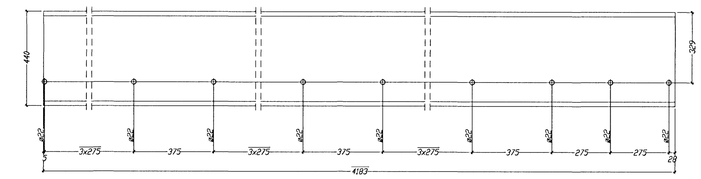
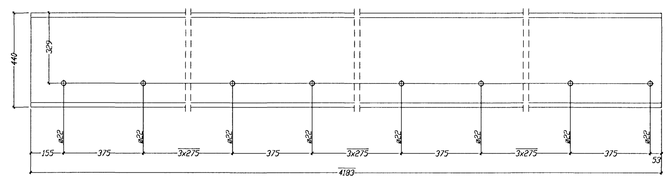


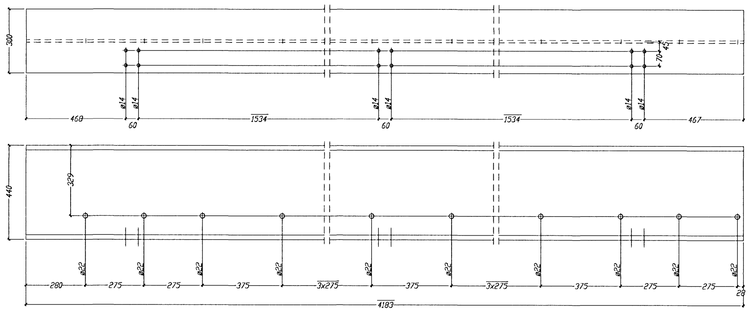
1 x Pos. 120

HEA450 - S355J2G3.4183



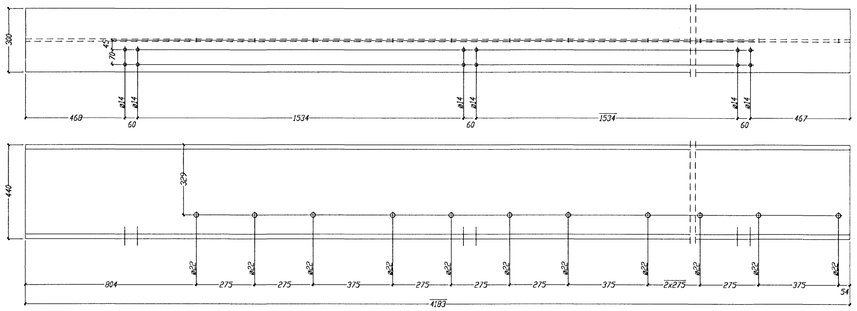
1 x Pos. 126

HEA450 - S355J2G3.4183



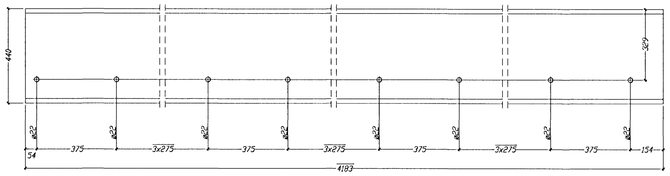
1 x Pos. 121

HEA450 - S355J2G3.4183



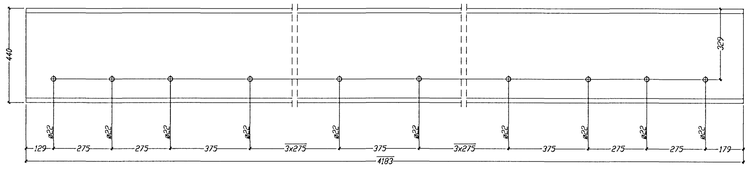
1 x Pos. 127

HEA450 - S355J2G3.4183



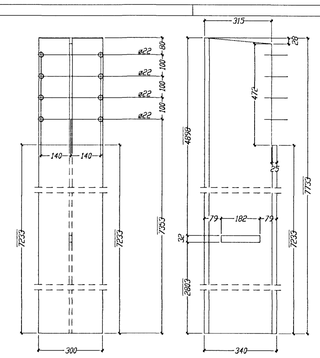
1 x Pos. 122

HEA450 - S355J2G3.4183



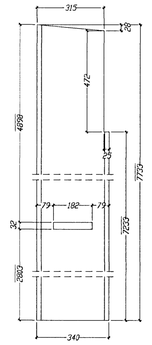
1 x Pos. 128

HEA450 - S355J2G3.4183



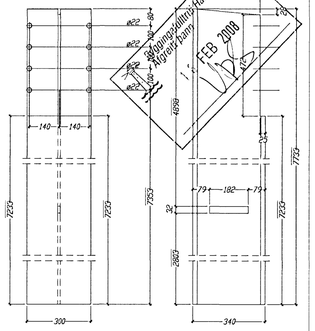
1 x Pos. 132

HEB340 - S235J2G3.7733



1 x Pos. 133

HEB340 - S235J2G3.7733



1 x Pos. 134

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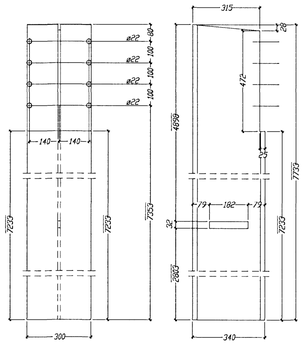

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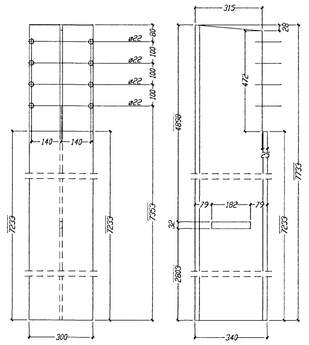
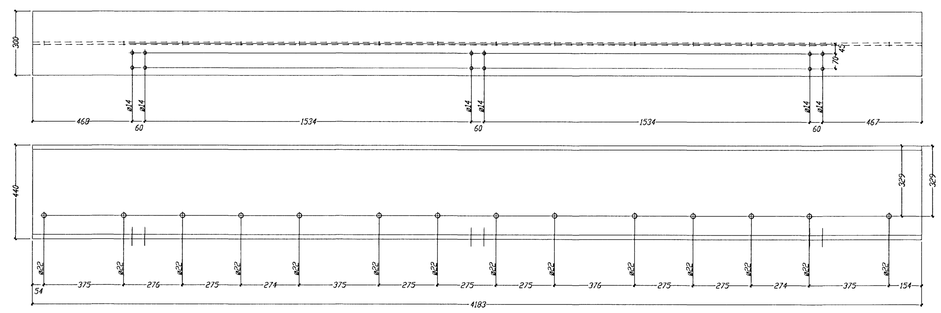
HEB340 - S235J2G3.7733



