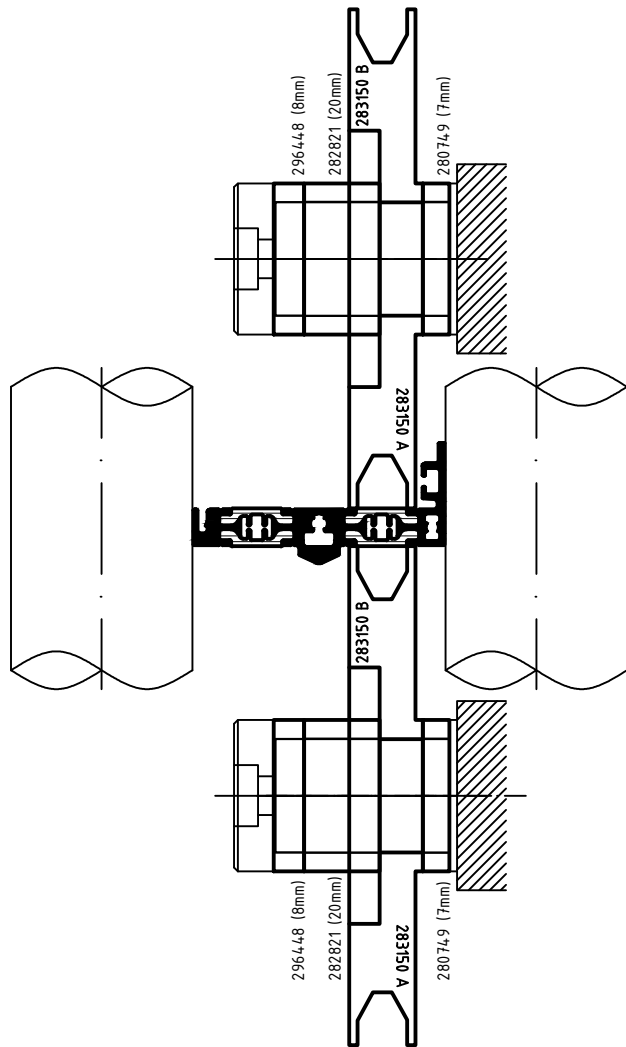
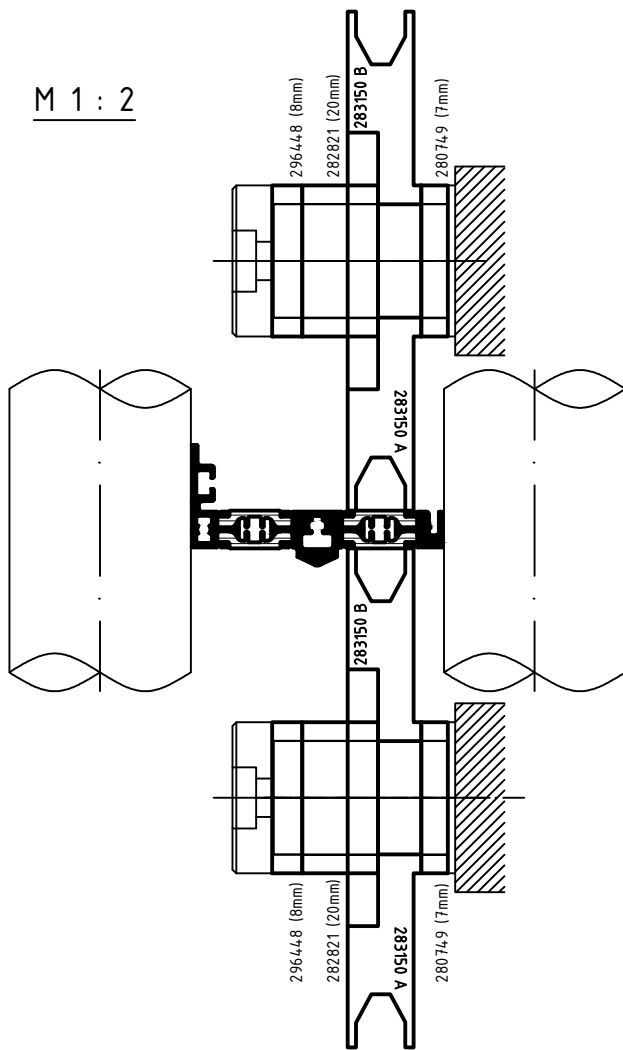


