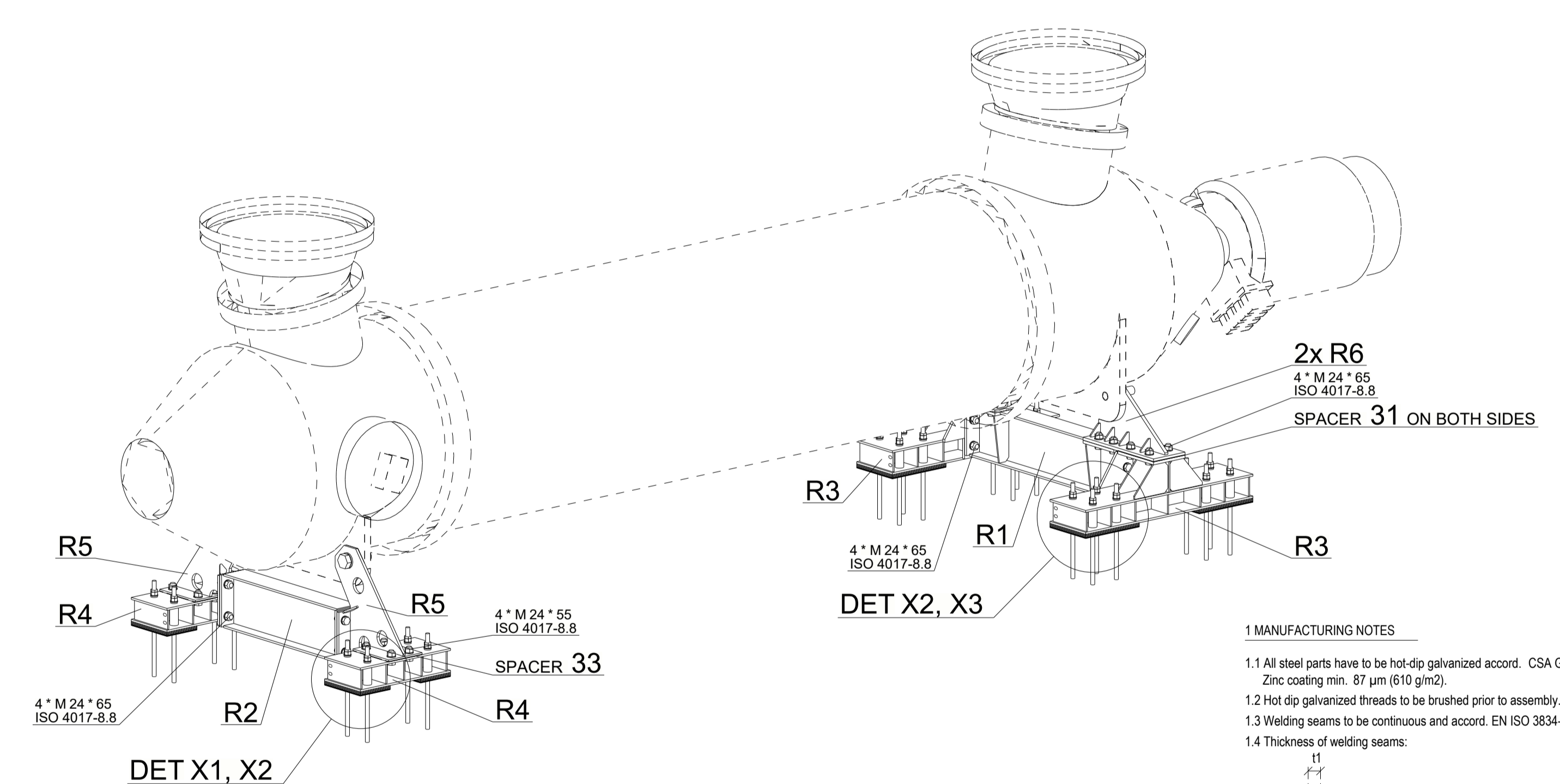
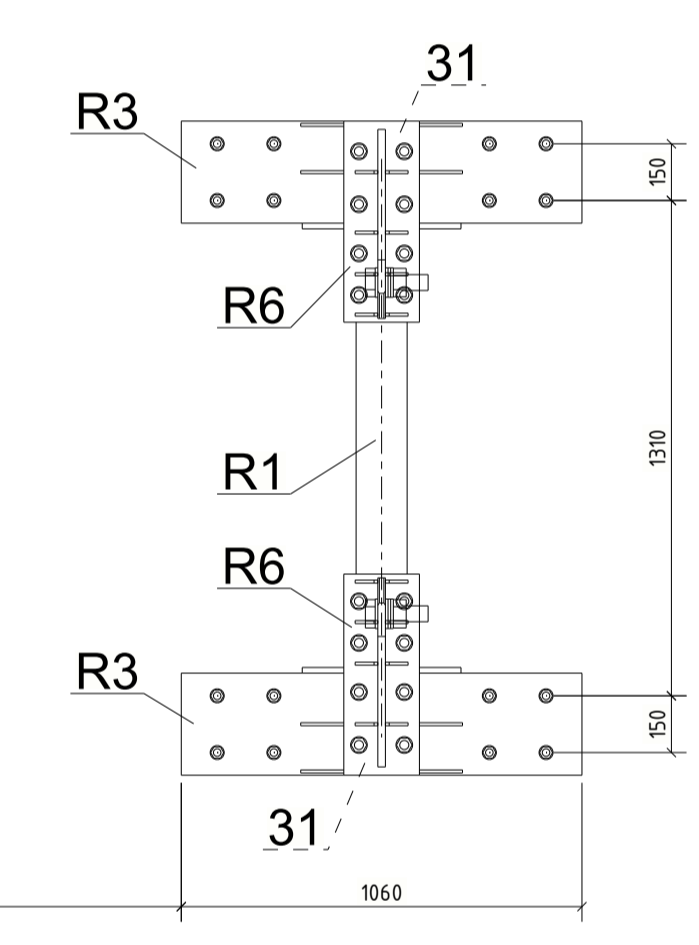
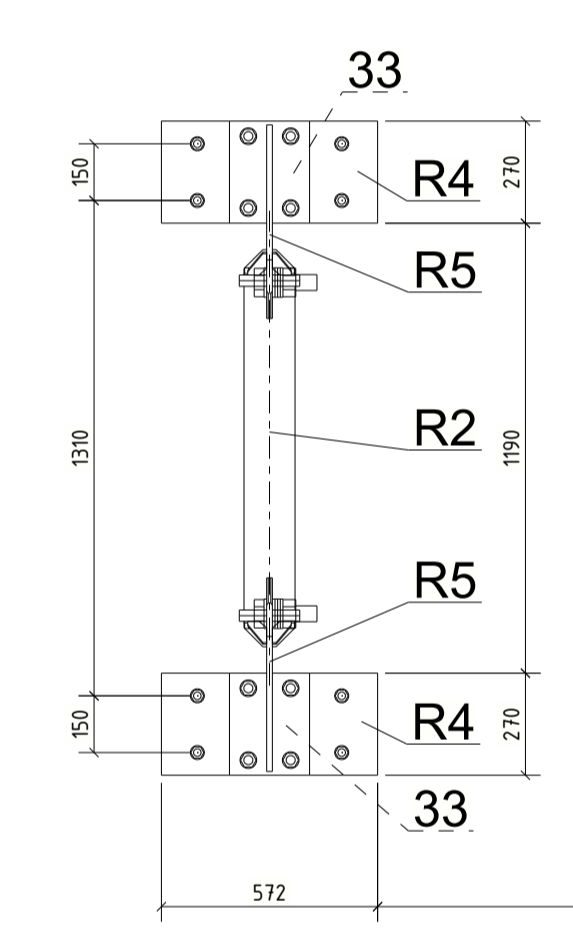
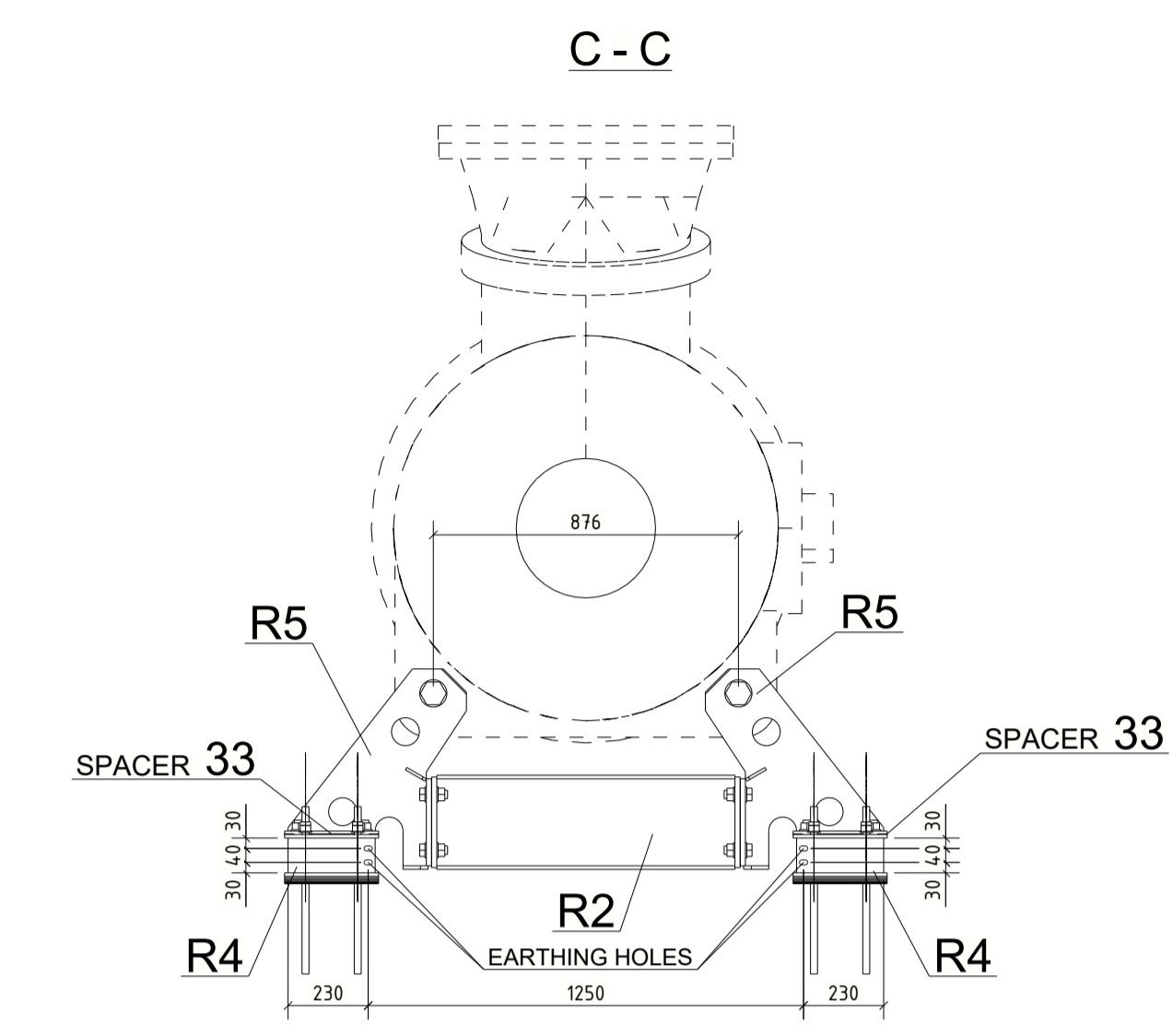
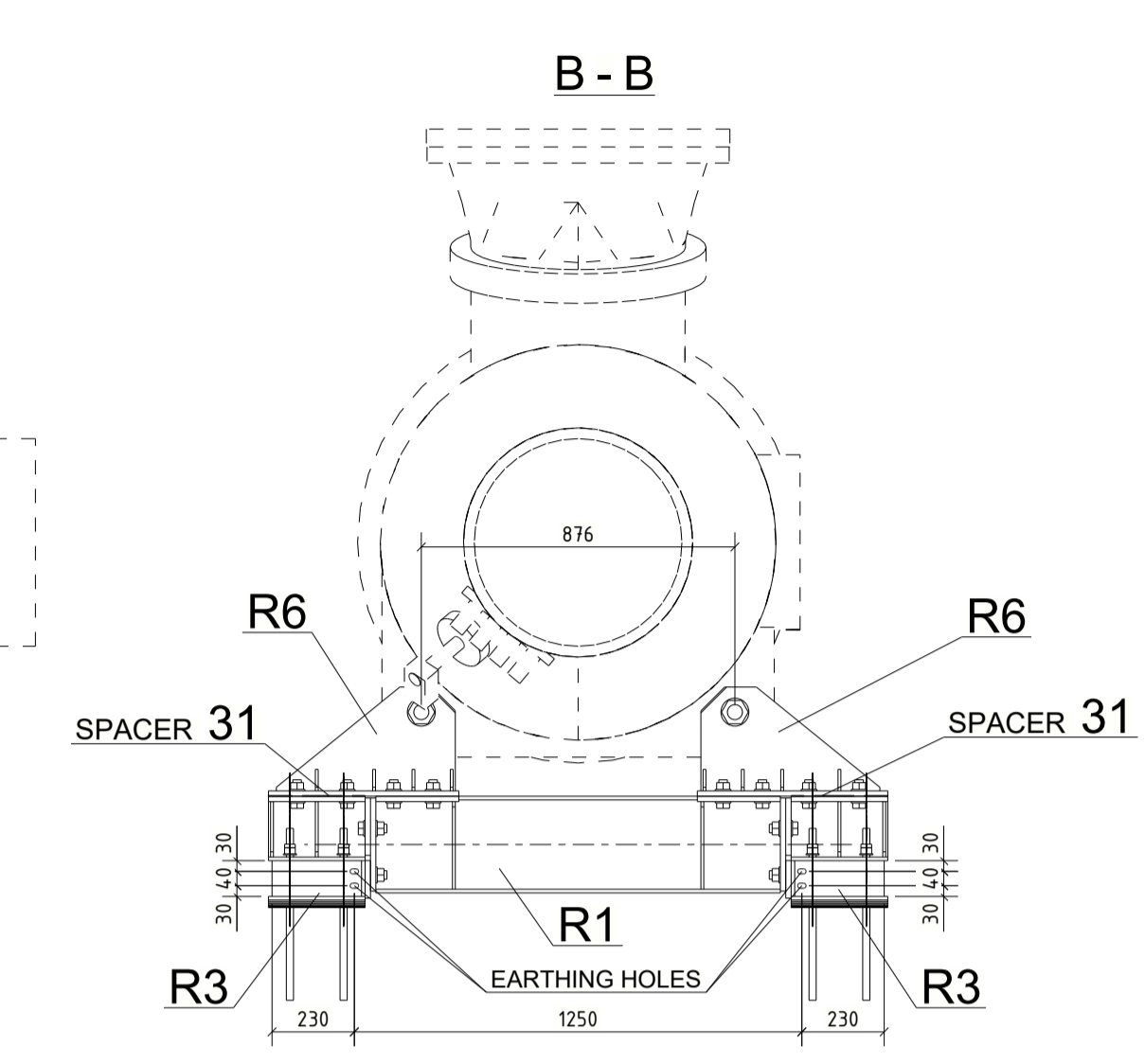
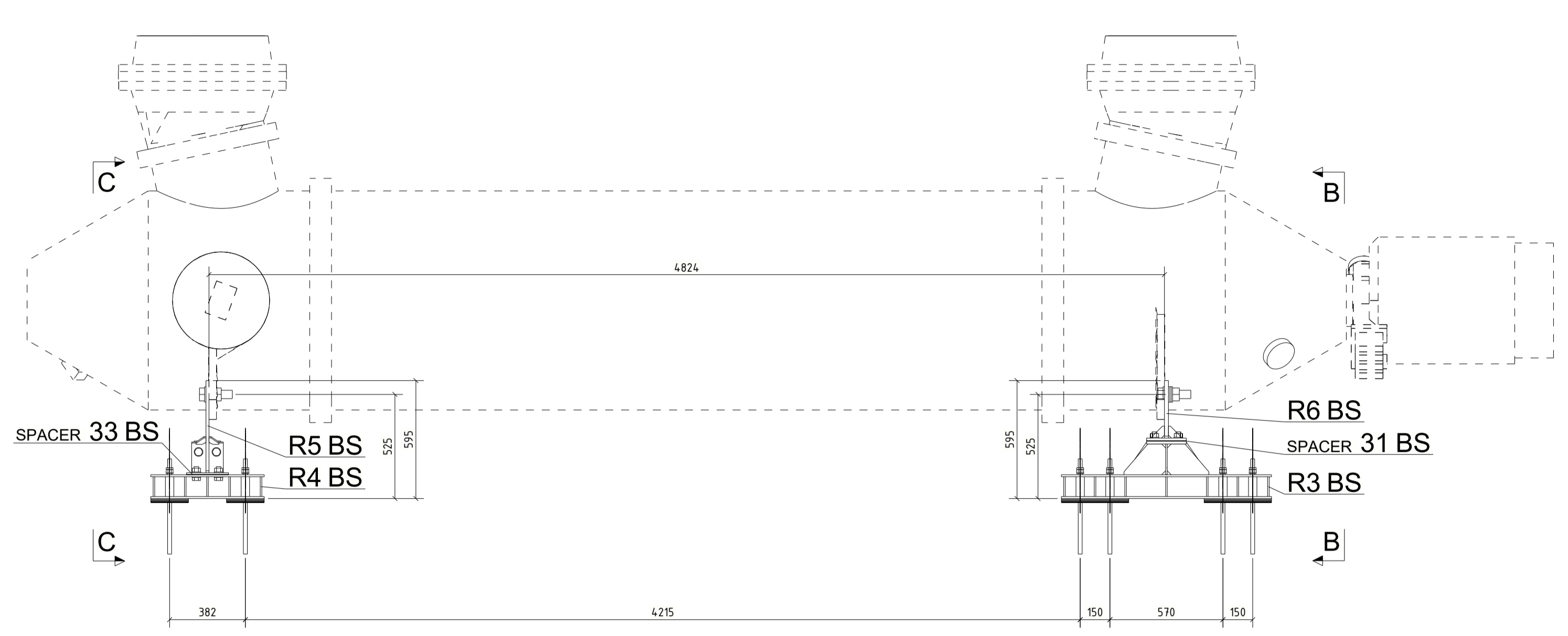
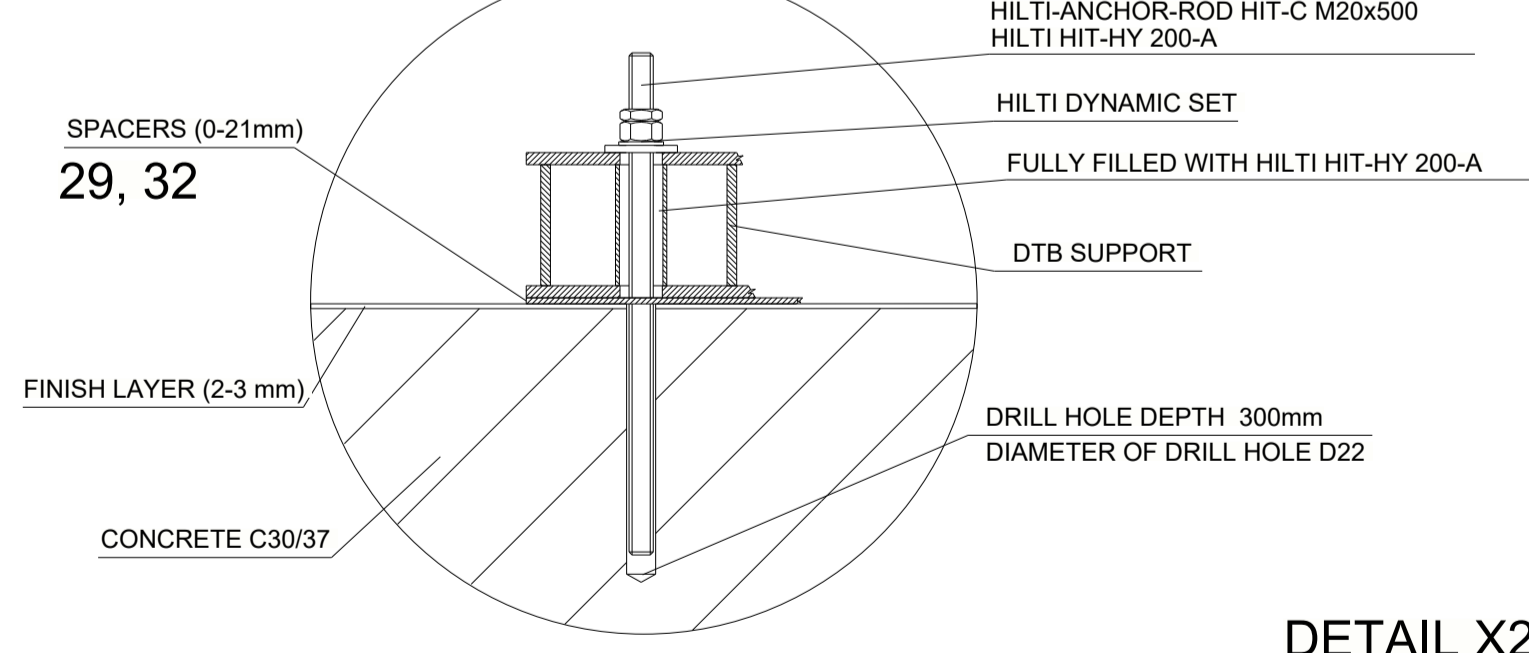


