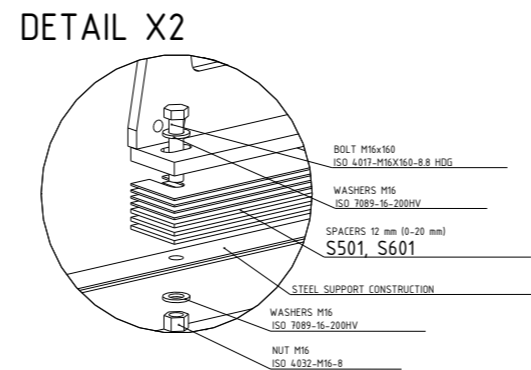
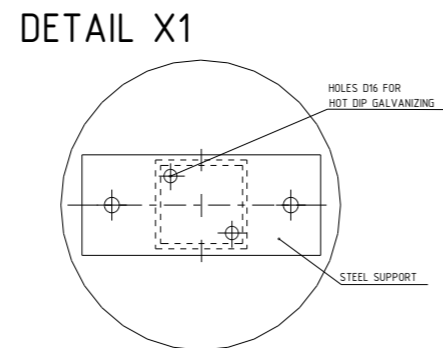
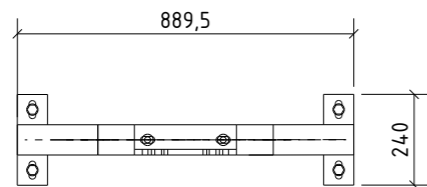
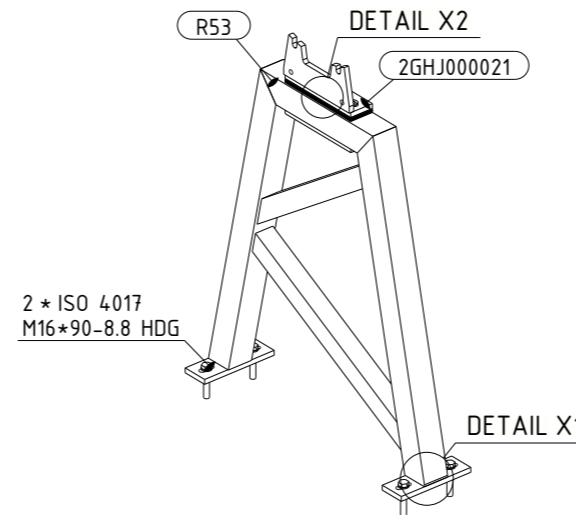
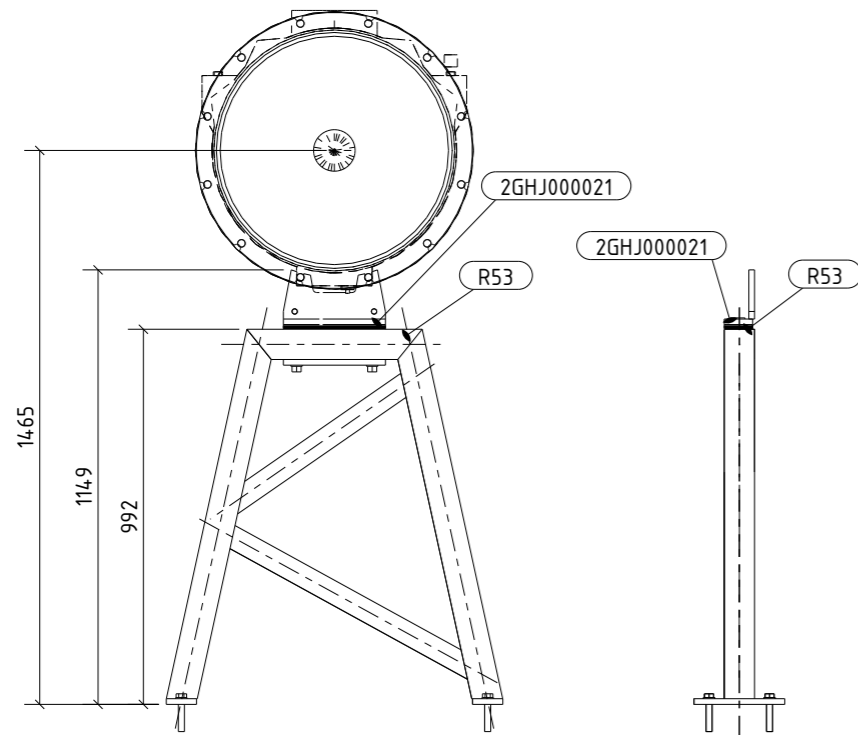