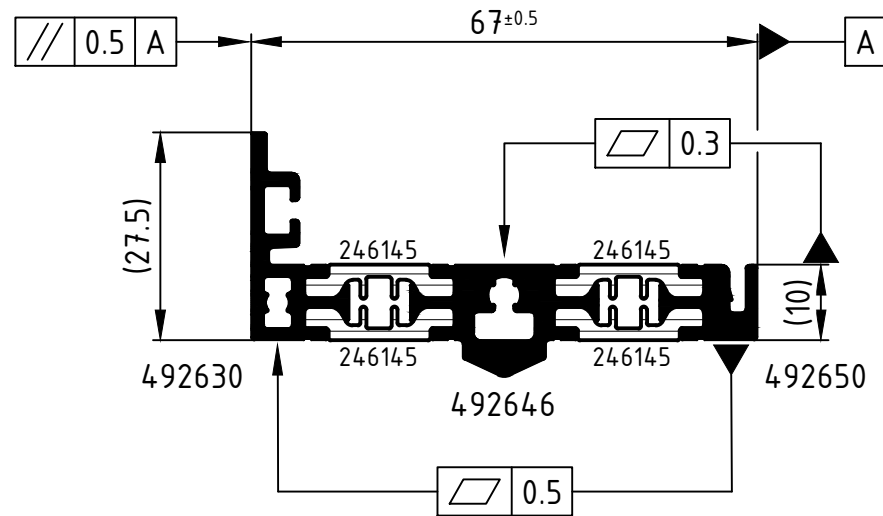
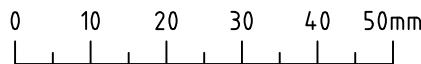
1. Stage



2. Stage

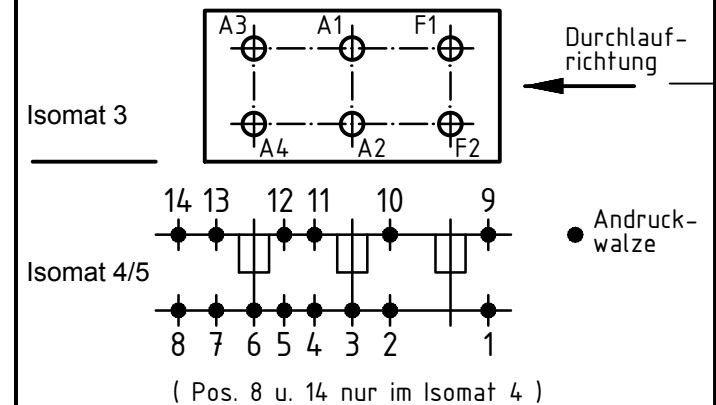
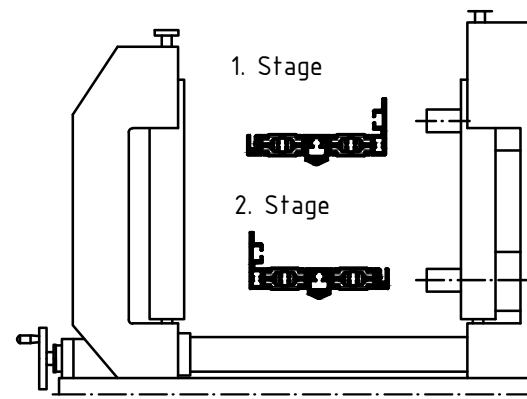


M 1 : 2



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

		Zulässige Abweichung Permissible tolerance	Oberflächenabwicklung Circumference		VP PU	Info-Plan:
			mech. polished	—		
			uml. total		Maßstab Scale	Gewicht Weight
Paßmaße Close tol.	Abmaße Std. tolerance					
Original / Änderung Revision / Version		0100	Datum Date	Name	Werkstoff Material	
Name			16.02.2021		Benennung Title	
		gez. drawn	Finkemeyer, C.		Rollenplan Isomat 3/4/5 Schüco ASE 67 PD	
		gepr. checked	Winkler, A.			
		ges. seen	Nienhüser, R.			
					Zeichn.-Nr. Drawing No.	
					513630 RP 1000	
		EDV erstellt Ohne Unterschrift gültig generated by EDP valid without signature		Ersatz für Replacement for		