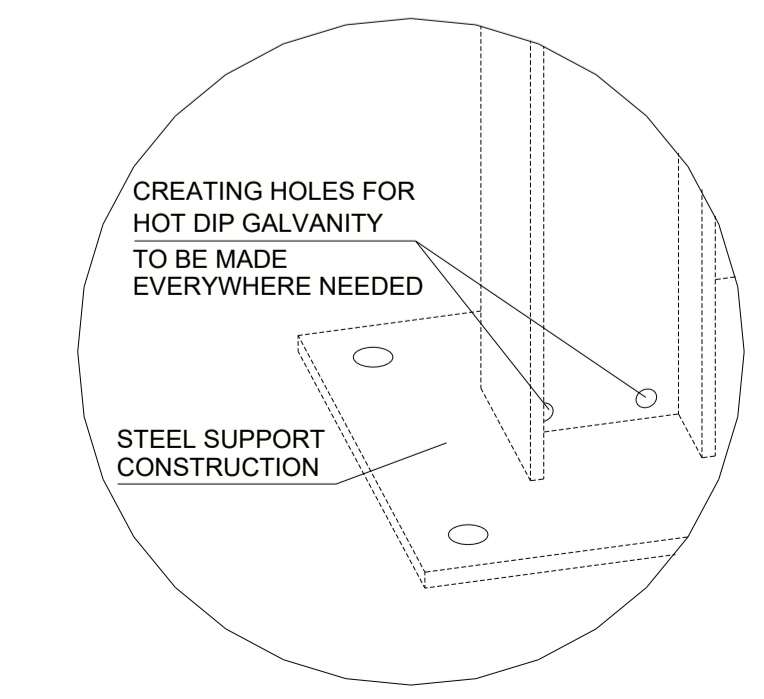
M1 SUPPORT Y1



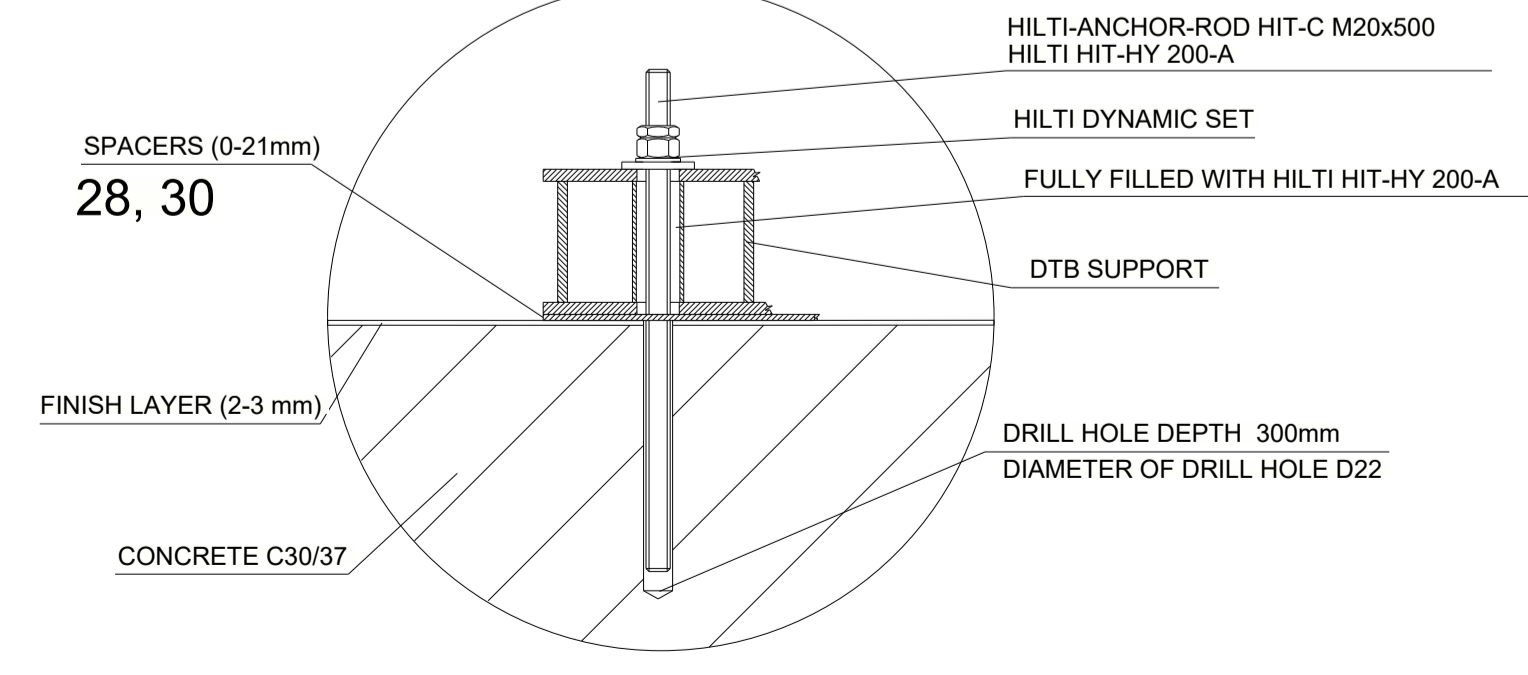
DETAIL X1



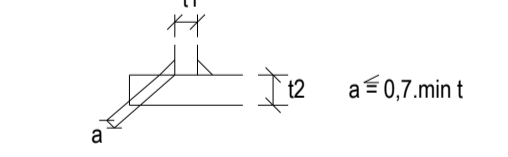
DETAIL X2



DETAIL X3



- 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.
 - Thickness of welding seams:



