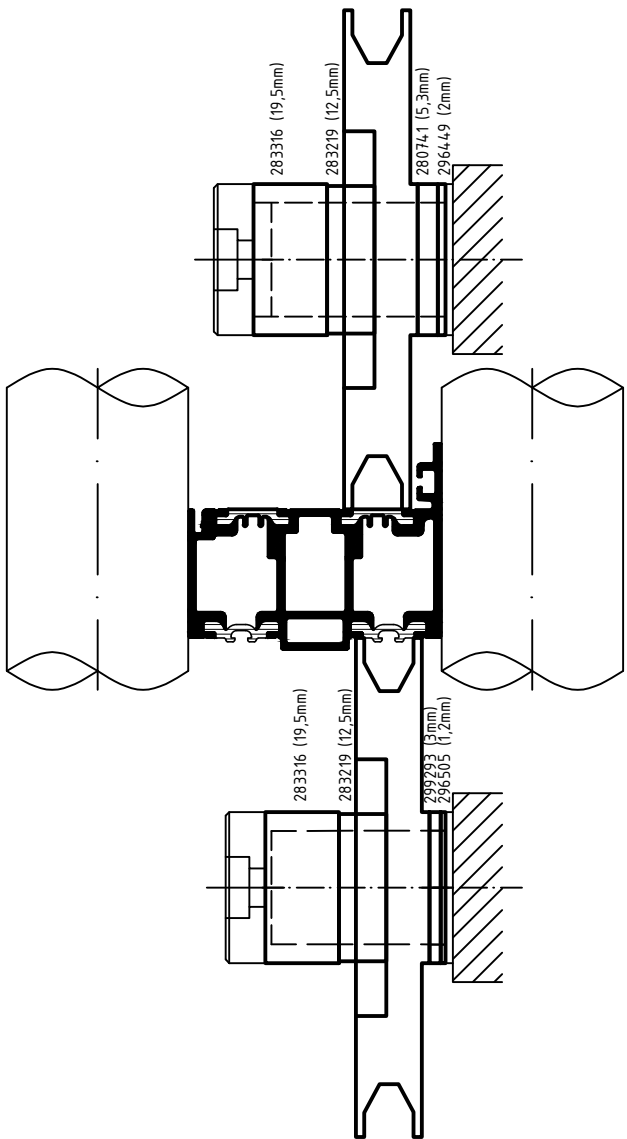
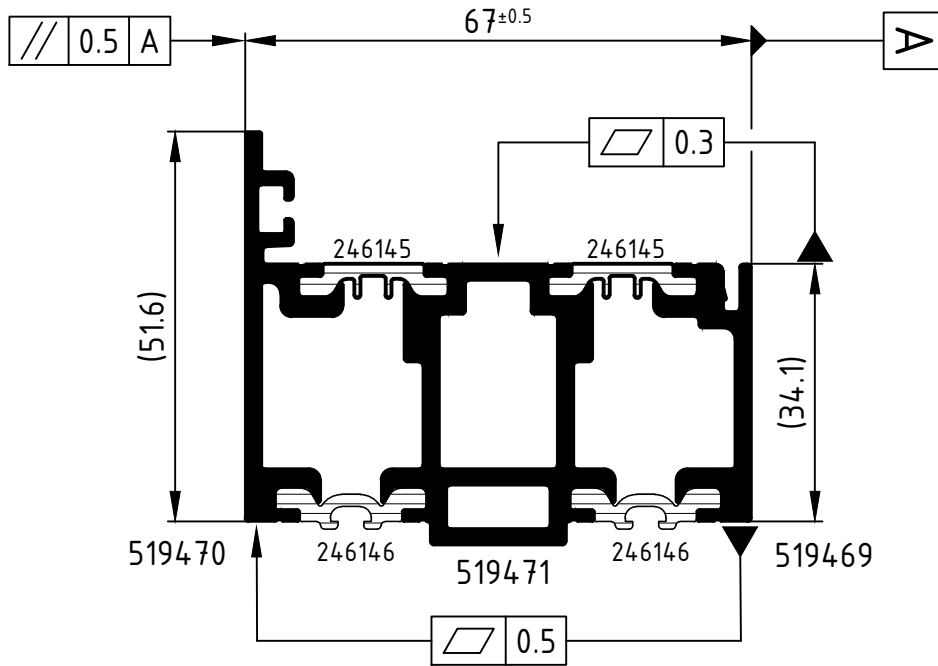
