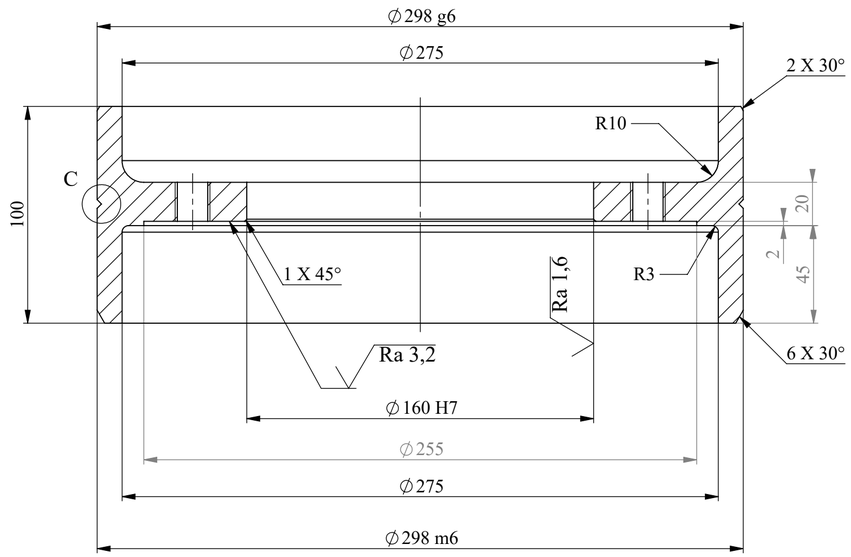
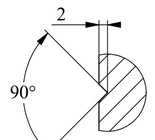
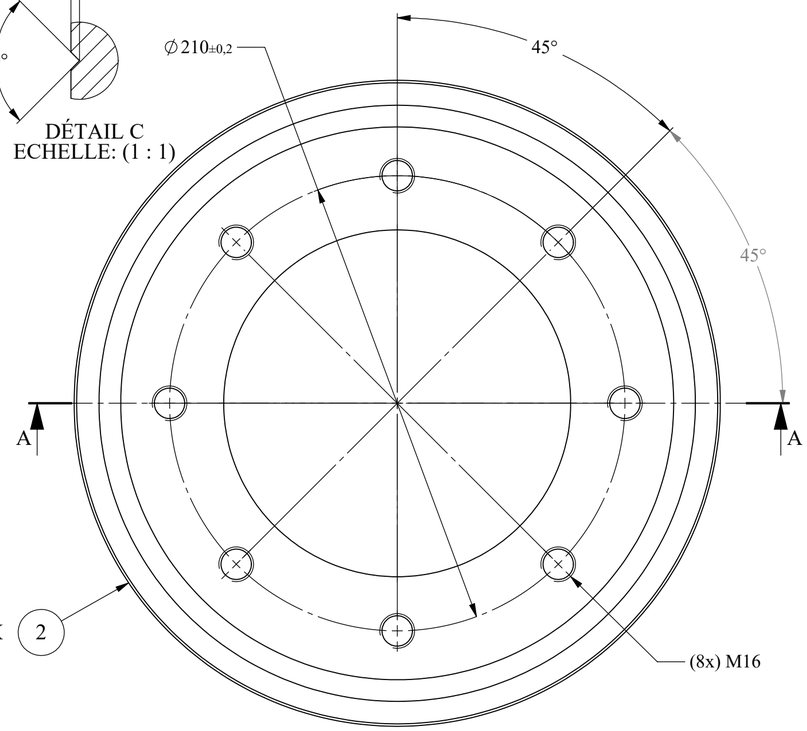
No.ARTICLE	QUANTITÉ	DESCRIPTION	LENGTH
1	1	Pipe - EN 10219 - Steel S235 JRH - 323.9x16.0	3250
2	2	Round steel bar	

A-A
ECHELLE: (1 : 2)

