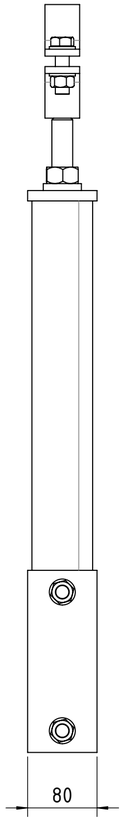
Metso:Outotec

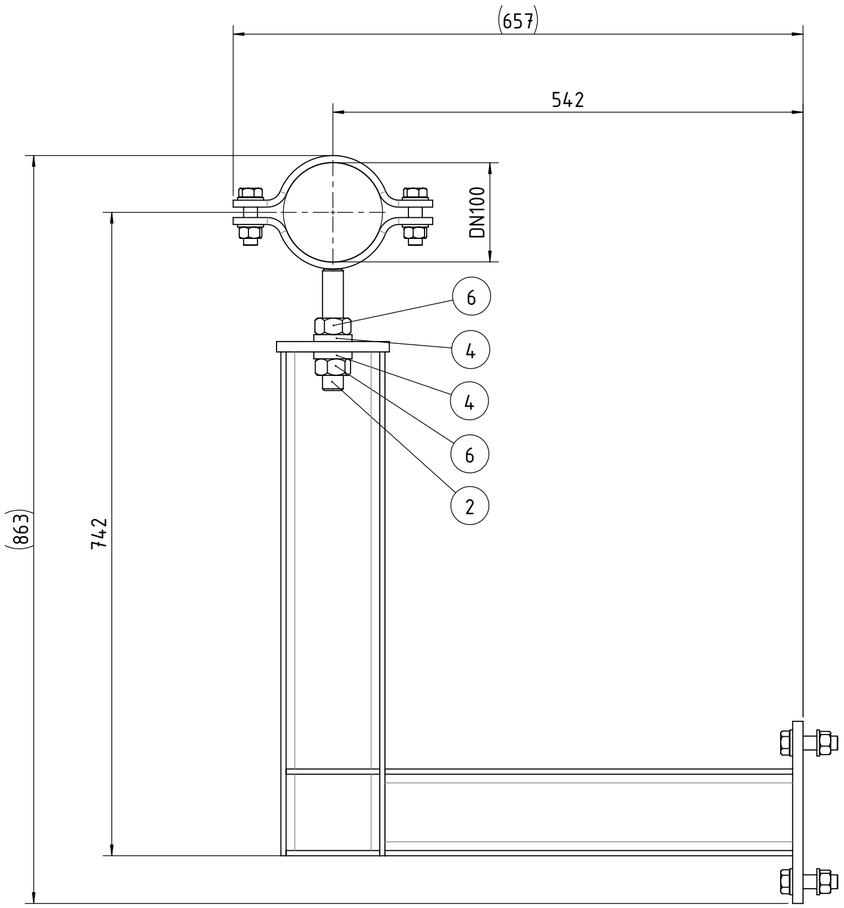
Item Number, rev.: **N031021326, 1** Item Description: **SUPPORT TankCell® e30** Related Documents: **OU600566605, 0 (Manufacturing Drawing)**	Weight: 17kg	Customer:

