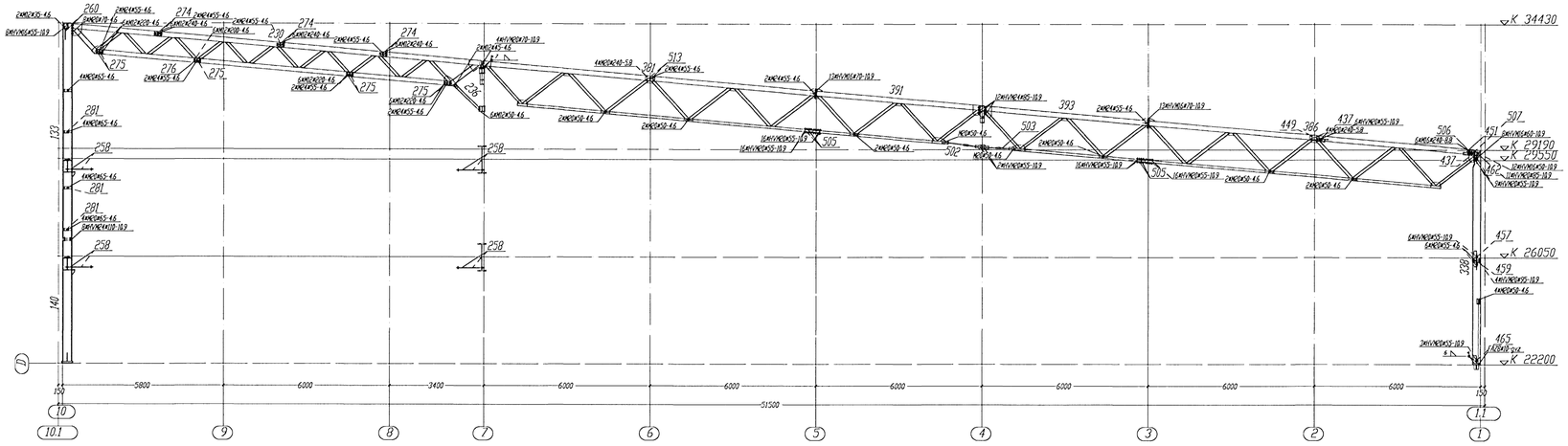
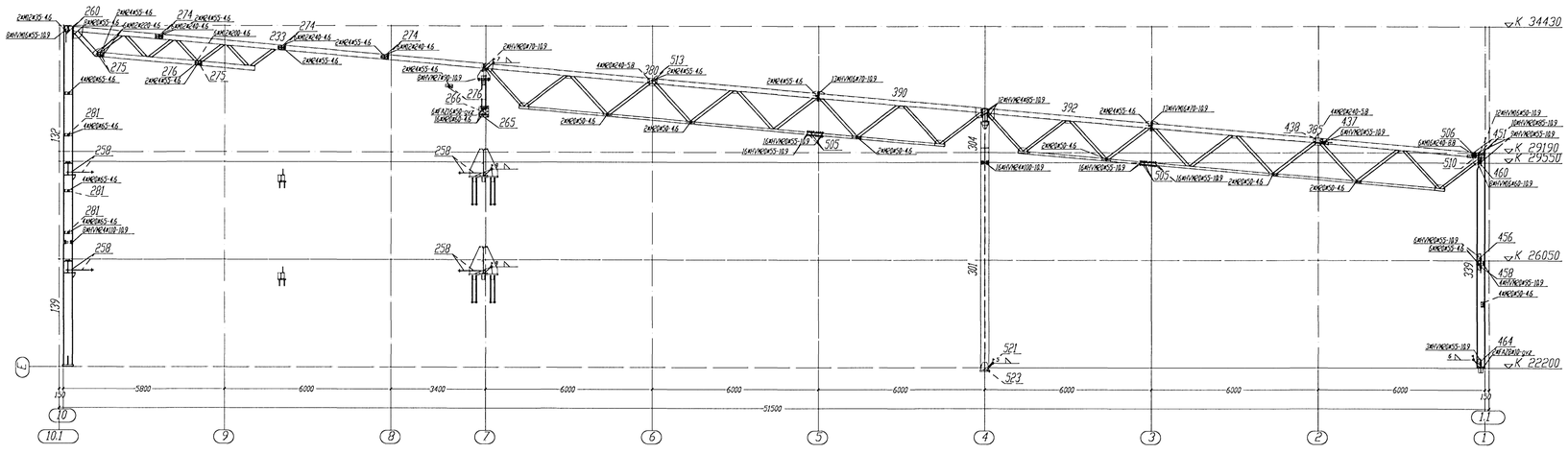
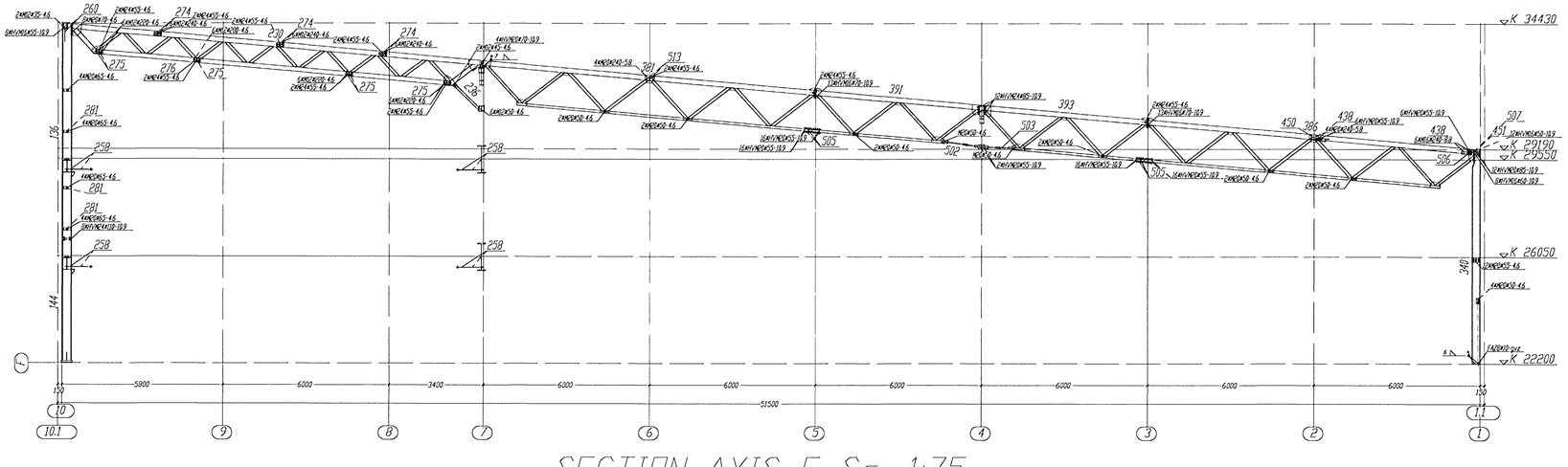


