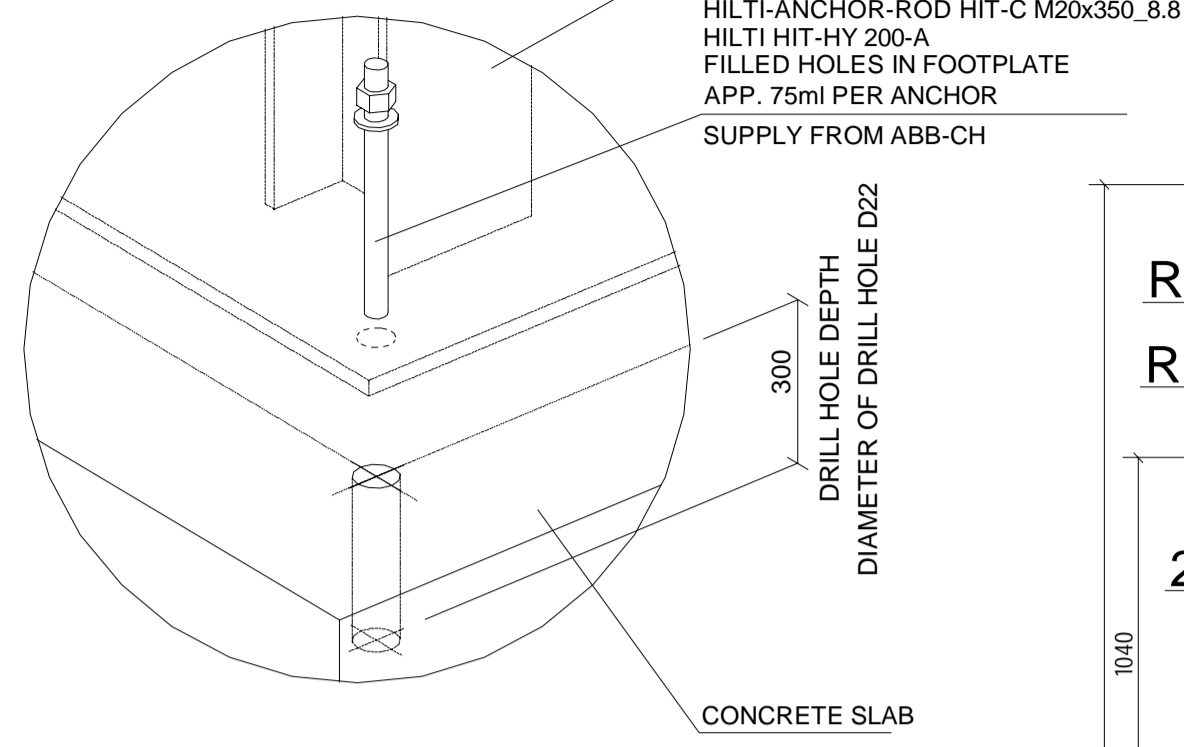
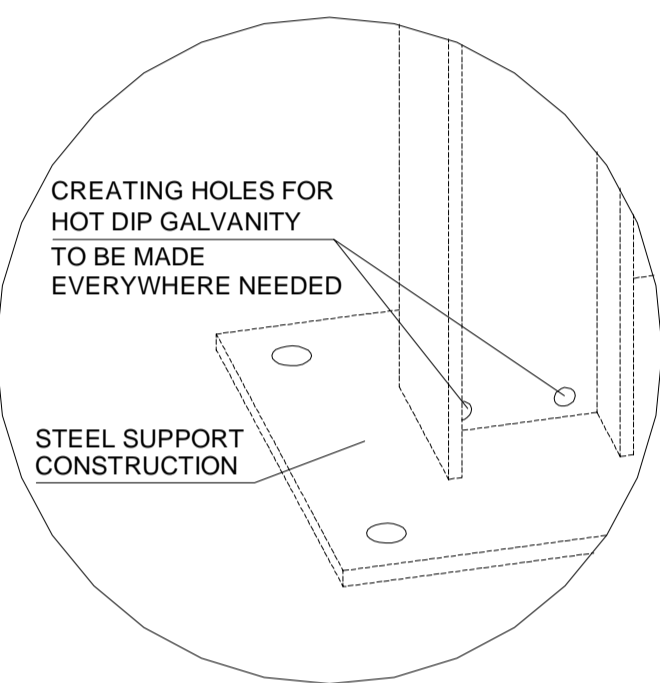


M1 SUPPORT C1

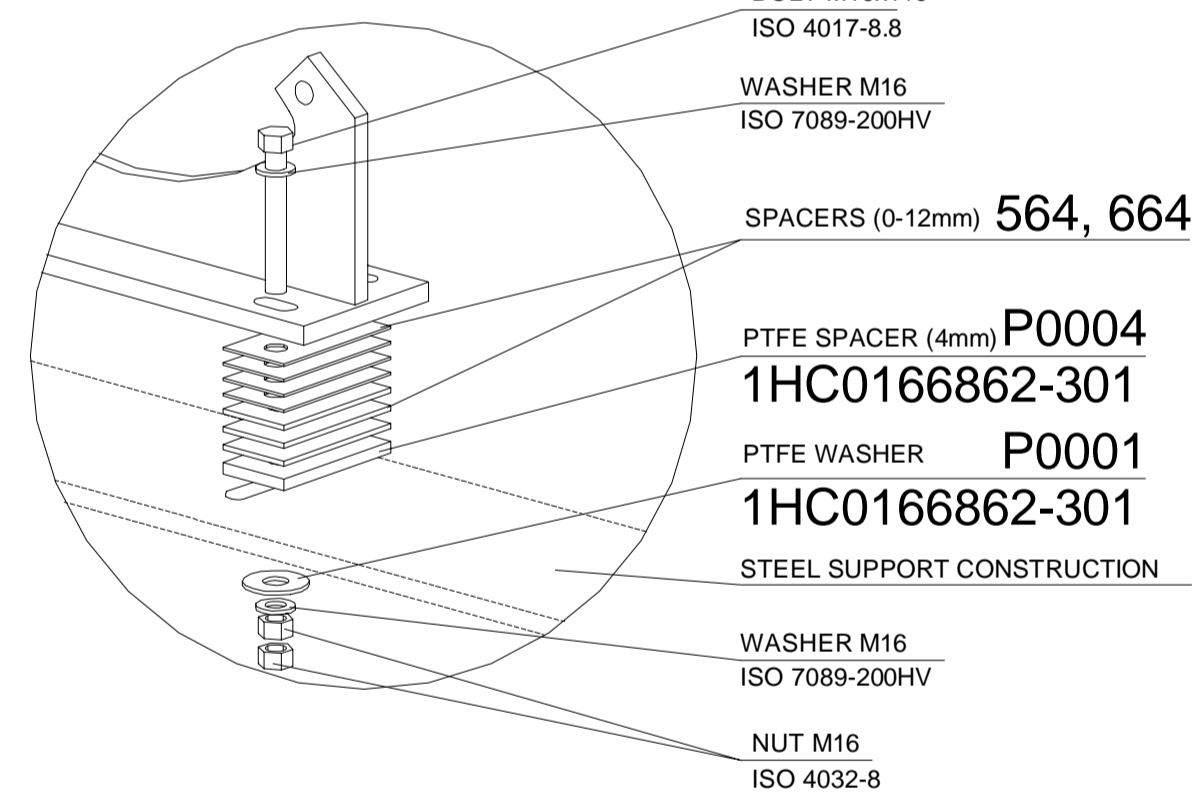
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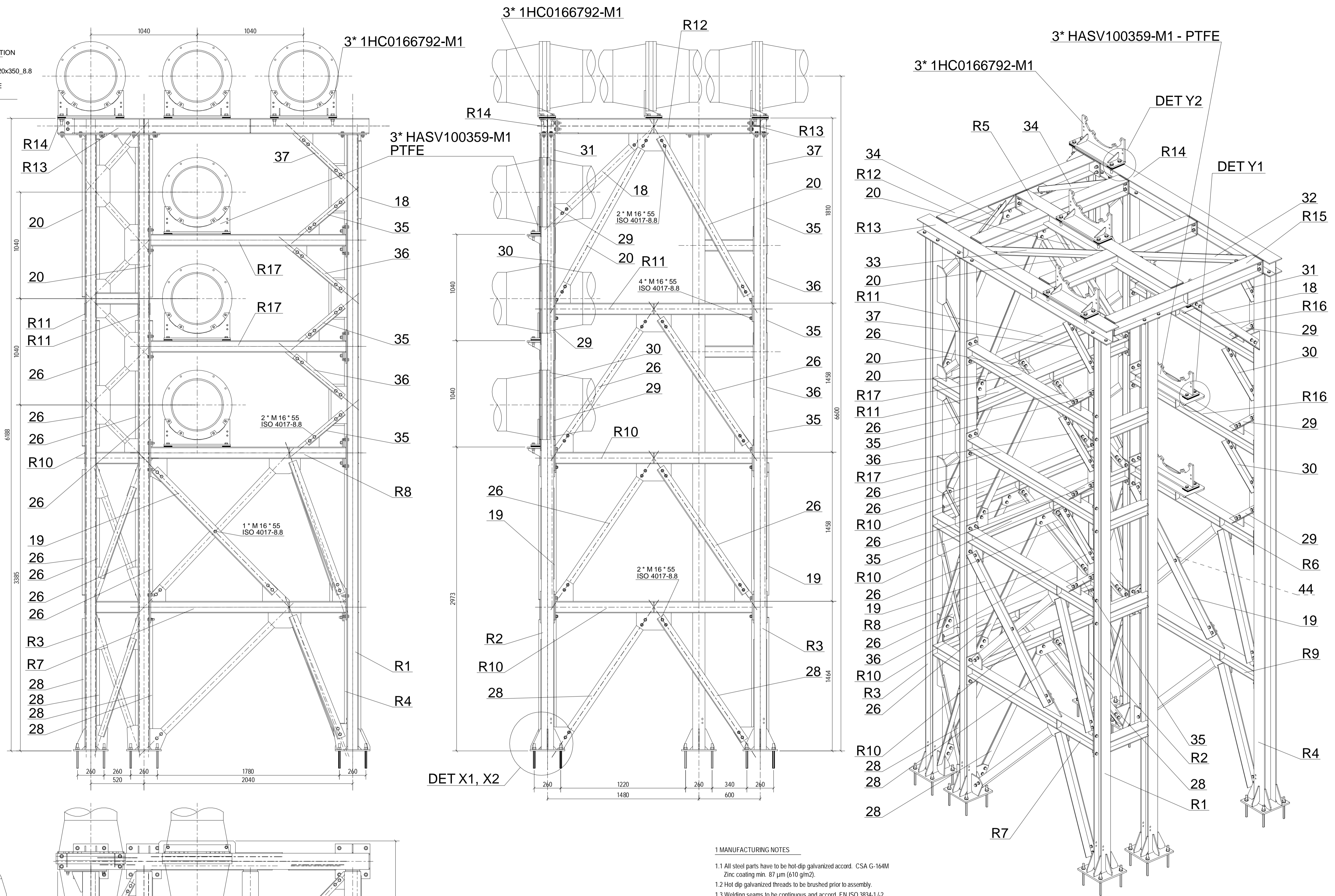
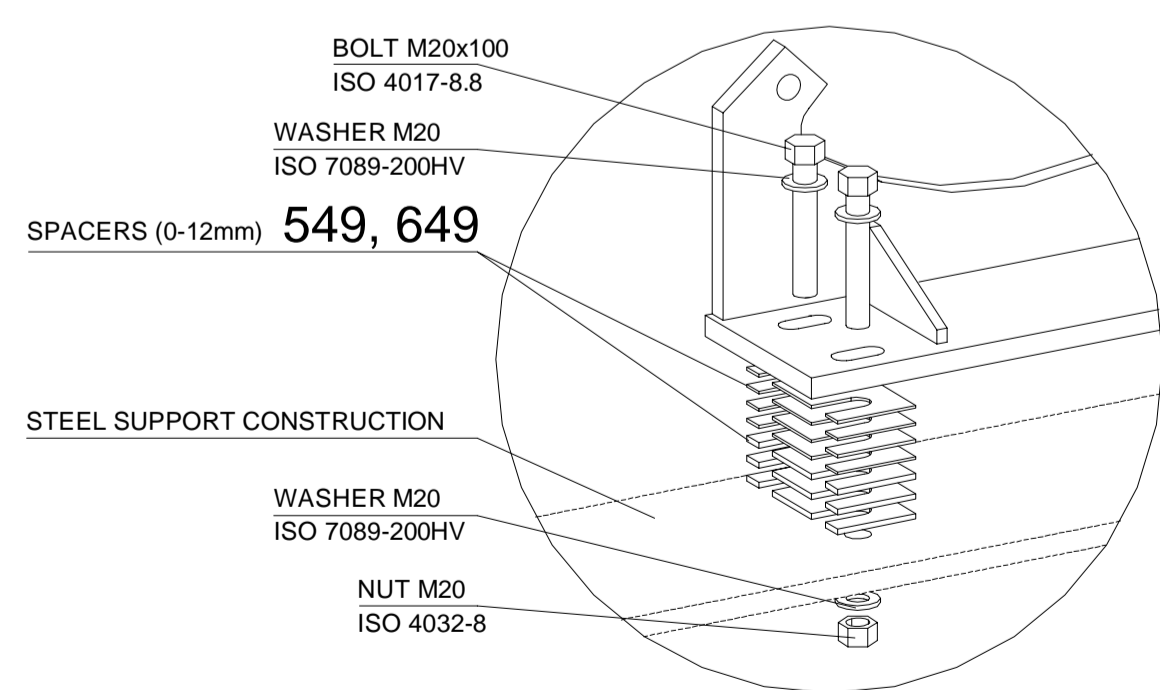
DETAIL X2



DETAIL Y1



DETAIL Y2



- 1 MANUFACTURING NOTES**
- All steel parts have to be hot-dip galvanized accord. CSA G-164M Zinc coating min. 87 µm (610 g/m²).
 - Hot dip galvanized threads to be brushed prior to assembly.
 - Welding seams to be continuous and accord. EN ISO 3834-1/-2.
 - All welds shall be all around fillet welds unless otherwise noted.
- 1.5 Thickness of welding seams:
-
- a min = 4 mm unless noted otherwise
a < max (0,7*1; 0,7*2)
- Dimension tolerances accord. EN ISO 13920 class A/E, EN 22768-1/-2 class m.
 - Material Quality/Rolling profile accord. EN 10025, EN 10219 Class S355JR if not other declared in manufacturing request.
 - Roughness of longholes accord. EN ISO 1302 roughness N8.
 - All bolts, nuts, washers, etc. have to be hot-dip galvanized accord. CSA G-164M.

- 2 ASSEMBLY RULES**
- Damaged parts, bolts and anchoring bolts have to be zinc painted after assembling.
 - Tightening torque for bolts
 - For fixed connections

for hot-dip galvanized bolts.

	M12	M16	M20	M24
Hex. Bolt Class 8.8 steel/ steel	70	175	340	580
Hex. Bolt Class 8.8 steel/ aluminum	42	90		

2.2.2 For sliding connections with PTFE-material: Torque in Nm.

- First nut with max. torque of 0,5% of values of table 2.1
- Second nut with torque acc. table 2.1

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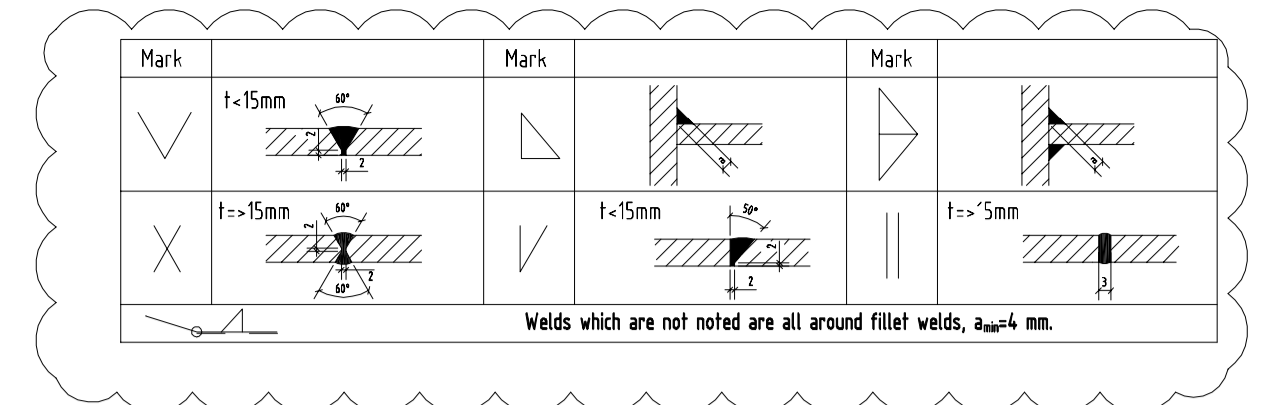
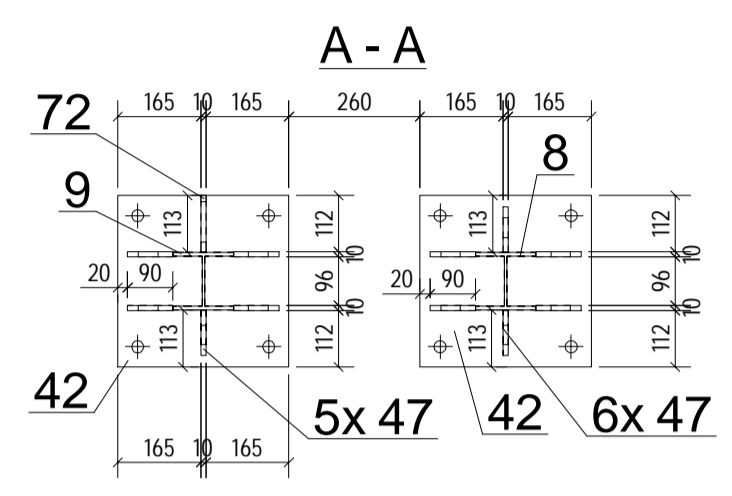
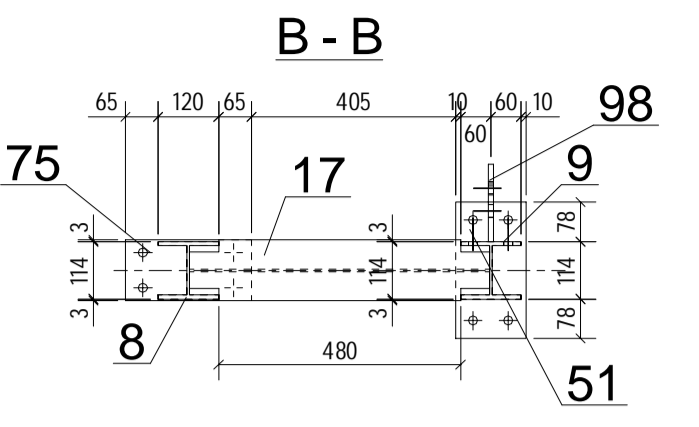
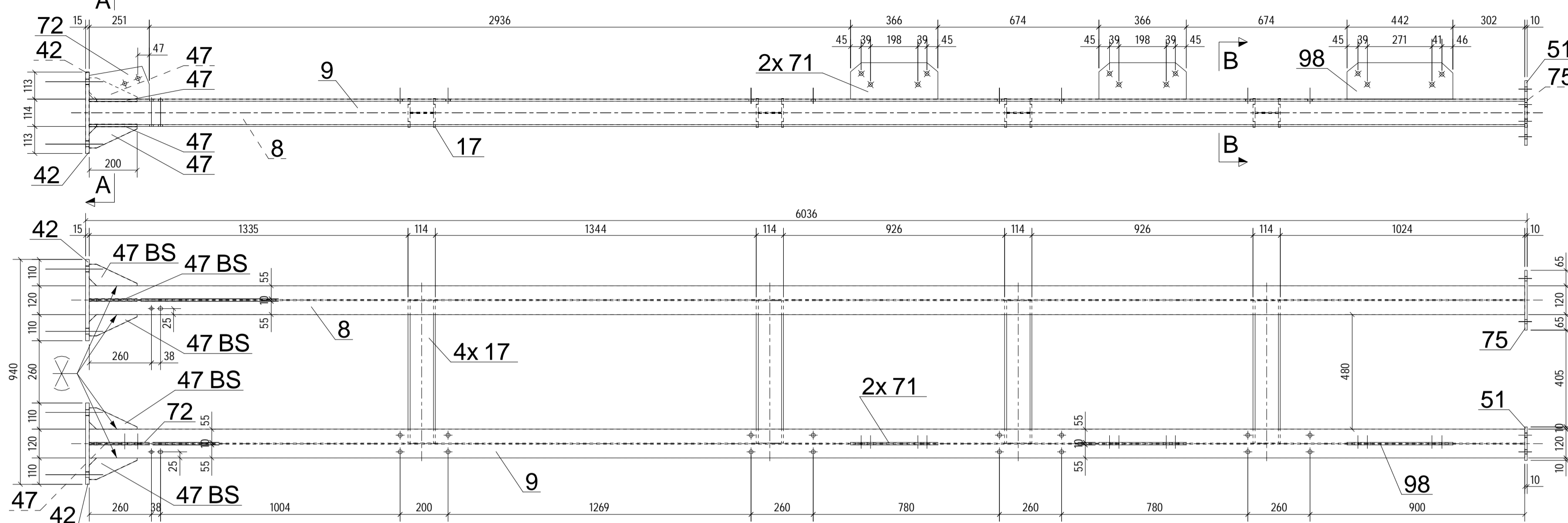
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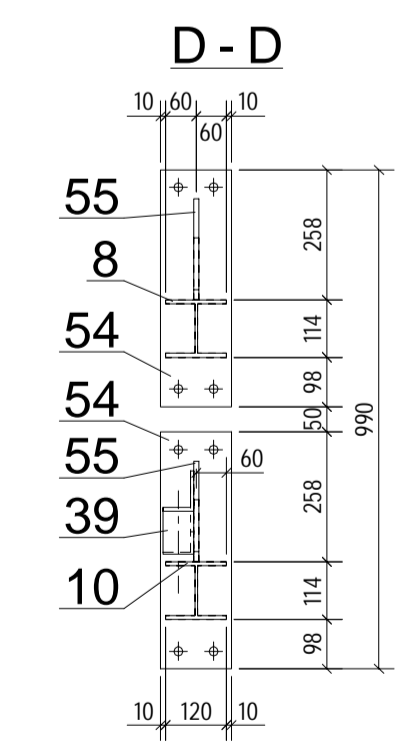
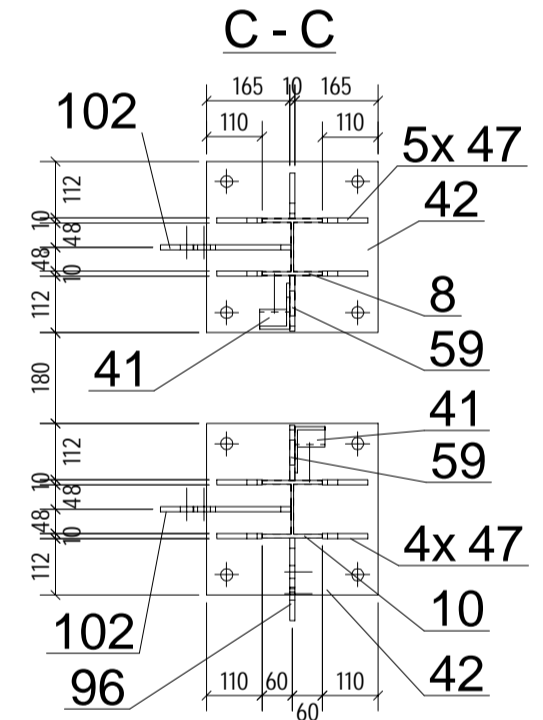
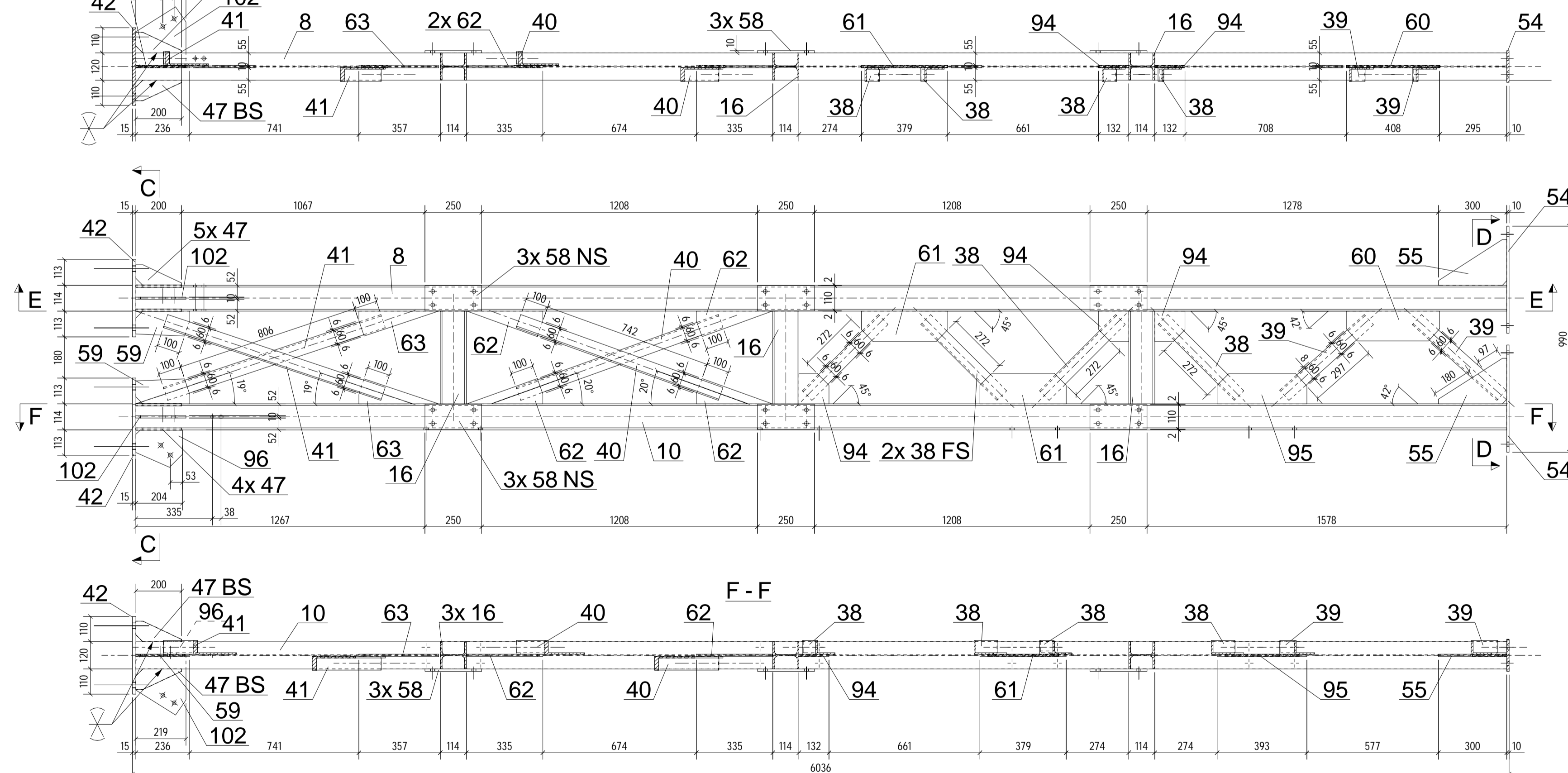
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R1



