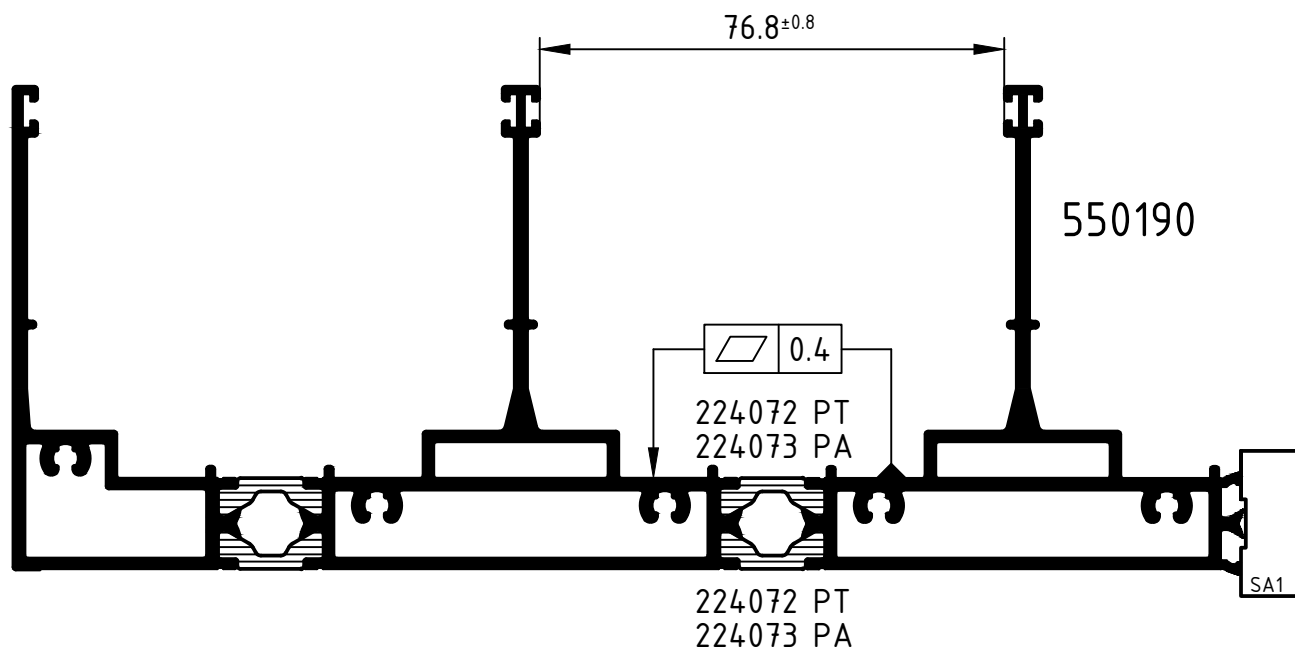


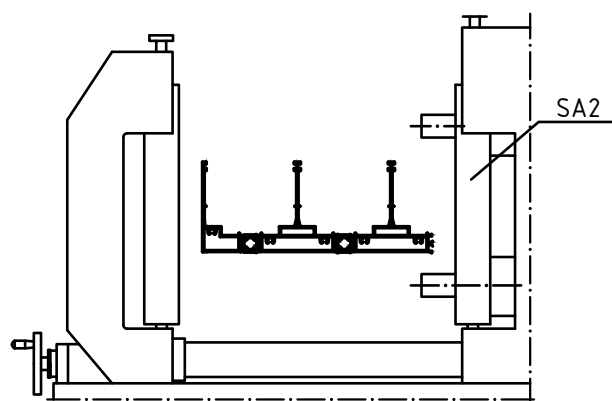
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without scale



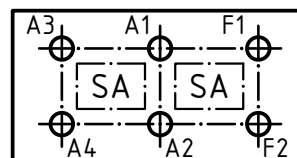
Reduced shear strength $R_{sv} \geq 24 \text{ N/mm}$
2nd roll process (3rd roll process, see 545770 RP 0300)

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



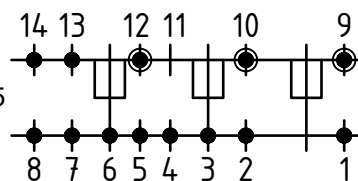
Position

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)
					R2	4	9626925
A1	1	9626590 A	9626590 A	R1/R2/A1	R3	1	280743 (5.0 mm)
A2	1	280693 A	280693 A	R1/R2/A2	SA2	3	9626927
A3	1	9626591 A	9626590 A	R1/R2/A3			
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 1 : 1		Gewicht Weight	
				uml. total							
Paßmaße Close tol.				Abmaße Std. tolerance							
Original / Änderung Revision / Version 0100				Datum Date		Name		Werkstoff Material			
Name				09.08.2022				Benennung Title			
				gez. drawn		Winkler, A.		Roller plan Isomat 4/5 Schüco ASE 70 PD.ME V8-9626844			
				gepr. checked		Finkemeyer, C.					
				ges. seen		Nienhüser, R.					
								Zeichn.-Nr. Drawing No.			
								545770 RP 0200			
								EDV erstellt Ohne Unterschrift gültig generated by EDP valid without signature			
								Ersatz für Replacement for			

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