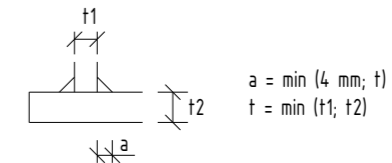
# SUPPORT A19

MATERIAL NUMBER: 2GHE002055A0019



## 1 GENERAL MANUFACTURING NOTES

- 1.1 All steel parts have to be hot galvanized according to manufacturing request.  
Otherwise: EN ISO 1461
  - Minimal layer for holes according to manufacturing request.  
Otherwise:  $40 \mu\text{m} / 285 \text{ g/m}^2$
  - Minimal layer for other parts according to manufacturing request.  
Otherwise:  $70 \mu\text{m} / 505 \text{ g/m}^2$
- 1.2 Hot dip galvanized threads to be brushed prior to assembly.
- 1.3 Welding to be continuous according to manufacturing request.  
Otherwise: EN ISO 3834-1/-2
- 1.4 All welds shall be all around fillet welds unless otherwise noted.
- 1.5 Thickness of welding seams:



- 1.6 Dimensions tolerances for welded construction according to EN ISO 13920-AE.
- 1.7 Dimensions tolerances for non-welded construction according to EN ISO 2768-mK.
- 1.8 Material quality according to manufacturing request.  
Otherwise: EN 10025, EN 10219
- 1.9 Material class according to manufacturing request.  
Otherwise: 235JR
- 1.10 The additional parts as fasteners, PTFE plates, rollers and etc (items in the bill of materials) have to be assembled by a supplier.
- 1.11 All bolts, nuts, washers and etc (except stainless steel) have to be hot galvanized according to manufacturing notes.  
Otherwise: EN ISO 1461

