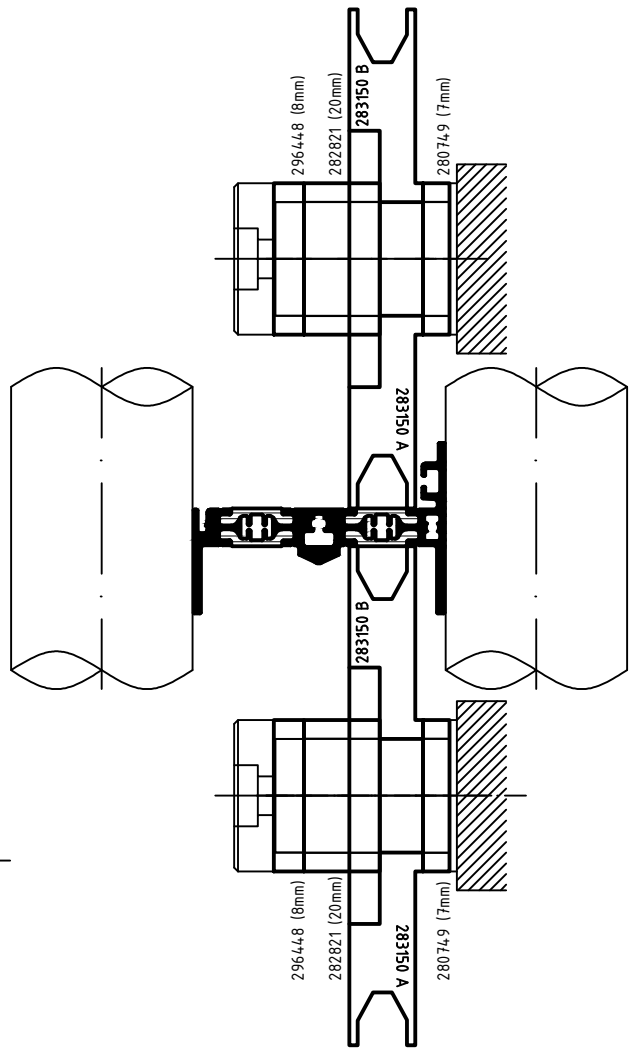
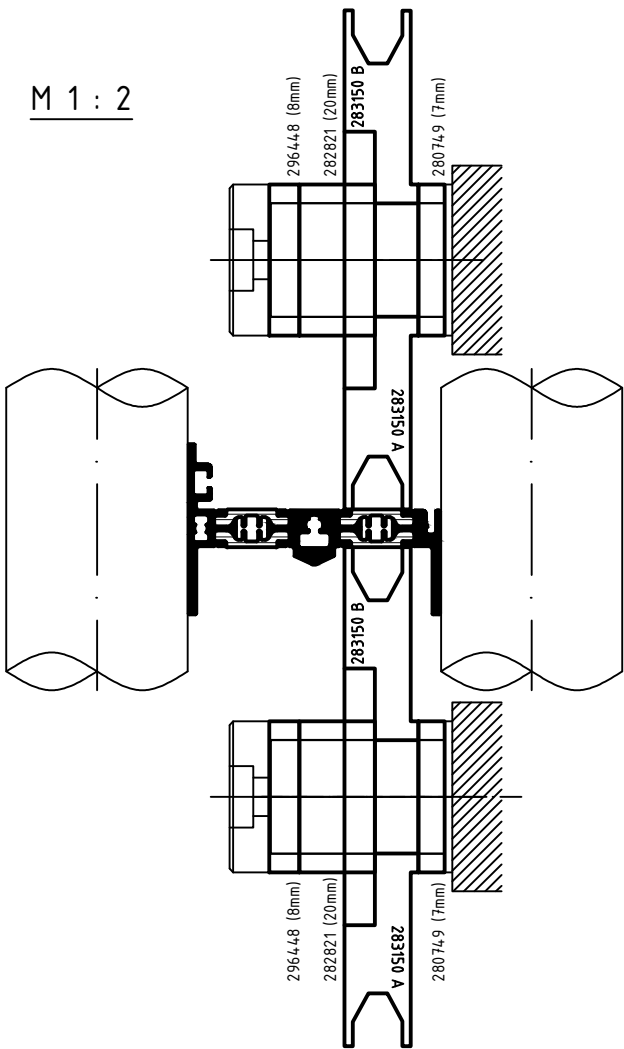


