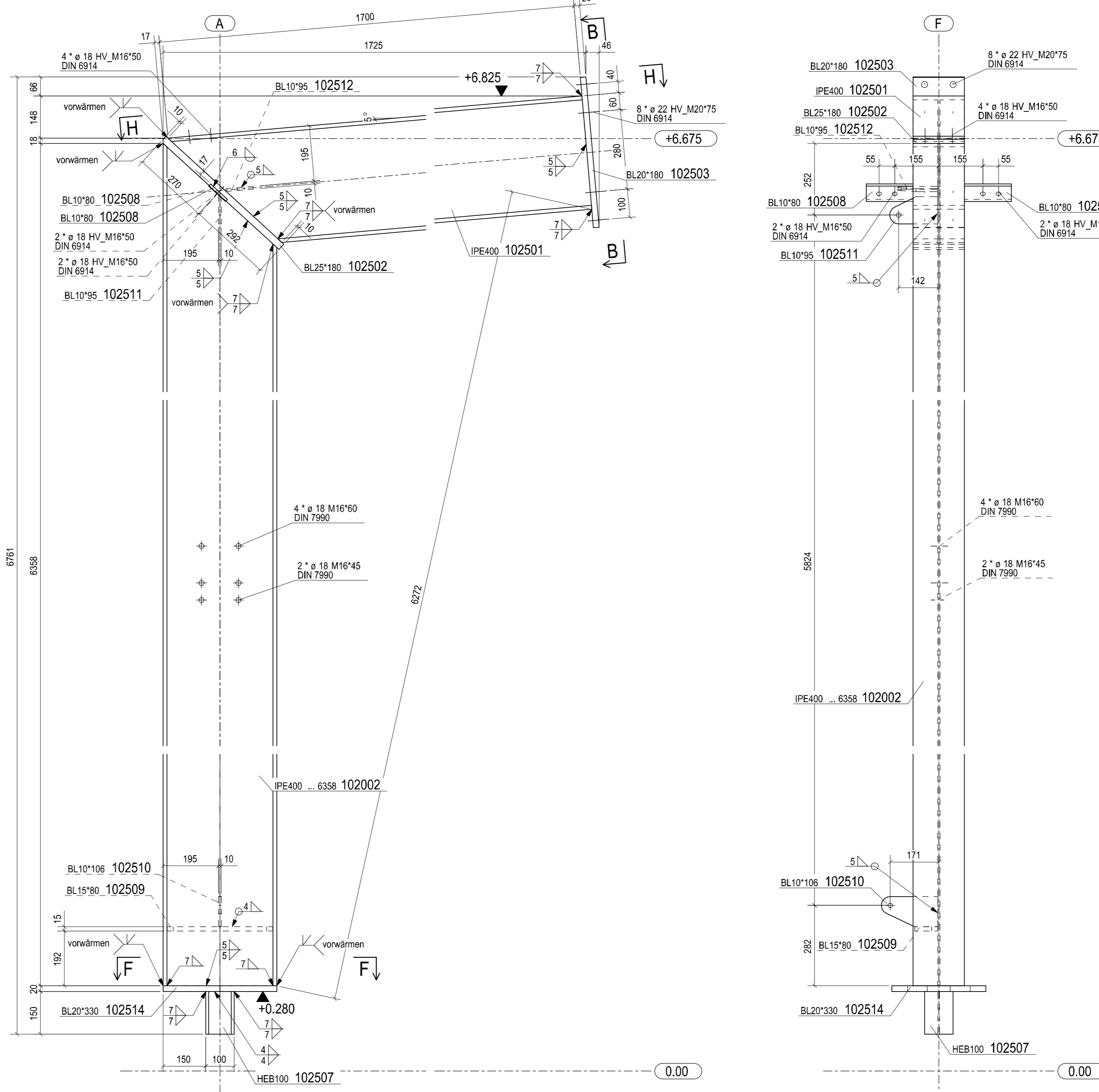


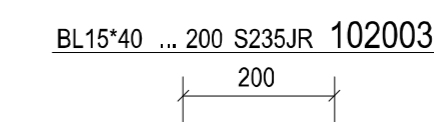
1*1PE400...6761 Pos.102001



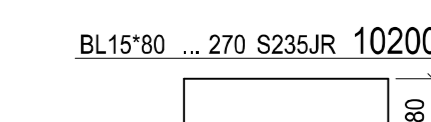
1*1PE400...6761 Pos.102002



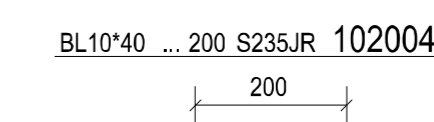
8*BL15*40...200 Pos.102003