R2

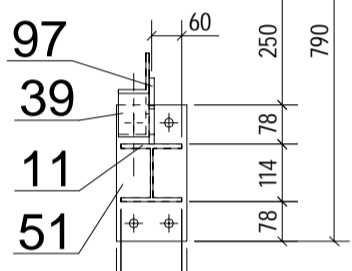
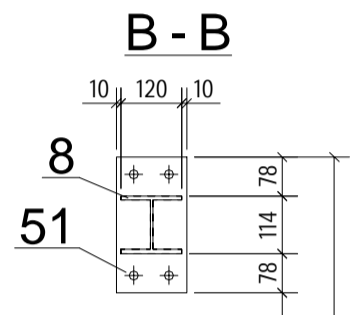
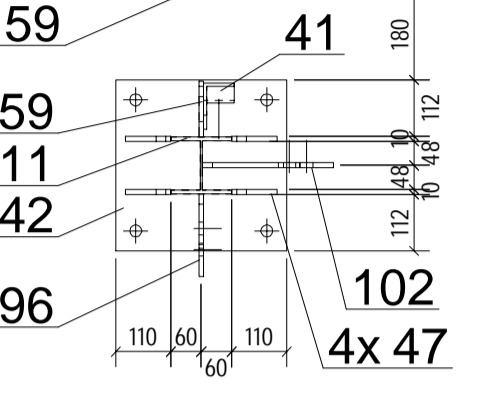
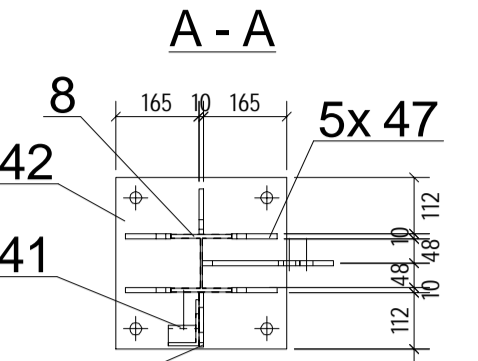
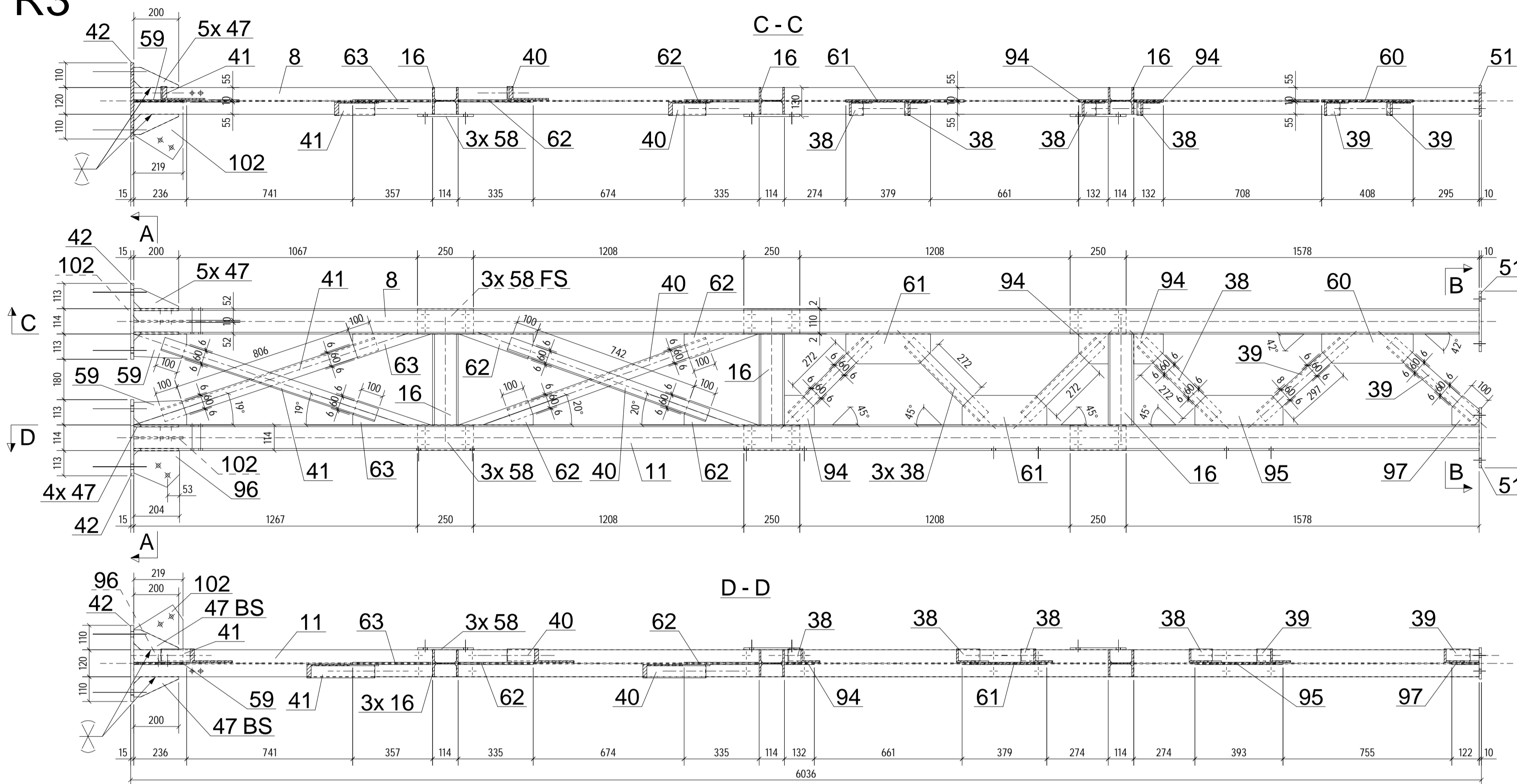


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 FS- FAR SIDE
 BS- BOTH SIDES
 CLASS OF STEEL S355JR
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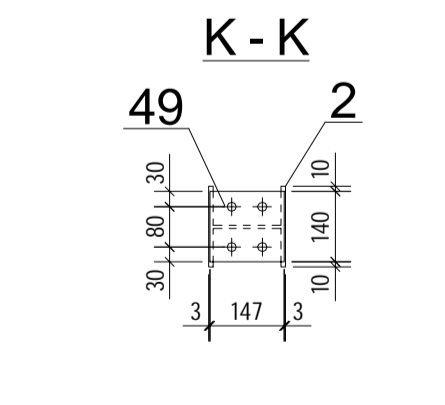
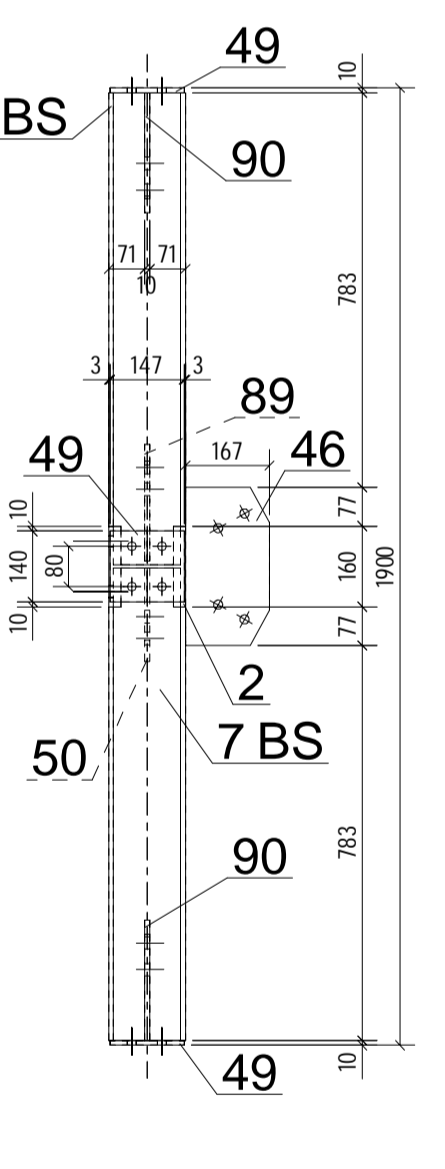
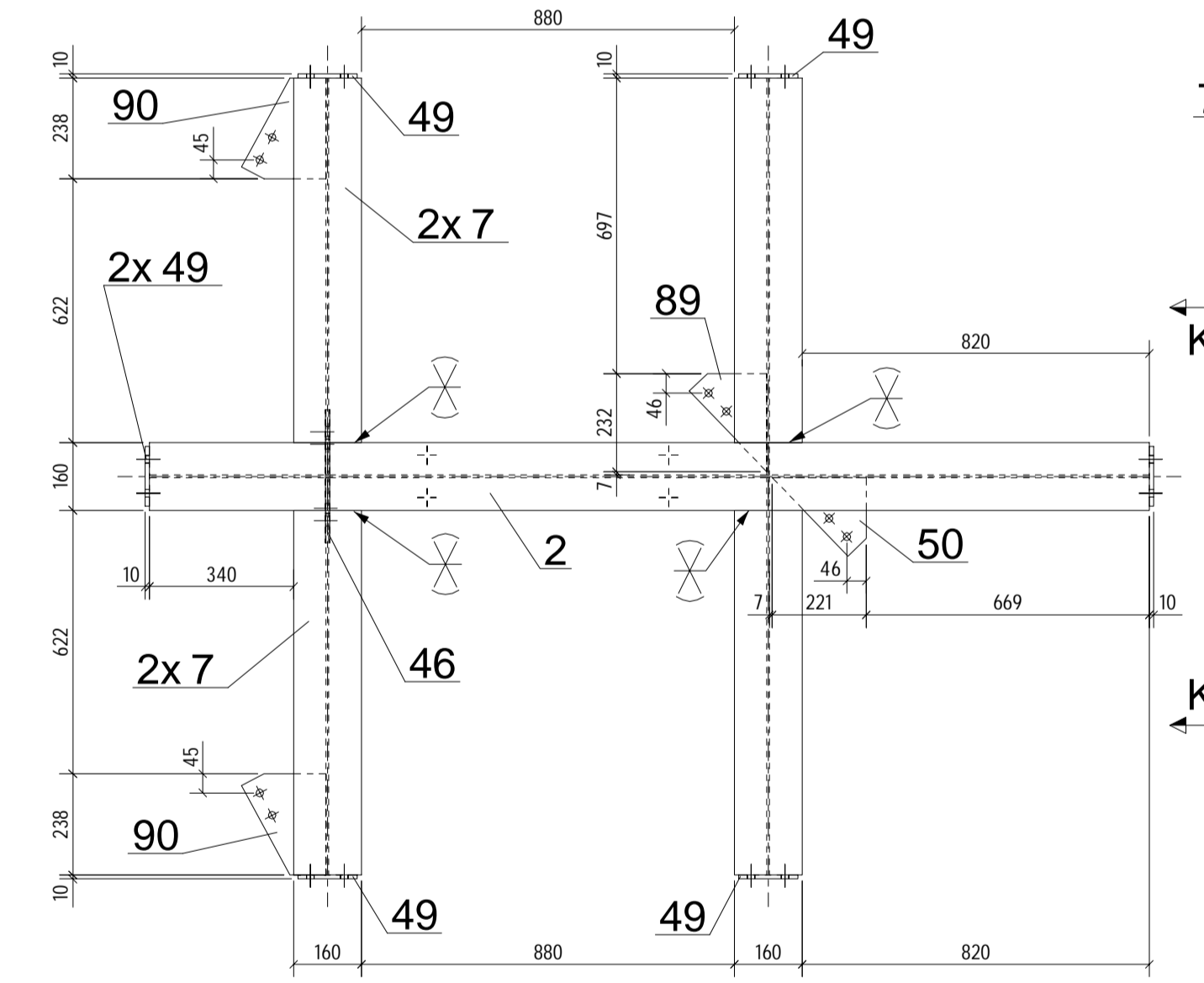
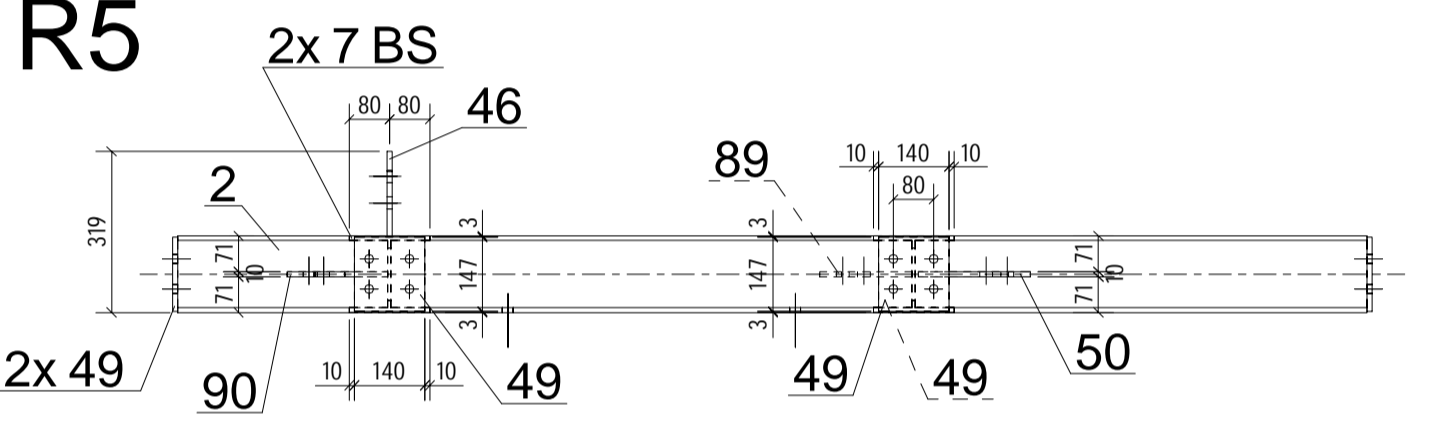
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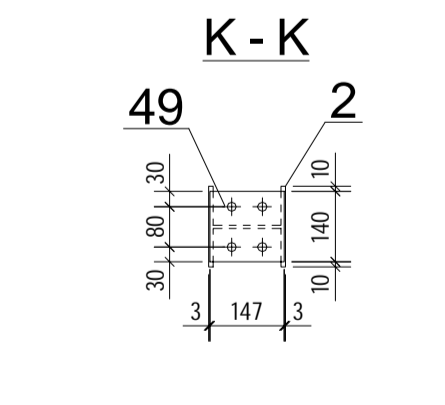
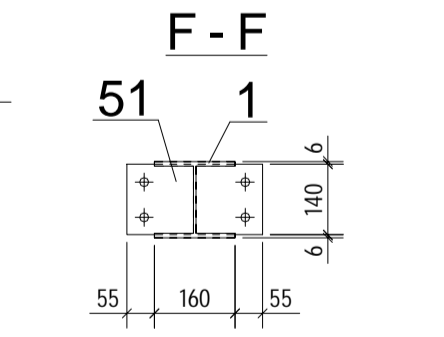
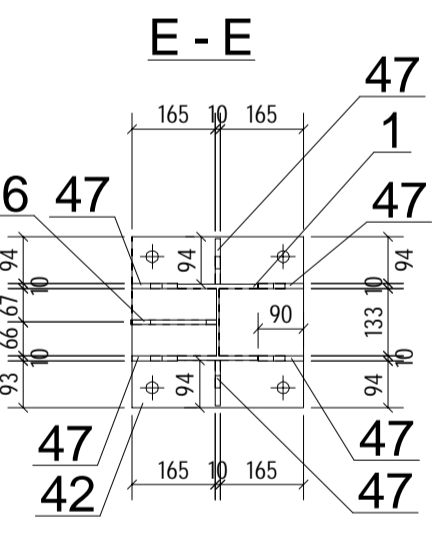
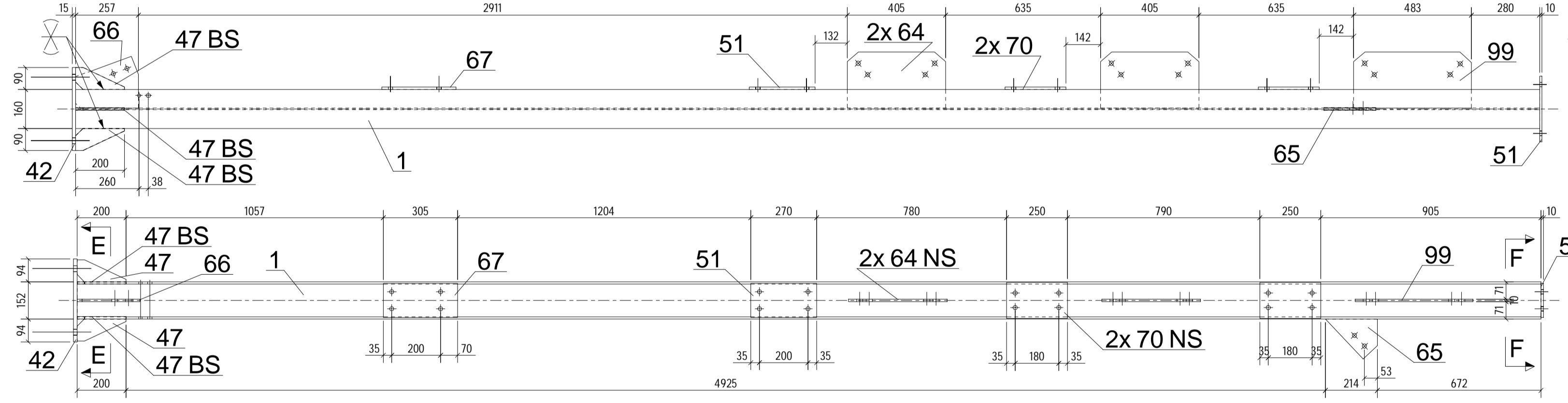
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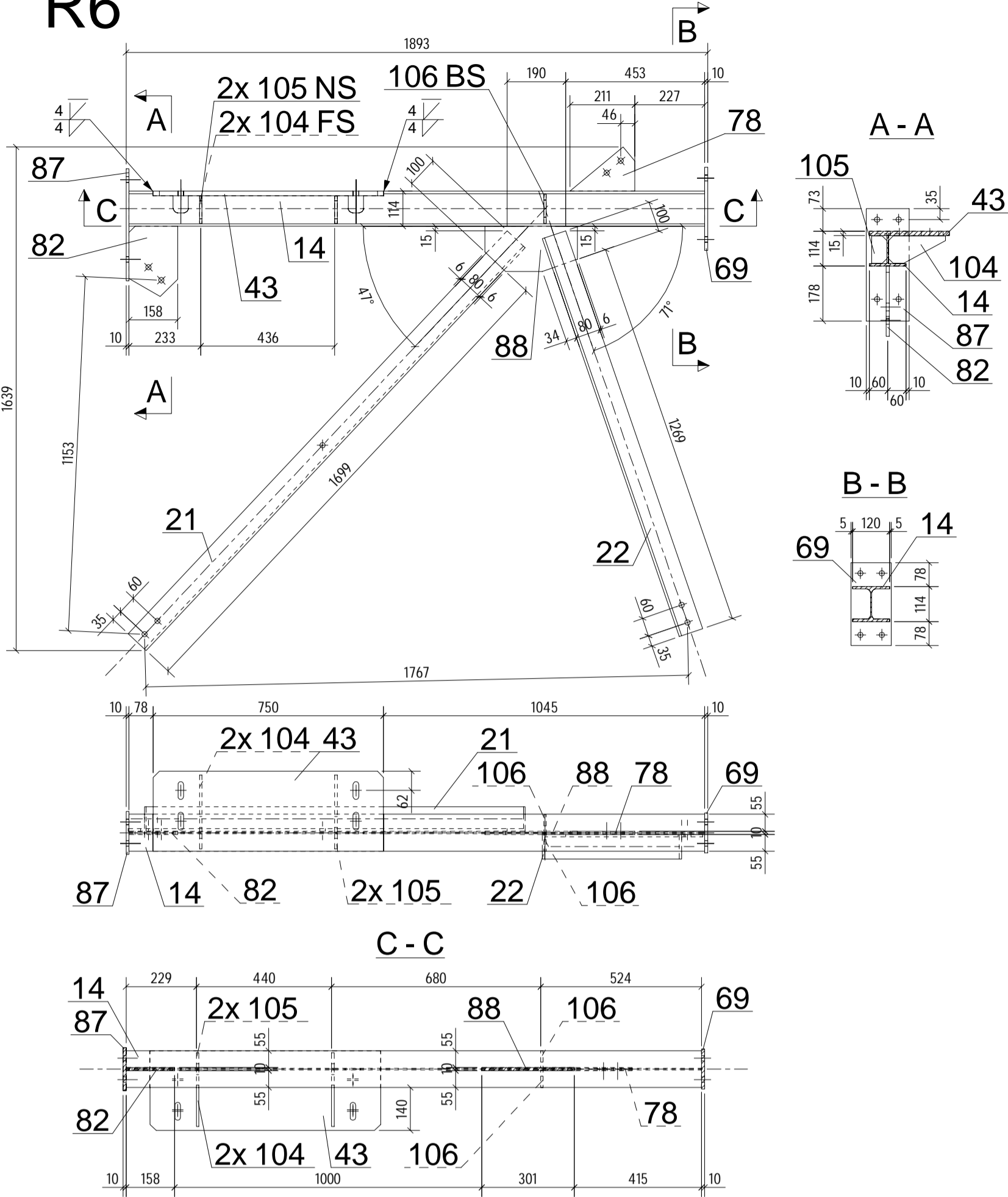


