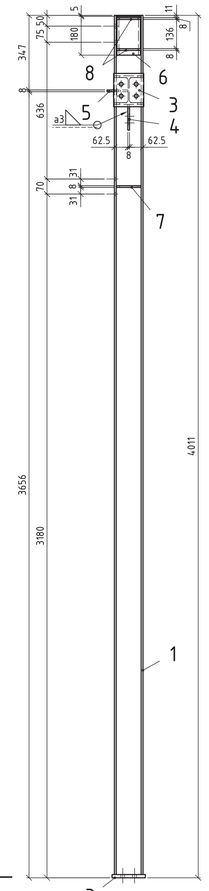
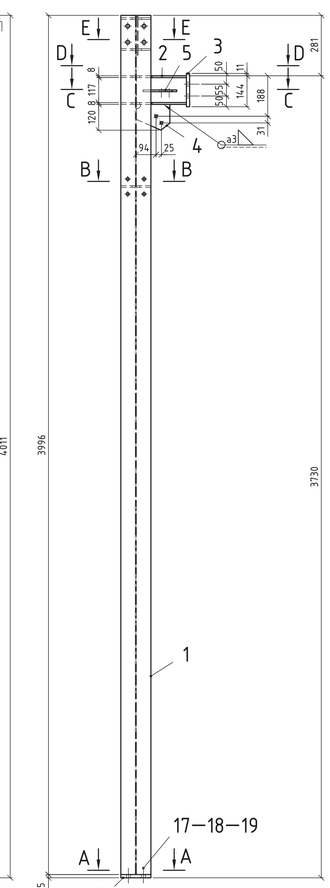
Zugehörige Zeichnungen