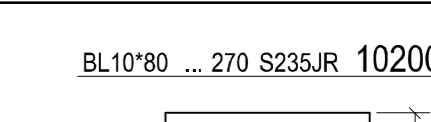
20*BL15*80...270 Pos.102007



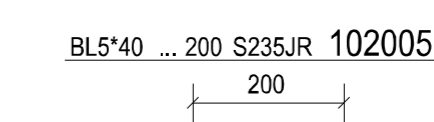
8*BL10*40...200 Pos.102004



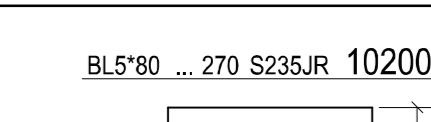
20*BL10*80...270 Pos.102008



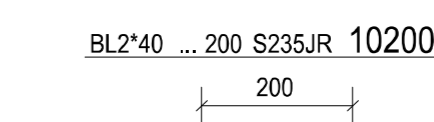
8*BL5*40...200 Pos.102005



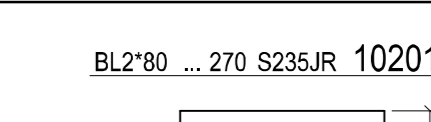
20*BL5*80...270 Pos.102009



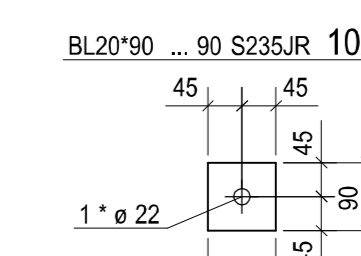
16*BL2*40...200 Pos.102006



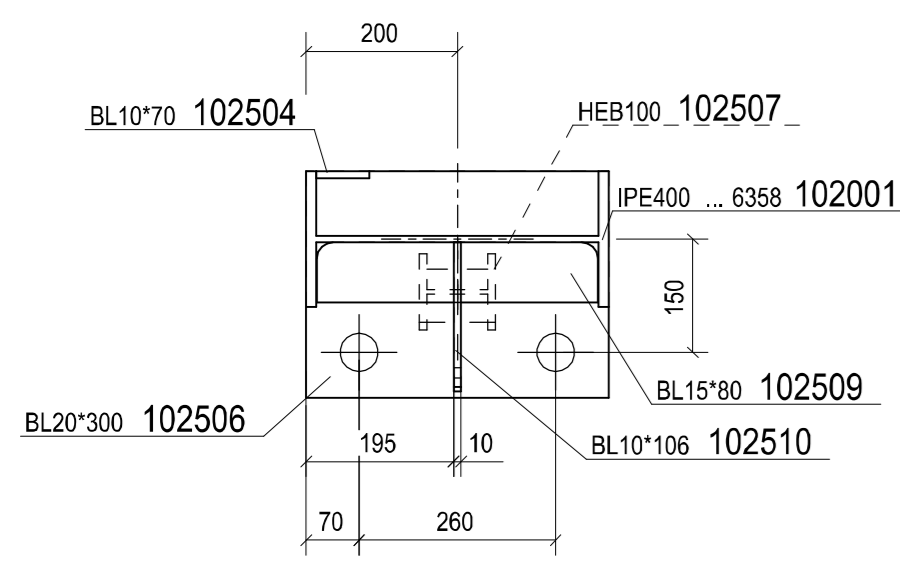
40*BL2*80...270 Pos.102010



