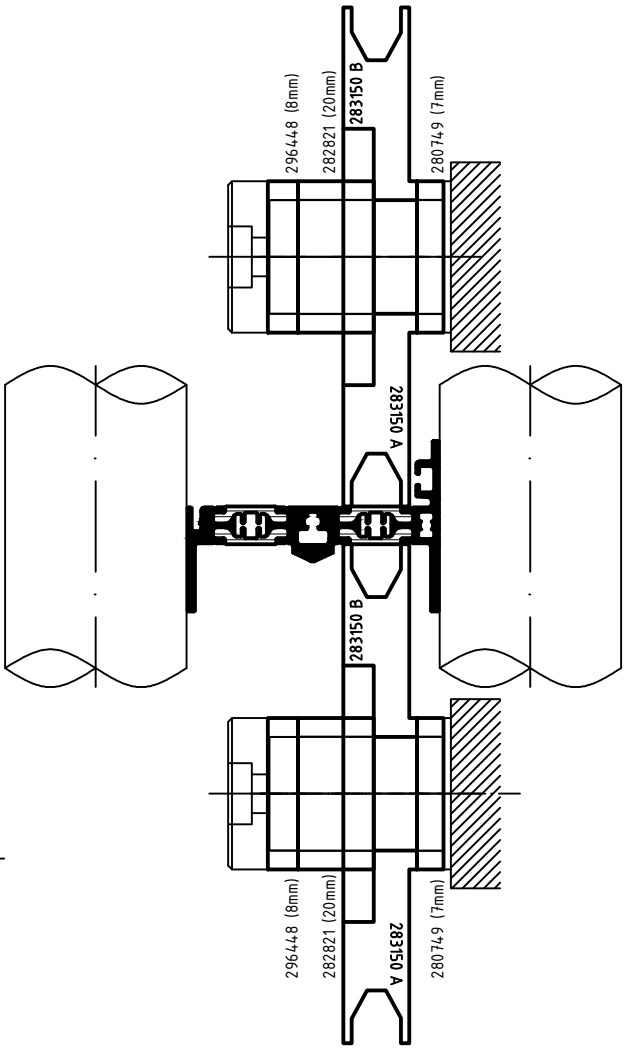
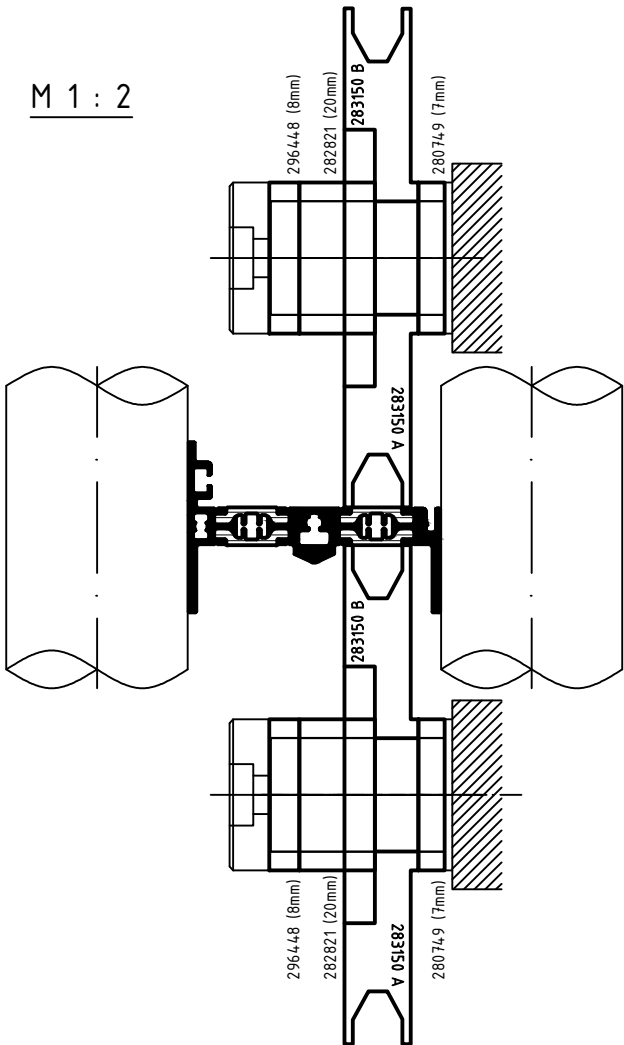