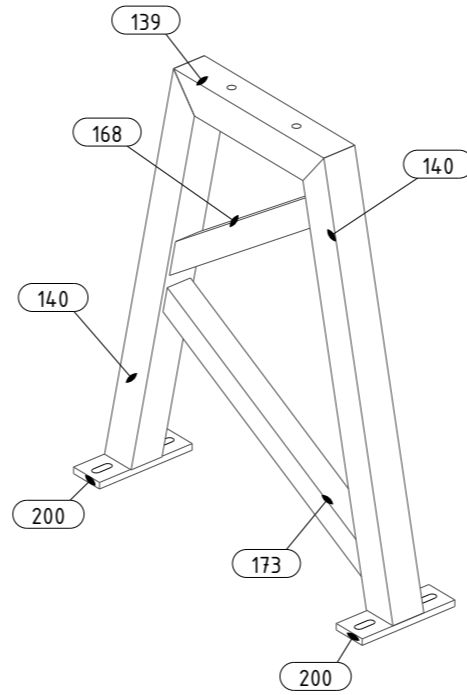
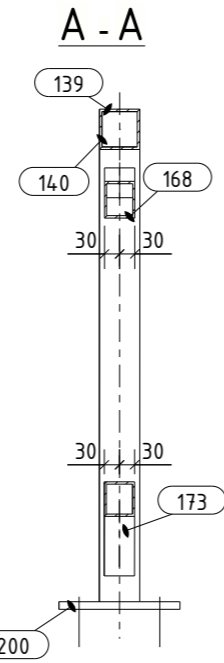
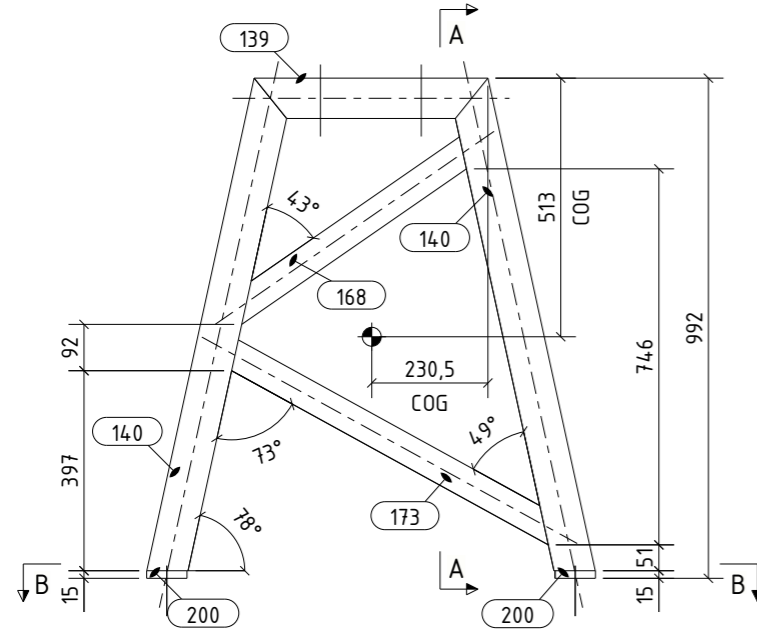
## 2 GENERAL ASSEMBLY NOTES

- 2.1 Damaged zinc layers have to be zinc painted after assembling.
- 2.2 The tightening torque is according to HASV600416.
- 2.3 For sliding connections with PTFE-material:
  - First nut with maximal torque of 0.5% of values of table in document HASV600416.
  - Second nut with torque according to document HASV600416.

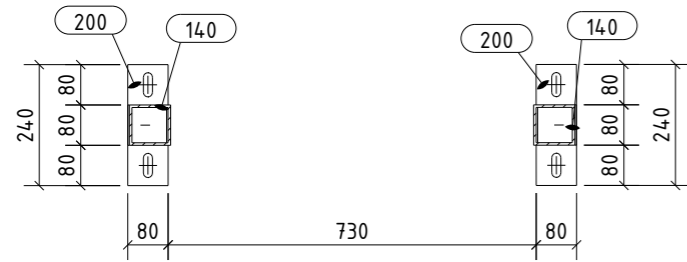
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Approved:	2023-04-14	BLAHA	Replaces:	-	SF6 SWITCHGEAR ELK4/170 ELIZABETH 69kV							
Released:	2023-04-14	CATALAN	Responsible department:	PTHS-SE								Language:
Order number:	101703	Revision:		A 2023-04-14	ASHQAR	SUPPORT A19		No sheets:	3	Sheet no.:		1
						Document Number:	2GHE002055-A19					

# R53



B - B



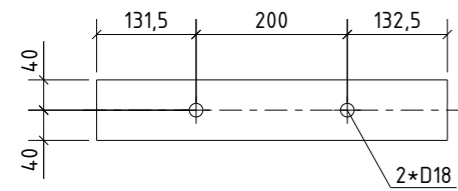
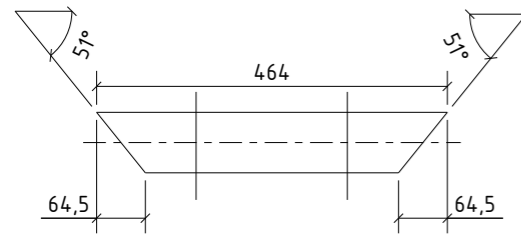
● CENTER OF GRAVITY (COG)  
 NS - NEAR SIDE, FS - FAR SIDE, BS - BOTH SIDES

CLASS OF STEEL S235JR. ALL DIMENSIONS ARE IN MILLIMETERS.  
 THREADED HOLES TO BE DRILLED AND THREADED AFTER THE ASSEMBLY IS WELDED.  
 THREADED HOLES GO ALSO THROUGH WALL THICKNESS OF BOTH THE PLATE AND THE PROFILE.