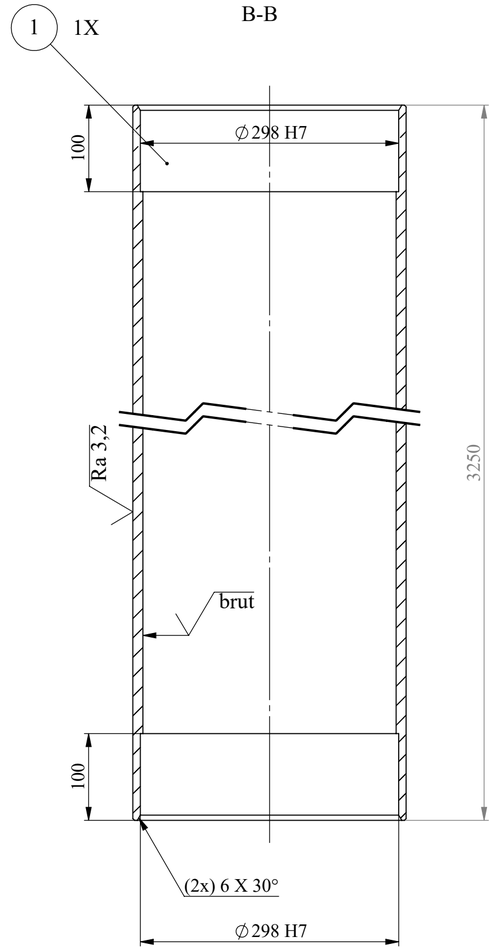


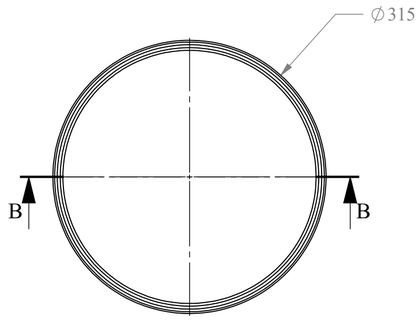


DÉTAIL C
ECHELLE: (1 : 1)



B-B





Traitement thermique de détente après soudage / After welding stress relief heat treatment

(Valeurs seulement pour indication / *Values only for indication*)

Température minimale de maintien *Minimum holding temperature* : 590°C	Temps de maintien, vitesse de chauffage et de refroidissement sont à fixer suivant indications de la ST 10000-00192-GS1 en fonction de l'épaisseur de référence indiquée ci-contre *Holding time, heating time, and cooling time will be set following document ST 10000-00192-GS1and according referenced thikness indicated under*
Epaisseur de référence *Referenced thickness* : **10** mm	

brut
Unless Otherwise Indicated

Suppression des bavures et angle tranchant | Removal of burrs and sharp angle

Material :
Steel S235 JR or AISI 1018

Heat treatment :

Protection of surf :

Procédé Soudure / *Welding process* : **141**

Pour toutes les decoupes et trous / For all cuts and holes Ra 12.5

EXEPT OTHER INDICATION
General tolerances to be respected :
ISO 2768 : m & k
Welding : v
Sheet Metal : v
Mould : ISO 8062
Surface texture : ISO 1302
Welding Symbols : ISO 2553

CAUTION :
All dimensions are in millimeters and projected view in ISO std

	Mod	Date	By	Modifications
WA+10	a	02-06-22	SPIE-DB	Pipe description updated
	-	03-11-21	SPIE-DB	Creation du document

Mass (Kg) : 303.640

Legacy ID

HR-ROL F-DRIVING ROLLER

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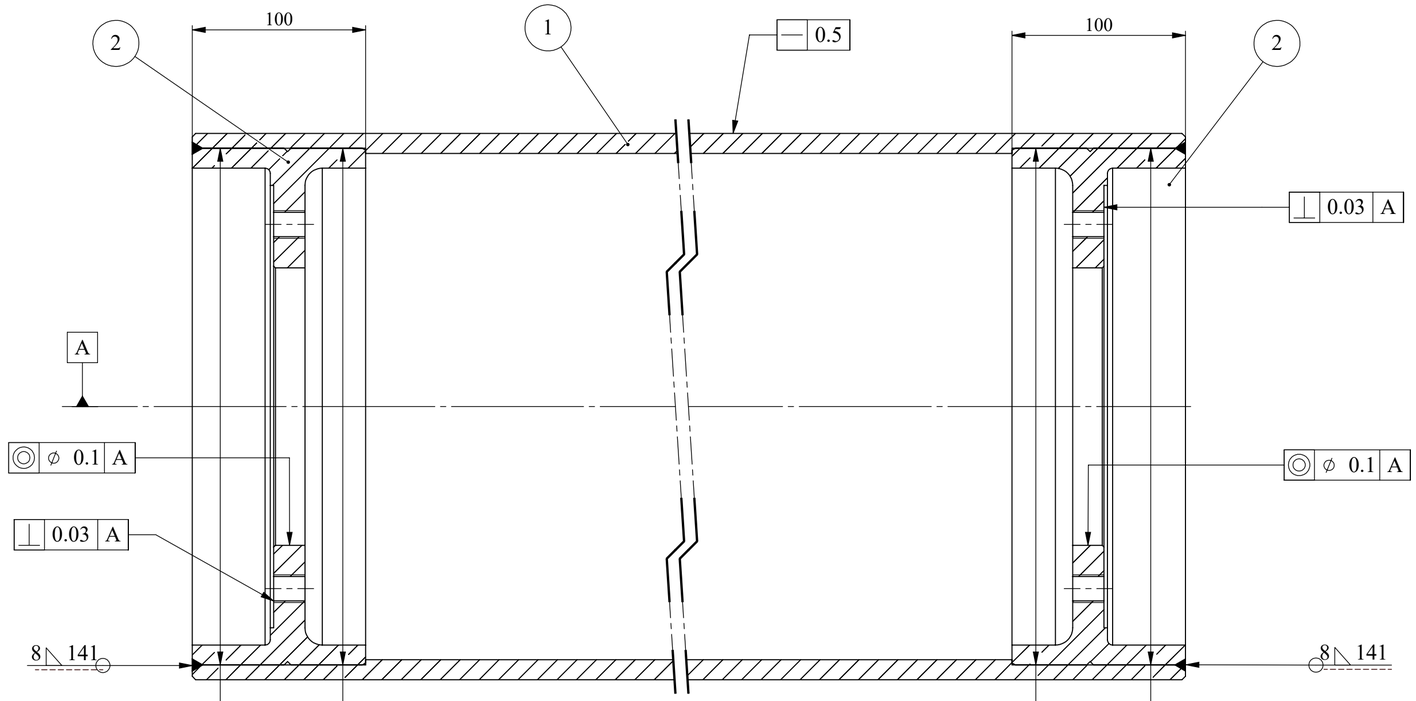
DES-000289809
Drawing Number