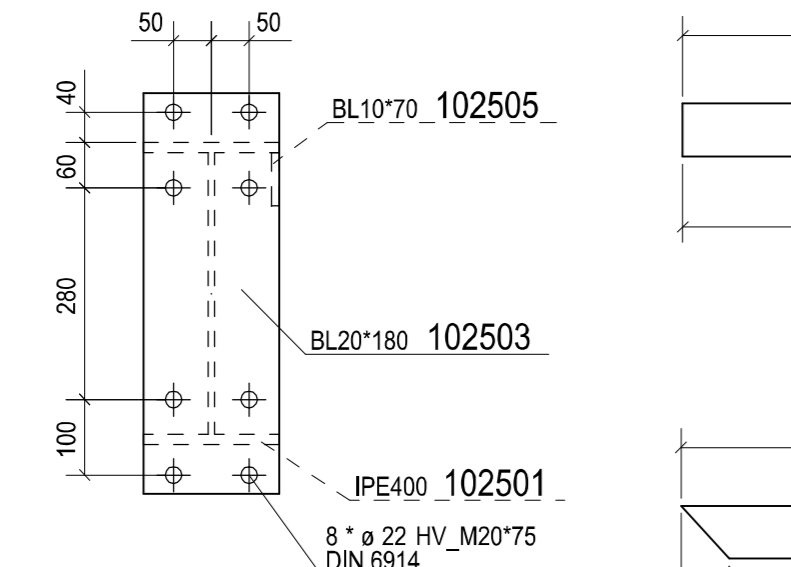
28*BL20...90 Pos.102011



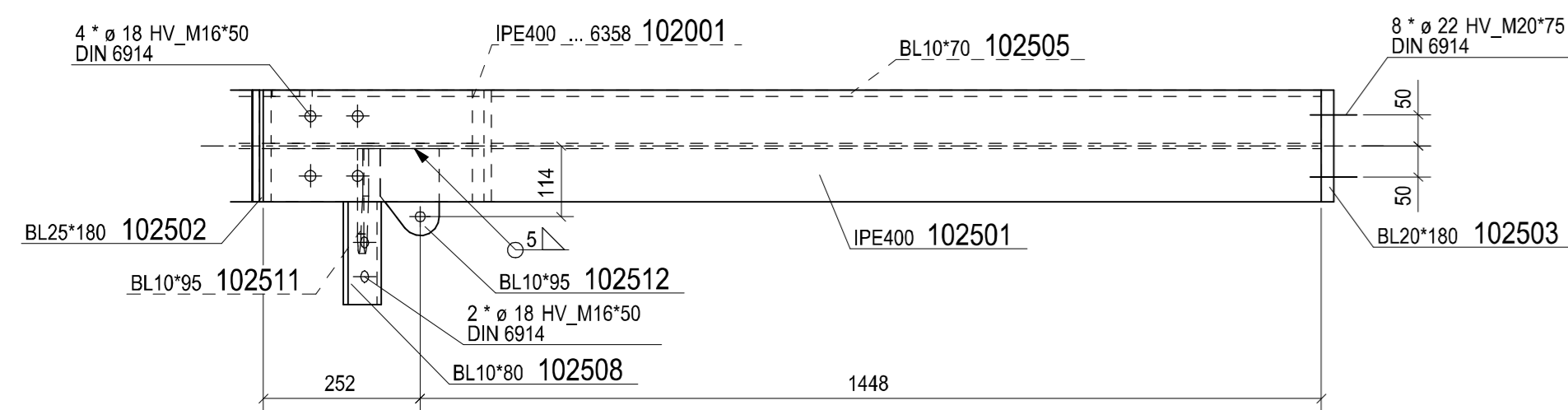
A - A



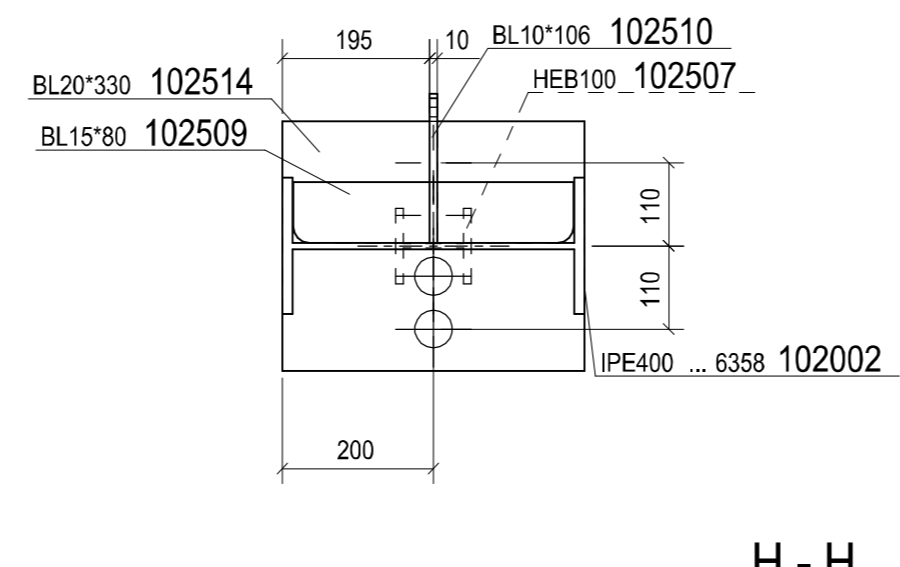
B - B



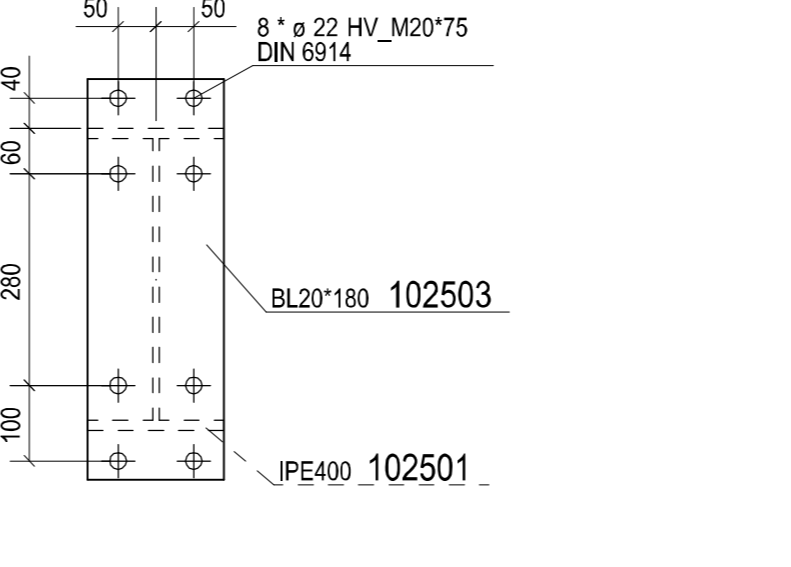
C - C



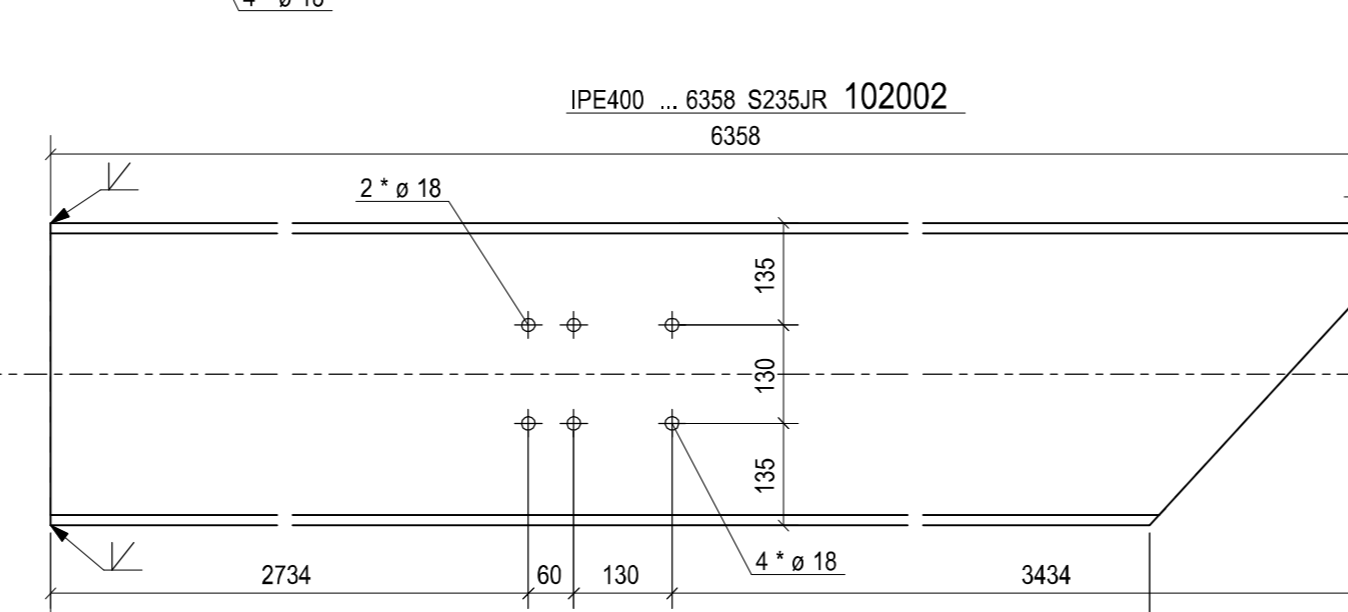