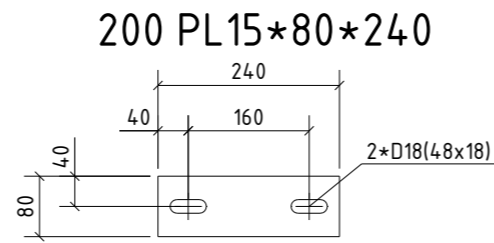
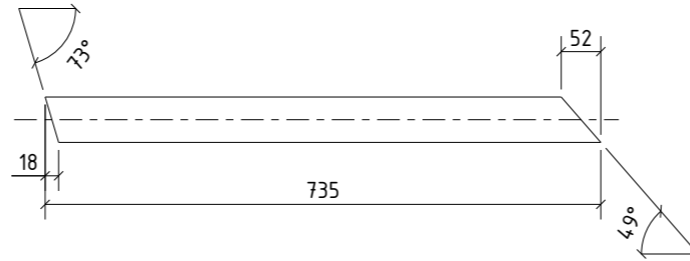
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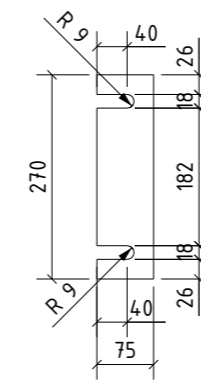
139 SHS80\*5\*464



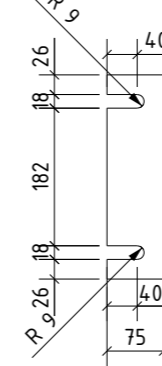
173 SHS 60\*60\*4\*735



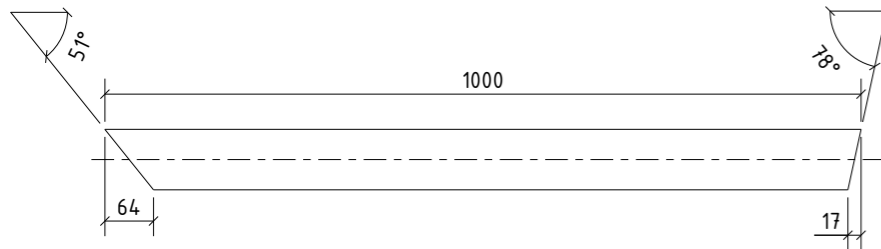
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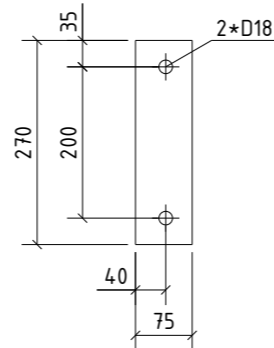
S601 PL2\*75\*270



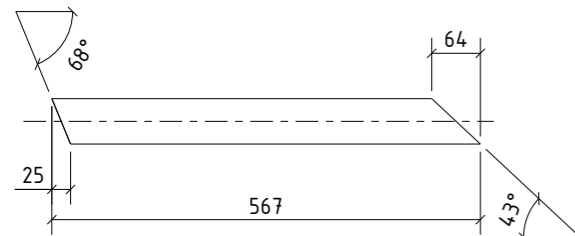
140 SHS80\*5\*1000



202 PL15\*75\*270



168 SHS 60\*60\*4\*567



THREADED HOLES TO BE DRILLED AND THREADED AFTER THE ASSEMBLY IS WELDED.  
CLASS OF STEEL S235JR. ALL DIMENSIONS ARE IN MILIMETERS.

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