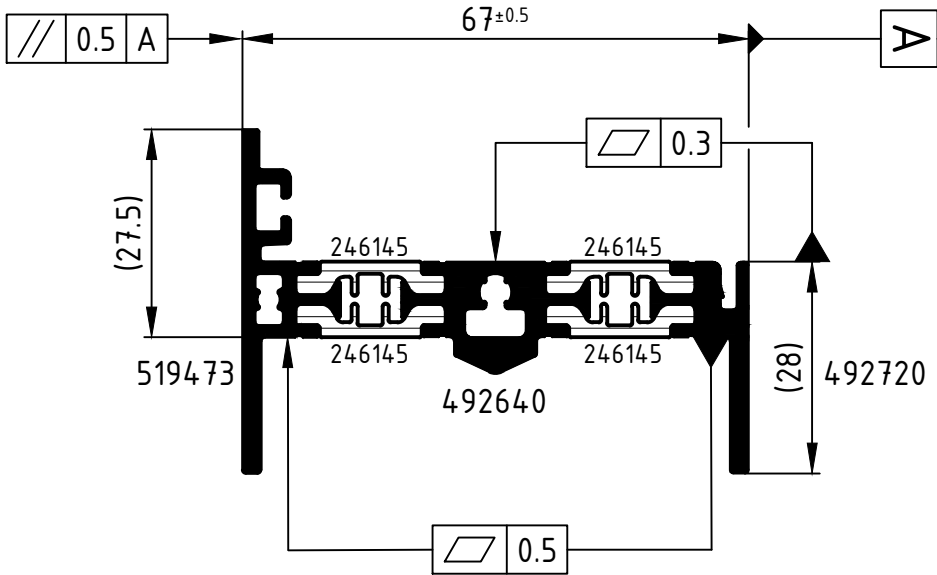
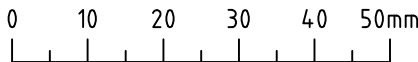
1. Stage



2. Stage

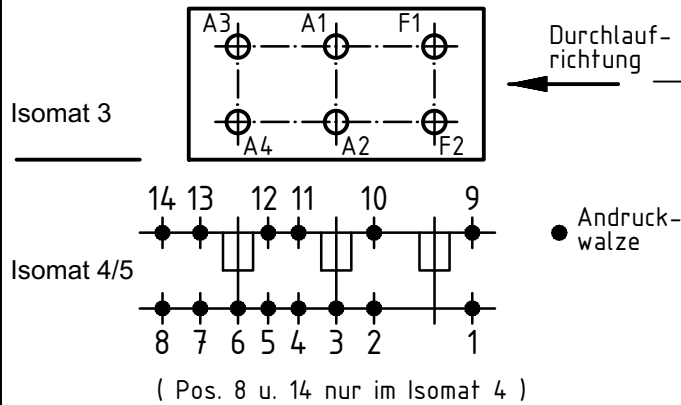
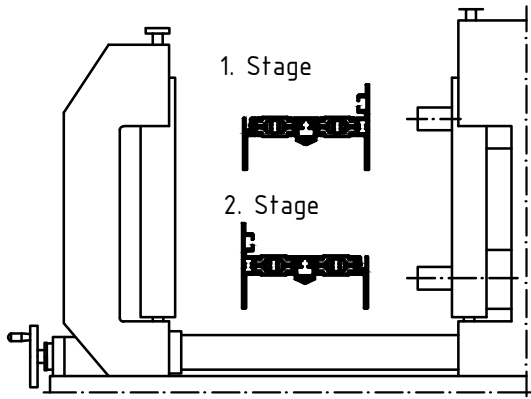


M 1 : 2



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. 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	
					R1	5	280749 (7.0 mm)
A1	1	283150 B	283150 B	R1/A1/R2/R3	R2	5	282821 (20.0 mm)
A2	1	283150 B	283150 B	R1/A2/R2/R3	R3	5	296448 (8.0 mm)
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 Permissible tolerance		Oberflächenabwicklung Circumference	VP PU		
				mech. polished	Info-Plan:		
				uml. total	Maßstab Scale		
					1 : 1		
		Paßmaße Close tol.			Werkstoff Material		
		Abmaße Std. tolerance			Benennung Title		
		Original / Änderung Revision / Version		Datum Date	Name		
		0100		24.01.2019	Finkemeyer, C.		
					Winkler, A.		
					Nienhäuser, R.		
					Schüco ASE 67 PD		
					Zeichn.-Nr. Drawing No.		
					519645 RP 1000		
					EDV erstellt Ohne Unterschrift gültig generated by EDP valid without signature		
					Ersatz für Replacement for		