Zeichn.-Nr.	Benennung

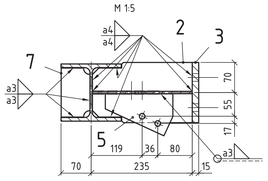
Schnitt A-A
M 1:5



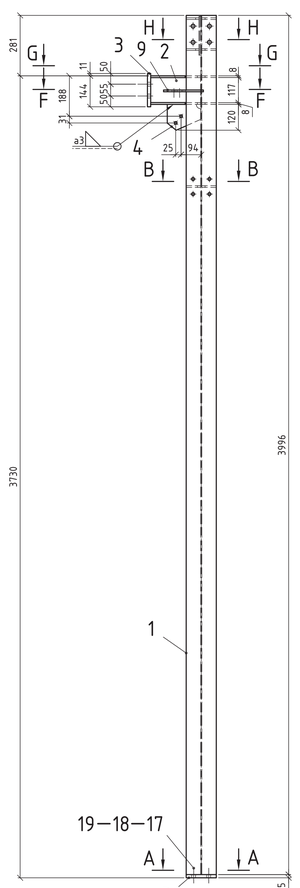
Schnitt B-B
M 1:5



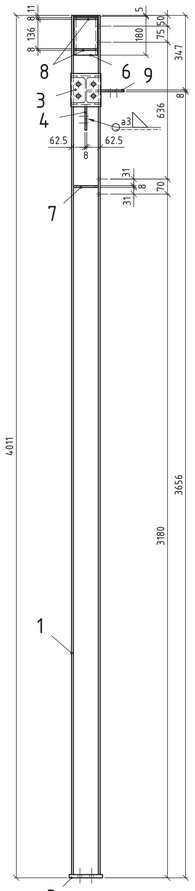
Schnitt C-C
M 1:5



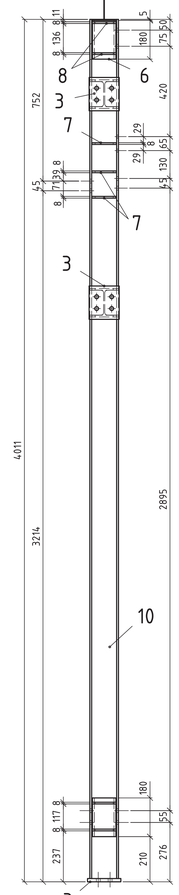
Schnitt F-F
M 1:5



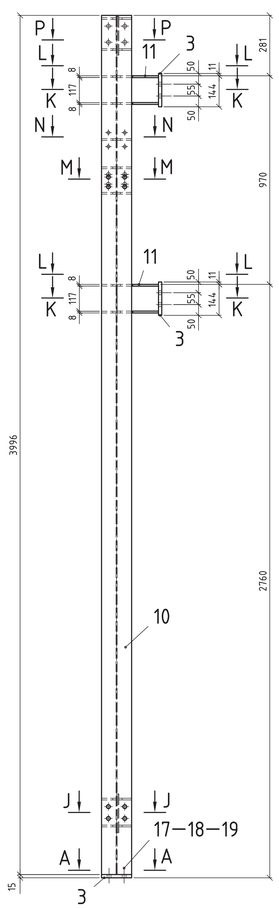
Schnitt G-G
M 1:5



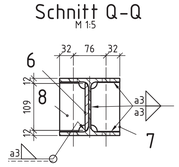
Schnitt H-H
M 1:5



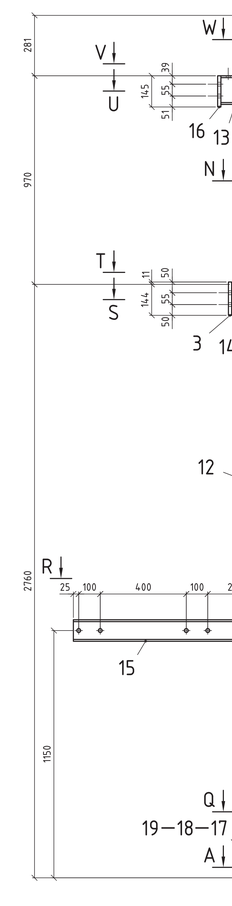
Schnitt J-J
M 1:5

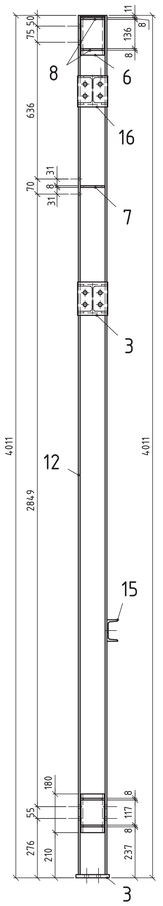


Schnitt Q-Q
M 1:5

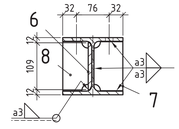


Schnitt R-R
M 1:10

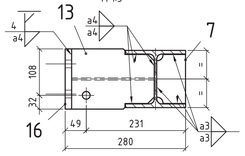




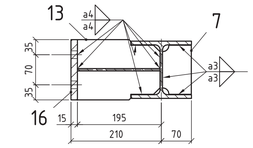
Schnitt W-W
M 1:5



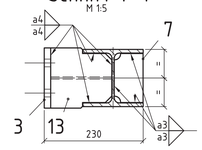
Schnitt V-V
M 1:5



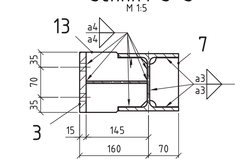
Schnitt U-U
M 1:5



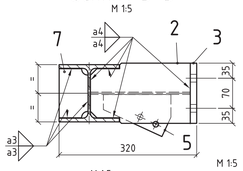
Schnitt T-T
M 1:5



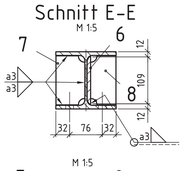
Schnitt S-S
M 1:5



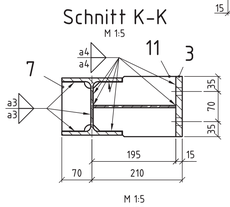
Schnitt D-D
