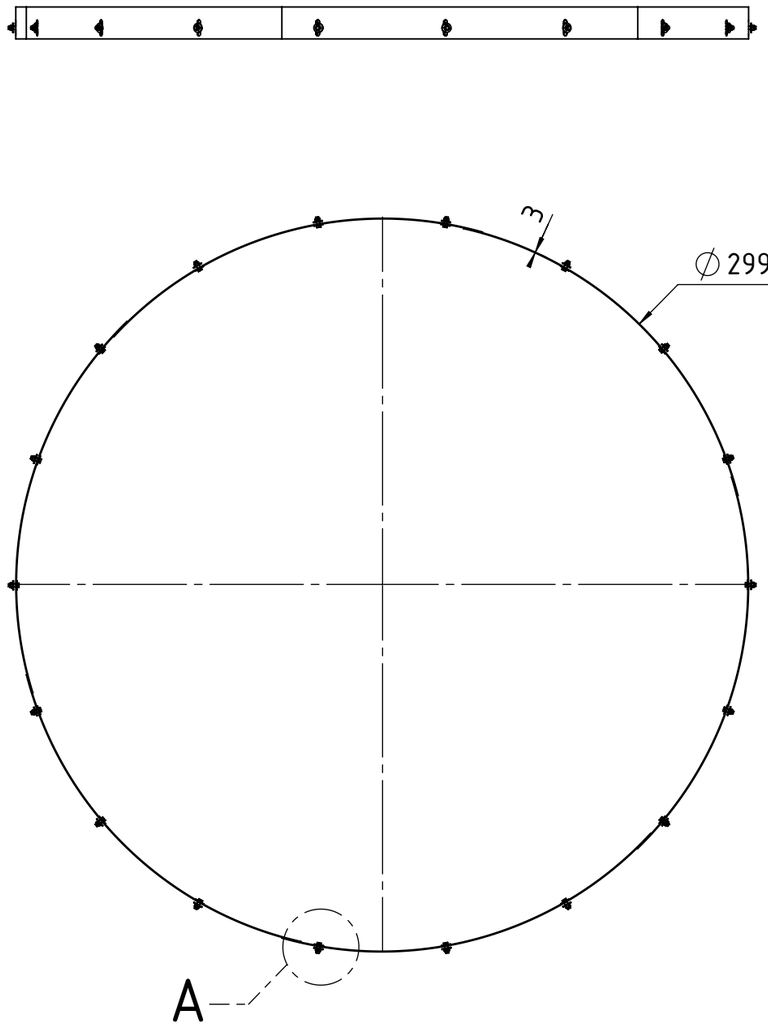
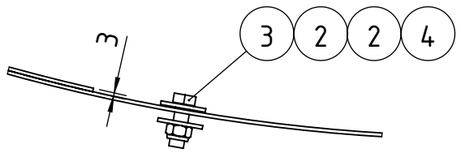
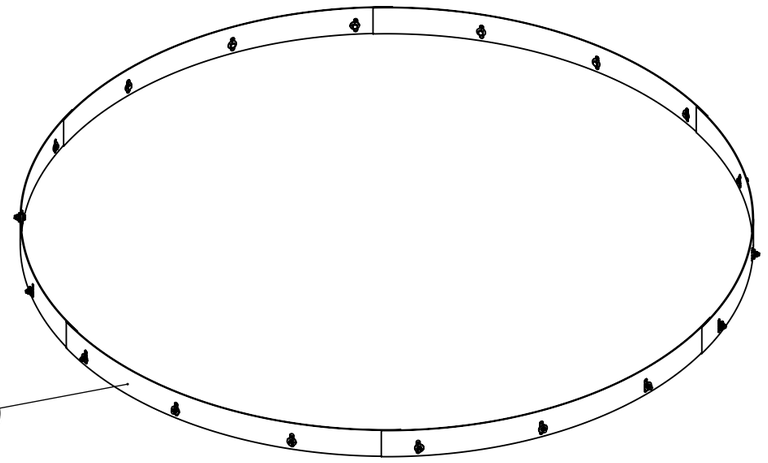




A 1 : 5



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					

ITEM NO.	DESCRIPTION	SUB-DWG.NO.	QTY.	WEIGHT	Remarks
4	HEXAGON LOCK NUT ISO 10511 - M12 - A4-70		18	0.0	
3	HEX HEAD SCREW ISO 4017 - M12x35 - A4-80		18	0.0	
2	PLAIN WASHER ISO 7093-1 - M12 - 200 HV - A4		36	0.0	
1	FROTH LIP	OU600384681	6	5.1	

DIMENSIONS & BASIC MATERIAL — WEIGHT 32.4

REV.	NAME	DATE	NAME	DATE	NAME	DATE	
	PREPARED		CHECKED		APPROVED		REVISION TEXT
0	kallau	19.12.2013	pekkall	19.12.2013	juhkau	16.01.2014	FOR FABRICATION

Outotec

DOCUMENT TITLE
MANUFACTURING DRAWING
FROTH LIP ASSEMBLY
TANK MAIN ASSEMBLY
TankCell® e30

REPLACED BY

REPLACES

LANGUAGE	UNITS	SCALE	SIZE	SHEET OF SHEETS
EN	mm	1:25	A3	1 / 1

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