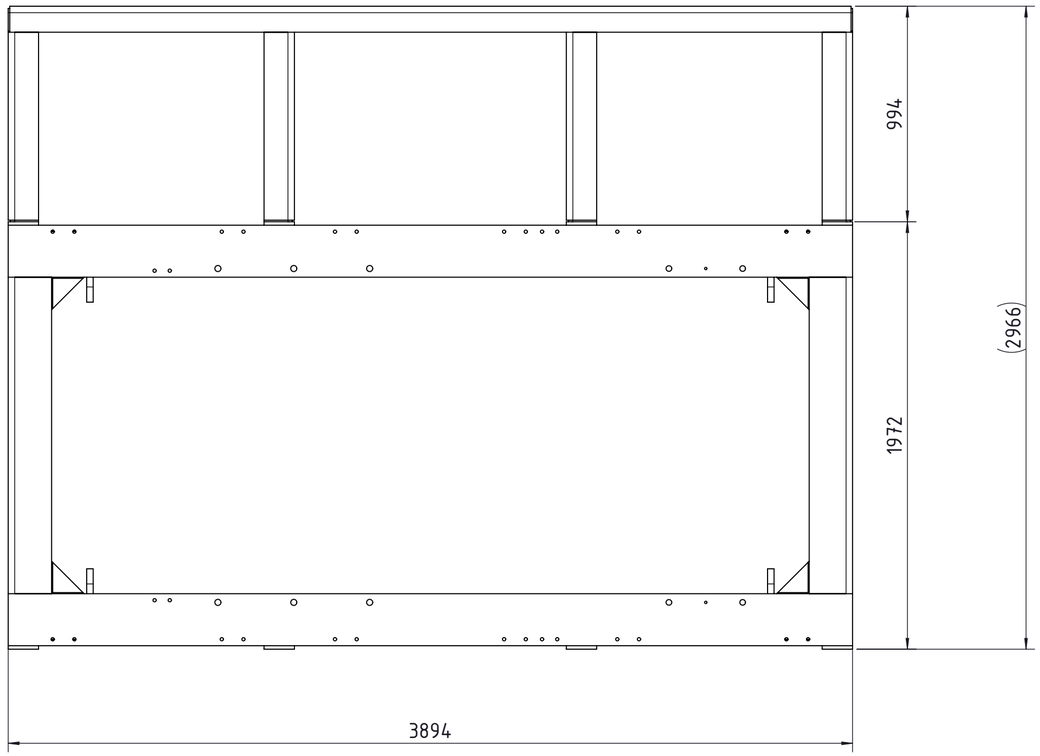
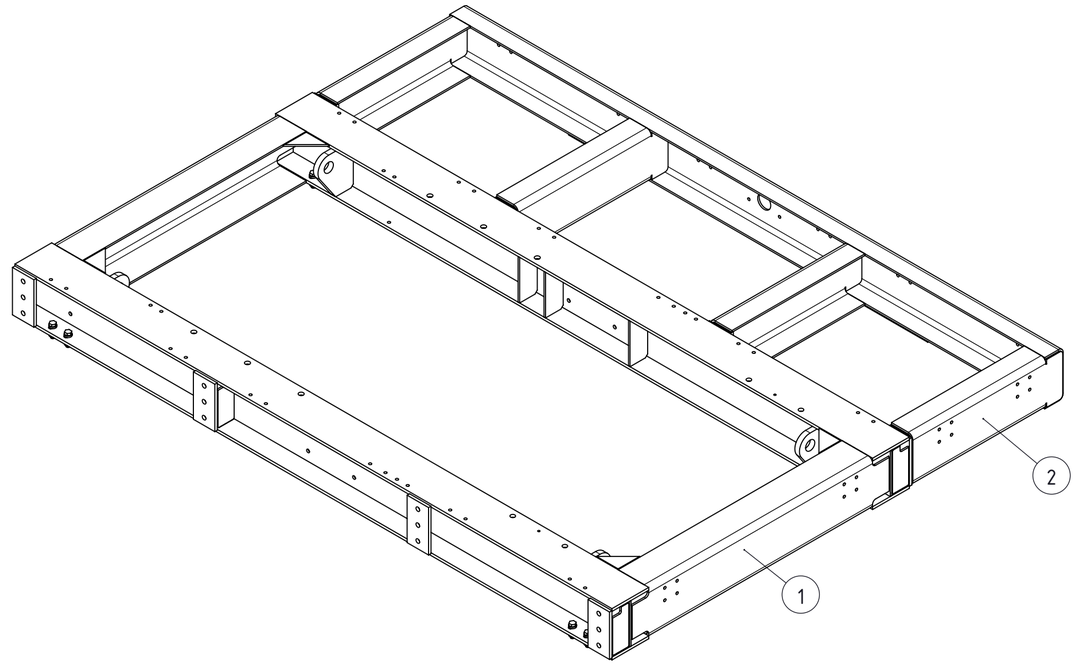
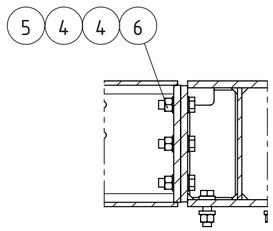


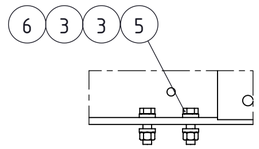
SECTION A-A







DETAIL B
SCALE 1 : 10



DETAIL C
SCALE 1 : 10

GENERAL TOLERANCES
ISO 2768-1 EN ISO 13920 EN ISO 9013 DIN 6935

Values in millimetres

	Basic size range											
LINEAR DIMENSIONS	> 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 Chamfers and external radii	± 0,1 ± 0,2	± 0,1 ± 0,5	± 0,2 ± 1	± 0,3	± 0,5	± 0,8	± 1,2	± 2					
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					

PART	DESCRIPTION	SUB_DWG.NO.	QTY	WEIGHT [kg]	ITEM NO.	REMARKS
6	HEXAGON NUT ISO 4032 - M20 - 8 - tZn		24	0.1	N048003452	
5	HEX HEAD SCREW ISO 4014 - M20x70 - 8.8 tZn		24	0.3	N048004482	
4	WASHER ISO 7089 - M20 - 200HV - tZn		24	0.0	515282	
3	WASHER DIN 7989 - M20 - 200HV - tZn		24	0.04	N048003719	
2	WALKWAY FRAME TankCell® s30	OU601835556	1	327	N031248275	
1	BRIDGE FRAME TankCell® s30	OU601835557	1	892	N031248230	

DIMENSIONS & BASIC MATERIAL — WEIGHT 1228 kg

REV.	NAME	DATE	NAME	DATE	NAME	DATE	REVISION TEXT
	PREPARED		CHECKED		APPROVED		
0	leeilo	18.02.2022	JorLeh	18.02.2022	pekkall	18.02.2022	FOR FABRICATION

Metso:Outotec

REPLACED BY

REPLACES

DOCUMENT TITLE
ASSEMBLY DRAWING
BRIDGE
IL & EL WITH FASTENERS LEFT
TankCell® s30

LANGUAGE	UNITS	SCALE	SIZE	SHEET OF SHEETS
EN	mm	1:20	A2	1 / 1

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