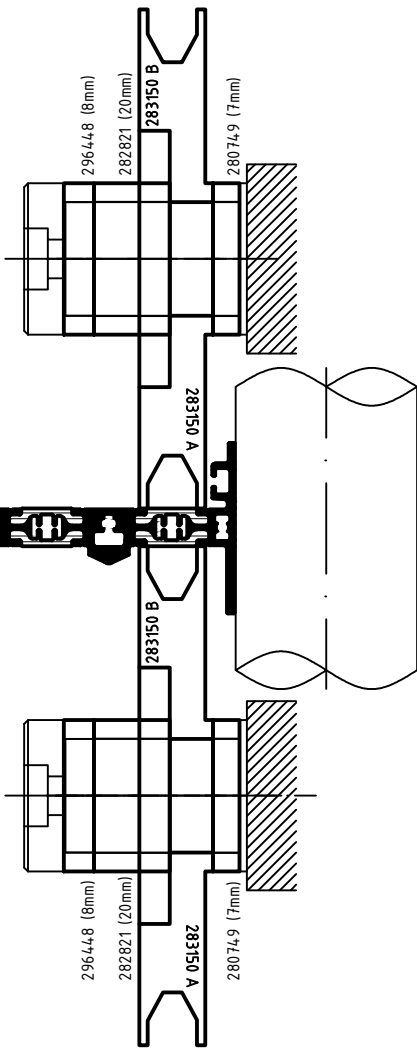
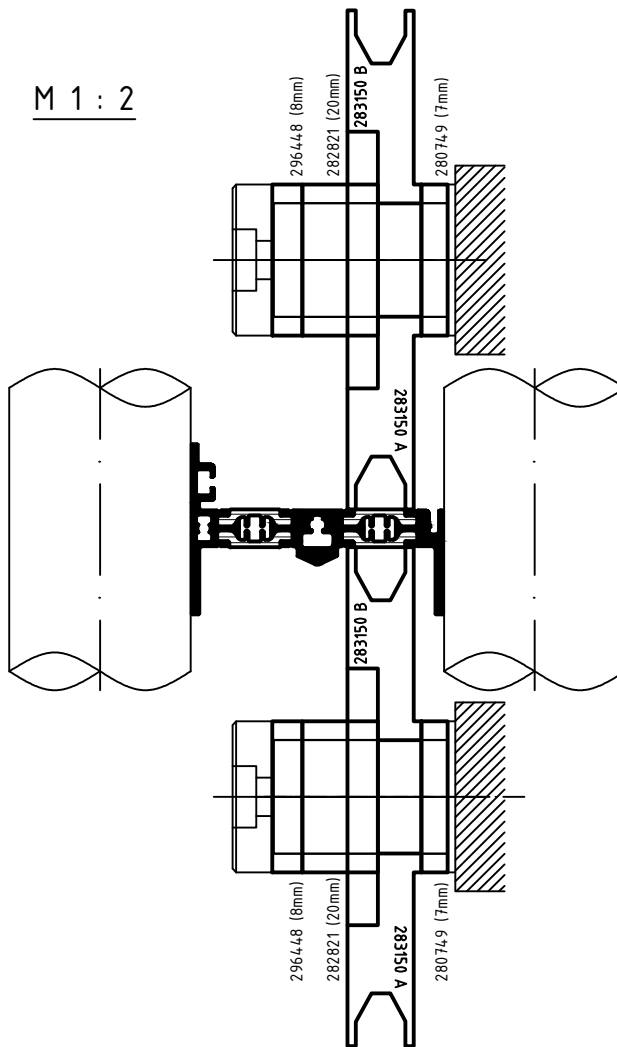
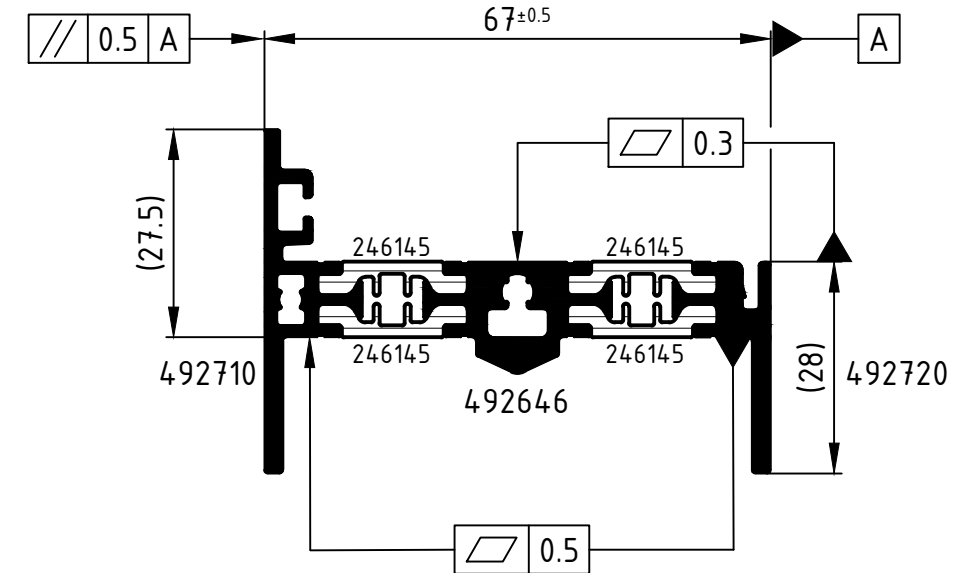
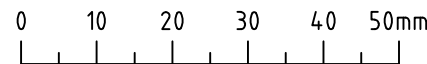


1. Stage

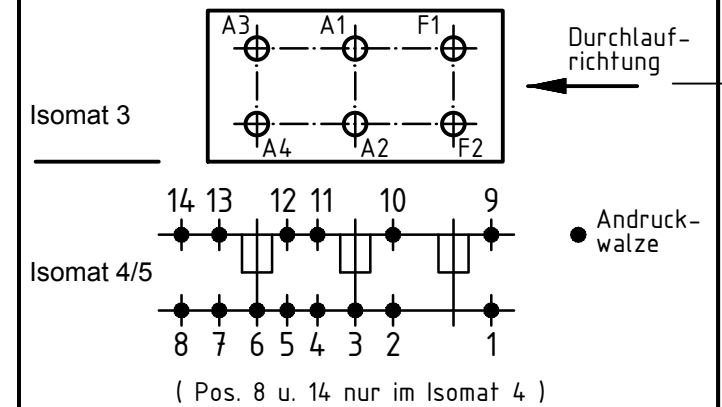
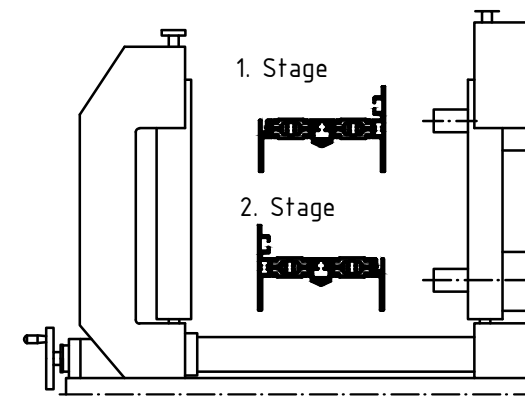


2. Stage

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
Attention: roller plan. Please note the examination advices of the current roller manual



	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)		Stck. Qty.	Art.-Nr. Zubehör Art.-No. Accessories
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					1 : 1	
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.		
					513640 RP 1000		
					EDV erstellt Ohne Unterschrift gültig generated by EDP valid without signature		
					Ersatz für Replacement for		