section 106 , E-E

view 106 , G-G

** bill of material for 1 Ship- pos. 106 total 1 x done

Nr.	Tot	pos.	designation	qty	profil	quality	length	weight	Rem.
1		106		1	IPE400	S235JR+Z	5091	388.28	
2		1002		2	HEA140	S235JR+Z	315	15.58	
3		1015	STEGBLECH	1	BL1*1268	S235JR+Z	1071	57.66	
4		1027	KNOTENBLECH	1	BL12*338	S235JR+Z	265	8.39	
5		1033		2	BL10*278	S235JR+Z	217	10.04	
6		1035		1	BL20*260	S235JR+Z	470	28.81	
7		1069	PLATTE	1	BL15*100	S235JR+Z	1438	33.47	
8		1071	PLATTE	1	BL15*100	S235JR+Z	1122	23.79	
9		1076	PLATTE	1	BL35*100	S235JR+Z	400	22.75	
10		1116	PLATTE	2	FLT40*20	S235JR+Z	145	6.37	
11		1130	RIPPE	2	BL20*90	S235JR+Z	421	11.89	
12		1131	RIPPE	2	BL15*90	S235JR+Z	420	8.87	
total weight (kg)								613.98	
Shipping dimensions (H x B x L): 1917 x 581 x 5239									

view 106 , B-B

view 106 , A-A

section 106 , D-D

view 106 , H-H

view 106 , C-C

section 106 , F-F

view 107 , C-C

view 107 , B-B

section 107 , A-A

** bill of material for 1 Ship- pos. 107 total 1 x done

Nr.	Tot	pos.	designation	qty	profil	quality	length	weight	Rem.
1		107		1	IPE400	S235JR+Z	9031	598.78	
2		1073	PLATTE	1	BL25*100	S235JR+Z	513	16.19	
3		1076	PLATTE	1	BL35*100	S235JR+Z	400	22.75	
4		1084		2	BL15*171	S235JR+Z	330	13.25	
5		1100		2	BL15*137	S235JR+Z	86	3.17	
total weight (kg)								656.12	
Shipping dimensions (H x B x L): 315 x 195 x 9091									

view 108 , C-C

view 108 , B-B

section 108 , A-A

** bill of material for 1 Ship- pos. 108 total 1 x done

Nr.	Tot	pos.	designation	qty	profil	quality	length	weight	Rem.
1		108		1	IPE400	S235JR+Z	9031	598.78	
2		1073	PLATTE	1	BL25*100	S235JR+Z	515	16.19	
3		1076	PLATTE	1	BL35*100	S235JR+Z	400	22.75	
4		1084		2	BL15*171	S235JR+Z	330	13.25	
5		1100		2	BL15*137	S235JR+Z	86	3.17	
total weight (kg)								656.12	
Shipping dimensions (H x B x L): 315 x 195 x 9091									

section 110 , D-D

section 110 , F-F

view 110 , C-C

view 110 , B-B

view 110 , A-A

section 110 , E-E

view 110 , C-C

section 111 , B-B

view 111 , C-C

view 111 , D-D

section 111 , A-A

** bill of material for 1 Ship- pos. 111 total 1 x done

Nr.	Tot	pos.	designation	qty	profil	quality	length	weight	Rem.
1		111		1	IPE300	S235JR+Z	10254	591.19	
2		1066		2	BL15*108	S235JR+Z	151	6.68	
3		1074	PLATTE	1	BL25.5*140	S235JR+Z	465	15.43	
4		1075	PLATTE	1	BL25*180	S235JR+Z	465	16.43	
5		1084		2	BL15*171	S235JR+Z	330	13.25	
6		1101		2	BL15*157	S235JR+Z	81	2.98	
7		1134	RIPPE	4	BL12*90	S235JR+Z	338	8.45	
total weight (kg)								655.43	
Shipping dimensions (H x B x L): 328 x 200 x 10407									

section 112 , A-A

view 112 , D-D

view 112 , C-C

section 112 , B-B

view 109 , B-B

view 109 , A-A

** bill of material for 1 Ship- pos. 109 total 4 x done

Nr.	Tot	pos.	designation	qty	profil	quality	length	weight	Rem.
1		109		1	IPE400	S235JR+Z	9031	598.78	
2		1073	PLATTE	1	BL25*100	S235JR+Z	513	16.19	
3		1076	PLATTE	1	BL35*100	S235JR+Z	400	22.75	
total weight (kg)								637.72	
Shipping dimensions (H x B x L): 315 x 100 x 9091									