- 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

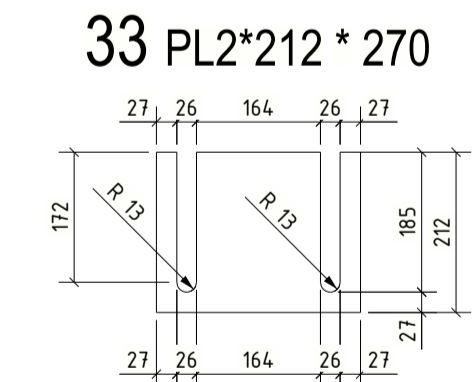
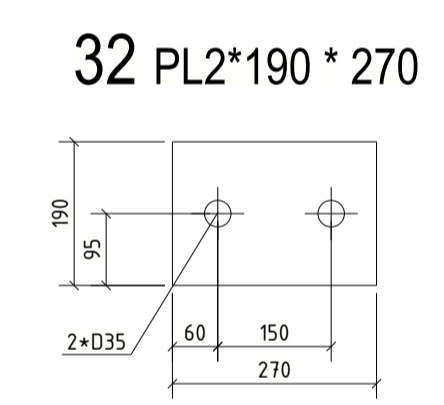
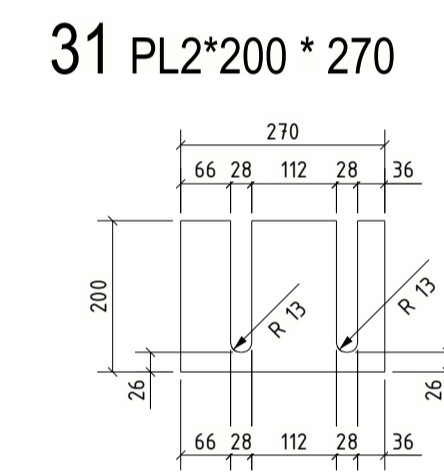
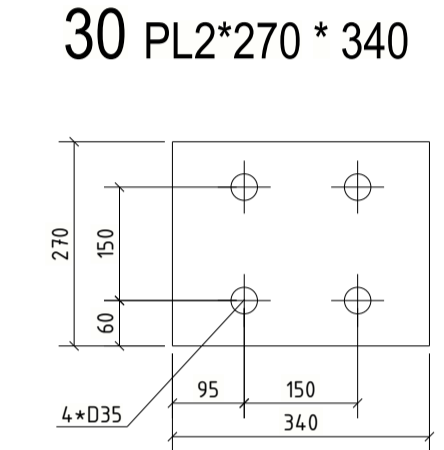
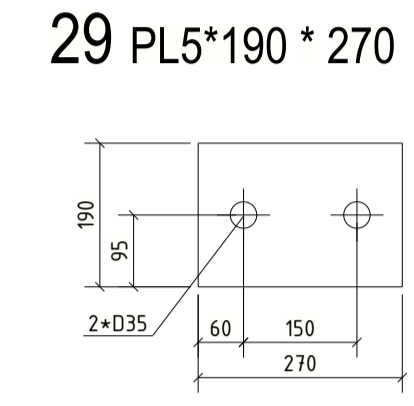
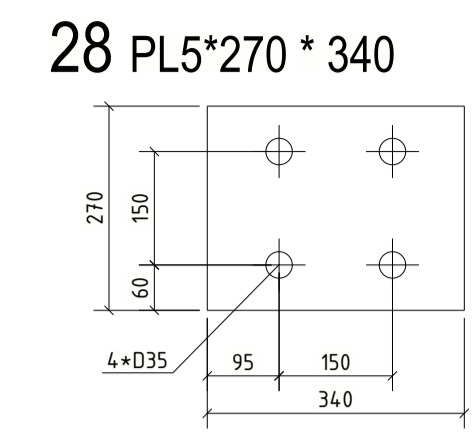