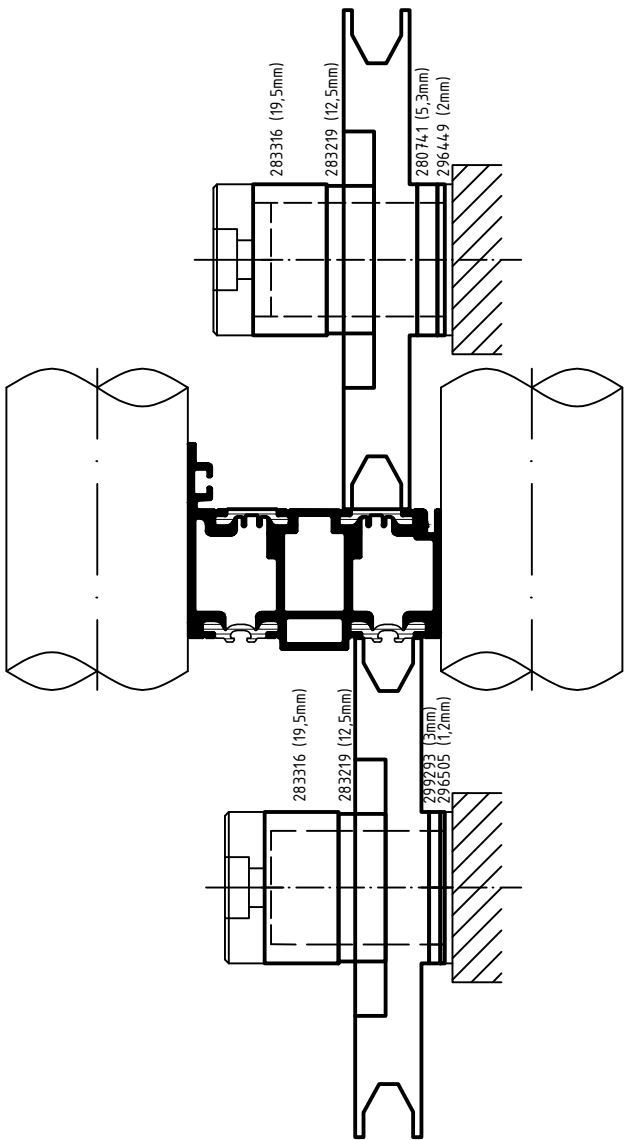


