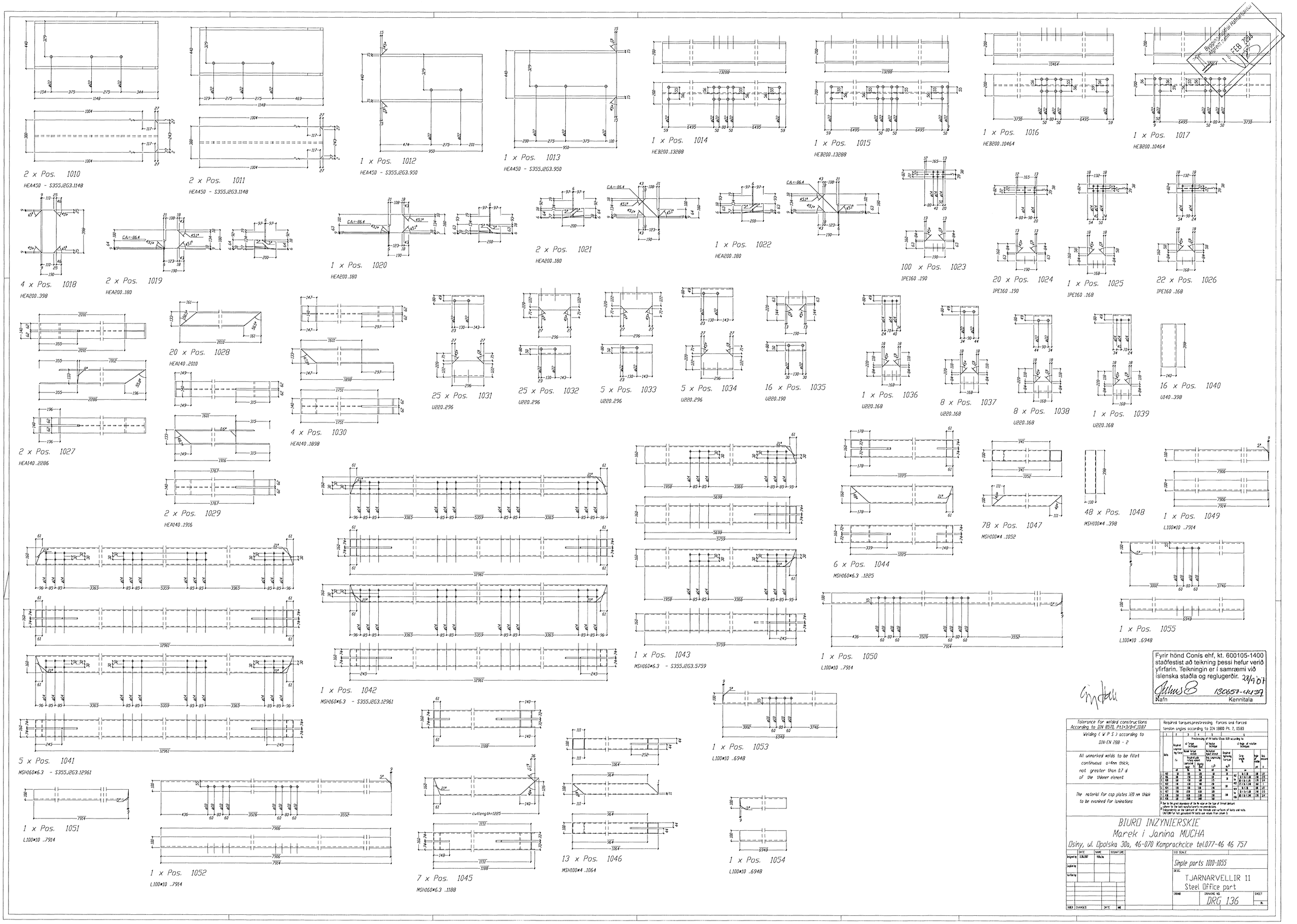

Fyrir hönd Conís ehf, kt. 600105-1400 staðfestist að teikning þessi hefur verið yfirfarin. Teikningin er í samræmi við íslenska staðla og reglugerðir. 28/9'07

Nafn — Kennitala 130657-4139

Tolerance for welded constructions According to DIN 8570, Pt.1+3/3+5,1987

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 torquesprestressing Forces and forces tension angles according to DIN 18800 Pt. 7, 0583

					1	2	3	4	5				
					Provisioning of HV bolts Class 8.8 according to								
	Bolts	Required prestressing Force Fv	a) Torque wrench		b) Turn of nut				a) Angle of rotation tolerances				
			Nominal torque value		Rotation angle method		Method of impact wrench		Grip length		Angle of rotation tolerance		Bolt, nut, washer
			Required grip length for torque wrench	Grip length	Required grip length for rotation angle method	Grip length	Required grip length for impact wrench	Grip length	Grip length				
		kN	Nm	mm	Nm	mm	Nm	mm	mm		°	μm	
1	M12	70	110	1.5	110	1.5	110	1.5		M	A	0.1	LUT
2	M16	130	270	2.0	270	2.0	270	2.0	3	M	B	0.1	LUT
3	M20	210	470	2.0	470	2.0	470	2.0		M	C	0.1	LUT
4	M22	270	630	2.0	630	2.0	630	2.0	3	M	A	0.1	T
5	M24	310	810	2.0	810	2.0	810	2.0		M	B	0.1	LUT
6	M27	390	1100	2.0	1100	2.0	1100	2.0	3	M	C	0.1	LUT
7	M30	490	1500	2.0	1500	2.0	1500	2.0		M	A	0.1	LUT
8	M36	710	2600	2.0	2600	2.0	2600	2.0	3	M	B	0.1	LUT

1) Due to the great dimensions of the fit bolts use the type of bmd lubrant where to the bolt manufacturer's recommendation.
2) Independently on the lubricant of the threads and surfaces of bolts and nuts.
CAUTION For 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	12.06.07	MAUNA	
Checked by			
Verified by			
DATE	CHANGES	DATE	NAME

JOB SCALE

Simple parts 1010-1055

DESC.

TJARNARVELLIR 11
Steel Office part

DRAWING NO. DRG 136

SHEET