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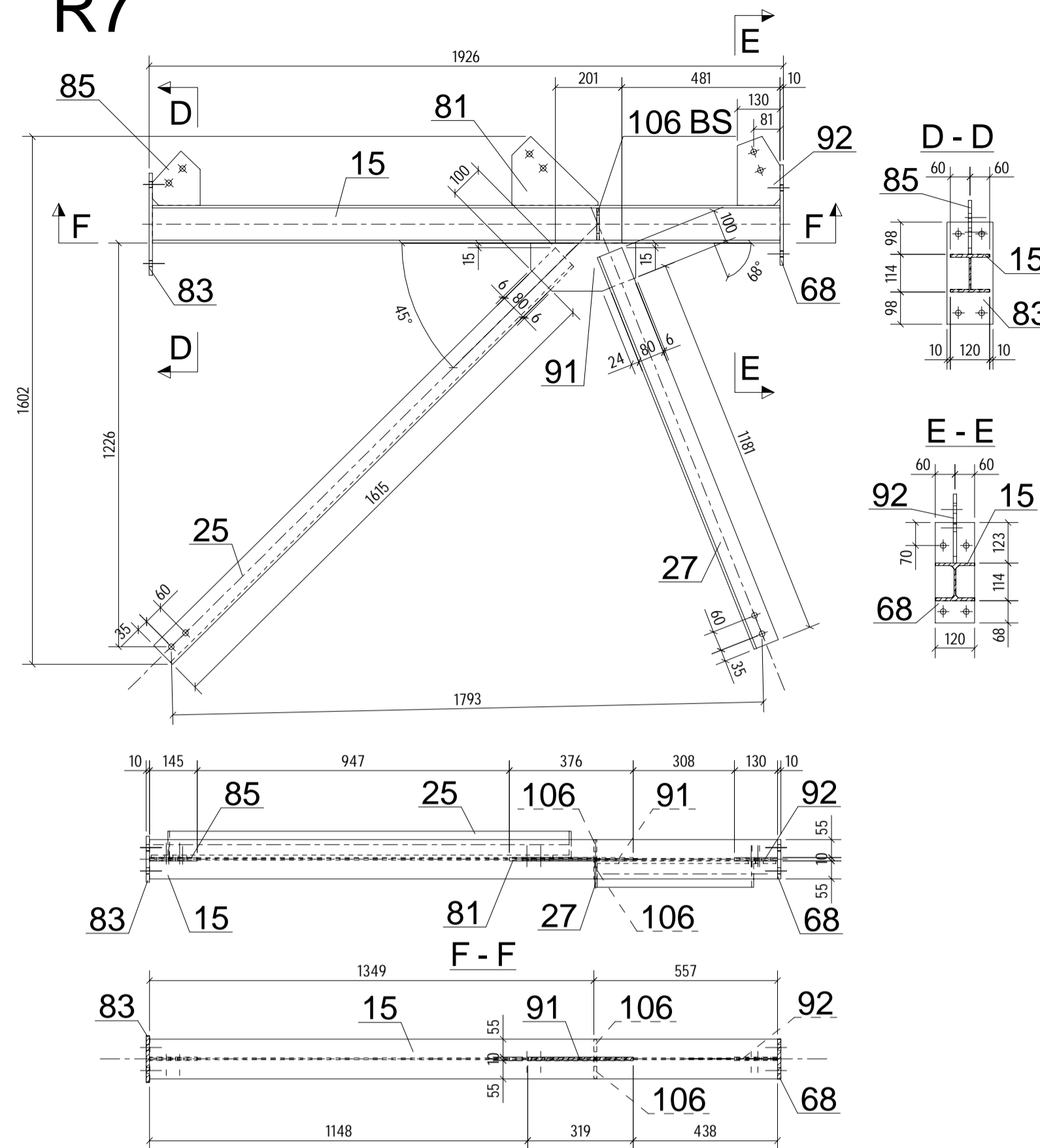
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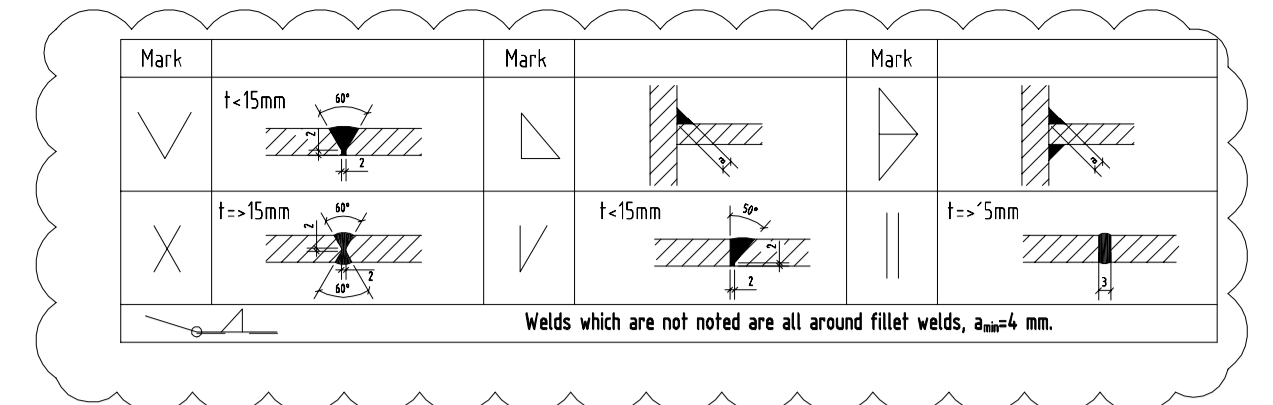
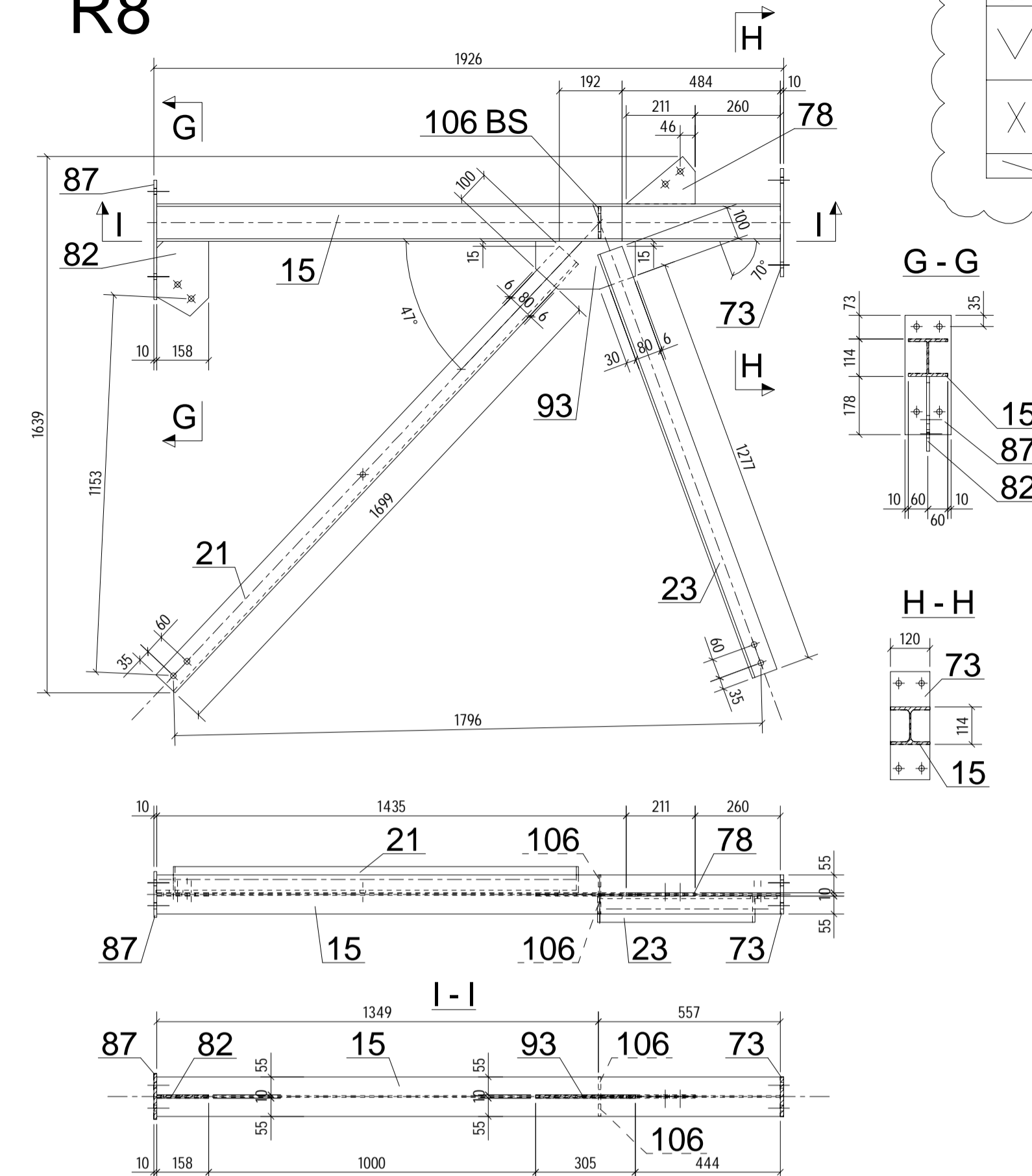
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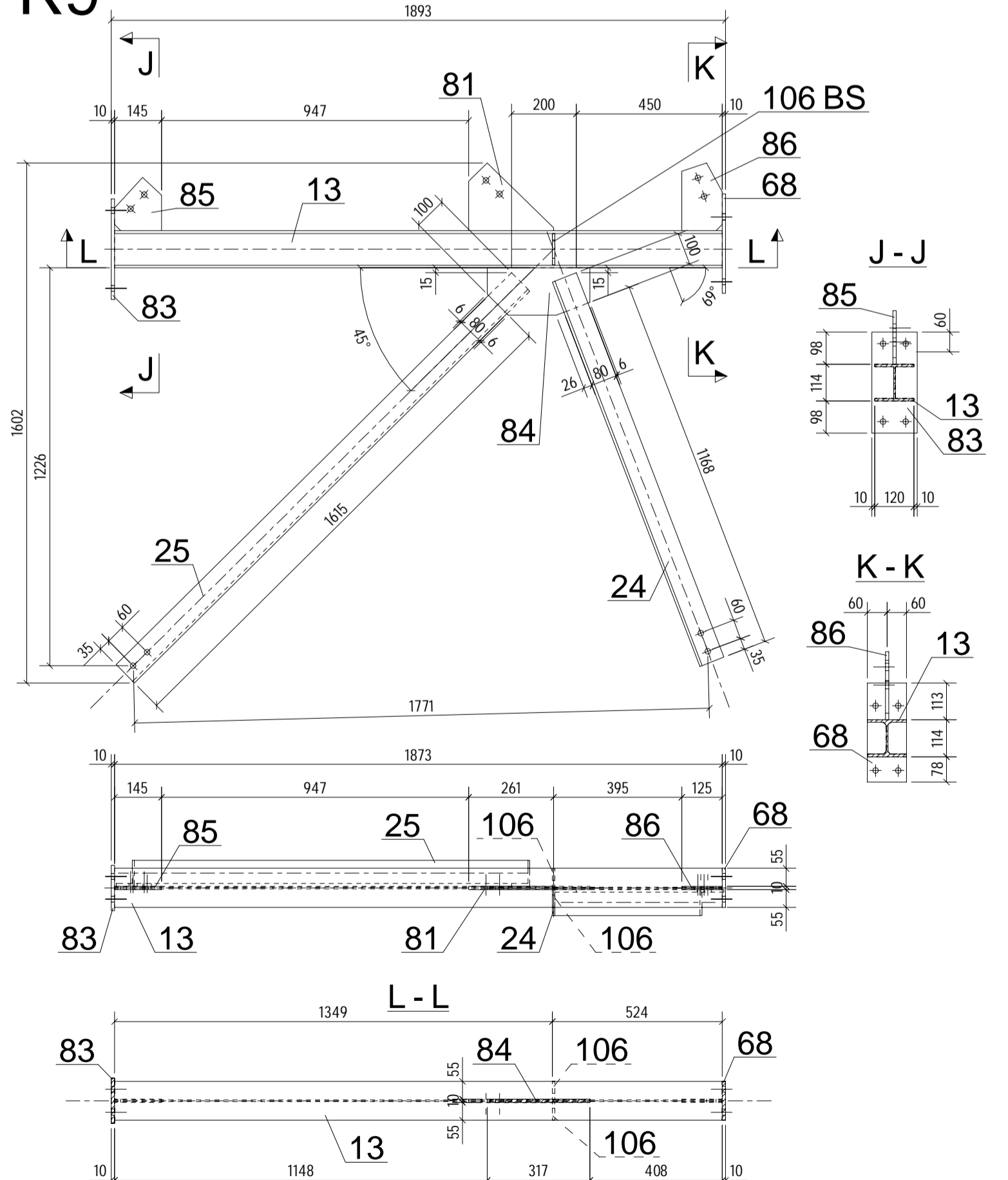
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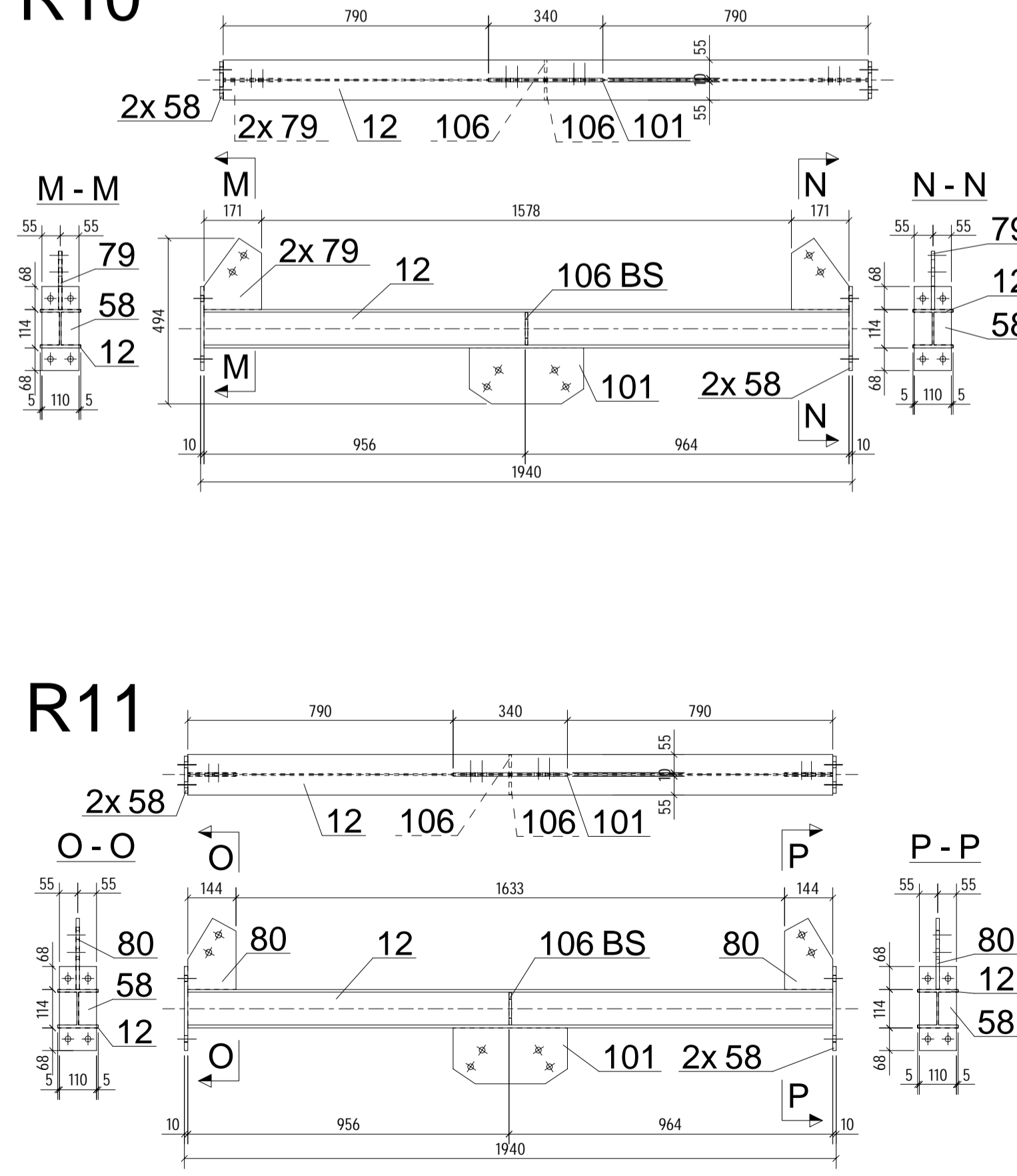
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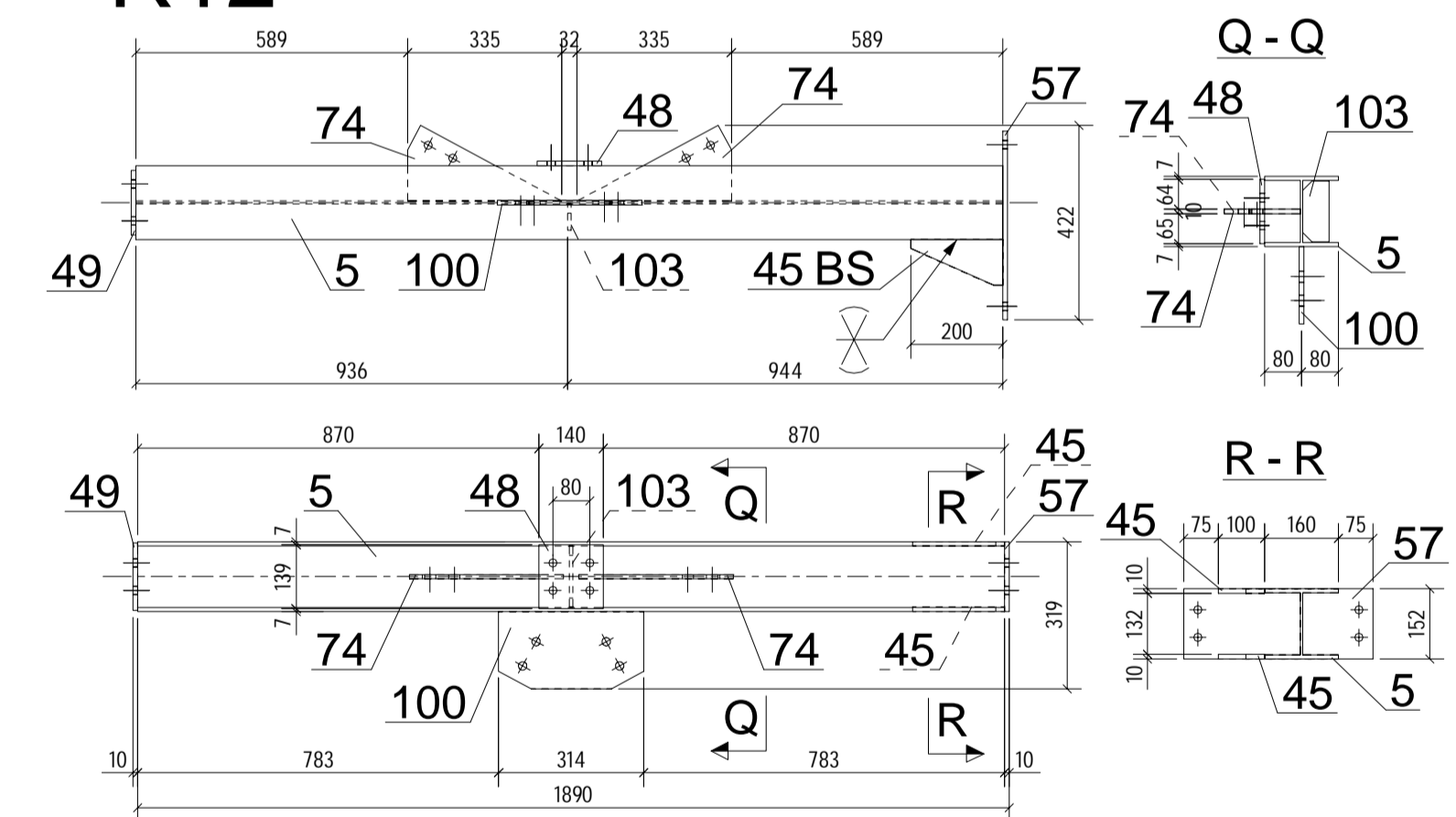
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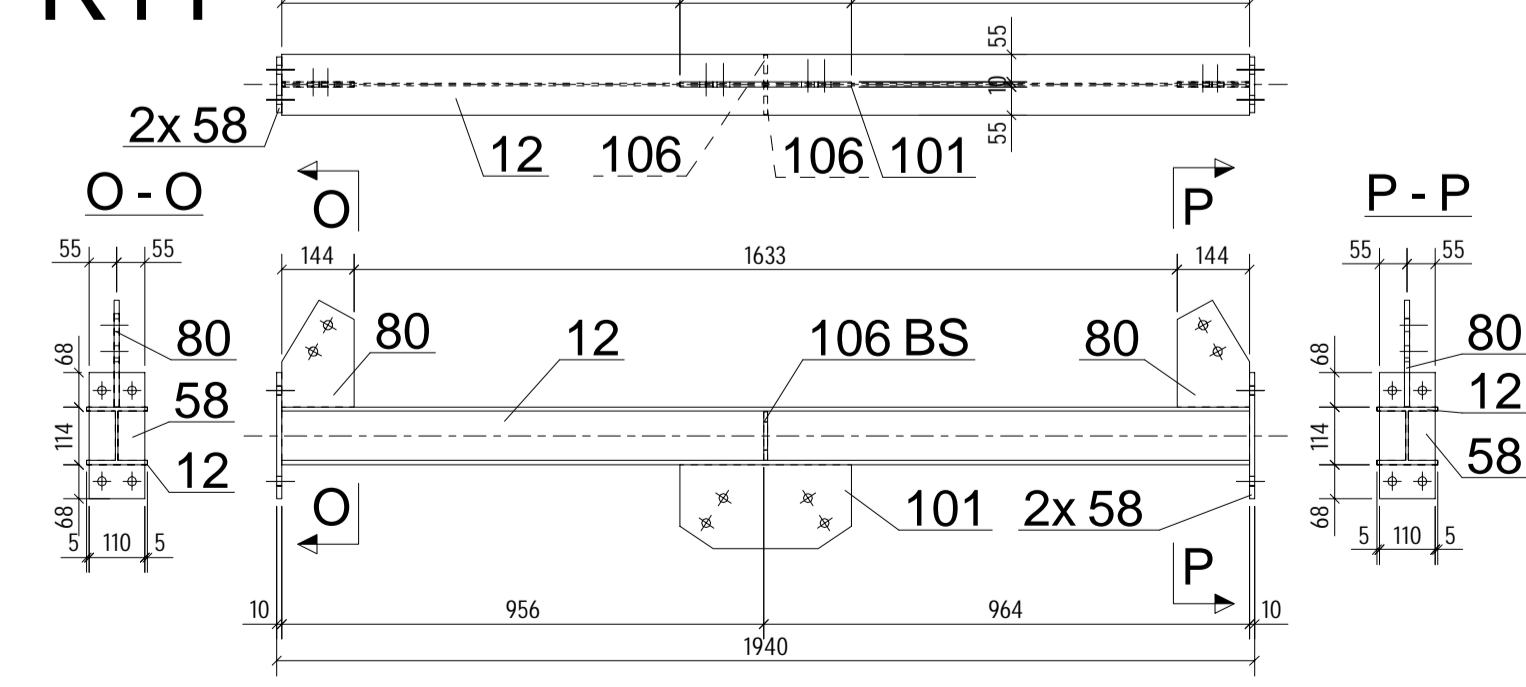
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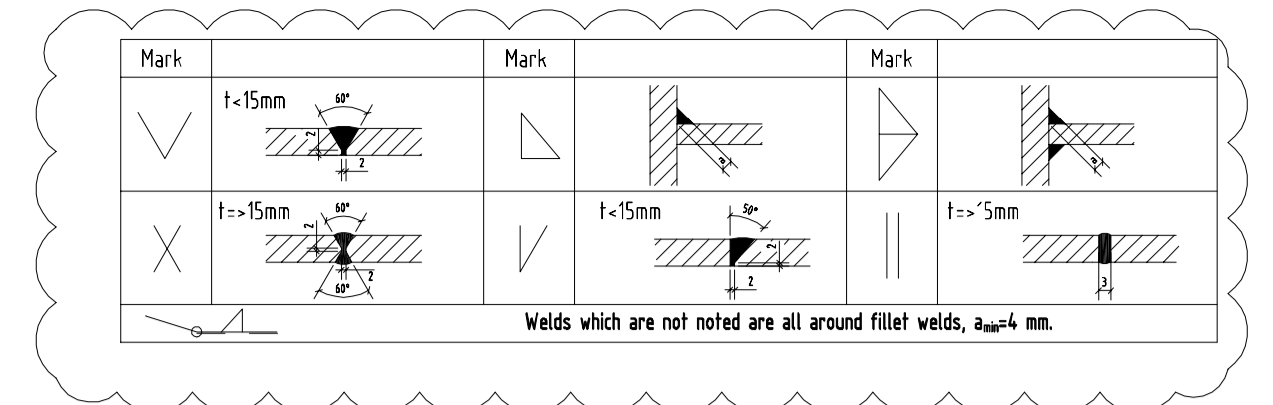
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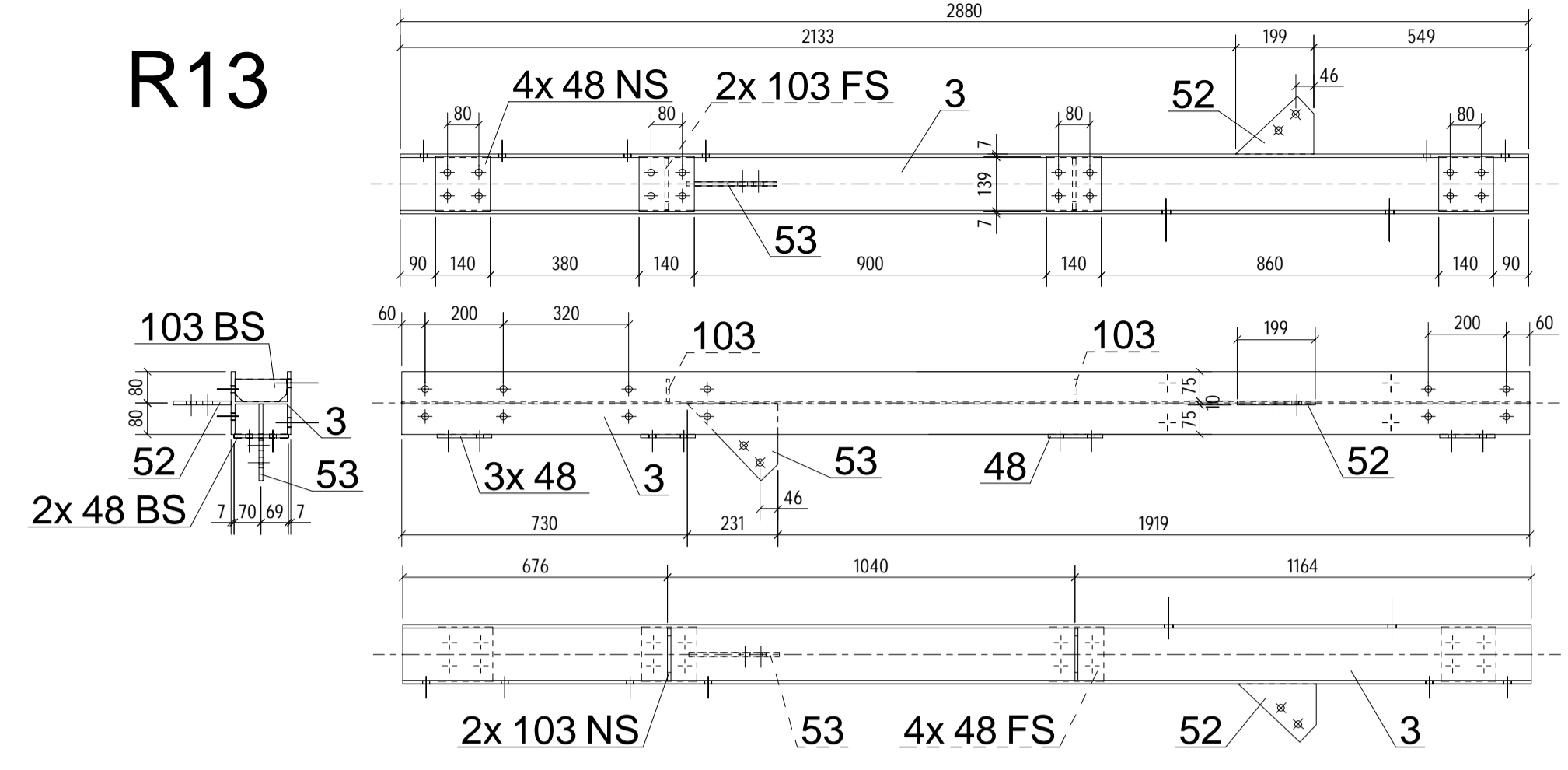
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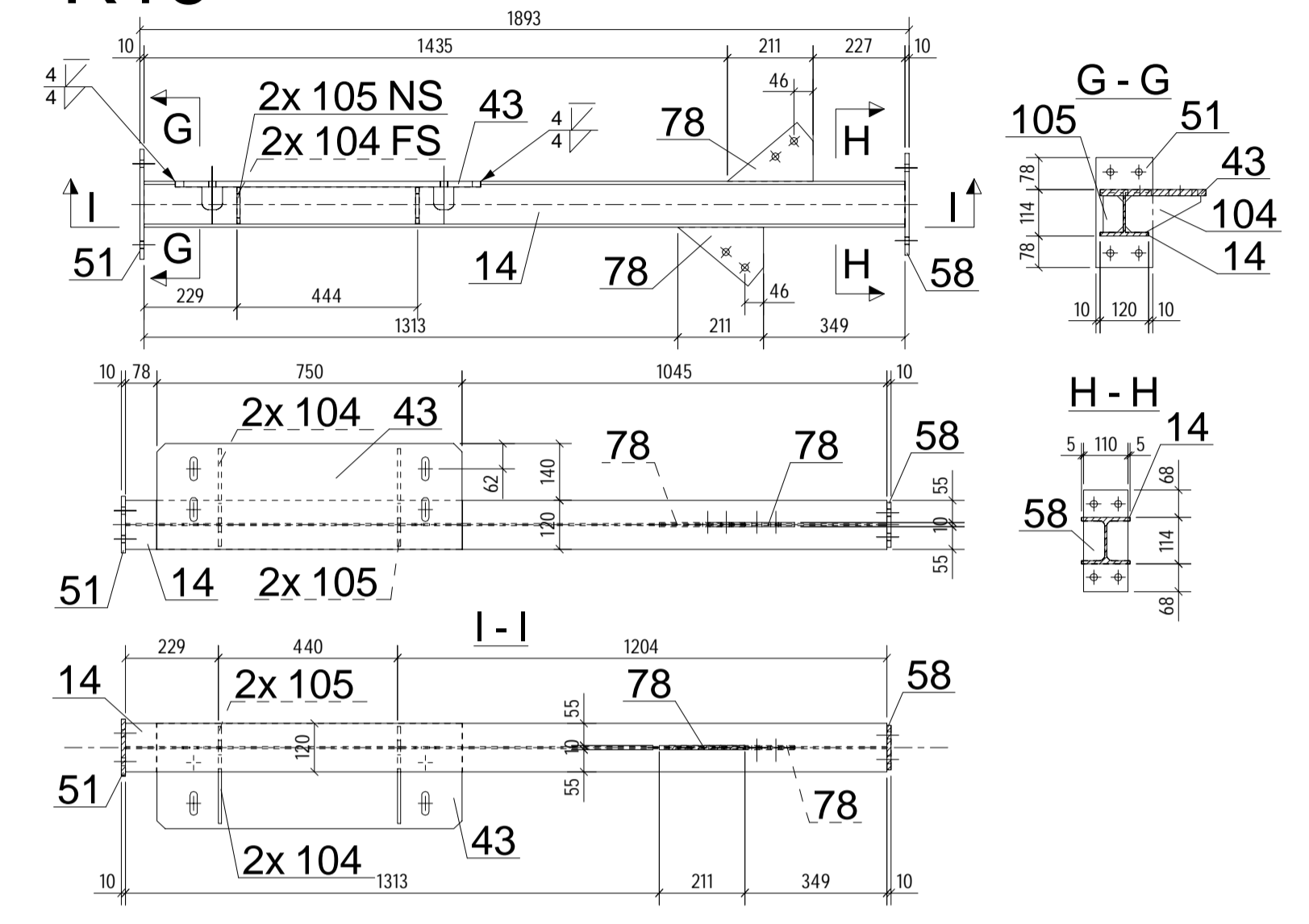
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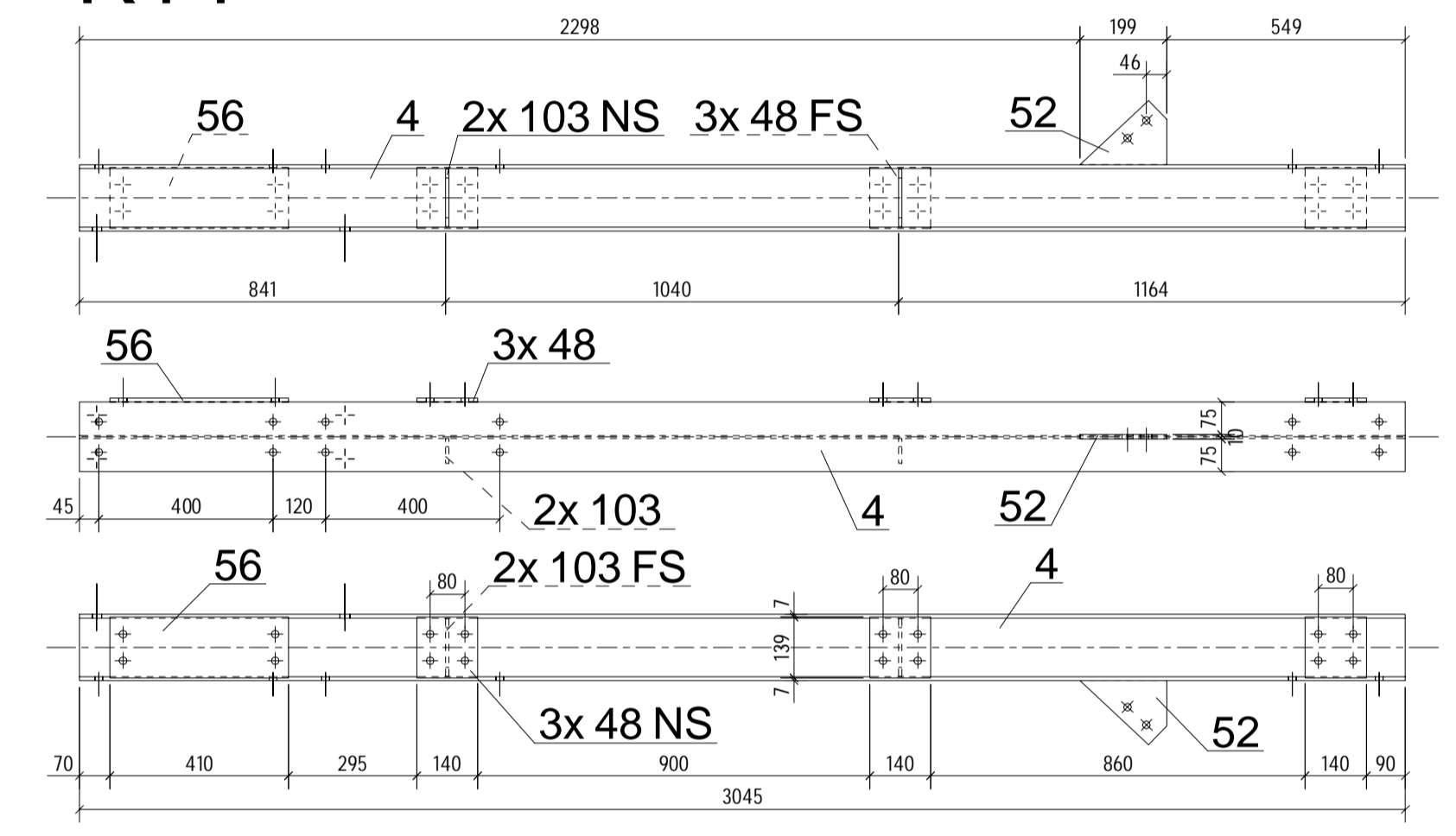
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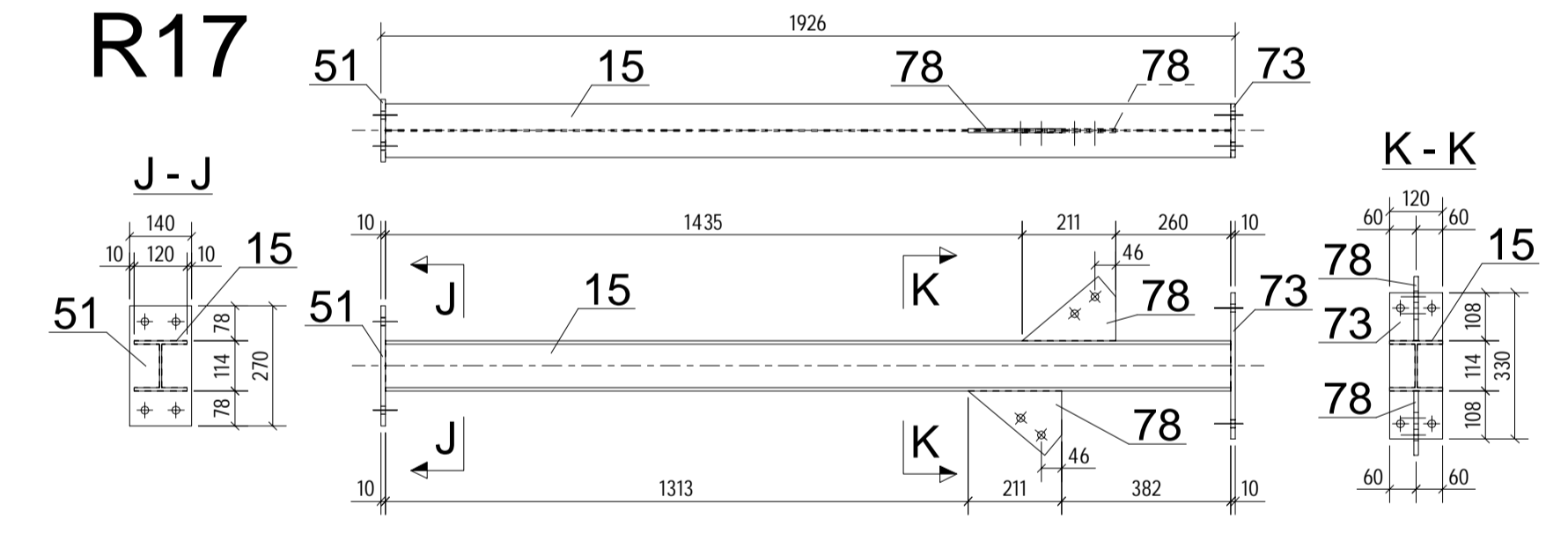
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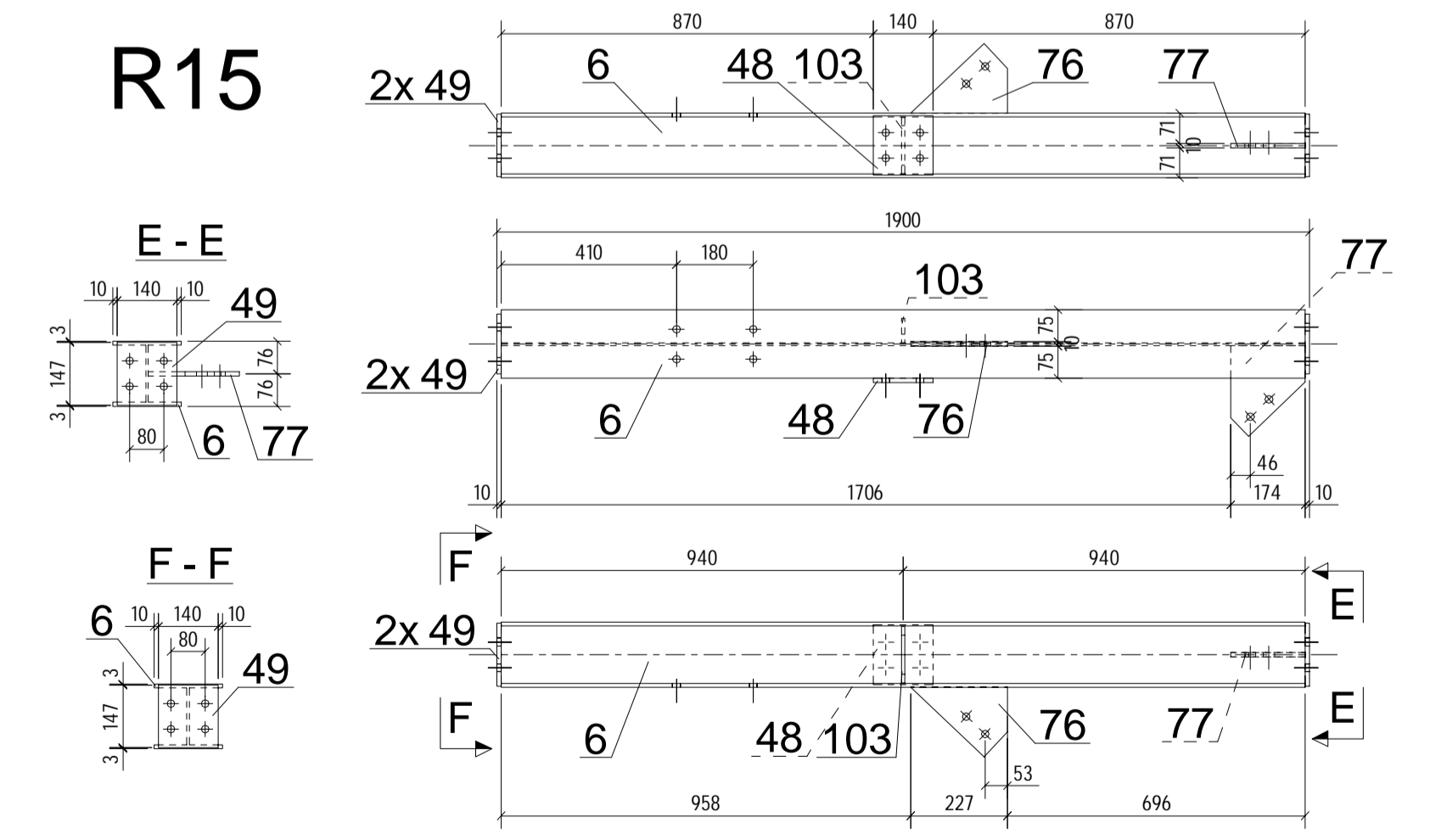
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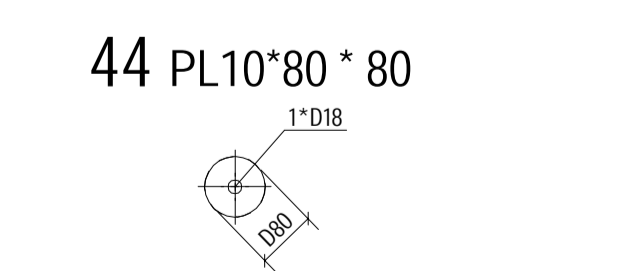
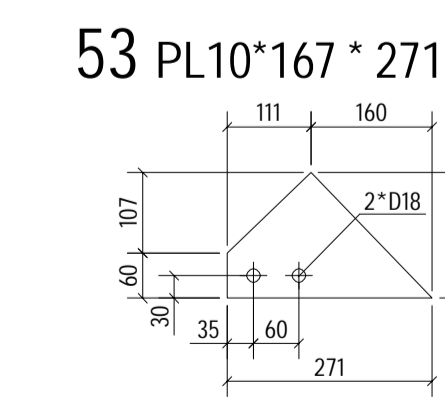
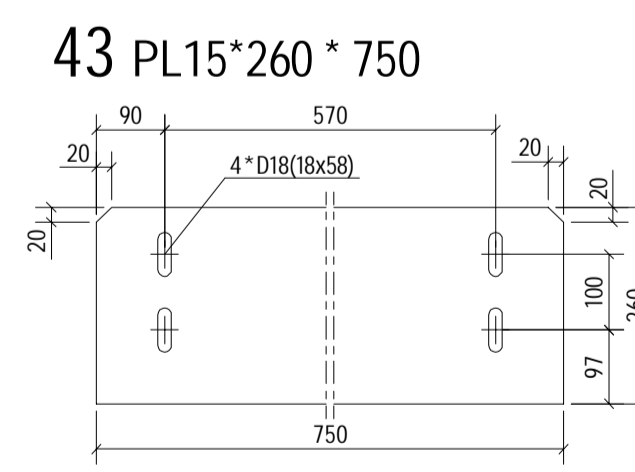
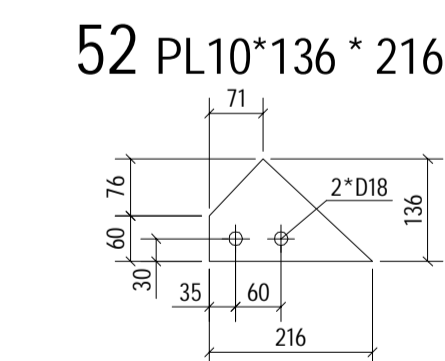
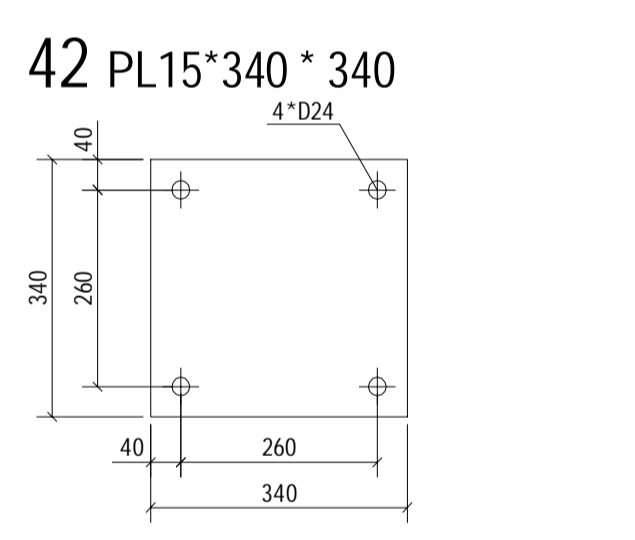
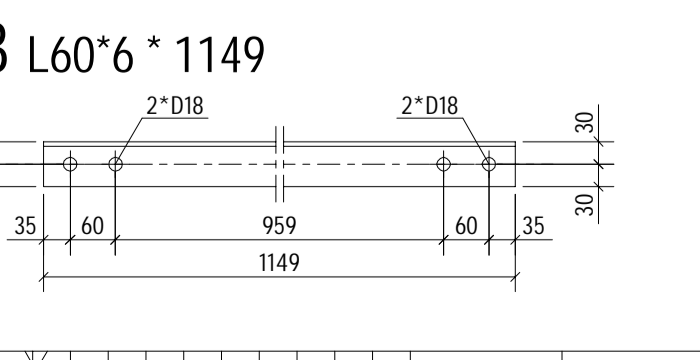
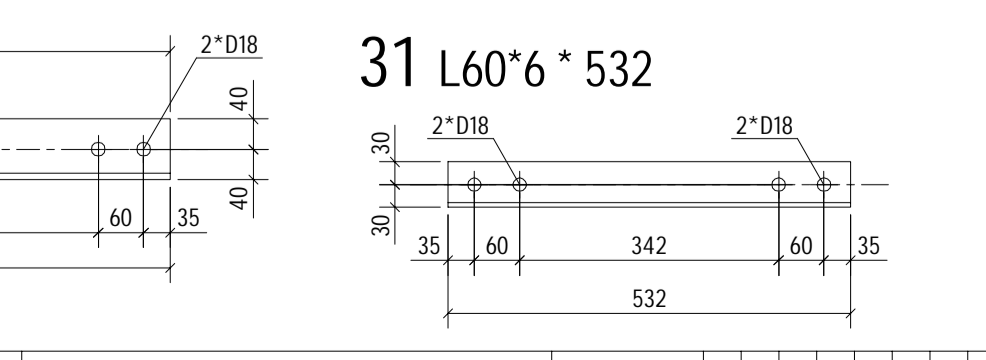
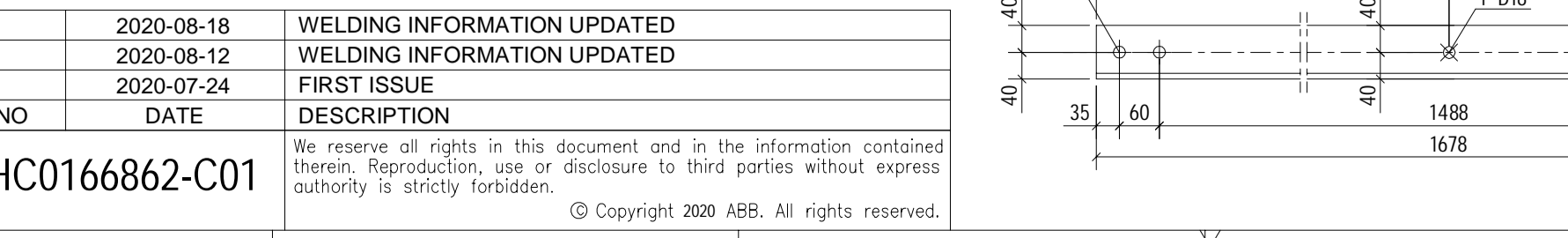
