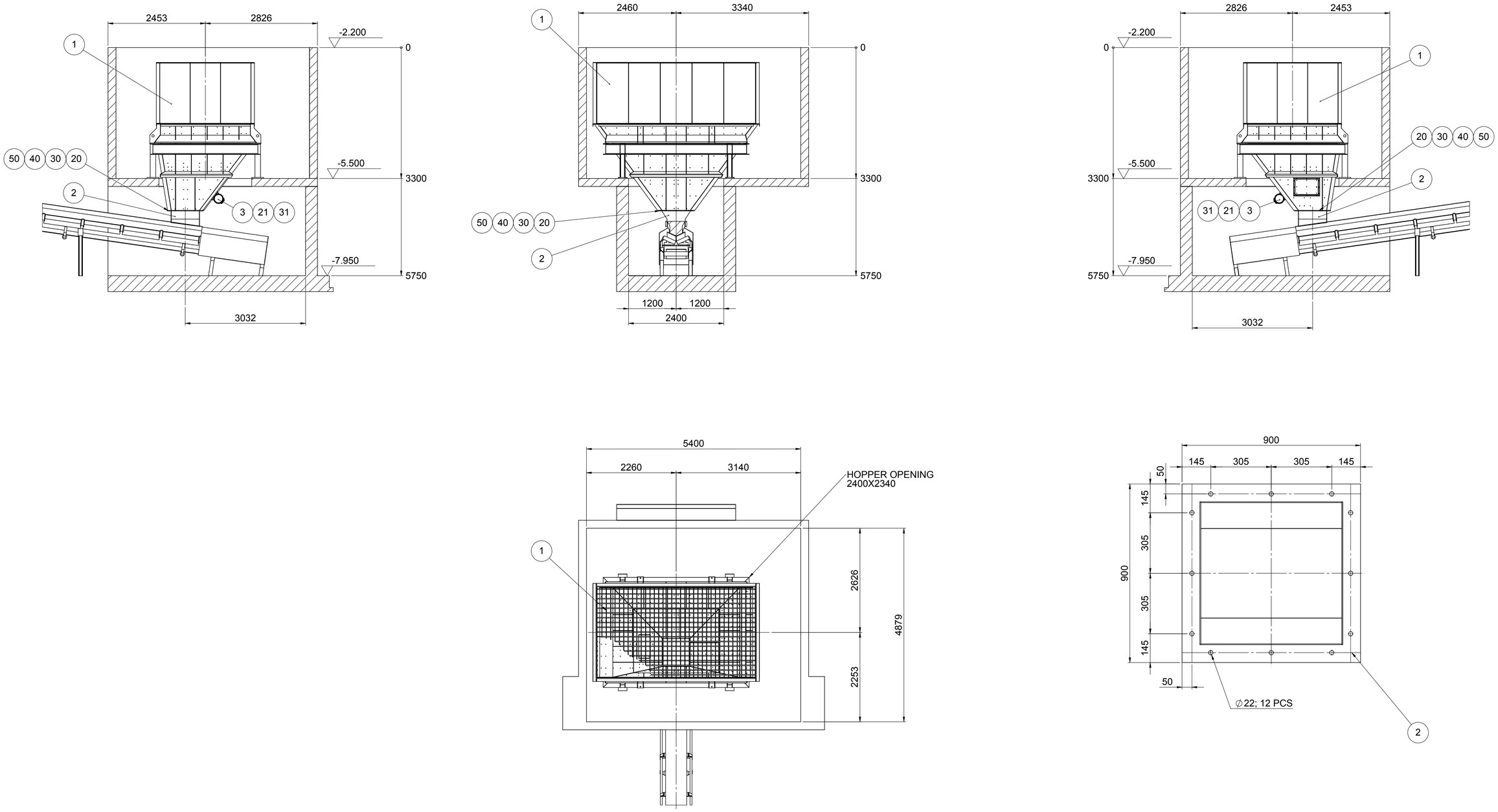

GENERAL TOLERANCES	YLEISTOLERANSSIT	SFS-EN 22768-1													
		Dimension range/Mitta-alue													
LENGTH DIMENSIONS	PITUUSMITAT	>0.5 ≤3	>3 ≤6	>6 ≤30	>30 ≤120	>120 ≤400	>400 ≤1000	>1000 ≤2000	>2000 ≤4000	>4000 ≤8000	>8000 ≤12000	>12000 ≤16000	>16000 ≤20000		
Machining	Koneistus	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6		
Chamfers and radii	Pyöristykset, viisteet	±0.2	±0.5	±1	±2	±3									
Cutting, bending	Leikkaus, taivutus		±0.2	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8		
Thermal cutting	Polttoleikk. 3Cs ≤ 50				±1.5	±2.5	±3.5	±4	±5						
	50Cs ≤ 100				±2.5	±2.5	±3.5	±4	±4.5						
Welding	Hitsaus				±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	
ANGULAR DIMENSIONS	KULMAMITAT	Shorter side/lyhyempi sivu													
		L ≤ 10	10< L ≤ 50	50< L ≤ 120	120< L ≤ 315	315< L ≤ 1000	L ≤ 1000								
Machining	Koneistus	±0.8/100 mm	±0.9/100 mm	±0.6/100 mm	±0.4/100 mm										
Bending ≤4	Taivutukset ≤4	±2.6/100 mm	±1.5/100 mm	±0.7/100 mm	±0.4/100 mm										
Bending ≥4, welding	Taiv. ≥ 4, hitsaus	±5.2/100 mm	±3.5/100 mm	±1.8/100 mm	±1.3/100 mm	±0.9/100 mm	±0.6/100 mm								

WELD QUALITY ACCORDING TO SFS-EN ISO 5817 CLASSIFICATION C / HITSAUSLAADUT SFS-EN ISO 5817 MUKAAN, HITSILUOKKA C

	Date	Name
Model	27.03.2018	/ KOMM
Drawning	27.03.2018	/ KOMM
Checked		/
Accepted	29.03.2018	/ KOMM
Office		

LAHTI PRECISION

Work No.

Pcs

Actual Weight 26674.59

3D Model Code C228862

Drawing Document Code C228898

Model Drawing

Projection

SAND RECEIVING

ITEM 1110

AZERFLOAT INC, AZERBAIJAN

AKP

Scale 1:50

Size A1

Drawing No.

Project 81961110

Pos.

Item Code B055600

Sheet 1/1

Revision -

Printed: 29.3.2018

This drawing and the design shown therein is the property of Lahti Precision Oy. Any duplication or use of this print for purposes other than for which it was furnished is hereby prohibited.

Do not take information by measuring from this copy