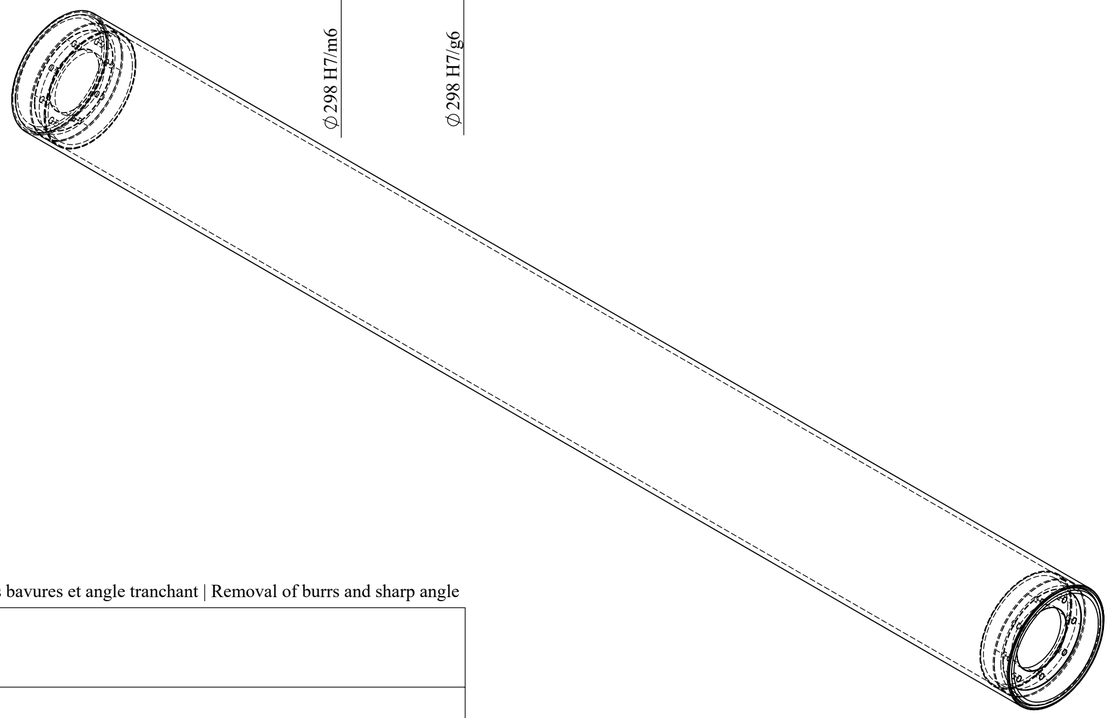
Rev : **a**

DTM Class : 2-01-07 | D3

Size : A2 | Scale : **1:5** | Units : mm | SOLIDWORKS

Sheet : **1/2**





THIS PART HAS TO BE BALANCED WITH ITS STUB SHAFTS
BALANCE WEIGHT DIVIDING EQUALLY IN BOTH ENDS
- QUALITY G40 (EXAMPLE: CAR WHEELS)
- ROTATION SPEED : 100 TO 200 RPM

brut
Unless Otherwise Indicated

Suppression des bavures et angle tranchant | Removal of burrs and sharp angle

Material :
Steel S235 JR or AISI 1018

Heat treatment :

Protection of surf :

EXEPT OTHER INDICATION

General tolerances to be respected :

ISO 2768	: m & k
Welding	: v
Sheet Metal	: v
Mould	: ISO 8062
Surface texture	: ISO 1302
Welding Symbols	: ISO 2553

CAUTION :
All dimensions are in millimeters and projected view in ISO std

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Mass (Kg) : 303.640

HR-ROL F-DRIVING ROLLER

DES-000289809

Drawing Number

Rev : **a**

DTM Class : 2-01-07 | D3

Size : A2 | Scale : **2:5** | Units : mm | SOLIDWORKS

Sheet : **2/2**