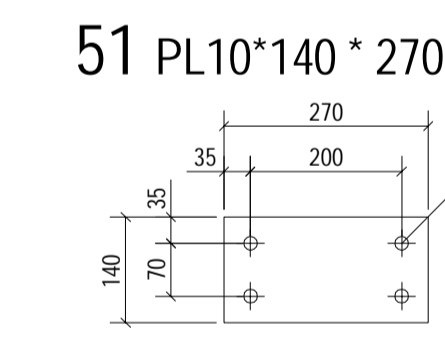
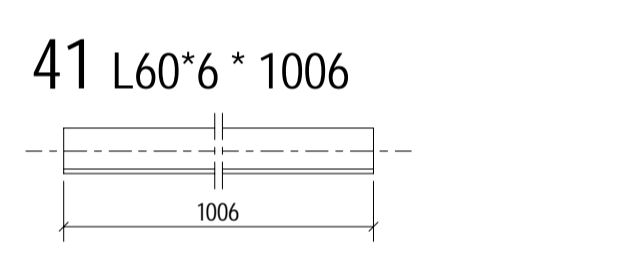
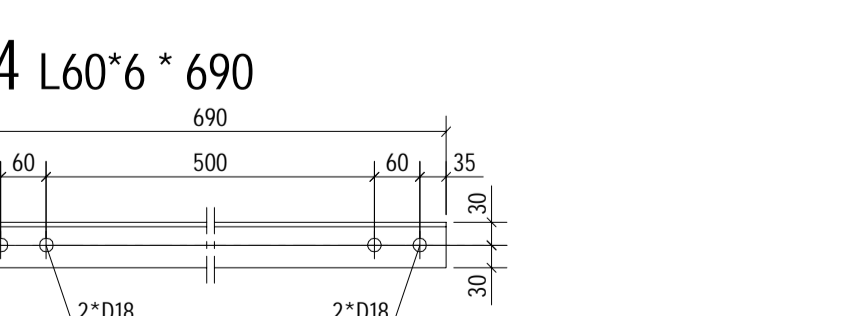
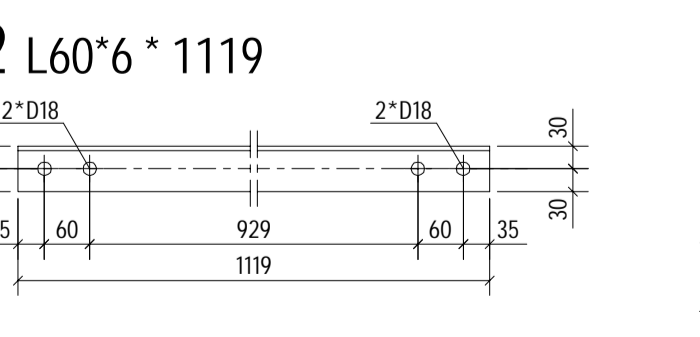
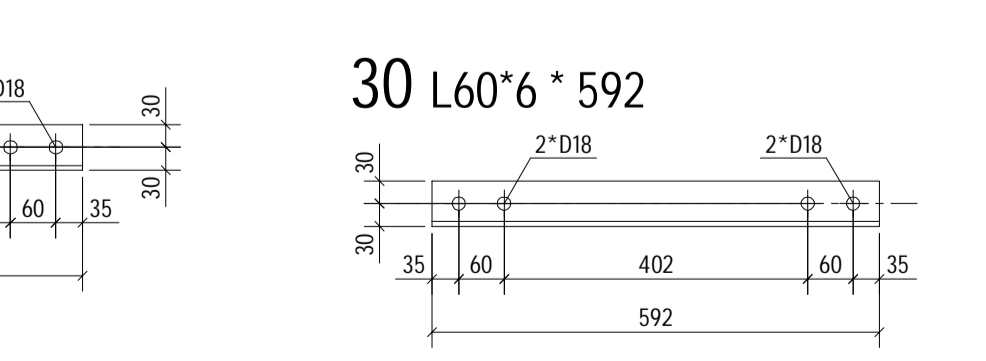
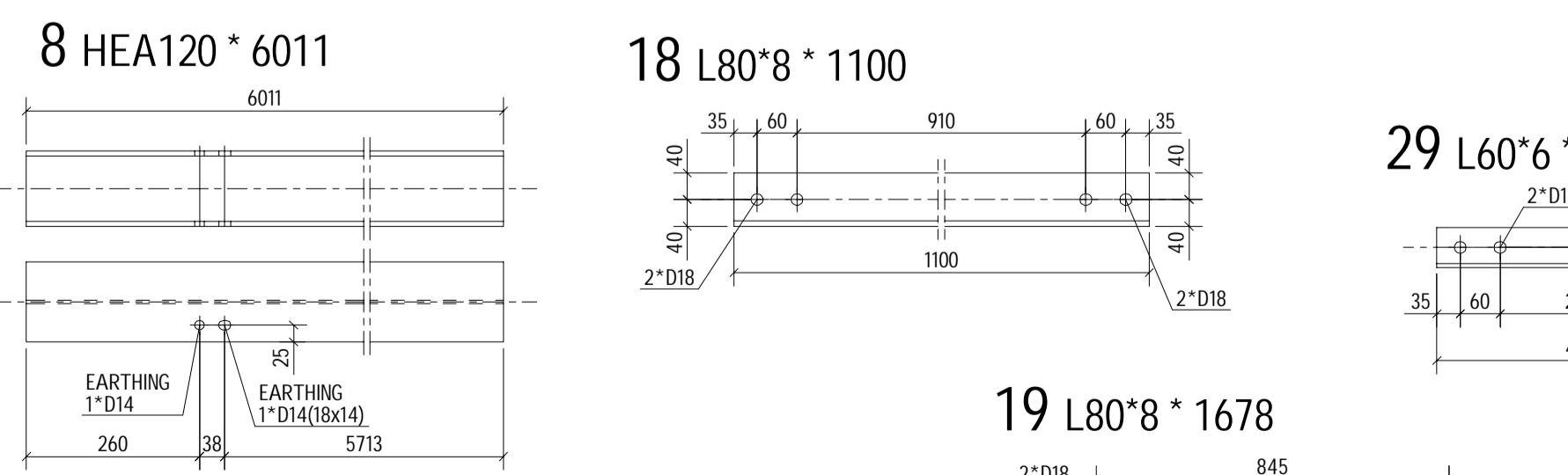
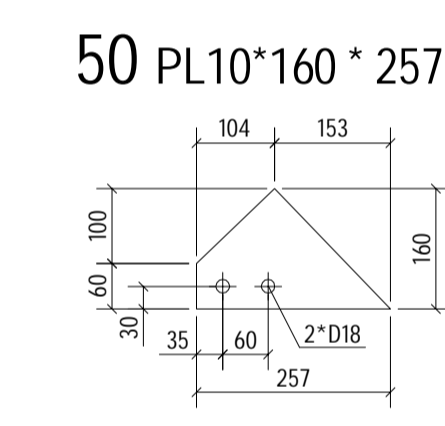
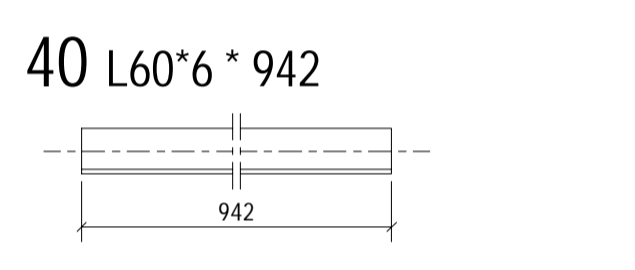
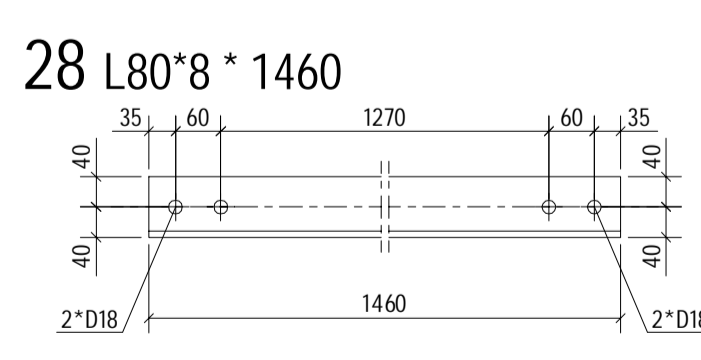
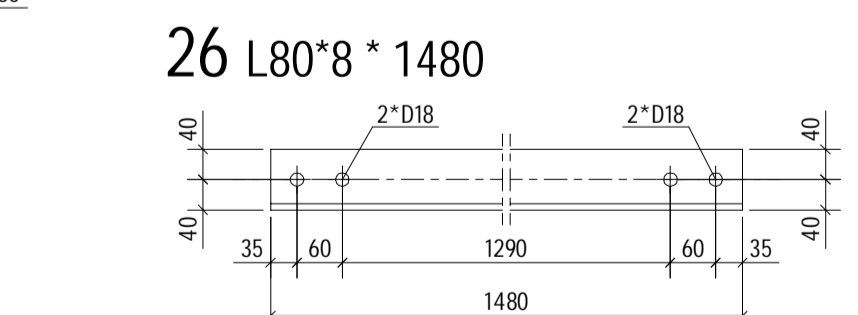
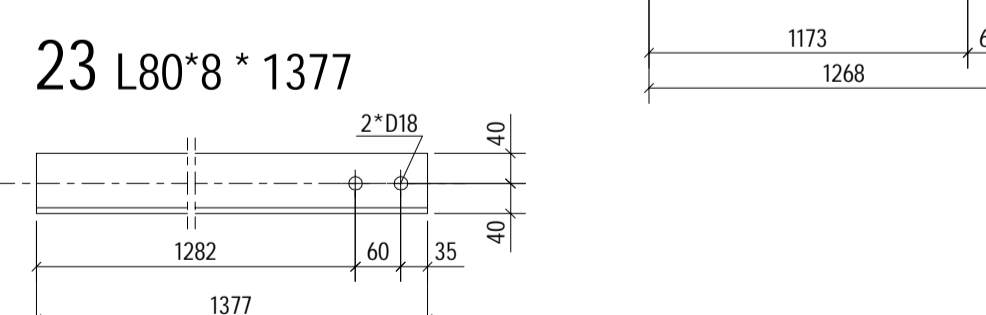
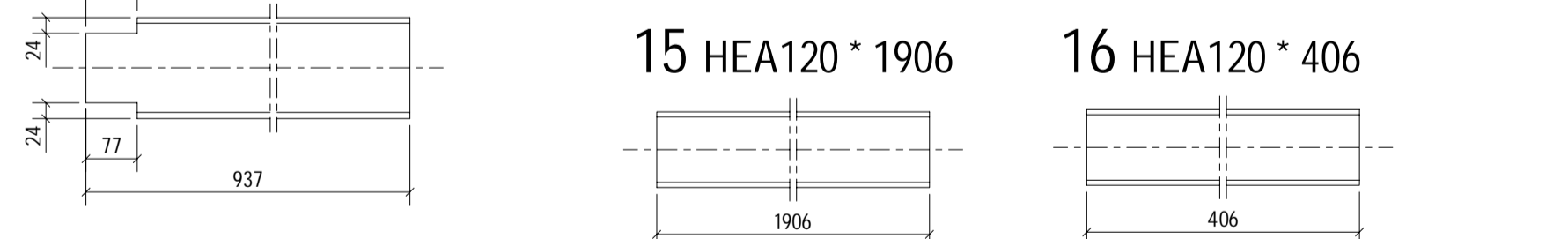
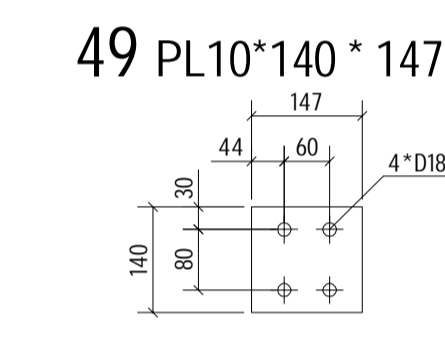
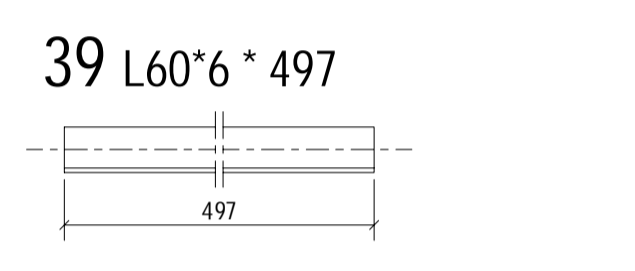
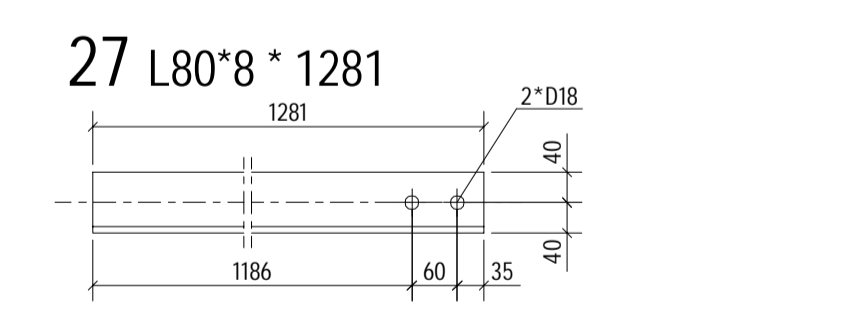
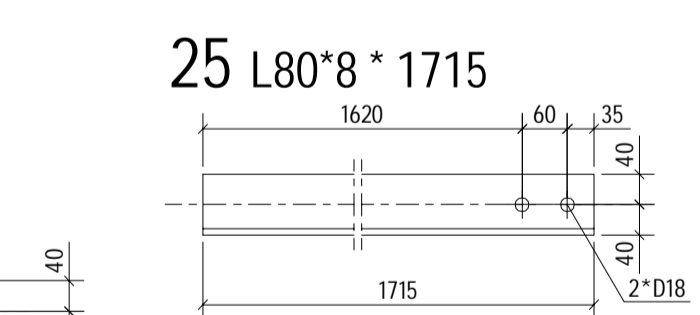
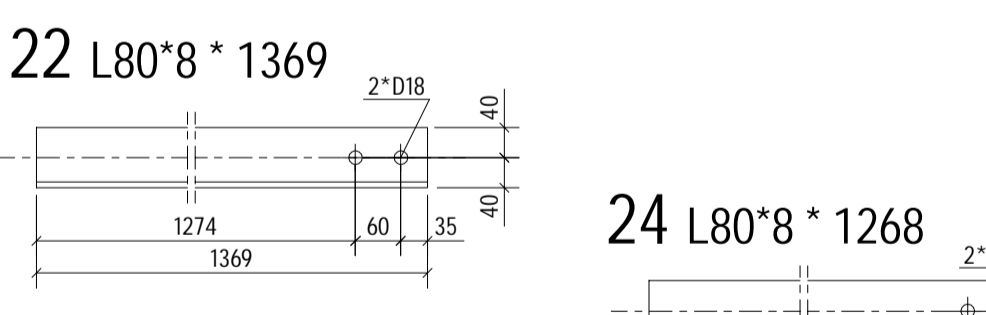
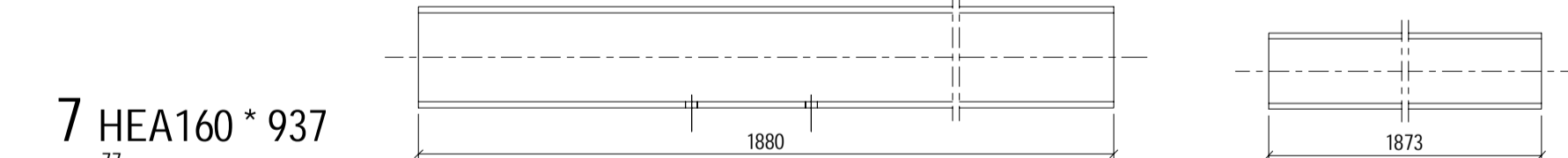
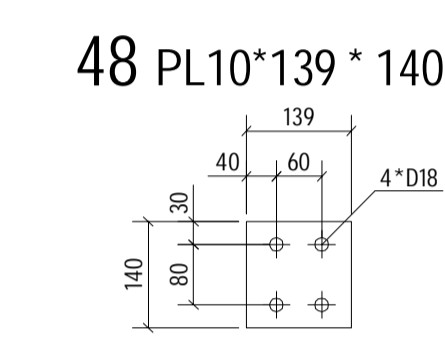
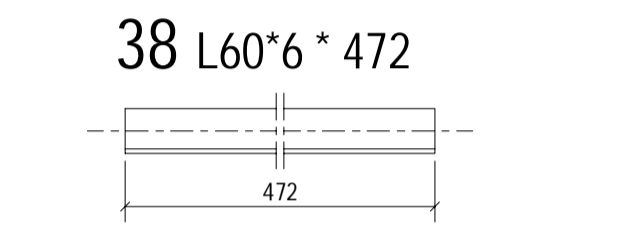
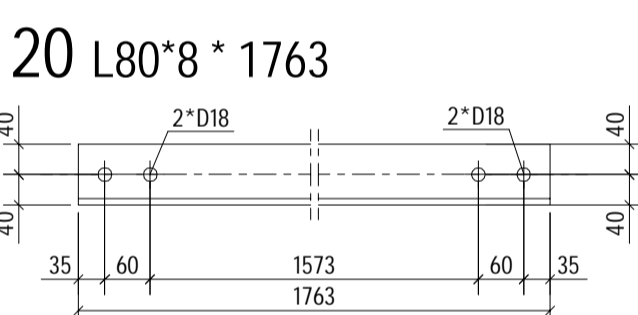
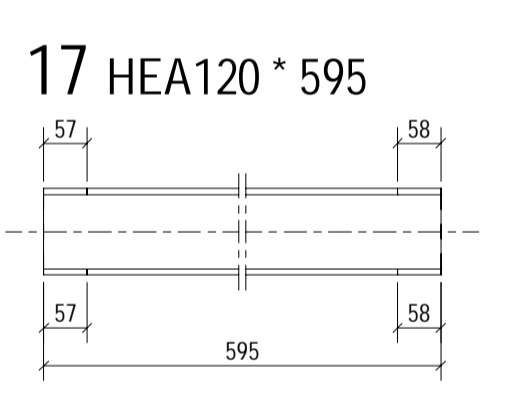
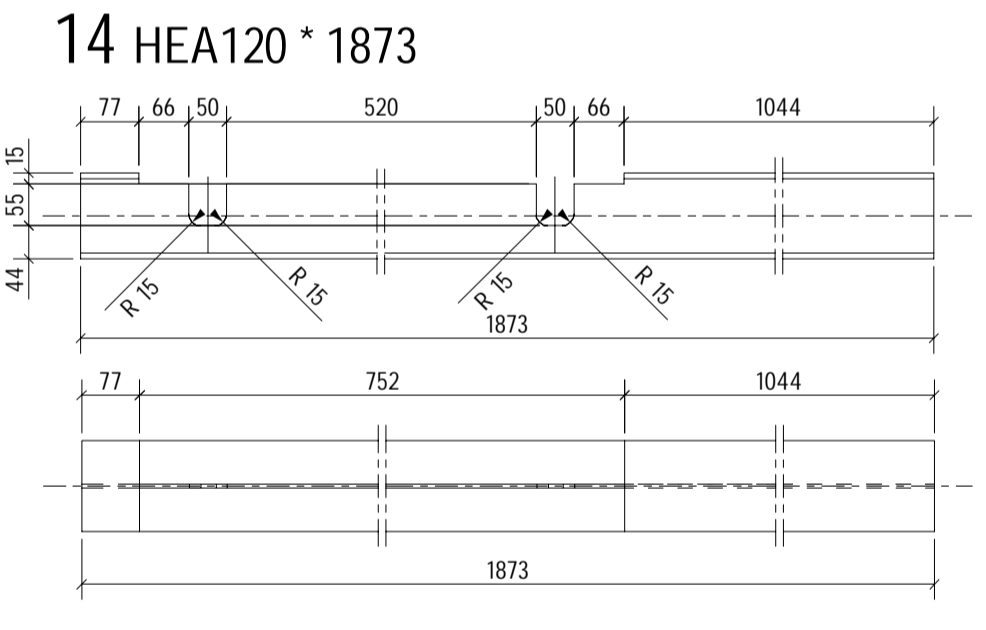
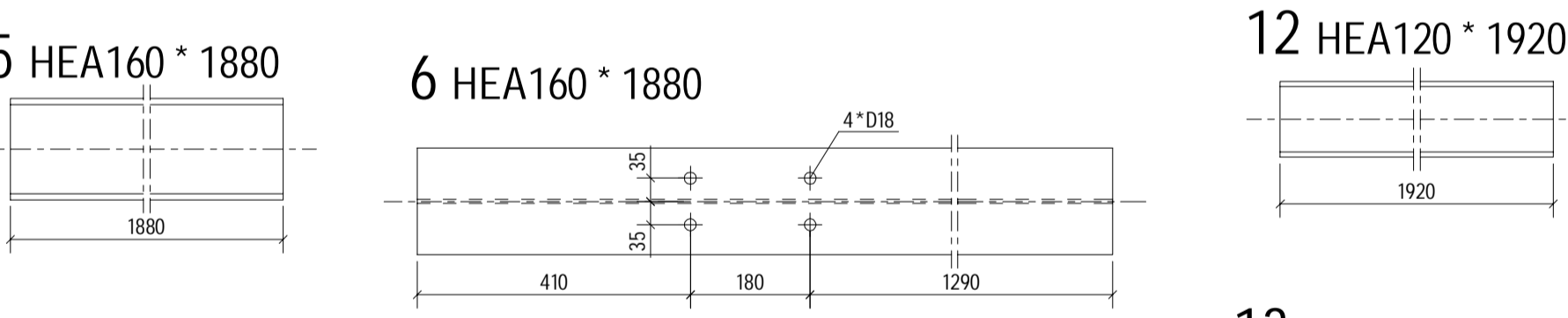
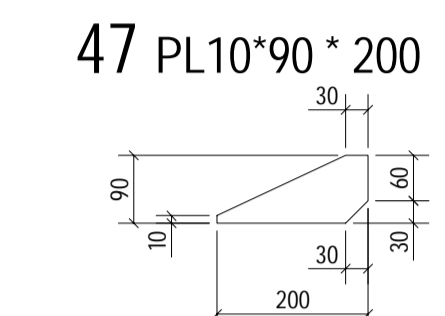
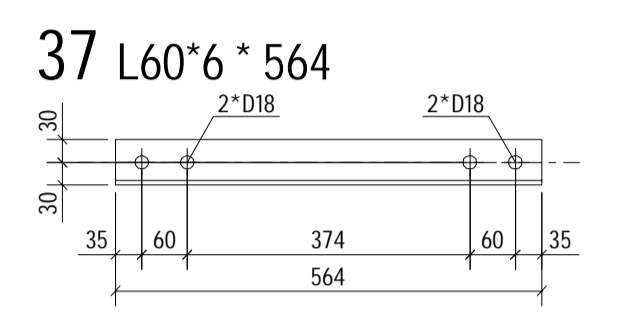
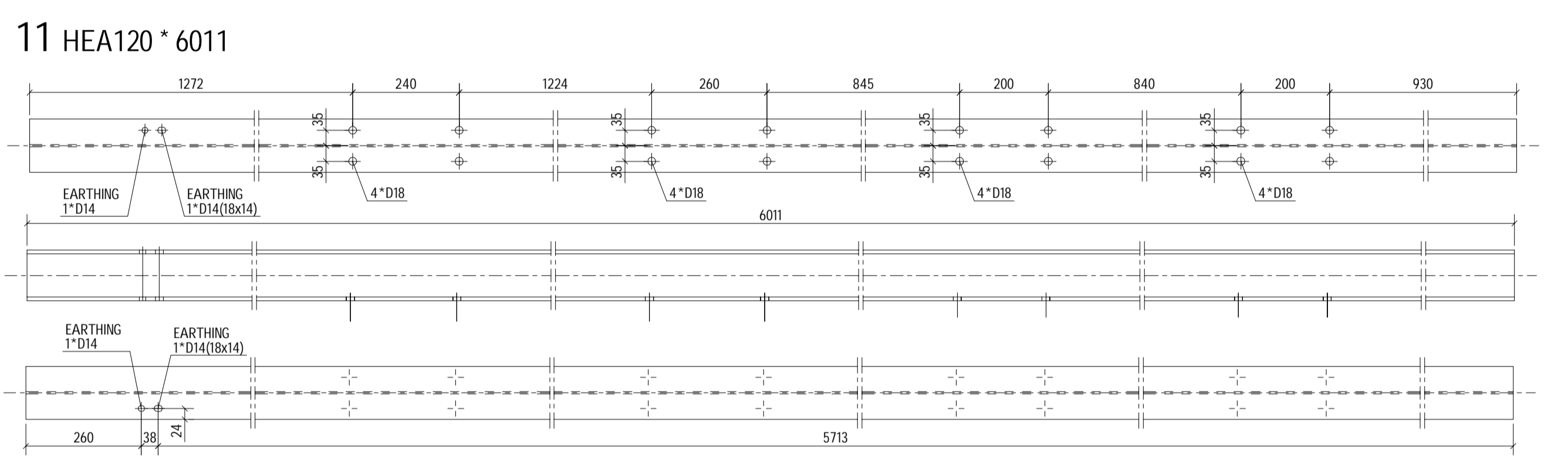
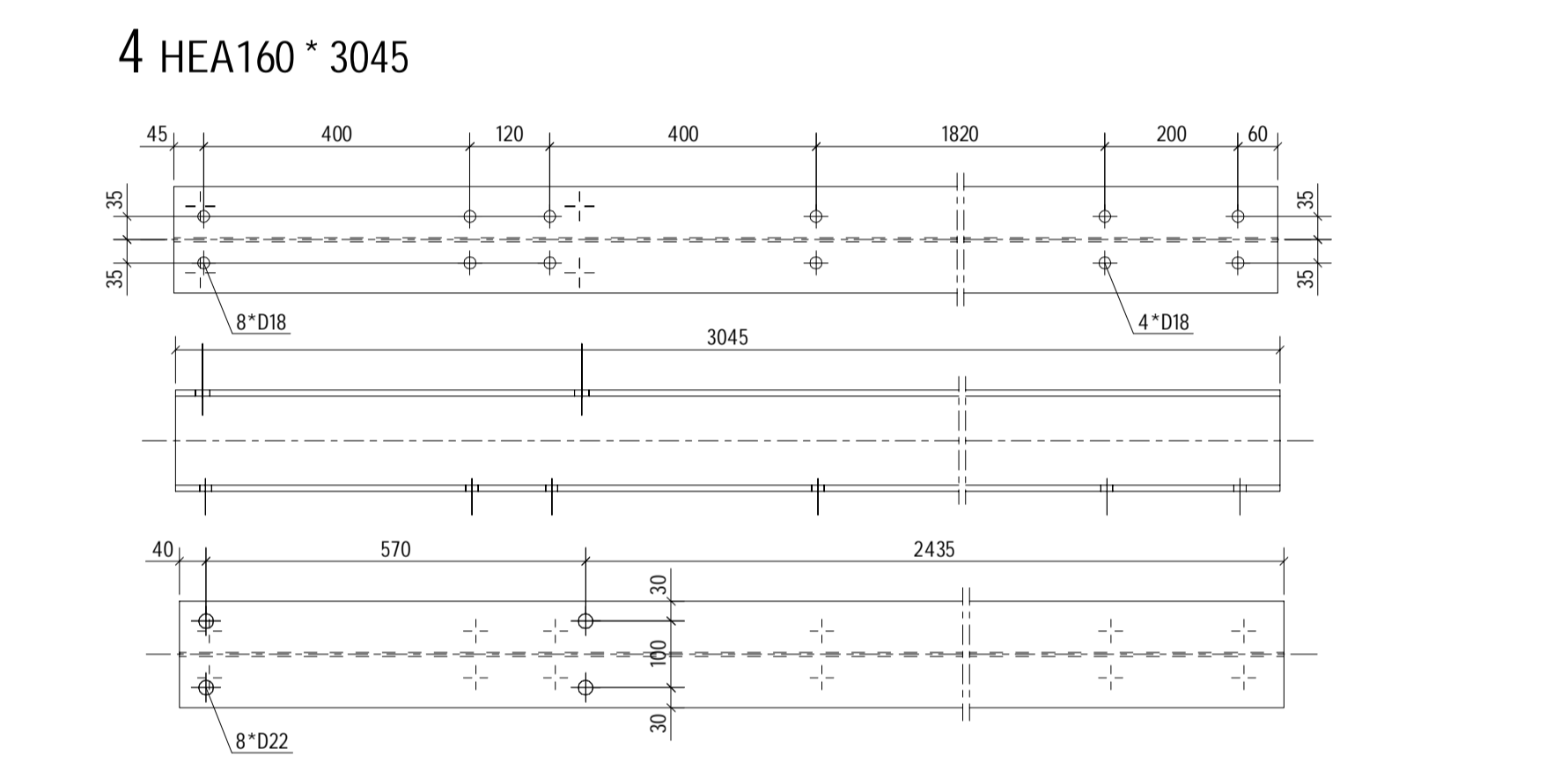
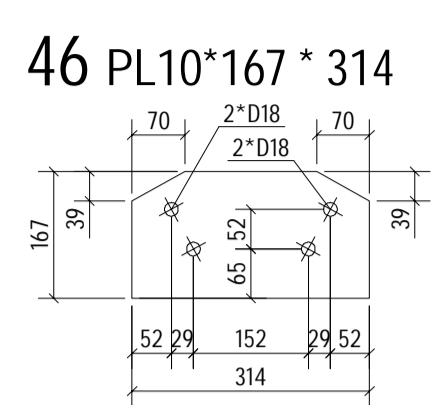
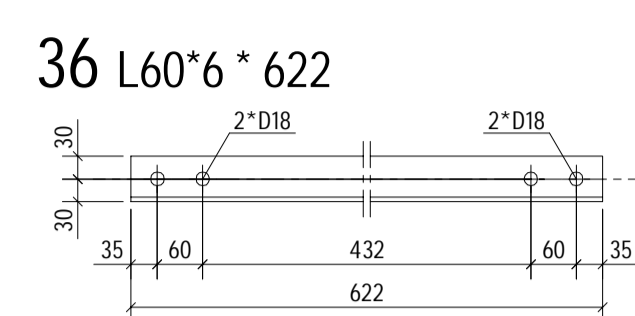
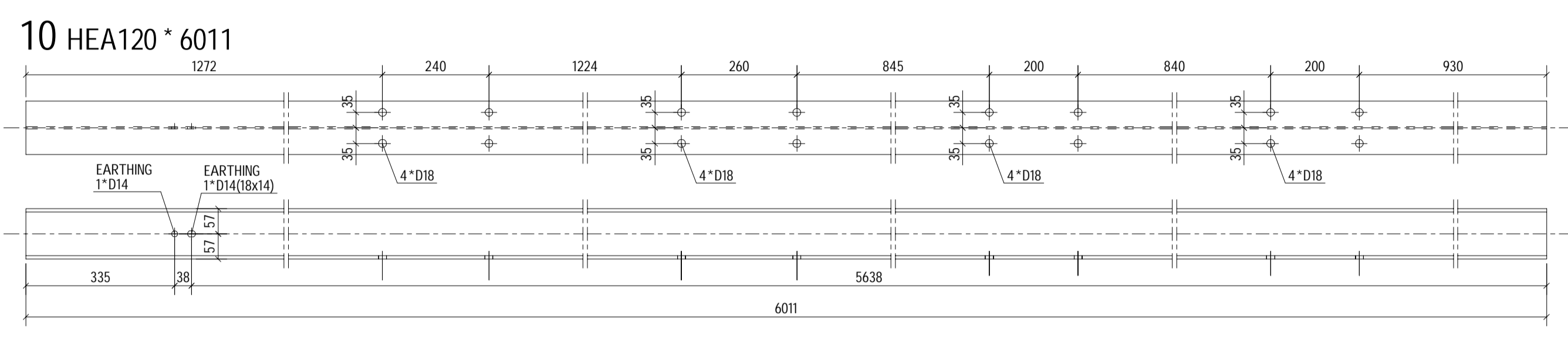
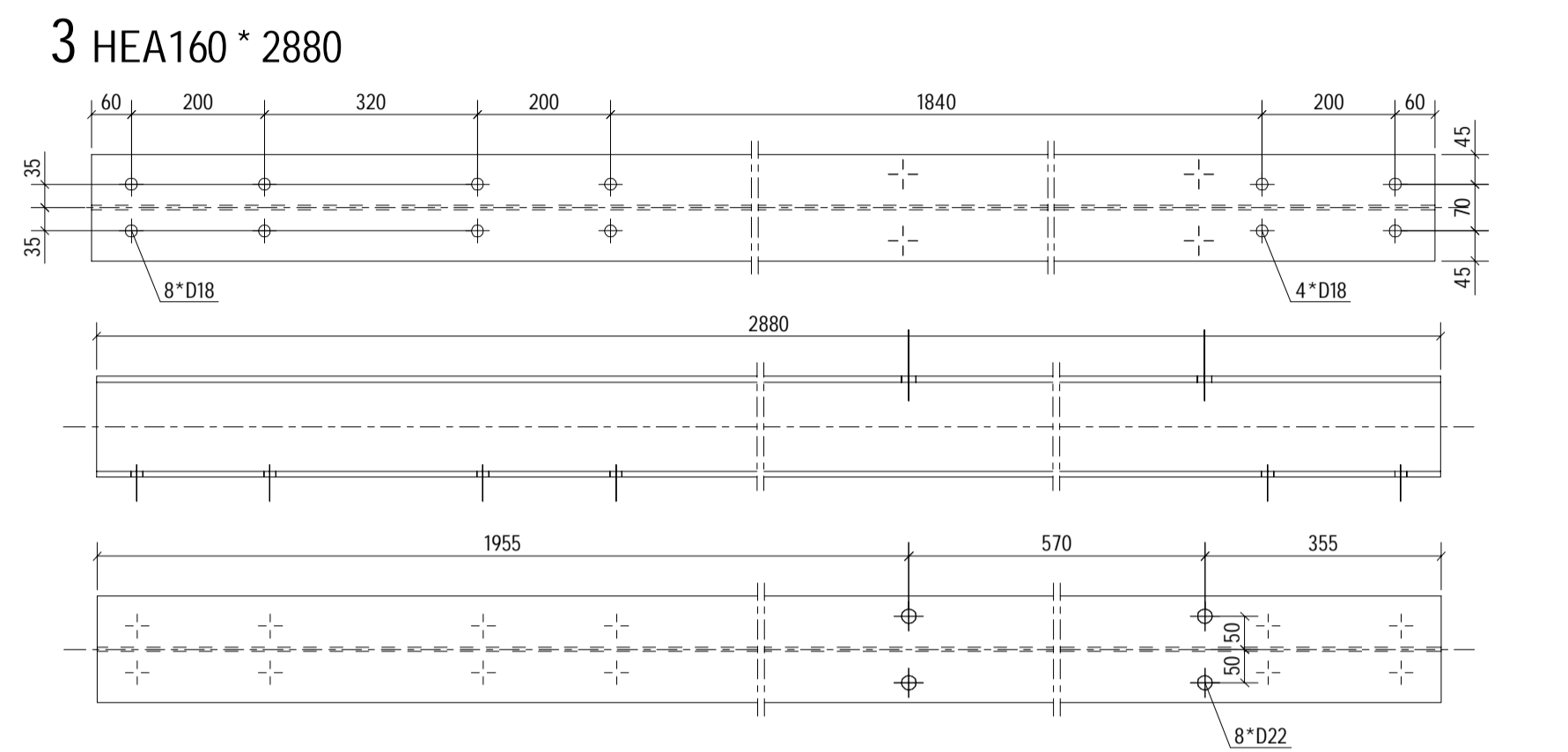
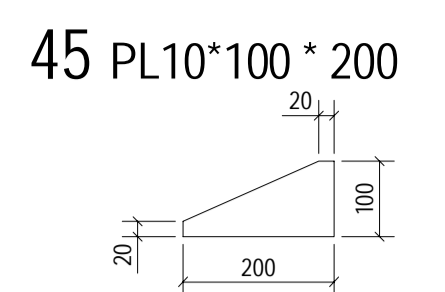
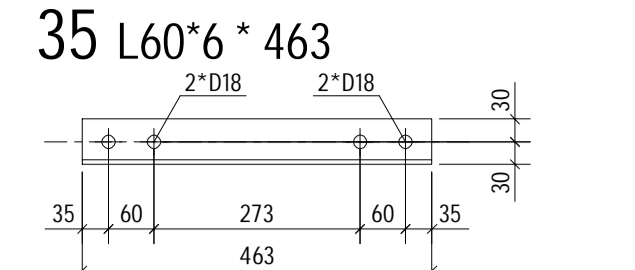
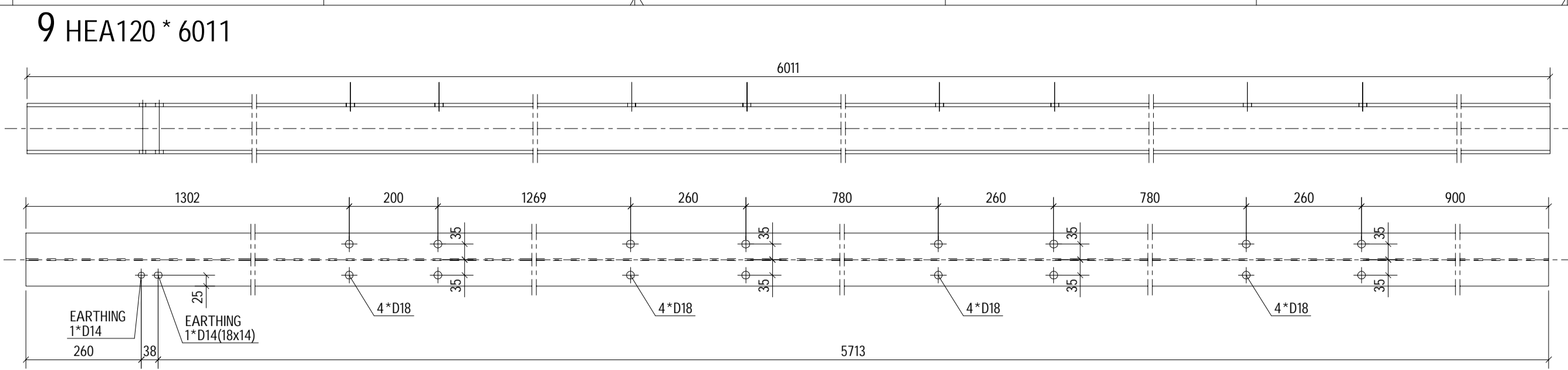
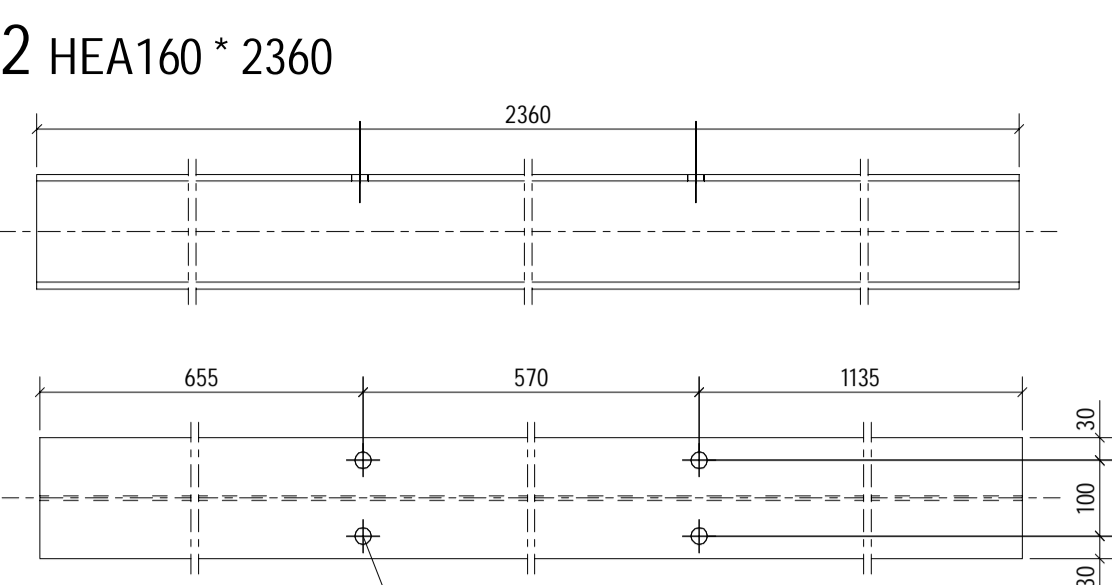
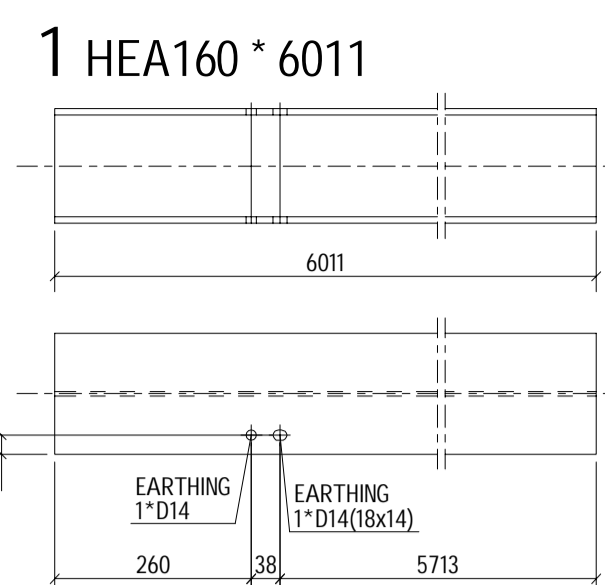
R15