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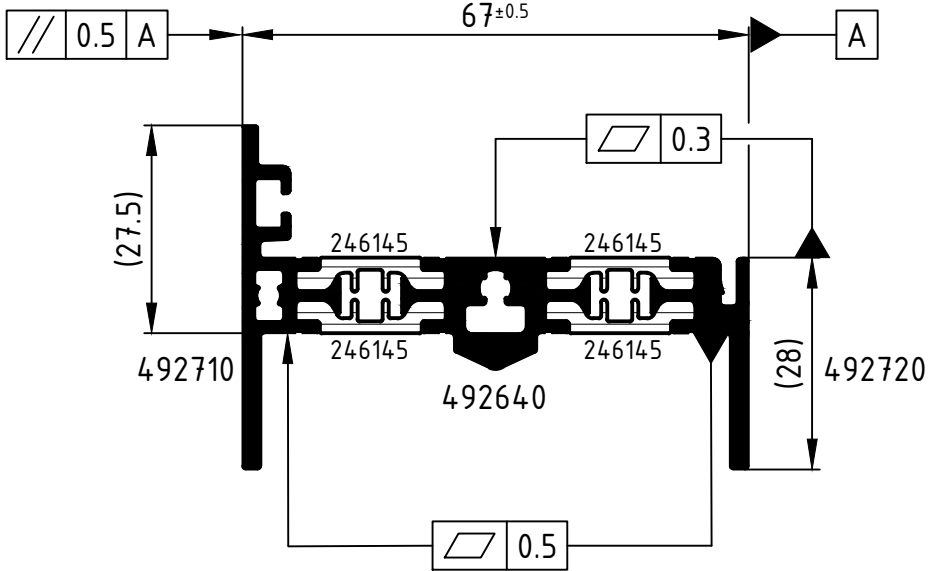
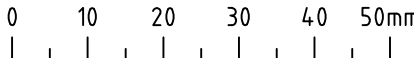
# 1. Stage



## 2. Stage

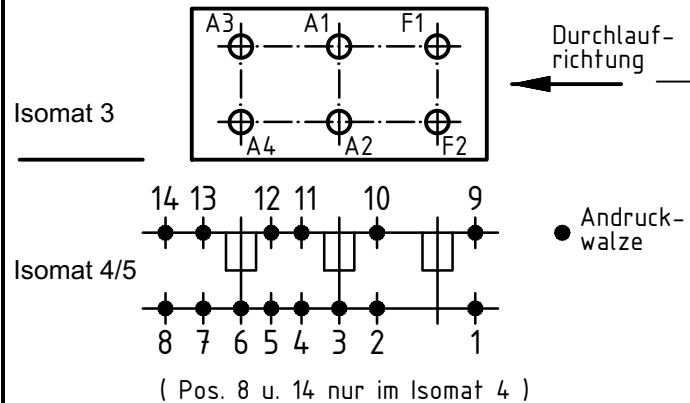
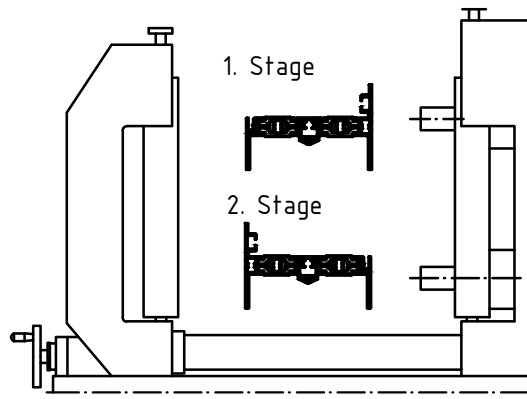


M 1 : 2



Roll in 2 stages.