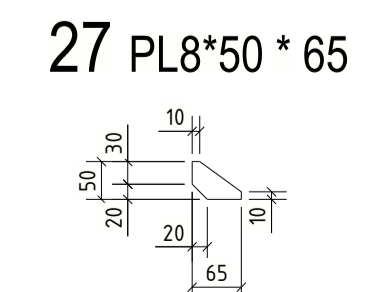
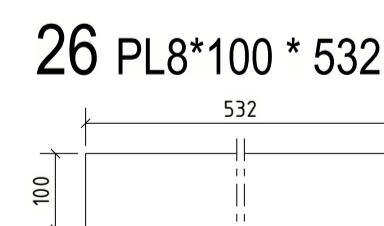
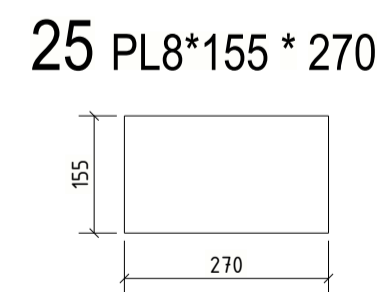
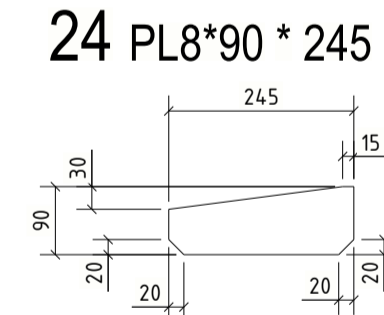
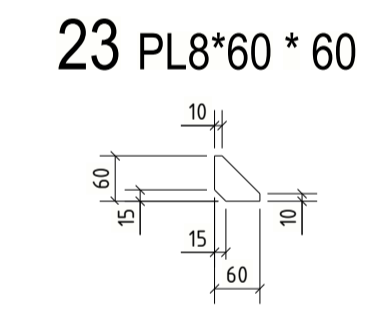
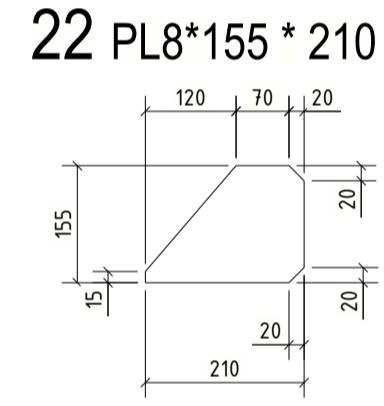