M 1:5



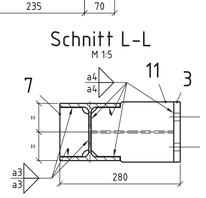
Schnitt E-E
M 1:5



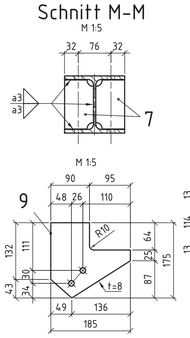
Schnitt K-K
M 1:5



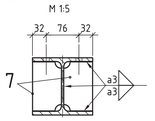
Schnitt L-L
M 1:5



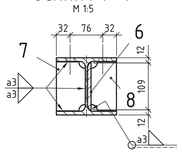
Schnitt M-M
M 1:5

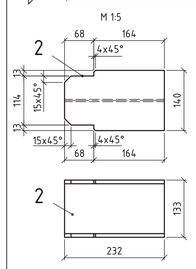


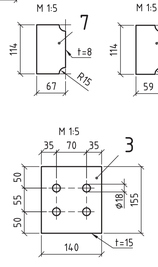
Schnitt N-N
M 1:5

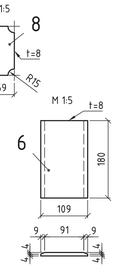


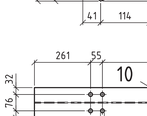
Schnitt P-P
M 1:5



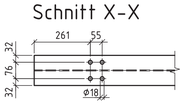


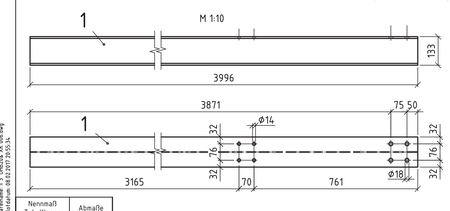


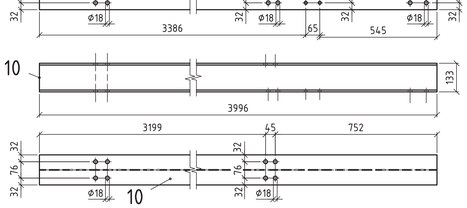


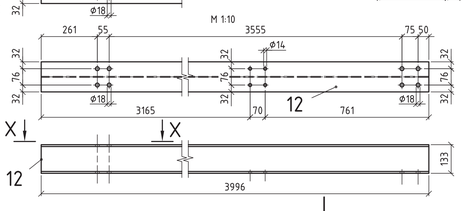


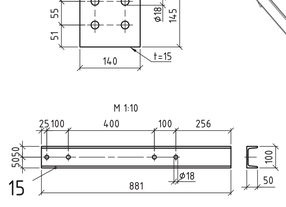
Schnitt X-X



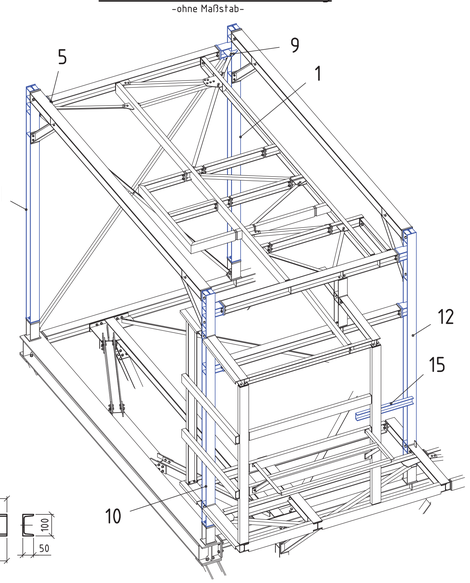








Schematische Darstellung
-ohne Maßstab-



Vorspannkräfte und Anziehmomente für SL-Verbindungen nach DIN EN 1090-2 u. DIN EN 1993-1-8 (EC3) für
HV-Schrauben gem. DIN EN 14399-4 bzw.
HVP-Schrauben gem. DIN EN 14399-8, Schraubengüte 10.9 :