**Achtung:** The result of the rolling process has to be checked on the basis of the reference dimensions in this roller plan. Please note the examination advices of the current roller manual



|    |      |                                        |                                      |                                                                                 |    | Stck. | Art.-Nr. Zubehör     |  |
|----|------|----------------------------------------|--------------------------------------|---------------------------------------------------------------------------------|----|-------|----------------------|--|
|    | Qty. | Art.-Nr.<br>Art.-No.<br>für Isomat 3/5 | Art.-Nr.<br>Art.-No.<br>für Isomat 4 | Bestückungsfolge (v. innen nach außen)<br>Assembly sequence (inside to outside) |    | Qty.  | Art.-No. Accessories |  |
|    |      |                                        |                                      |                                                                                 | R1 | 5     | 280749 ( 7.0 mm)     |  |
|    |      |                                        |                                      |                                                                                 | R2 | 5     | 282821 (20.0 mm)     |  |
|    |      |                                        |                                      |                                                                                 | R3 | 5     | 296448 ( 8.0 mm)     |  |
| A1 | 1    | 283150 B                               | 283150 B                             | R1/A1/R2/R3                                                                     |    |       |                      |  |
| A2 | 1    | 283150 B                               | 283150 B                             | R1/A2/R2/R3                                                                     |    |       |                      |  |
| A3 | 1    | 283151 B                               | 283150 B                             | R1/A3/R2/R3                                                                     |    |       |                      |  |
| A4 | 1    | 283151 B                               | 283150 B                             | R1/A4/R2/R3                                                                     |    |       |                      |  |
| F1 | 1    | 283149 B                               |                                      | R1/F1/R2/R3                                                                     |    |       |                      |  |
| F2 | 1    | 264023                                 |                                      |                                                                                 |    |       |                      |  |

|                                                       |                          |                                               |                                        |      |                                                                                         |                                                                                                              |
|-------------------------------------------------------|--------------------------|-----------------------------------------------|----------------------------------------|------|-----------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------|
|                                                       |                          | Zulässige Abweichung<br>Permissible tolerance | Oberflächenabwicklung<br>Circumference |      | VP<br>PU                                                                                | Info-Plan:                                                                                                   |
|                                                       |                          |                                               | mech.<br>polished                      | —    | Maßstab<br>Scale<br><b>1 : 1</b>                                                        | Gewicht<br>Weight                                                                                            |
|                                                       |                          |                                               | uml.<br>total                          |      |                                                                                         |                                                                                                              |
| Paßmaße<br>Close tol.                                 | Abmaße<br>Std. tolerance |                                               |                                        |      |                                                                                         |                                                                                                              |
| Original / Änderung<br>Revision / Version <b>0302</b> |                          |                                               | Datum<br>Date                          | Name | Werkstoff<br>Material                                                                   | <div style="text-align: center;"> <h1>Rollenplan</h1> <h2>Isomat 3/4/5</h2> <h3>Schüco ASE 67 PD</h3> </div> |
| Name                                                  |                          | <b>12.10.2018</b>                             |                                        |      |                                                                                         |                                                                                                              |
| Englische ersetzt                                     |                          | gez.<br>drawn                                 | Finkemeyer, C.                         |      |                                                                                         |                                                                                                              |
| Italienische Variante                                 |                          | gepr.<br>checked                              | Winkler, A.                            |      |                                                                                         |                                                                                                              |
|                                                       |                          | ges.<br>seen                                  | Nienhüser, R.                          |      |                                                                                         |                                                                                                              |
|                                                       |                          |                                               |                                        |      |                                                                                         |                                                                                                              |
|                                                       |                          | <b>SCHÜCO</b>                                 |                                        |      | Zeichn.-Nr.<br>Drawing No.                                                              | <b>481640 RP 1000</b>                                                                                        |
|                                                       |                          |                                               |                                        |      | EDV erstellt<br>Ohne Unterschrift gültig<br>generated by EDP<br>valid without signature | Ersatz für<br>Replacement<br>for                                                                             |