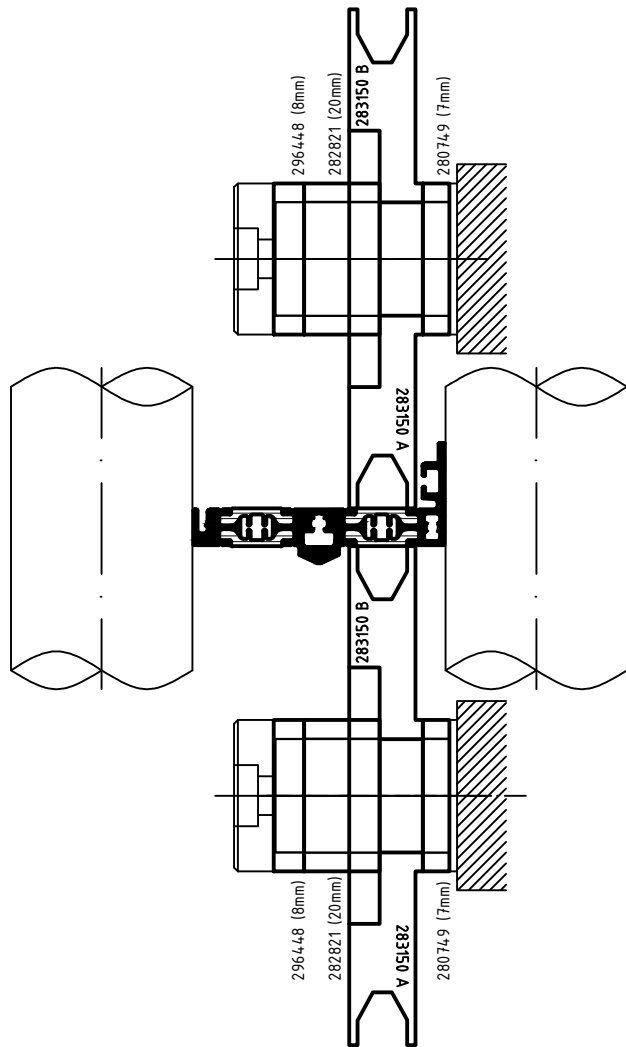
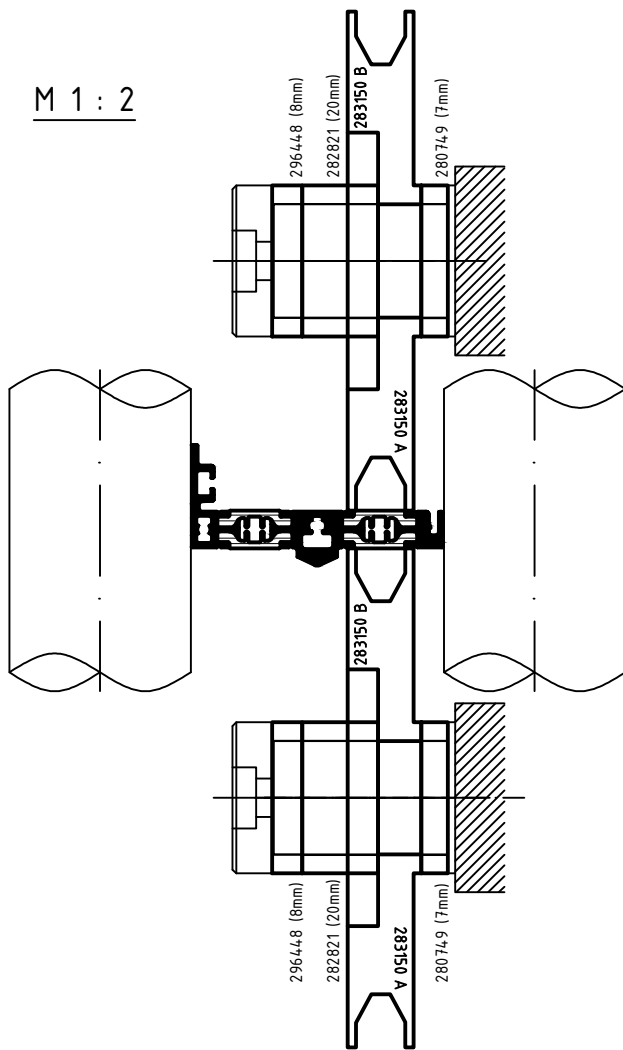