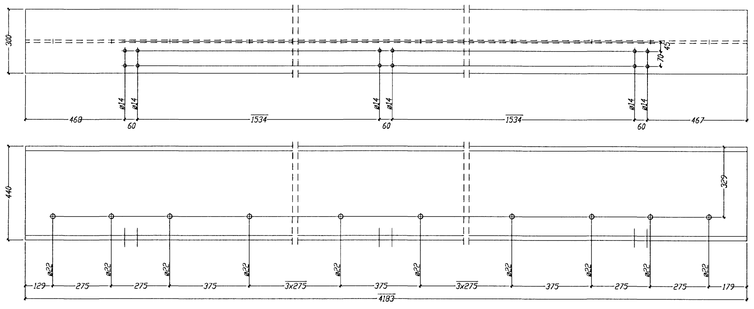
1 x Pos. 136

HEB340 - S235J2G3.7733



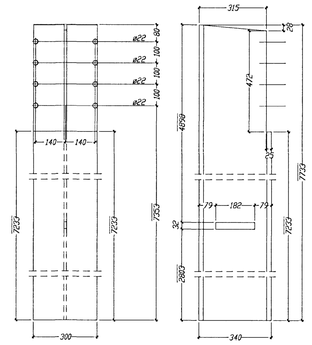
1 x Pos. 123

HEA450 - S355J2G3.4183



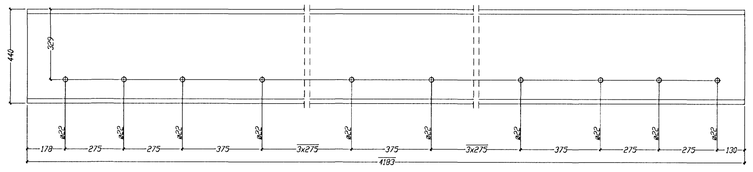
1 x Pos. 129

HEA450 - S355J2G3.4183



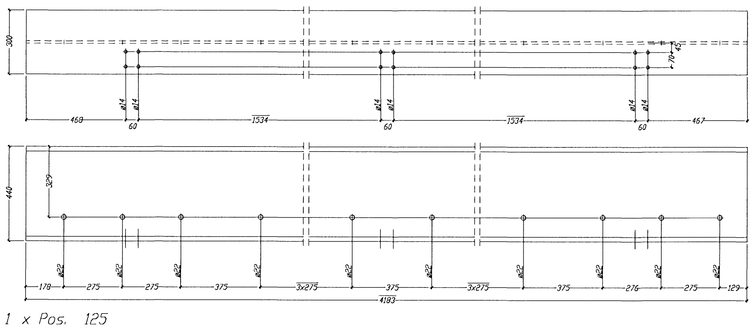
1 x Pos. 137

HEB340 - S235J2G3.7733



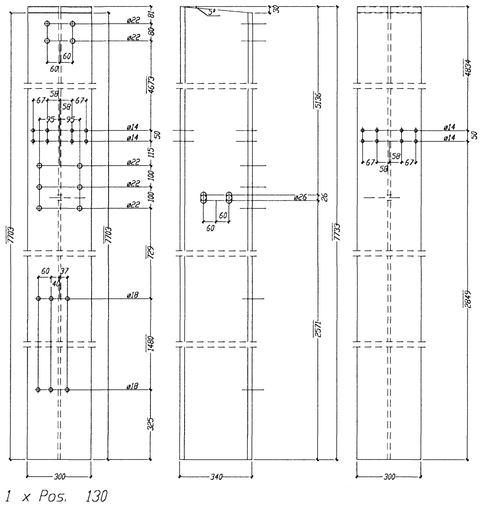
1 x Pos. 124

HEA450 - S355J2G3.4183



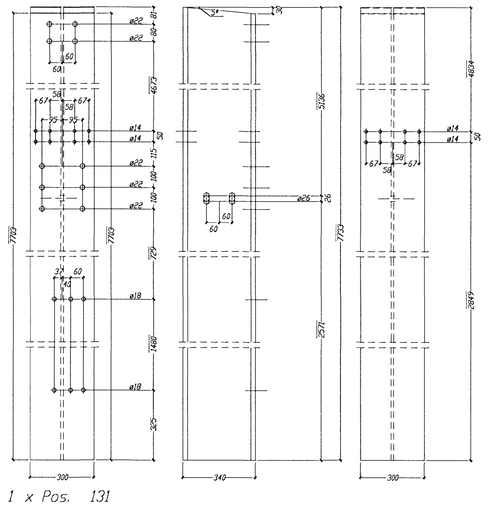
1 x Pos. 125

HEA450 - S355J2G3.4183



1 x Pos. 130

HEB340 - S235J2G3.7733



1 x Pos. 131

HEB340 - S235J2G3.7733

Fyrir hönd Conís ehf, kt. 600105-1400 staðfestist að teikning þessi hefur verið yfirfarin. Teikningin er í samræmi við íslenska staðla og reglugerðir. 29/9 07

Nafn — Kennitala

Tolerance for welded constructions According to DIN 8570, Pt.1+3/84F,1087

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 120 mm thick to be examined for lamnations

Required torquepretressing forces and forced tension angles according to DIN 18800 Pt. 7, 05.83

1	2	3	4	5	6				