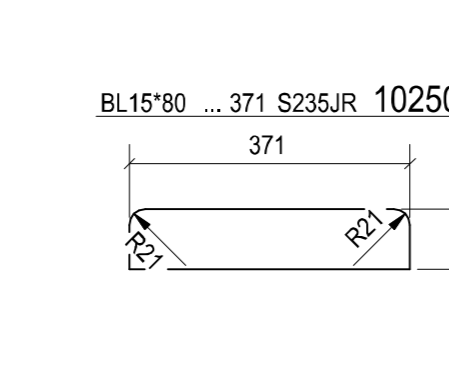
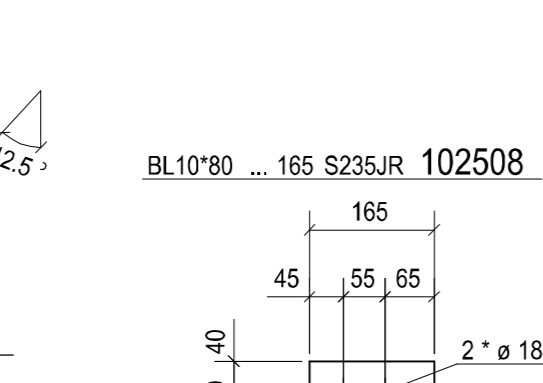
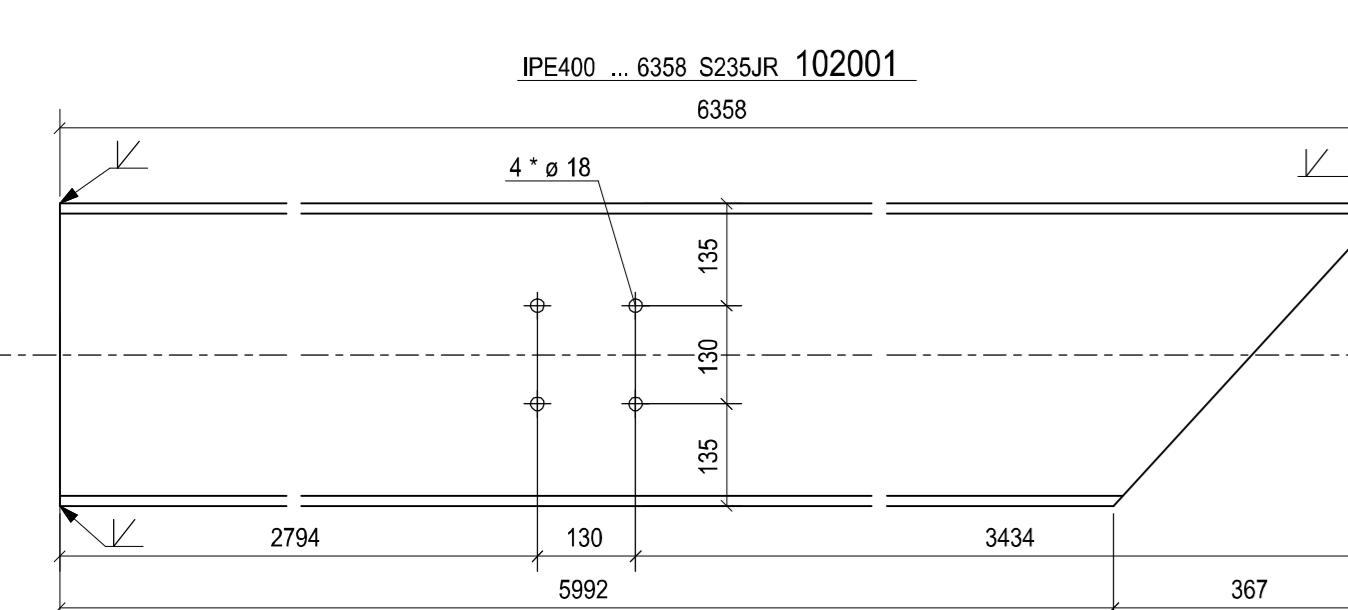
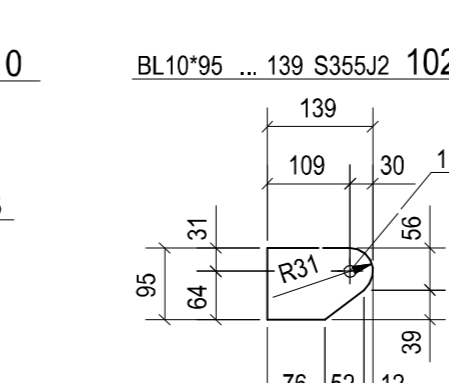
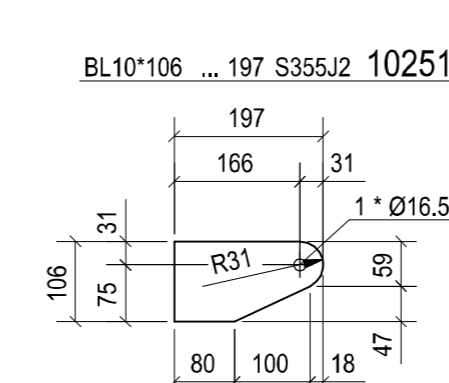
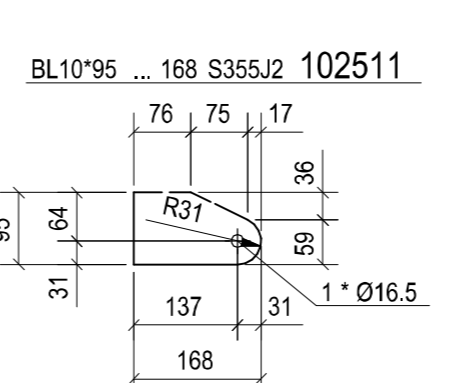