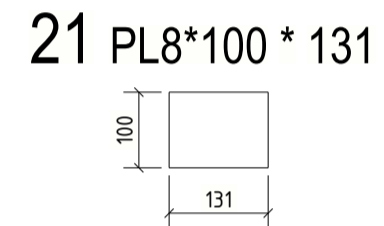
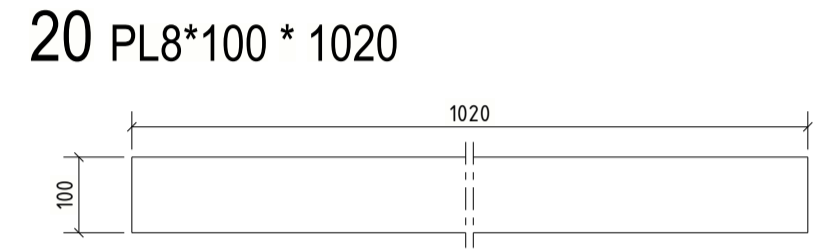
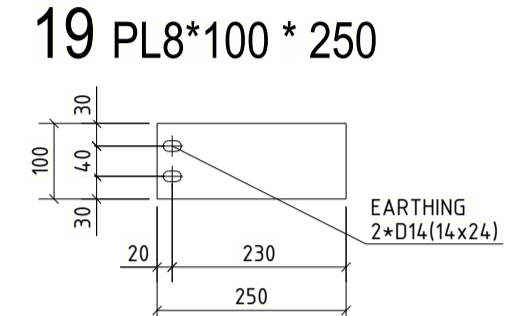
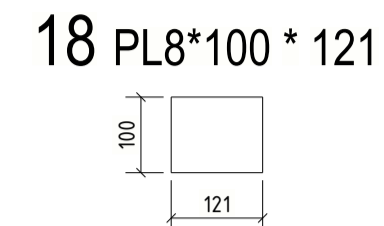
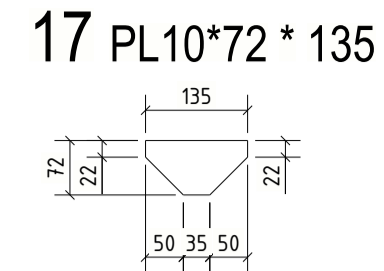
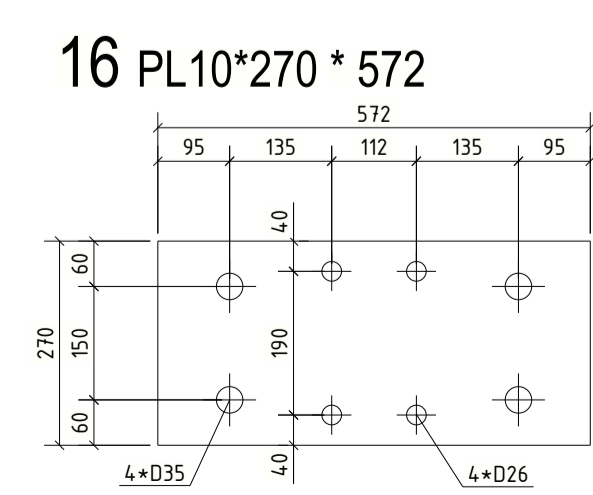
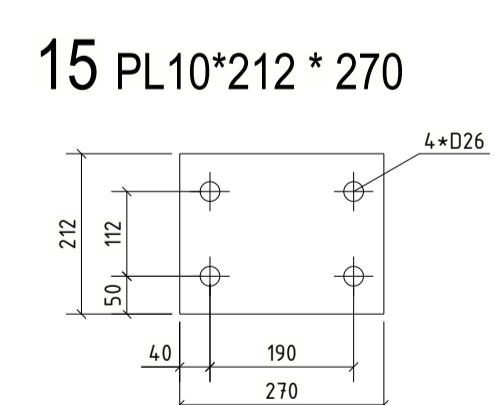