NS- NEAR SIDE
 FS- FAR SIDE
 BS- BOTH SIDES
 CLASS OF STEEL S355JR
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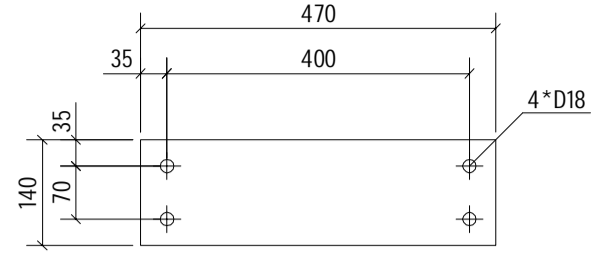


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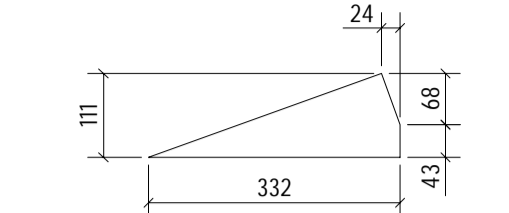
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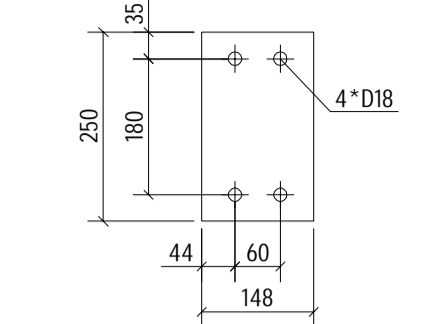
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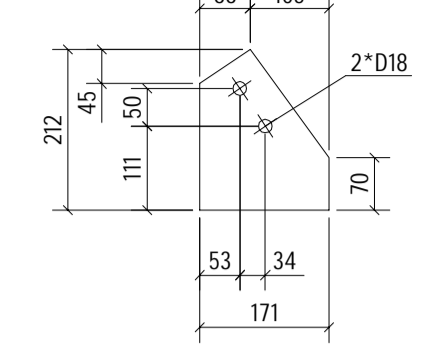
62 PL10*111 * 332