Bolts	Required pretressing force Fv	Prestressing of the bolts Class 10.9 according to: a) Torque Method: Normal torque wrench: Required setting torque MA (Nm) for lubricated bolts a)	b) Rotation Method: Impact wrench: Req. impression Range	Required tightening turn-over	a) Appl. of rotation Methods: Grip length	Appl. of rotation	Bolt, Nut, Washer		
	kN	M	Nm	M	Nm				
M12	59	100	100	30	30	M12	0.5 D	30	0.2
M16	113	210	210	35	70	M16	0.5 to 1.0 D	70	0.15
M20	176	410	400	35	130	M20	0.5 to 1.0 D	130	0.1
M22	218	550	550	40	180	M22	0.5 to 1.0 D	180	0.1
M24	255	710	700	40	240	M24	0.5 to 1.0 D	240	0.1
M27	330	1000	1000	45	360	M27	0.5 to 1.0 D	360	0.1
M30	405	1350	1350	45	490	M30	0.5 to 1.0 D	490	0.1

a) Due to the great dependence of the Nm value on the type of thread lubricant, adhere to the bolt manufacturer's recommendations.
b) Independently on the lubricant of the threads and surfaces of bolts and nuts. DACROMET or Hot galvanized HV bolts use values from column 3.

BIURO INZYNIERSKIE
Marek i Janina MUCHA
Osiny, ul. Opolska 30a, 46-070 Komprachcice tel.077-46 46 757

	DATE	NAME	SIGNATURE
Designed by	28.08.07	MUCHA	
Drafted by			
Verified by			

NR.	CHANGES	DATE	NR.

SCALE

Simple parts 120 - 137

DESC.

TJARNARVELLIR 11
Steel Office part

DRAWING

DRAWING NO.

DRG 132

SHEET

BL.