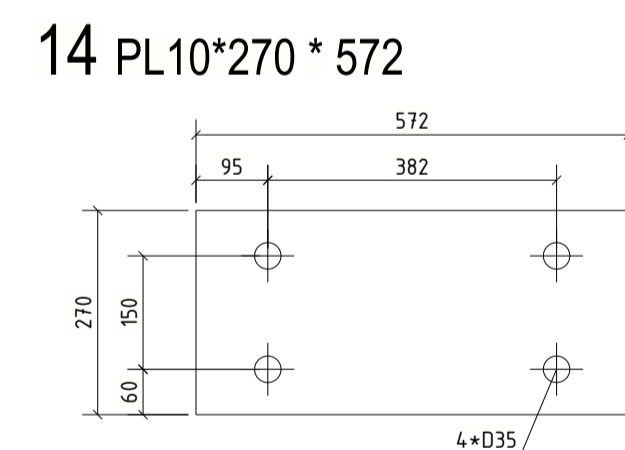
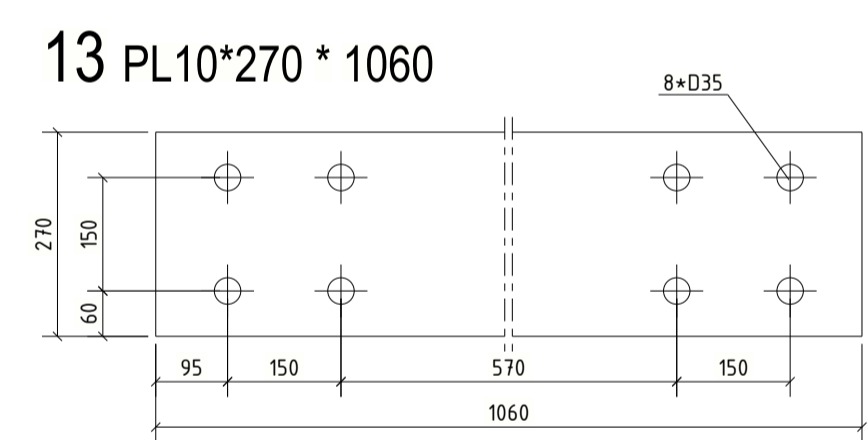
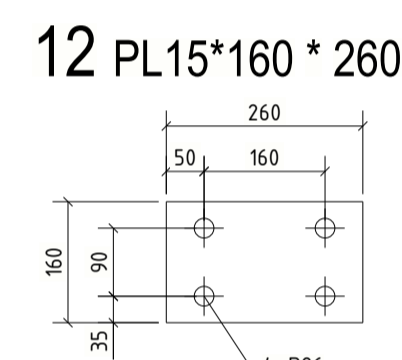
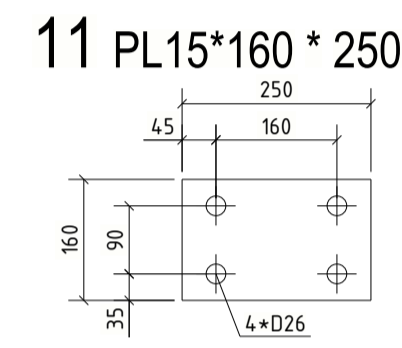
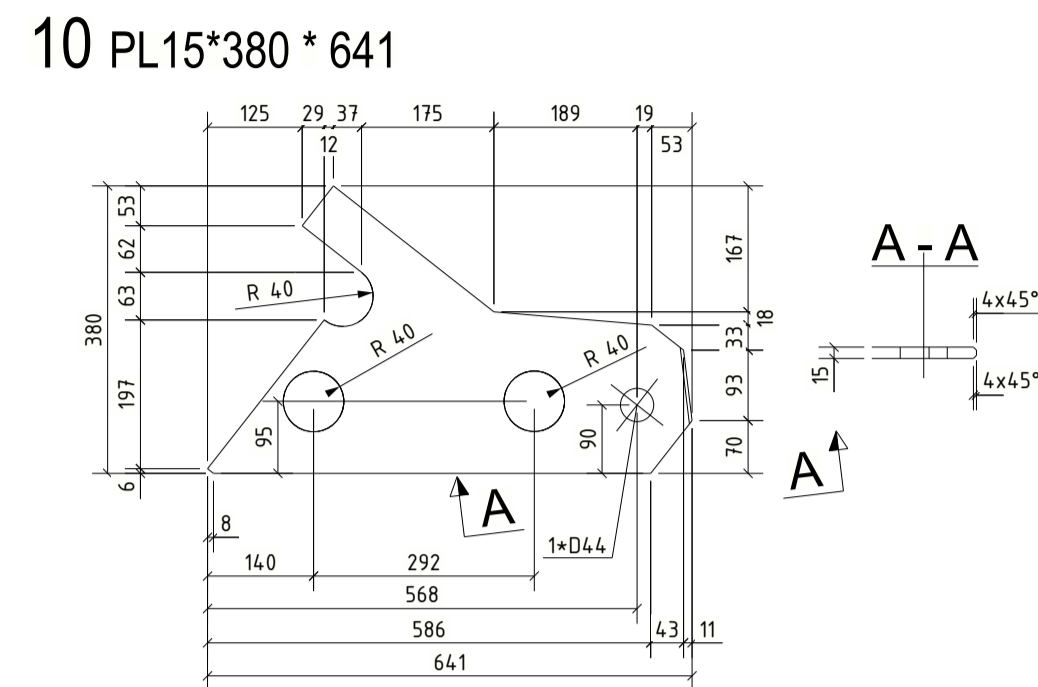
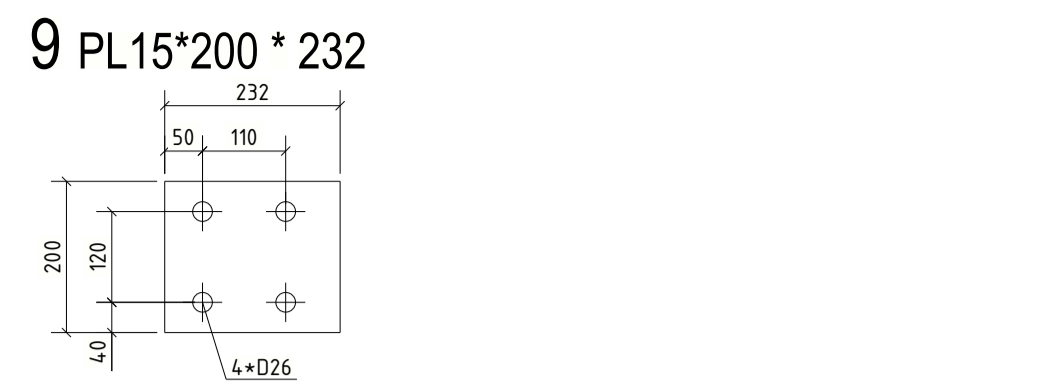
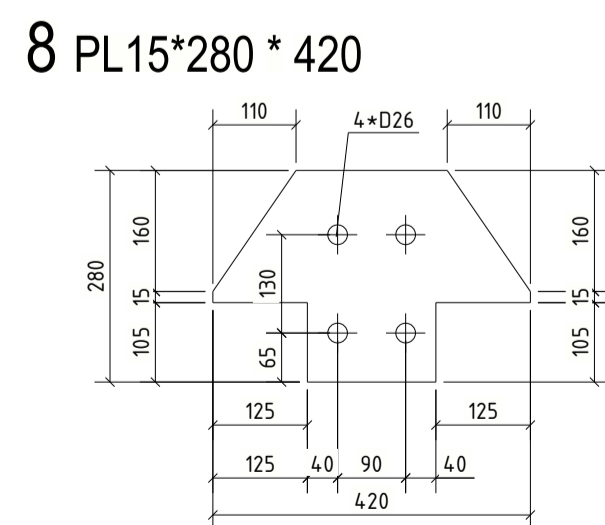