** bill of material for 1 Ship- pos. 112 total 1 x done

Nr.	Tot	pos.	designation	qty	profil	quality	length	weight	Rem.
1		112		1	IPE300	S235JR+Z	10354	596.19	
2		1059		2	BL15*205	S235JR+Z	172	8.29	
3		1074	PLATTE	1	BL25.5*180	S235JR+Z	465	16.43	
4		1075	PLATTE	1	BL25*180	S235JR+Z	465	16.43	
5		1084		2	BL15*171	S235JR+Z	330	13.25	
6		1101		2	BL15*157	S235JR+Z	81	2.98	
7		1134	RIPPE	4	BL12*90	S235JR+Z	338	8.45	
total weight (kg)								657.12	
Shipping dimensions (H x B x L): 328 x 200 x 10407									

** bill of material for 1 Ship- pos. 110 total 3 x done

Nr.	Tot	pos.	designation	qty	profil	quality	length	weight	Rem.
1		110		1	IPE400	S235JR+Z	6555	434.59	
2		1016	STEGBLECH	2	BL10*569	S235JR+Z	983	87.85	
3		1037		1	BL10*260	S235JR+Z	400	25.72	
4		1070	PLATTE	2	BL15*180	S235JR+Z	1191	50.47	
5		1072	PLATTE	2	BL15*180	S235JR+Z	327	19.31	
6		1073	PLATTE	2	BL25*100	S235JR+Z	513	16.18	
7		1133	RIPPE	2	BL15*85	S235JR+Z	372	7.43	
total weight (kg)								681.75	
Shipping dimensions (H x B x L): 2432 x 260 x 6600									

Tolerance for welded constructions
According to DIN 8570, PL1+3/BH1, 10.87

Welding (W P S) according to DIN-EN 288 - 2

All unmarked welds to be fillet continuous a=4mm thick, not greater than 0,7 d of the thinner element

The material for cap plates ≥20 mm thick to be examined for laminations

Required torque-prestressing forces and forced tension angles according to DIN 18800 Pt. 7, 05.83

1	2	3	4	5	6
Bolts	Required torque-prestressing force	Prestressing of HV bolts (Class 10.9) according to			Angle of rotation
		M bolts turned	M bolts ribbed		
		Inclined head, round nut, leg unmounted	Inclined head, round nut, leg unmounted	Twisted tightening torque		
	Fv	Mp	Mp	Mp		
	kN	Nm	Nm	Nm		
M12	70	100	90	80	60	1 x 0.08
M16	130	250	225	200		1 x 0.12
M20	200	490	440	390		1 x 0.16
M22	250	650	580	520		1 x 0.20
M24	290	820	730	650		1 x 0.24
M27	380	1200	1050	950		1 x 0.28
M30	460	1600	1450	1300		1 x 0.32
M36	670	2800	2500	2250		1 x 0.40

1) Due to the great dependence of the Mp data on the type of thread selected, adhere to the bolt manufacturer's recommendations.
2) Interchangeability of the bolts/nuts of the Strength steel grades 8.8 and 10.9.
CAUTION! The bolt galvanized HV bolts can vibrate from column 3.

Byggingarfulltrúi Hafnarfjarðar
Aðgreitt þann
03. jan. 2005

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Hannað / Teiknað	Kvarði: 1:15	Dagsetning: 31/10/05	Verknr.: 12-05	Teikn.nr.: 1-08