SECTION AXIS D Sc. 1:75



SECTION AXIS E Sc. 1:75



SECTION AXIS F Sc. 1:75

Fyrir hönd Conís ehf, kt. 600105-1400 staðfestist að teikning þessi hefur verið yfirfarin. Teikningin er í samræmi við íslenska staðla og reglugerðir. 28/9 '07

Nafn: Gunnar S. — Kennitala: 130657-4139

Tolerance for welded constructions According to DIN 8570, Pt.1+3/8+F,10.87

Welding (V 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 torques,prestressing forces and forced tension angles according to DIN 18800 Pt. 7, 0583

1	2	3	4	5	6							
			Prestressing of HV bolts Class 8.8 S according to									
Bolts	Required bolt preset tensile force F_v	α) Torque wrench		α) Torque controller		α) Angle of rotation Wrench						
		Manual torque wrench		Mechanical impact wrench (Pneumatic hammer)		Required tightening torque	Grip length		Angle of rotation	Bolt reduction		
		Required grip length range (washers incl.)	Max. torque	Max compressing force								
	kN	mm	Nm	kN	Nm	Nm						
1 M12	49	30	115	49	3	3	M12	16 & 1.00	30	1.0
2 M16	91	35	270	91	10	10	M16	18 & 1.00	30	0.9
3 M20	141	40	530	141	25	25	M20	20 & 1.00	30	0.9
4 M22	176	45	720	176	35	35	M22	22 & 1.00	30	1
5 M24	203	50	900	203	45	45	M24	24 & 1.00	30	1.0
6 M27	267	60	1250	267	65	65	M27	27 & 1.00	30	0.9
7 M30	324	65	1700	324	90	90	M30	30 & 1.00	30	0.9
8 M36	475	80	2500	475	160	160	M36	36 & 1.00	30	0.9

α) Due to the great dependence of the Nm value on the type of thread lubricant adhere to the bolt manufacturer's recommendations.
β) Independently on the lubricant of the threads and surfaces of bolts and nuts DASTUM for not grounded HV bolts can relaxs from column 5.

BIURO INZYNIERSKIE
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	DATE	NAME	SIGNATURE
Designed by	02.06.07	M.&J.M.	
Checked by			
Verified by			

INDEX	CHANGES	DATE	NAME
A	1st edition	02.06.07	M.&J.M.

DWG SCALE: SECTION AXIS D,E,F

DESC: TJARNARVELLIR 11 Steel Office part

DRAWING NO.: DRG 017a

SHEET: 3L