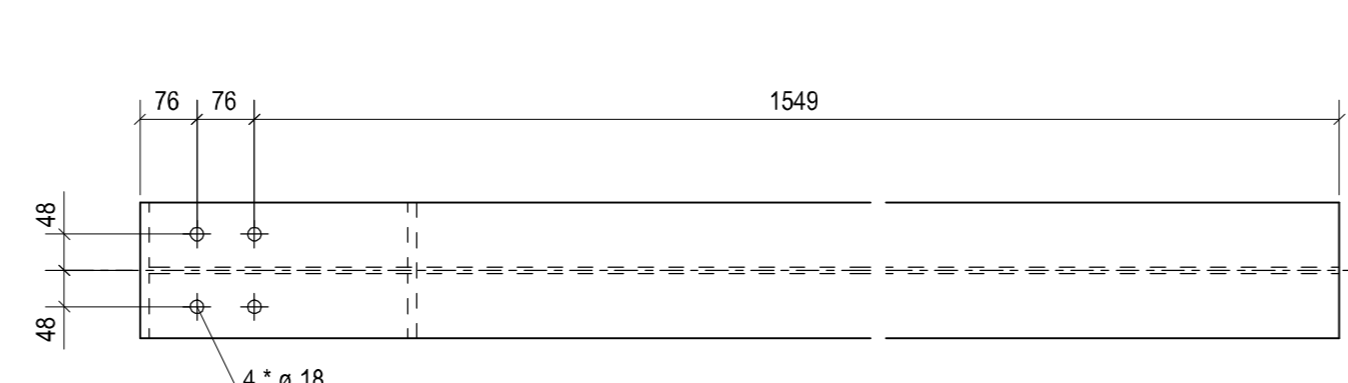
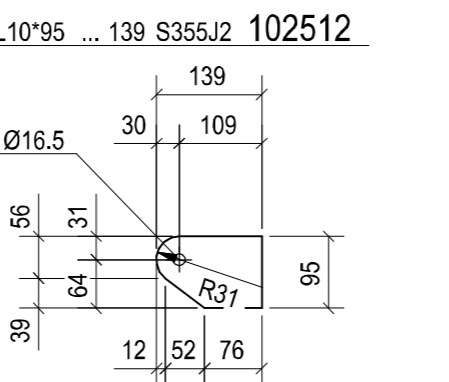
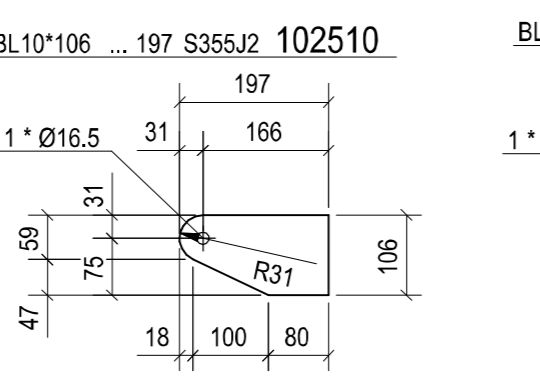
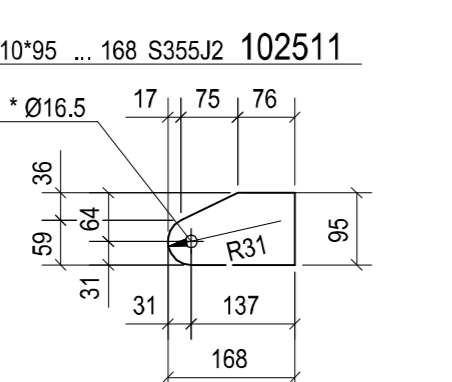
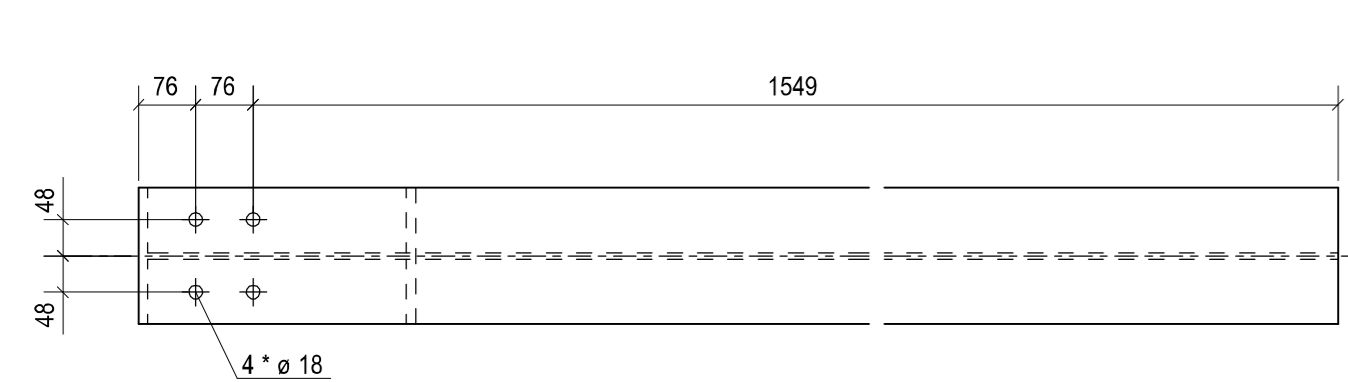
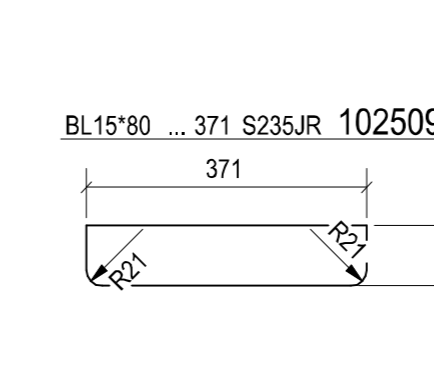