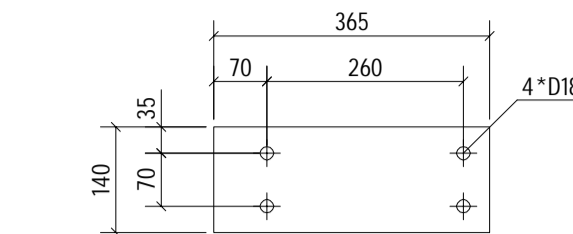
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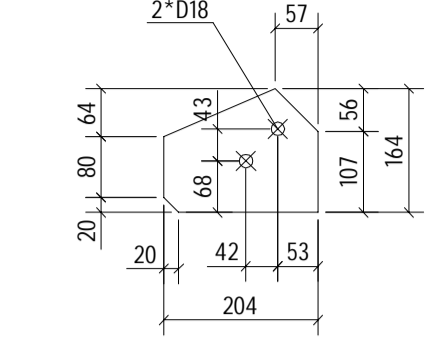
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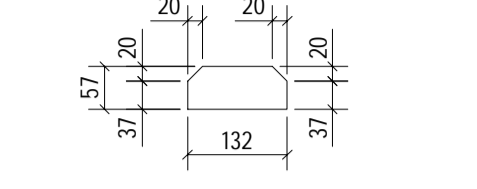
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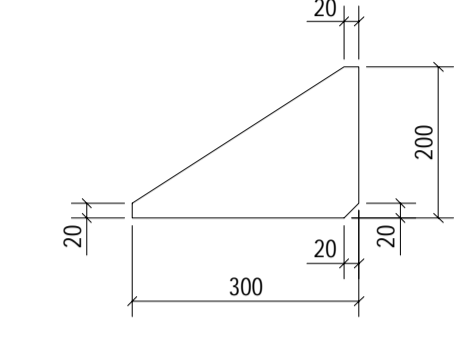
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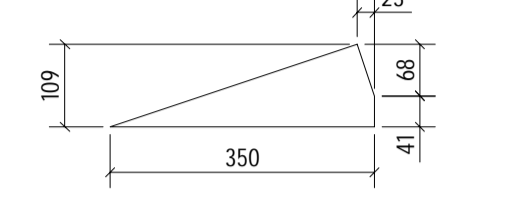
103 PL8*57 * 132