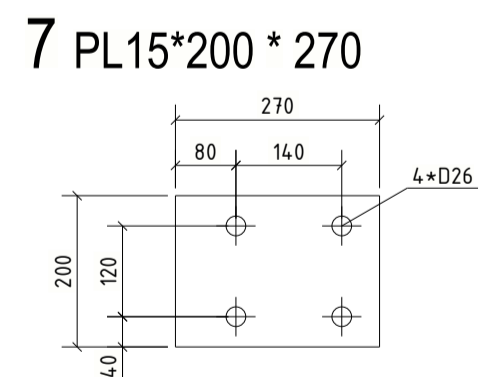
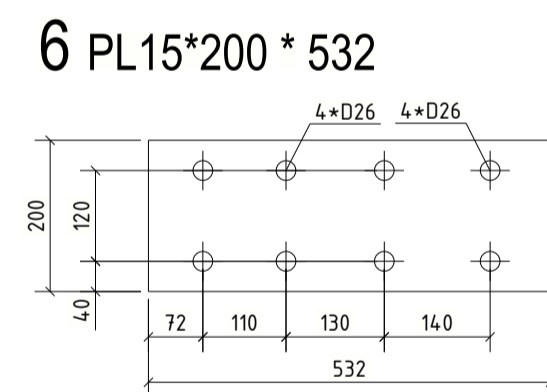
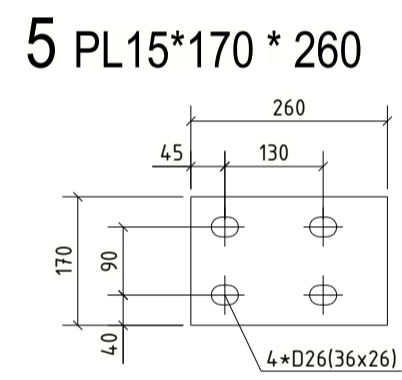
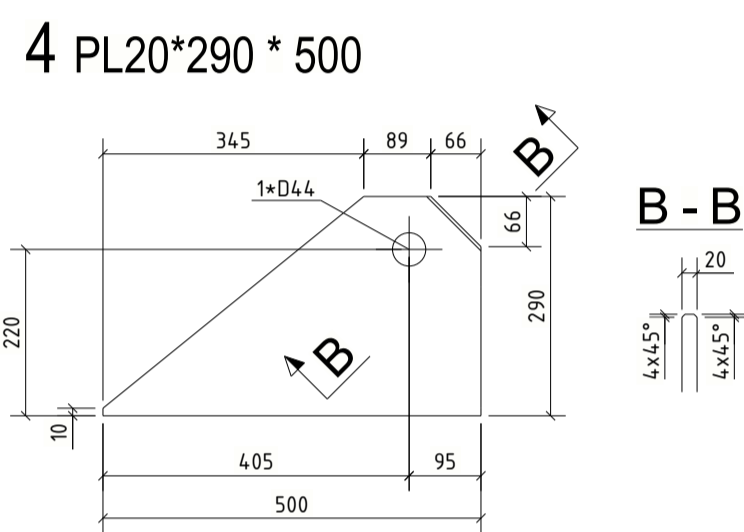
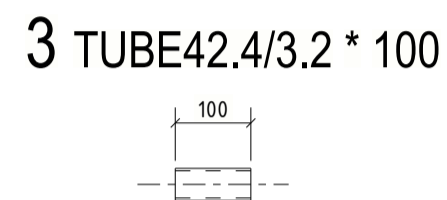
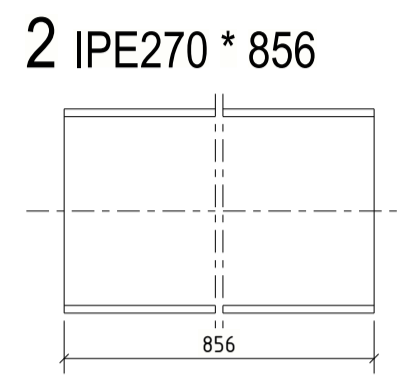
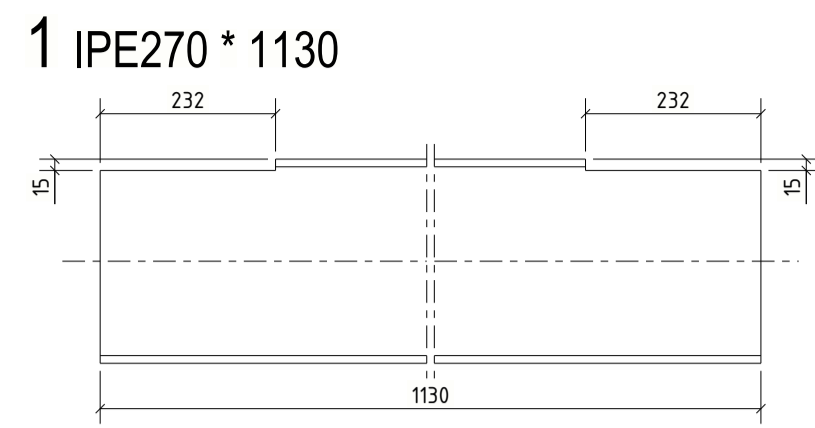
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Order number:	22934	AB	Revision:	DTB SUPPORT Y1			
			Revision:	1HC0159935-Y01			
			Document Number:	1HC0159935-Y01			
			Sheet no.:	1			

Table Structures



CLASS OF STEEL S355JR
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