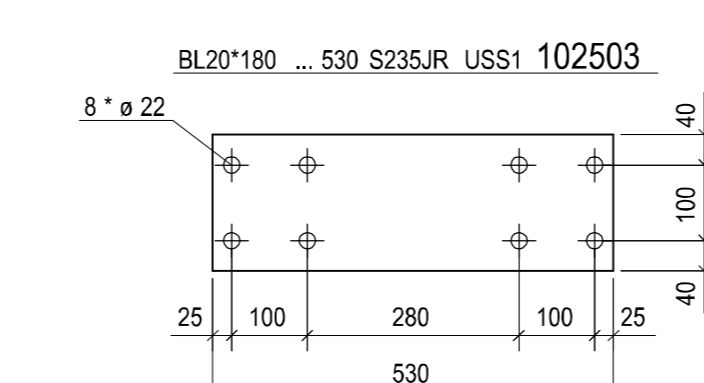
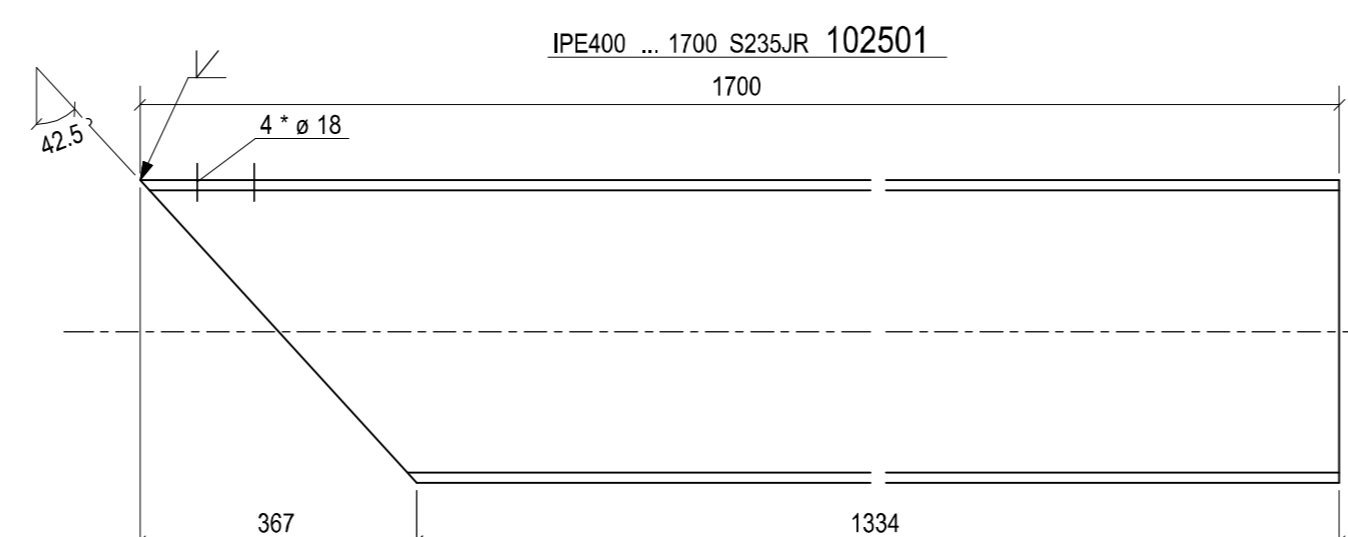
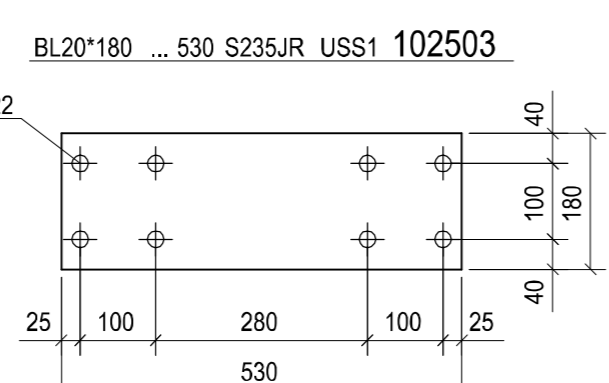
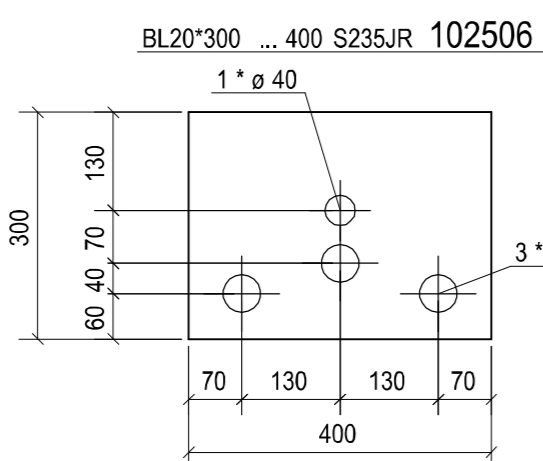
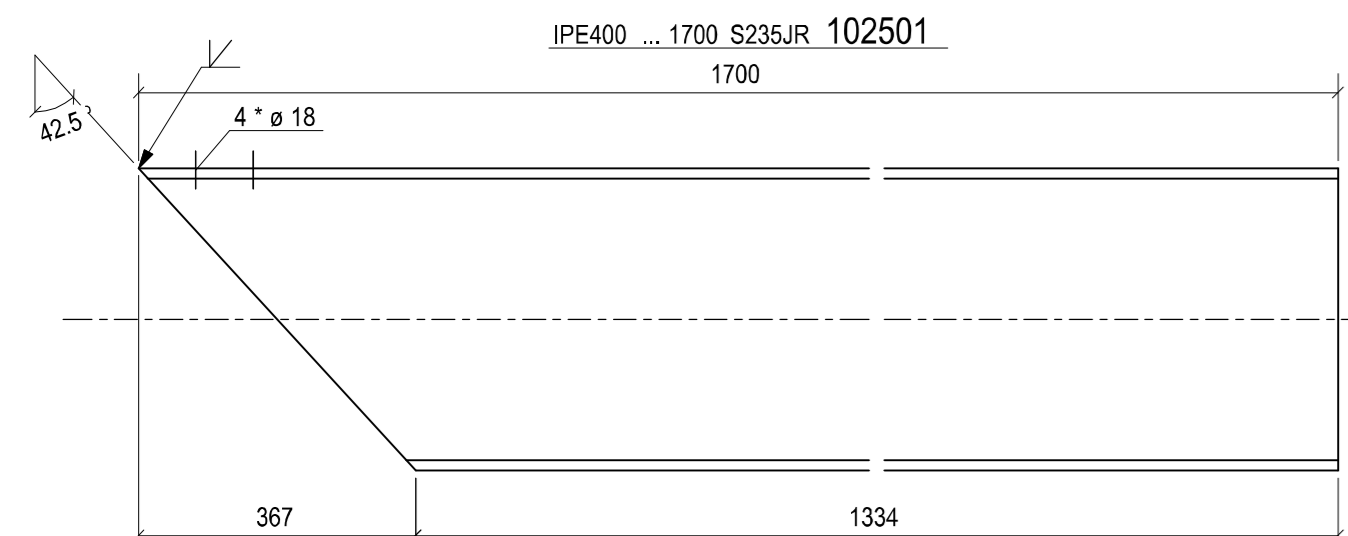
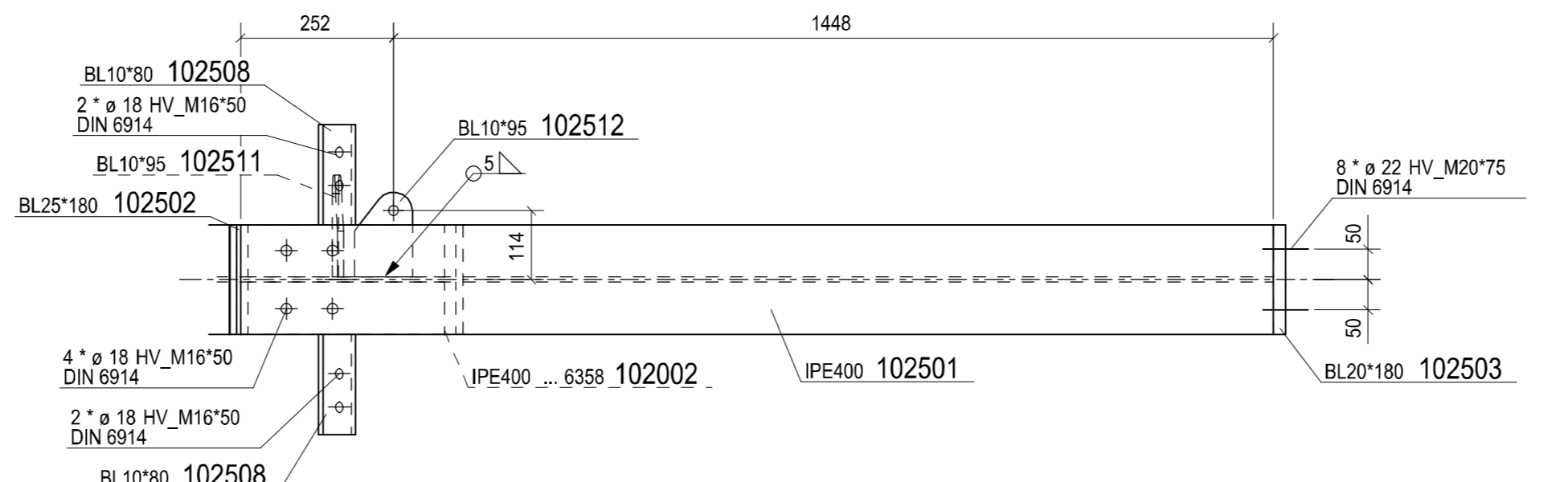
F - F