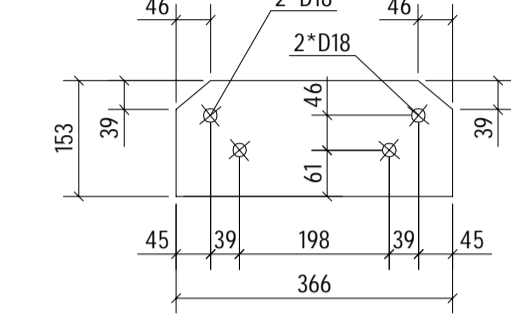
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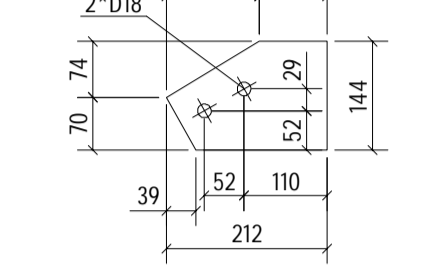
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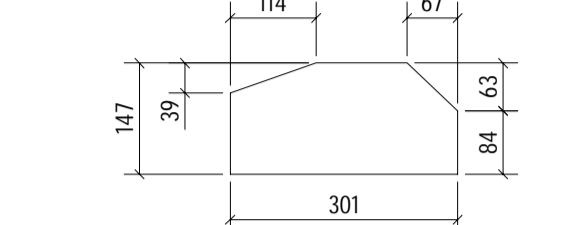
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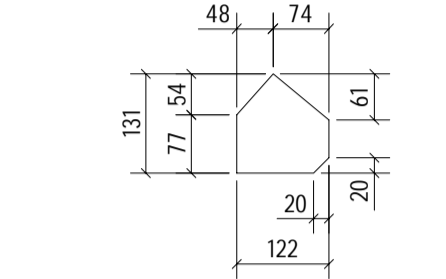
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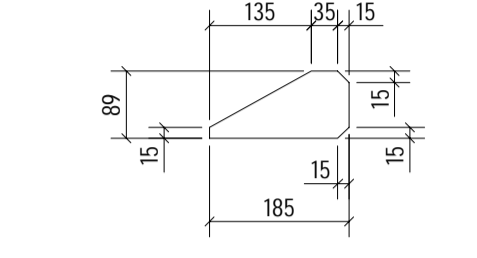
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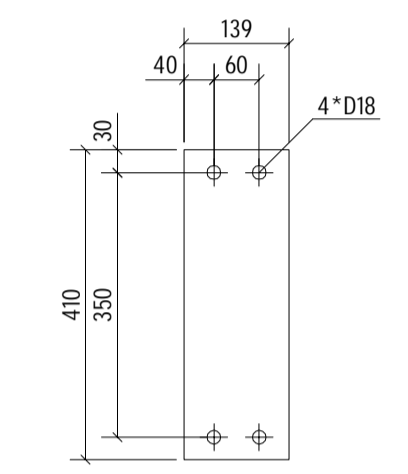
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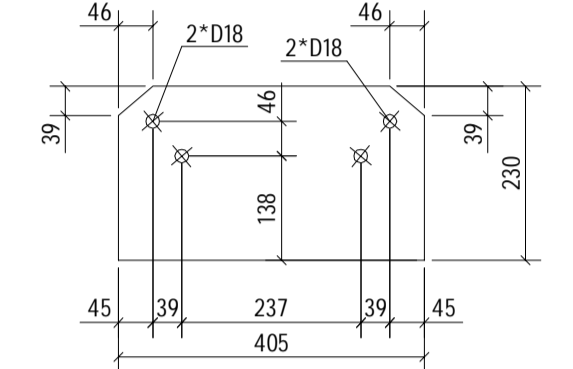
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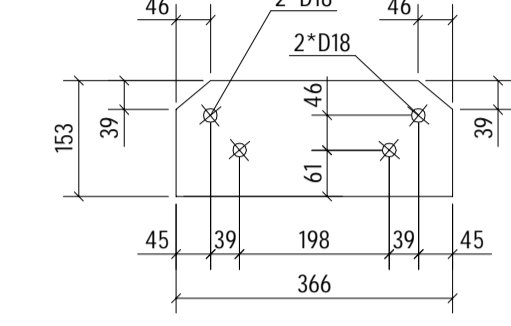
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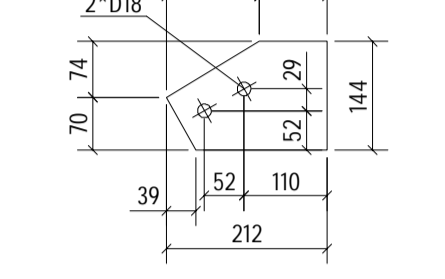
64 PL10*230 * 405