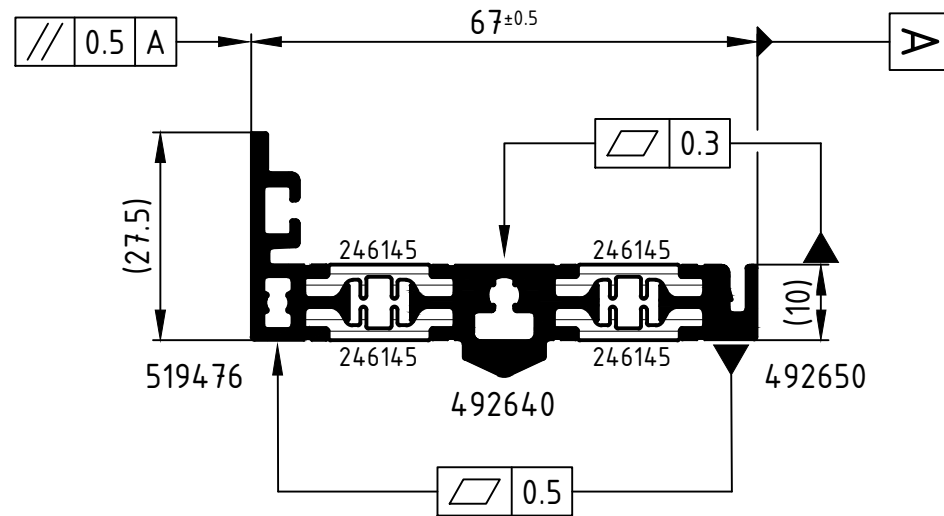
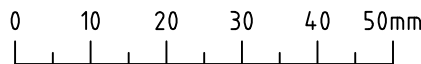
1. Stage



2. Stage

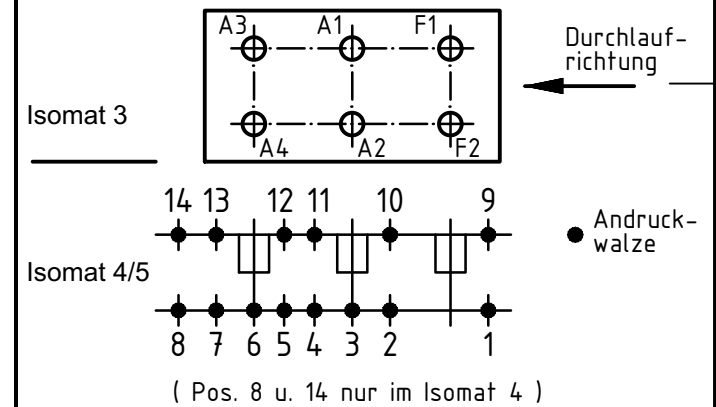
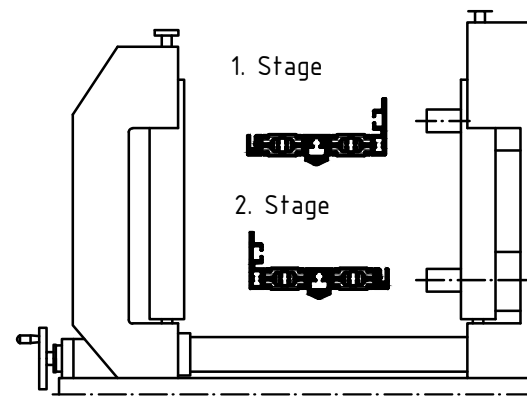


M 1 : 2



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)	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	283151 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	Info-Plan:
			mech. polished	—	Maßstab Scale	Gewicht Weight
			uml. total			
Paßmaße Close tol.	Abmaße Std. tolerance					
Original / Änderung Revision / Version			0100	Datum Date	Name	Werkstoff Material
Name			24.01.2019	Benennung Title		
			gez. drawn	Roller plan		
			gepr. checked	Isomat 3/4/5		
			ges. seen	Schüco ASE 67 PD		
			Zeichn.-Nr. Drawing No.			
			519646 RP 1000			
			EDV erstellt Ohne Unterschrift gültig generated by EDP valid without signature			
			Ersatz für Replacement for			