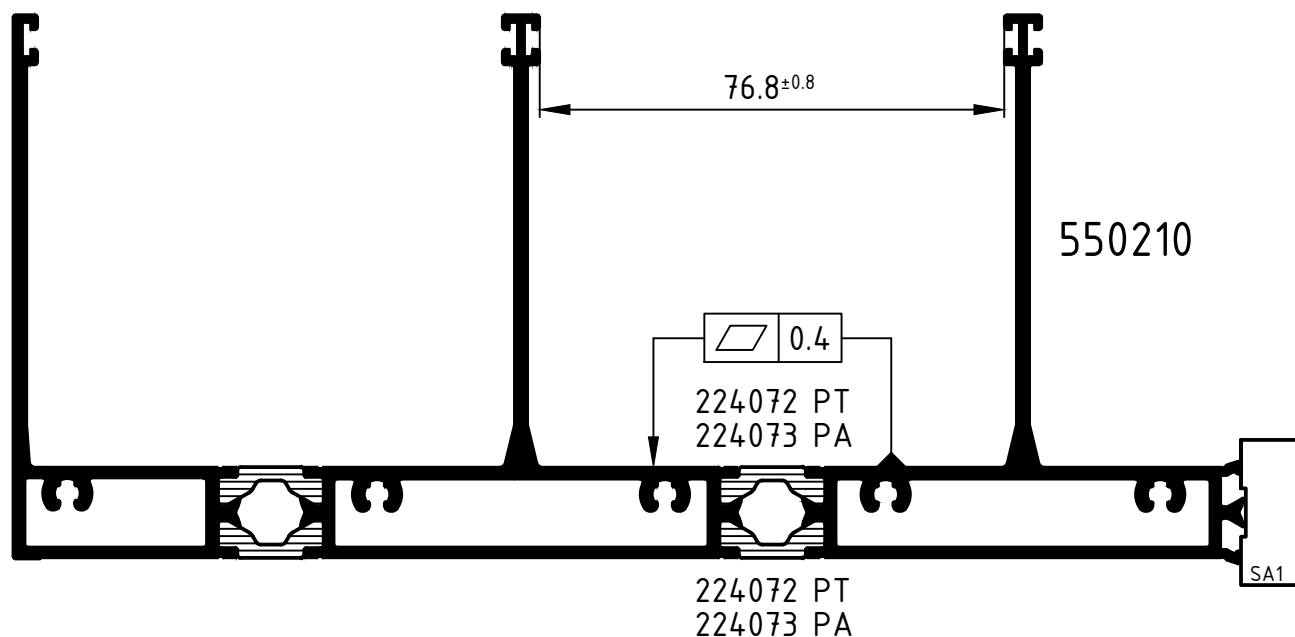
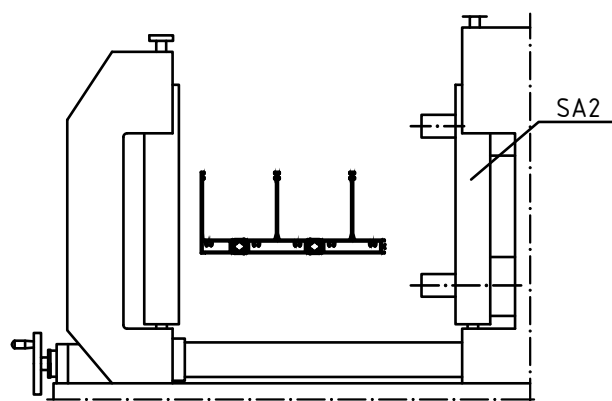


without scale



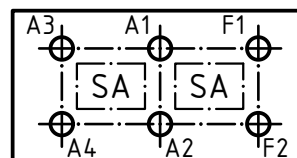
Reduced shear strength $R_{sv} \geq 24 \text{ N/mm}$
2nd roll process (3rd roll process, see 545760 RP 0300)

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 guidelines



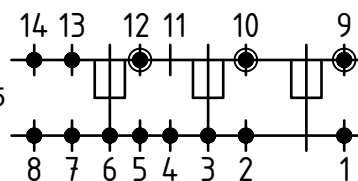
Position

SA-Rollen



Durchlauf-
richtung

Isomat 4/5



● Andruck-
walze

● Seitliche
Andruck-
rolle

(Pos. 8 u. 14 nur im Isomat 4)

Attention : if using anodised profiles, the rolling procedure may need to be done in 2 steps !

	Stck. Qty.	Art.-Nr. Art.-No. für Isomat 5	Art.-Nr. Art.-No. für Isomat 4	Bestückungsfolge (v. innen nach außen) Assembly sequence (inside to outside)		Qty.	Art.-No. Accessories
					R1	4	296452 (1.5 mm)
A1	1	9626590 A	9626590 A	R1/R2/A1	R2	4	9626925
A2	1	280693 A	280693 A	R1/R2/A2	R3	1	280743 (5.0 mm)
A3	1	9626591 A	9626590 A	R1/R2/A3	SA2	3	9626927
A4	1	280694 A	280693 A	R1/R2/A4			
F1	1	9626592		R3/F1			
F2	1	9626926					

Zulässige Abweichung Permissible tolerance		Oberflächenabwicklung Circumference		VP PU	Info-Plan:
mech. polished		-		Maßstab Scale	Gewicht Weight
umf. total				1 : 1	
Paßmaße Close tol.	Abmaße Std. tolerance			Werkstoff Material	
Original / Änderung Revision / Version	0100	Datum Date	Name	Benennung Title	
		09.08.2022		Roller plan Isomat 4/5	
		Winkler, A.		Schüco ASE 70 PD.ME	V8-9626842
		Finkemeyer, C.		545760 RP 0200	
		Nienhüser, R.			
				Zeichn.-Nr. Drawing No.	
				EDV erstellt Ohne Unterschrift gültig generated by EDP valid without signature	
				Ersatz für Replacement for	

SCHÜCO