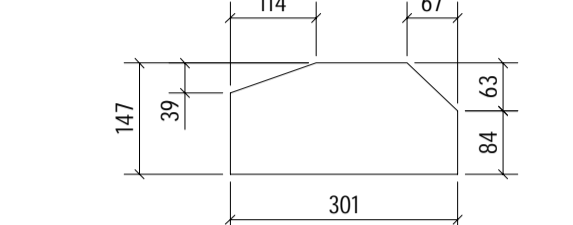
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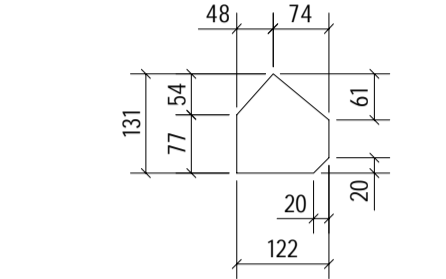
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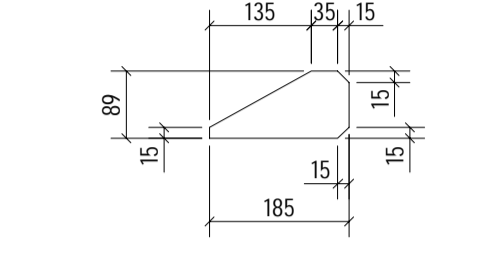
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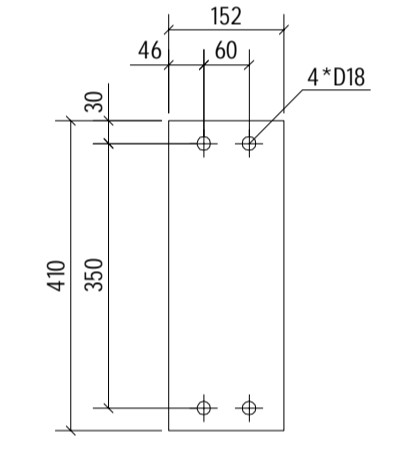
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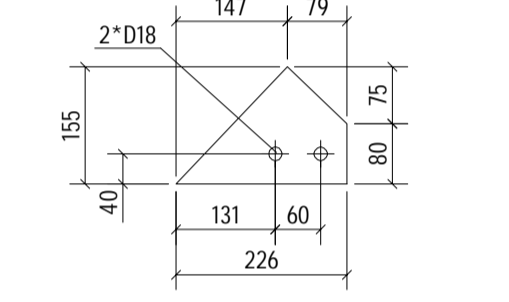
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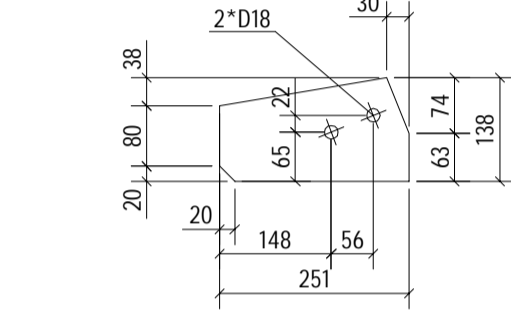
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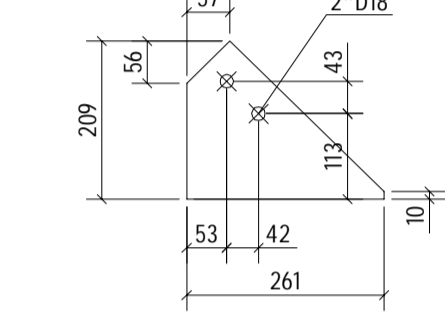
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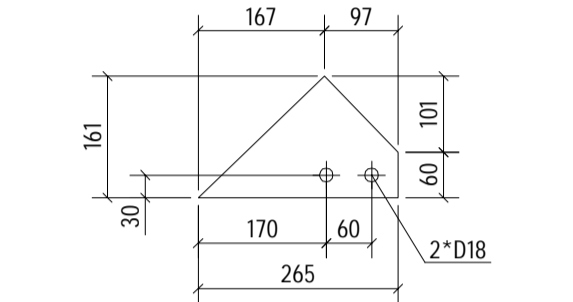
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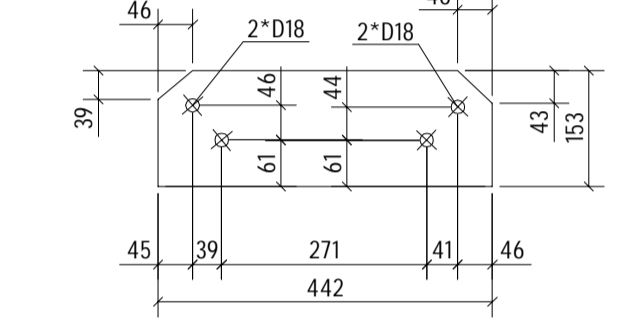
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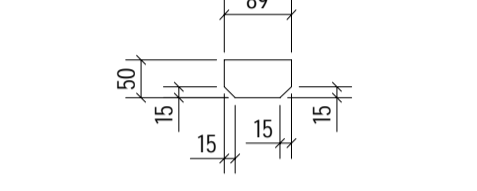
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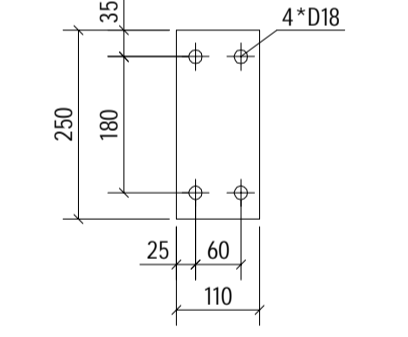
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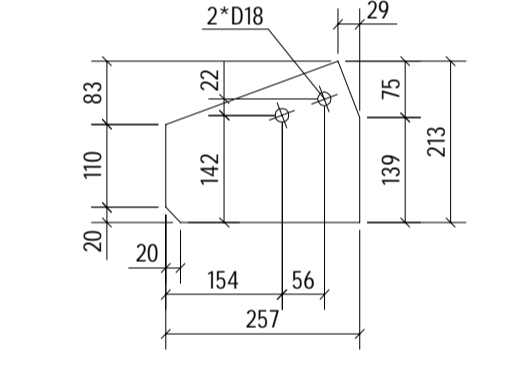
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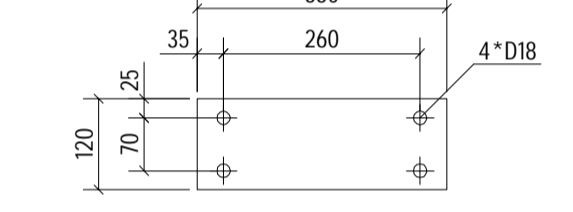
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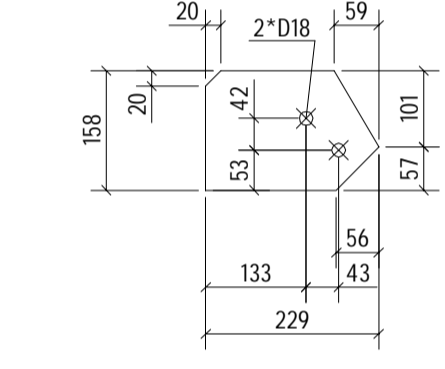
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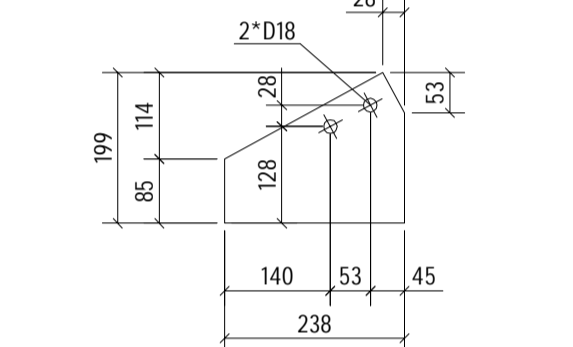
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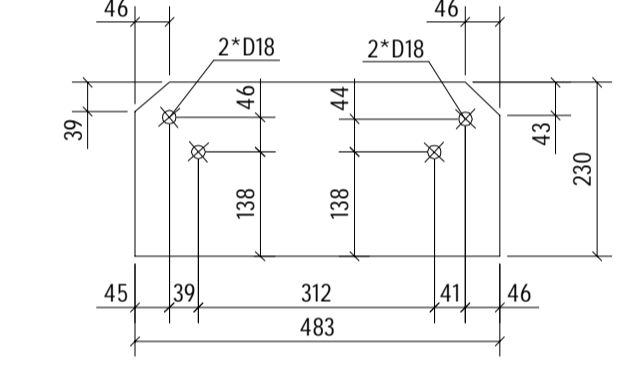
82 PL10*158 * 229



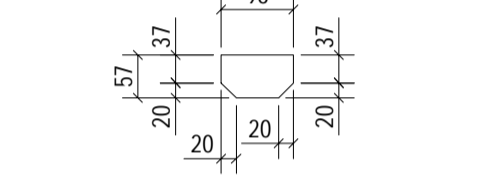
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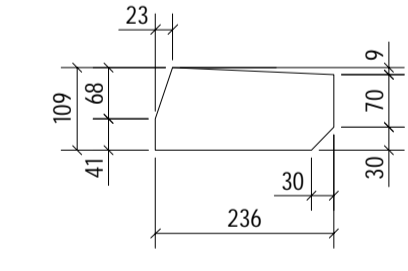
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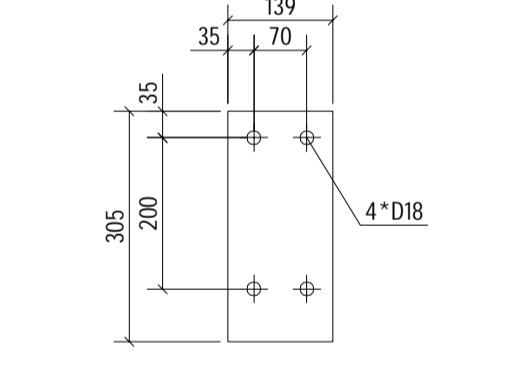
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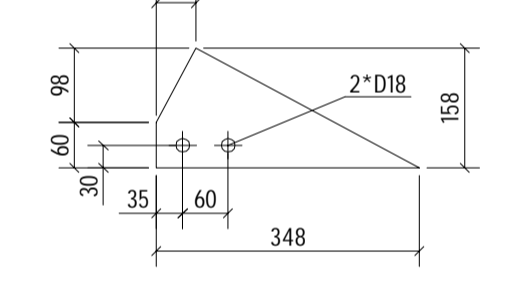
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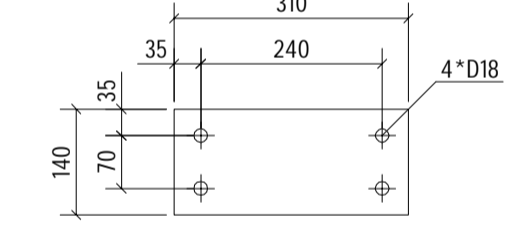
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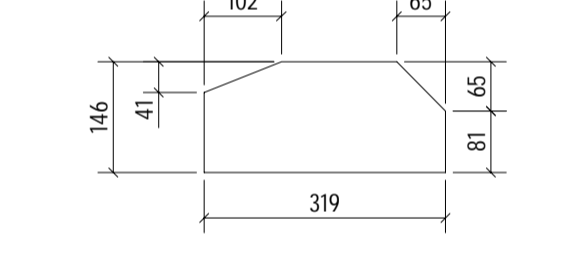
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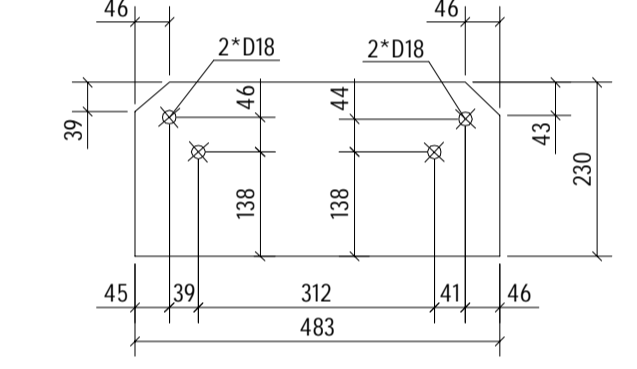
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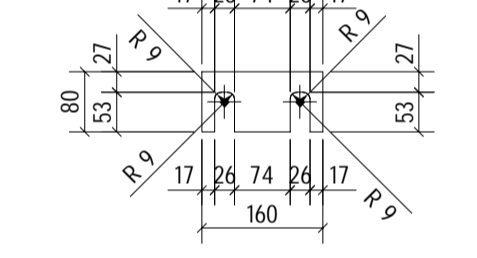
91 PL10*146 * 319



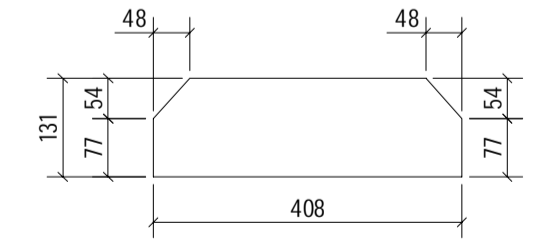
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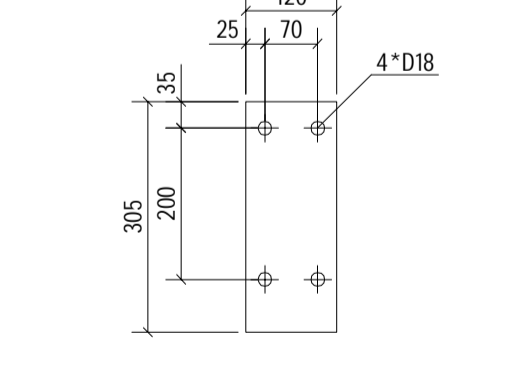
549 PL4*80 * 160



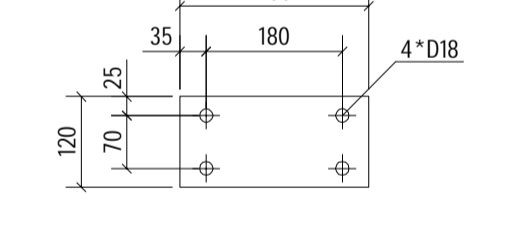
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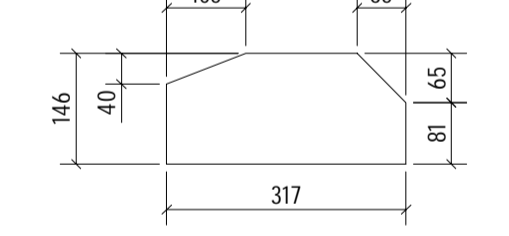
68 PL10*120 * 305



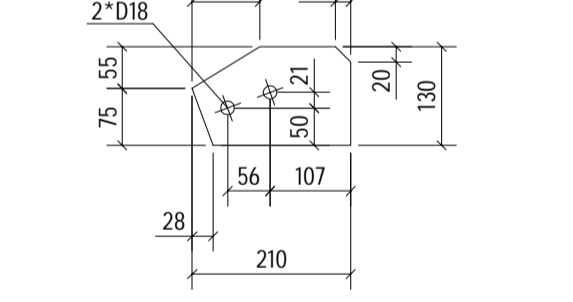
75 PL10*120 * 250



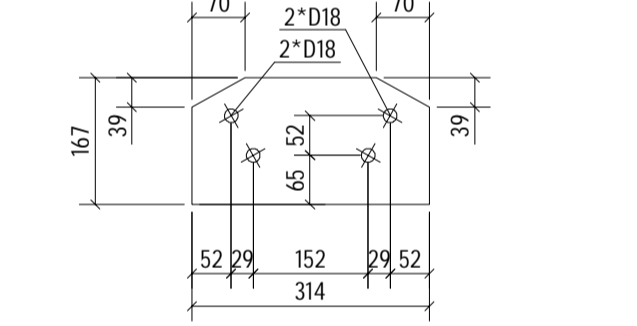
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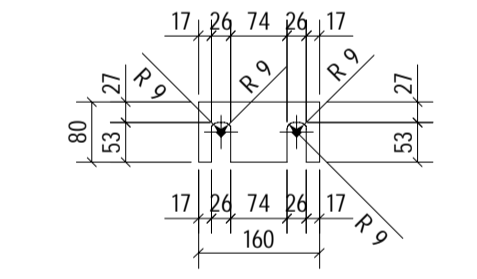
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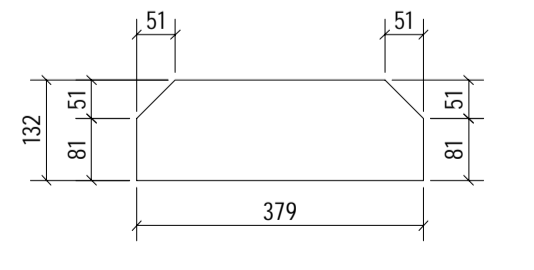
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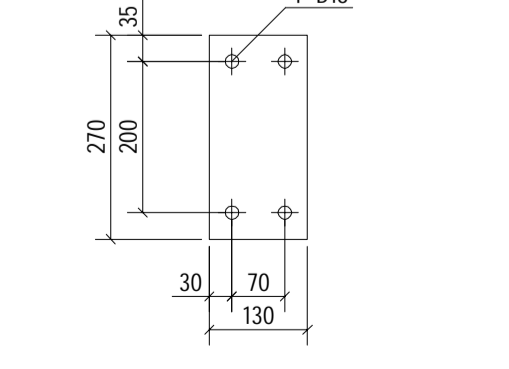
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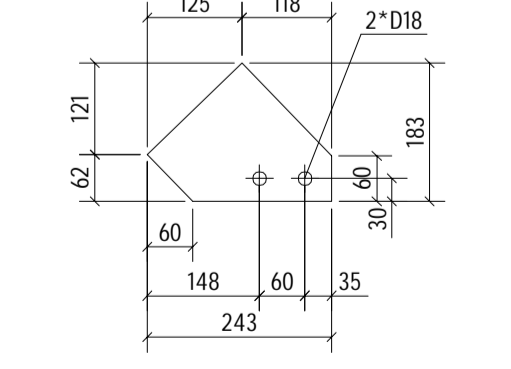
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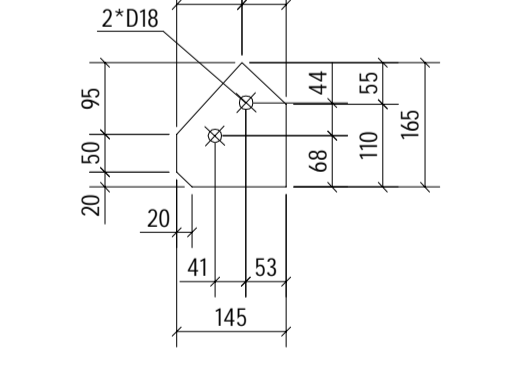
69 PL10*130 * 270



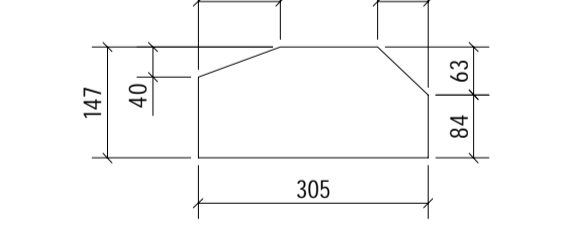
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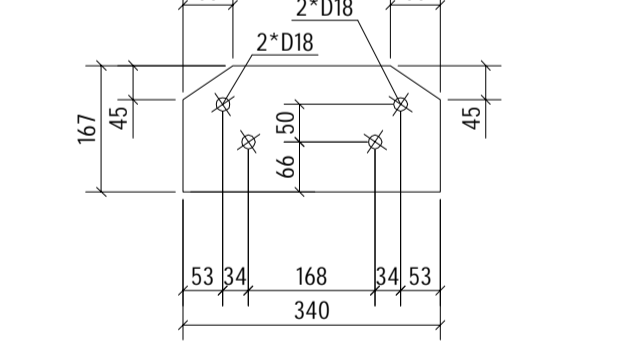
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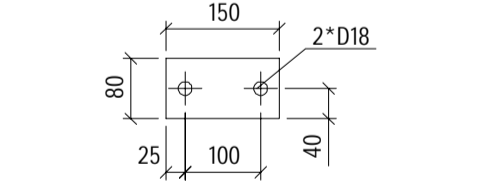
93 PL10*147 * 305



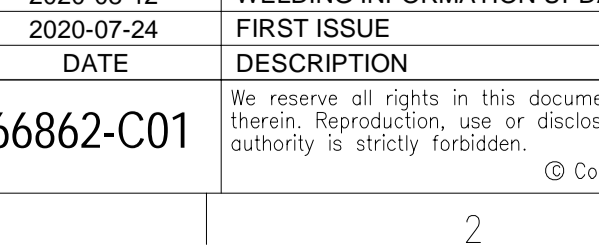
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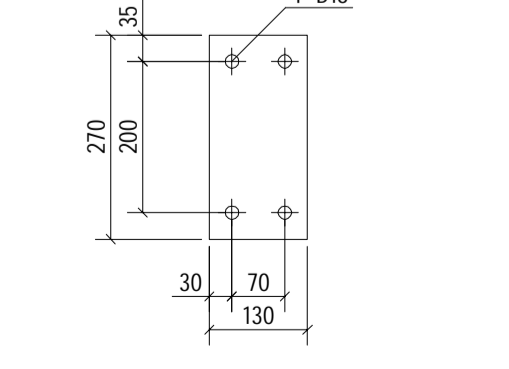
564 PL4*80*150



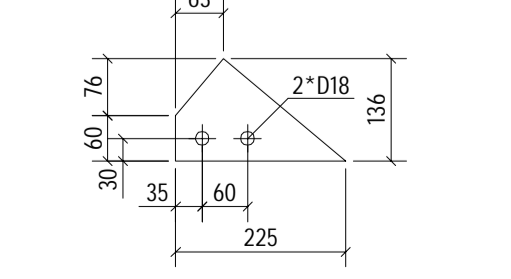
62 PL10*111 * 332



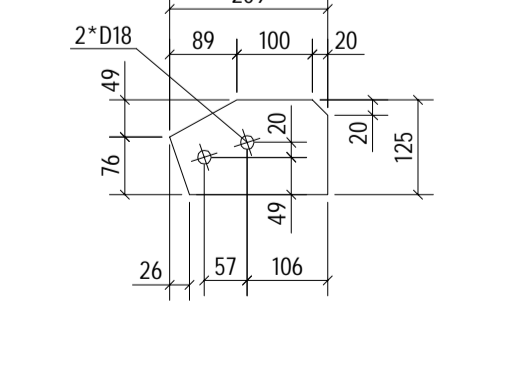
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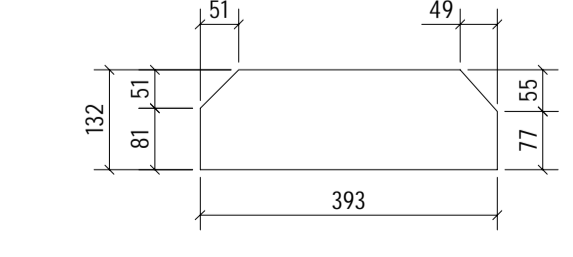
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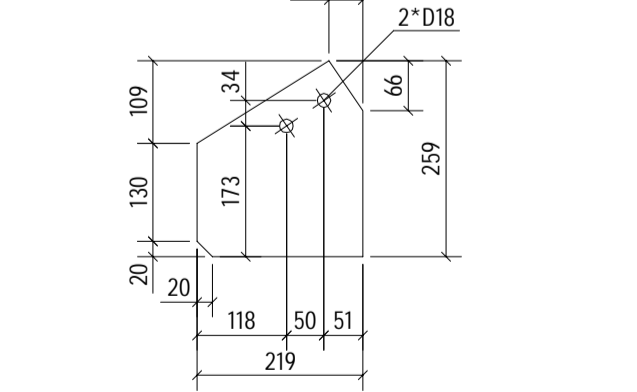
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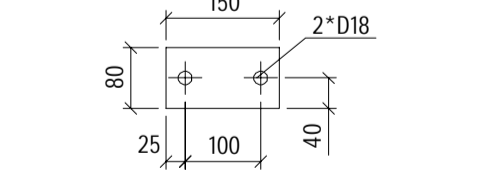
95 PL10*132 * 393



102 PL10*219 * 259



664 PL2*80*150



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