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## 1. Stage

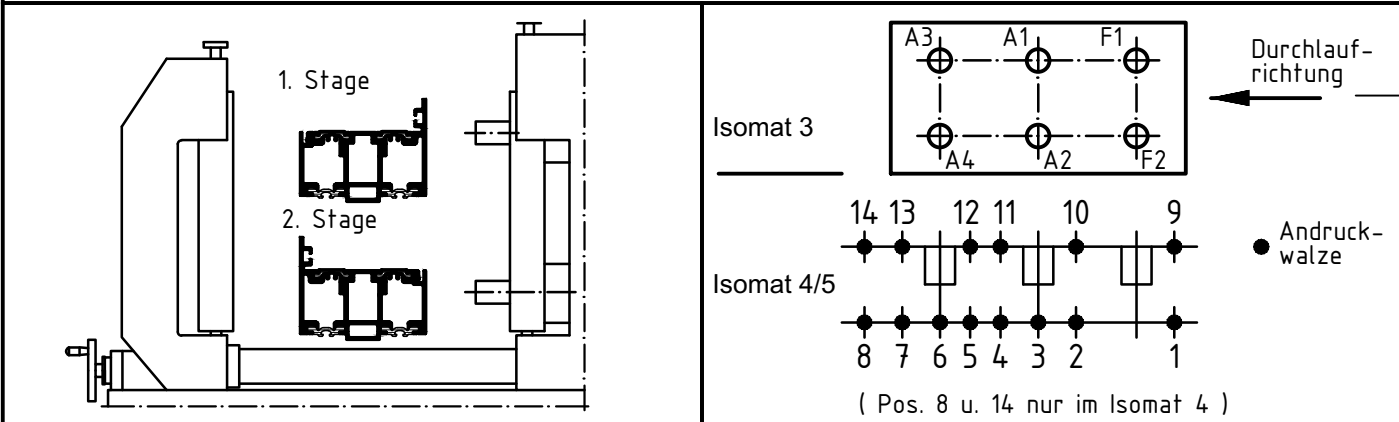


## 2. Stage



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.<br>Qty. | Art.-Nr. Zubehör<br>Art.-No. Accessories |                    |
|-------------------------------------------|---------------|-----------------------------------------------|--------------------------------------|-----------------------------------------------------------------------------------------|---------------|------------------------------------------|--------------------|
|                                           | Stck.<br>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)         | R1            | 3                                        | 296449 ( 2.0 mm)   |
| A1                                        | 1             | 283150 B                                      | 283150 B                             | R1/R2/A1/R3/R4                                                                          | R2            | 3                                        | 280741 ( 5.3 mm)   |
| A2                                        | 1             | 283150 B                                      | 283150 B                             | R5/R6/A2/R3/R4                                                                          | R3            | 6                                        | 283219 (12.5/39mm) |
| A3                                        | 1             | 283151 B                                      | 283150 B                             | R1/R2/A3/R3/R4                                                                          | R4            | 6                                        | 283316 (19.5 mm)   |
| A4                                        | 1             | 283151 B                                      | 283150 B                             | R5/R6/A4/R3/R4                                                                          | R5            | 3                                        | 296505 ( 1.2 mm)   |
| F1                                        | 1             | 283149 B                                      |                                      | R1/R2/F1/R3/R4                                                                          | R6            | 3                                        | 299293 ( 3.0 mm)   |
| F2                                        | 1             | 283149 B                                      |                                      | R5/R6/F2/R3/R4                                                                          |               |                                          |                    |
|                                           |               |                                               |                                      |                                                                                         |               |                                          |                    |
|                                           |               | Zulässige Abweichung<br>Permissible tolerance |                                      | Oberflächenabwicklung<br>Circumference                                                  |               | VP<br>PU                                 |                    |
|                                           |               |                                               |                                      | mech.<br>polished<br>uml.<br>total                                                      |               | Info-Plan:                               |                    |
|                                           |               |                                               |                                      | —                                                                                       |               | Gewicht<br>Weight                        |                    |
|                                           |               |                                               |                                      | Maßstab<br>Scale                                                                        |               | 1 : 1                                    |                    |
| Paßmaße<br>Close tol.                     |               | Abmaße<br>Std. tolerance                      |                                      | Werkstoff<br>Material                                                                   |               |                                          |                    |
| Original / Änderung<br>Revision / Version |               | 0100                                          |                                      | Datum<br>Date                                                                           |               | Benennung<br>Title                       |                    |
| Name                                      |               |                                               |                                      | 24.01.2019                                                                              |               | Roller plan<br>Isomat 3/4/5              |                    |
|                                           |               | gez.<br>drawn                                 |                                      | Finkemeyer, C.                                                                          |               | Schüco ASE 67 PD                         |                    |
|                                           |               | gepr.<br>checked                              |                                      | Winkler, A.                                                                             |               |                                          |                    |
|                                           |               | ges.<br>seen                                  |                                      | Nienhüser, R.                                                                           |               |                                          |                    |
|                                           |               |                                               |                                      |                                                                                         |               | Zeichn.-Nr.<br>Drawing No.               |                    |
|                                           |               |                                               |                                      |                                                                                         |               | 519644 RP 1000                           |                    |
|                                           |               |                                               |                                      | EDV erstellt<br>Ohne Unterschrift gültig<br>generated by EDP<br>valid without signature |               | Ersatz für<br>Replacement<br>for         |                    |
|                                           |               |                                               |                                      |                                                                                         |               |                                          |                    |

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