Schraube	volle Vorspannkraft	Regelvor-	Anziehmoment, kombiniertes Verfahren
	$F_{p,C}$ [kN]	$F_{p,C}$* [kN]	wie hergestellt aber Teilverdrehwinkel und M052 (leder gleichwertig) beachtet $M_{A,KV}$ [Nm]
M 12	59	50	75
M 16	110	100	190
M 20	172	160	340
M 24	247	220	600
M 27	321	290	940
M 30	393	350	1240
M 36	572	510	2100

Die Regelvorspannkraft dient der "Qualitätssicherung" der Gebrauchstauglichkeit und der "nicht voll vorgespannten Verbindung".
Alle nicht näher bezeichneten HV-Schrauben sind mit $F_{p,0}$=0,5 $F_{p,C}$ x vorzuspannen.

Schweißvorschriften		
Bewertungsgruppe		DIN EN ISO 5817- C
Nichtbenahte Schweißnähte	Nahtdicke und Symbol	a4
Thermisches Schneiden	Qualität und Toleranzklasse	DIN EN ISO 9013- 332
Allgemeintoleranz	Toleranzklasse	DIN EN ISO 13920- BF
Wärmebehandlung	Spannungsarm geglüht	Ja ☐ Nein ☐
	Abnahmeprüfzeugnis TKS-N 237047	Ja ☐ Nein ☐
Schweißung	Abnahmeprüfzeugnis TKS-N 237049	Ja ☐ Nein ☐
Weitere Festlegungen sind in der Fertigungszeichnung angegeben.		

neue Anlagenteile

Hierzu gehören die Montagezeichnungen:
=3 UHB20& XK/001 und =3 UHB20& XK/002

Alle nicht bemaßten Schweißnähte dicht a=4mm

..... mal nach Stückliste ausführen

1.0038 / S235JR

Pos	Benenung Norm-Kurzbezeichnung	Nennblatt-Nr. / Zeichnungs-Nr. / Abmessung (Breite x Dicke x Länge)	Werkstoff-Nr./Kurzname Bemerkung	Stück	Einzel- Gewicht kg	Gesamt- Gewicht kg
19	HV-Scheibe	EN 14399-6 / 17	C45	32		0.00
18	HV-Mutter	EN 14399-4 / M16	10	16		0.00
17	HV-Schrb.	EN 14399-4 / M16 x 60	10.9	16		0.00
16	Blech	EN 10029 / 140x15x145	S235JR	1	2.39	2.39
15	U100	EN 10279 / 881	S235JR	1	9.34	9.34
14	HEA140	EN 10034 / 142	S235JR	1	3.51	3.51
13	HEA140	EN 10034 / 192	S235JR	1	4.74	4.74
12	HEA140	EN 10034 / 3996	S235JR	1	98.70	98.70
11	HEA140	EN 10034 / 192	S235JR	2	4.74	9.48
10	HEA140	EN 10034 / 3996	S235JR	1	98.70	98.70
9	Blech	EN 10029 / 175x8x185	S235JR	1	2.03	2.03
8	Blech	EN 10029 / 59x8x114	S235JR	12	0.42	5.04
7	Blech	EN 10029 / 671x8x114	S235JR	36	0.48	17.28
6	Blech	EN 10029 / 109x8x180	S235JR	6	1.23	7.38
5	Blech	EN 10029 / 98x8x157	S235JR	1	0.97	0.97
4	Blech	EN 10029 / 120x8x155	S235JR	2	1.17	2.34
3	Blech	EN 10029 / 140x15x155	S235JR	9	2.56	23.04
2	HEA140	EN 10034 / 232	S235JR	2	5.73	11.46
1	HEA140	EN 10034 / 3996	S235JR	2	98.70	197.40

Nennmaß | Tol.-Klasse | Abmaße

Datenname: =3 UHB20& XK 006.dwg
Plotdatum: 08.02.2017 20:53:14

13.01.2012