B - B



H - H



Schweißvorgaben		DIN EN 33 920-1 (DIN 9572-1)	
1. Allgemeine Anweisungen für Schweißkonstruktionen			
2. Schweißnähte / Darstellung und Symbole in Zeichnung	DIN EN 29 692		
3. Schweißnahtvorbereitung	a = 4mm		
4. Alle nicht benannten Kehlnähte	DIN EN 25 817		
5. Bewertungsgruppe der Schweißverbindung "Kehlnähte"	S		
6. Materialgröße und "Nenn von Prüfbescheinigungen"	<input checked="" type="checkbox"/> DIN EN 10 025 <input checked="" type="checkbox"/> S 355 J2 G3 <input checked="" type="checkbox"/> S 355 J2 G3	DIN 17 100 RSt 37-3 St 52-3 U St 52-3 N	DIN 50 049/DIN EN 10 204 mind. 2,2 mind. 3.1B mind. 3.1C
7. Wärmebehandlung (z.B. 100-120°C)	DIN EN 17 103 (DIN 52 524)		
8. Zwischenprüfung erforderlich	JA <input type="checkbox"/> NEIN <input type="checkbox"/>		
9. Besondere Abnahmepflicht erforderlich (siehe Zeichnungsteilung)	JA <input type="checkbox"/> NEIN <input type="checkbox"/>		

Schraubenaufstellung		Autorengezeichnete Anzechnen	
Schraube durch- messer	Ertrocknete Vorspannkraft	Schraube M02 gestrichelt verletzt	
		Schraube leicht gelb	
Mp	MN	kgm	Nm
M 12	5	80	12
M 16	10	160	25
M 20	16	240	40
M 24	22	320	60
M 27	28	448	80
M 30	35	595	110

Bauteil: Werkstattzeichnung Rahmen			Blatt-Nr.: 102		
Datum	Name	Index	Änderung/bemerk.	Datum	Pos.
gezeichnet 29.09.2011	Bigel				Teil
geprüft					L.V.
in AV					Dos.