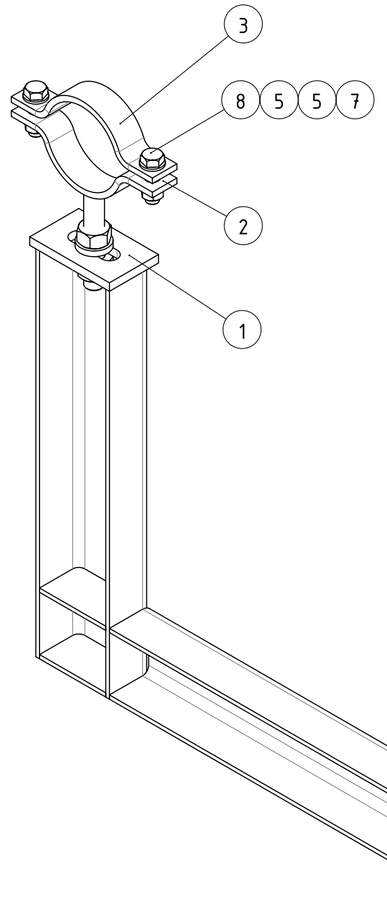
L	F/N	Reference Designator	Item Number	Description	Additional Information	BOM	Qty (unit)	Weight (kg)	Related Documents
1	01		N031021328, 1	SUPPORT			1 (EA)	14 14	
1	02		N031021284, 1	PIPE CLAMP			1 (EA)	1.1 1.1	
1	03		N031021283, 1	PIPE CLAMP			1 (EA)	0.7 0.7	
1	04		N048005227, 1	PLAIN WASHER M24	DIN 7989 - M24 - 200HV - tZn		2 (EA)	0.06 0.12	
1	05		515281, 1	PLAIN WASHER M16	ISO 7089 - M16 - 200HV - tZn		8 (EA)	0.01 0.08	
1	06		N048003453, 1	HEX NUT M24	ISO 4032 - M24 - 8 tZn		2 (EA)	0.09 0.18	
1	07		N048003451, 1	HEX NUT M16	ISO 4032 - M16 - 8 tZn		4 (EA)	0.04 0.16	
1	08		N048004454, 1	HEX HEAD SCREW M16x55mm			4 (EA)	0.13 0.52	

Legend: Green New Document Added
Yellow Document Revised

GENERAL TOLERANCES ISO 2768-1 EN ISO 13920 EN ISO 9013 DIN 6935													Values in millimetres
LINEAR DIMENSIONS	Basic size range	> 0,5 ≤ 3	> 3 ≤ 6	> 6 ≤ 30	> 30 ≤ 120	> 120 ≤ 400	> 400 ≤ 1000	> 1000 ≤ 2000	> 2000 ≤ 4000	> 4000 ≤ 8000	> 8000 ≤ 12 000	> 12 000 ≤ 16 000	> 16 000 ≤ 20 000	> 20 000
Machining ISO 2768-m		± 0,1	± 0,1	± 0,2	± 0,3	± 0,5	± 0,8	± 1,2	± 2					
Chamfers and external radii		± 0,2	± 0,5	± 1										
Welding ISO 13920-B		± 1 (Range 2-30)			± 2	± 2	± 3	± 4	± 6	± 8	± 10	± 12	± 14	± 16
Thermal cutting ISO 9013-2		≥ 3 < 10		≥ 10 < 35		≥ 35 < 125	≥ 125 < 315	≥ 315 < 1000	≥ 1000 < 2000	≥ 2000 < 4000		Quality of cut surface ISO 9013-44		
3,15 < t ≤ 6,3		± 0,7		± 0,8		± 0,9	± 1,1	± 1,2	± 1,3	± 1,3				
6,3 < t ≤ 10		± 1		± 1,1		± 1,3	± 1,4	± 1,5	± 1,6	± 1,7				
10 < t ≤ 50		± 1,8		± 1,8		± 1,8	± 1,9	± 2,3	± 3	± 4,2				
ANGULAR DIMENSIONS	Shorter side	≤ 10		> 10 ≤ 50		> 50 ≤ 120		> 120 ≤ 400		> 400 ≤ 1000		> 1000		
Machining ISO 2768-m		± 1°		± 0°30'		± 0°20'		± 0°10'		± 0°5'				
Welding ISO 13920-B		± 13 mm/m								± 9 mm/m		± 6 mm/m		
Bending		SEE DIN 6935												
GEOMETRICAL TOLERANCES		Machining ISO 2768-K Welding ISO 13920-F												







0	kallau	31.12.2014	pekkall	31.12.2014	juhkau	10.06.2015	FOR FABRICATION
REV.	NAME	DATE	NAME	DATE	NAME	DATE	REVISION TEXT
	PREPARED		CHECKED		APPROVED		

Outotec

REPLACED BY

REPLACES

DOCUMENT TITLE

MANUFACTURING DRAWING
SUPPORT
TANK MAIN ASSEMBLY
TankCell® e30

LANGUAGE	UNITS	SCALE	SIZE	SHEET OF SHEETS
EN	mm	1:5	A2	1 / 1

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REVISION 0