

Toleranz ± 1 (± 2)

РГУФДГУСК 80 баг

Brennschritte

Teil 1 vier Seiten von Hand brenngeschnitten
Teil 2,3,4 von Hand brenngeschnitten
Bohrungen von Hand brenngeschnitten

Anschweißende DN15 und DN20 von Hand gesägt

The figure consists of two parts: a top view diagram and a detailed cross-sectional view.

Top View Diagram:

- Components labeled 1 through 8 are shown.
- Dimensions include:
 - Vertical height of the main structure: 311
 - Width of the base plate: 141
 - Width of the side frame: 141
 - Width of the top frame: 141
 - Height of the side frame: 311
 - Width of the top frame: 311
 - Width of the base plate: 311
 - Width of the side frame: 111
 - Width of the top frame: 111
 - Width of the base plate: 111
 - Width of the side frame: 41
 - Width of the top frame: 41
 - Width of the base plate: 41
 - Width of the side frame: 30
 - Width of the top frame: 30
 - Width of the base plate: 30
 - Width of the side frame: 25
 - Width of the top frame: 25
 - Width of the base plate: 25
 - Width of the side frame: 5
 - Width of the top frame: 5
 - Width of the base plate: 5
 - Width of the side frame: 32
 - Width of the top frame: 32
 - Width of the base plate: 125

Cross-Sectional View:

- Dimensions include:
 - Width of the base plate: 95±2
 - Width of the side frame: 30
 - Width of the top frame: 30
 - Diameter of the hole: $\phi 28$
 - Radius of the corner: $R \frac{3}{4}''$
 - Width of the base plate: 25
 - Width of the side frame: 25
 - Width of the top frame: 25
 - Width of the base plate: 5
 - Width of the side frame: 5
 - Width of the top frame: 5
 - Width of the base plate: 32
 - Width of the side frame: 125

Schweißzusätze

311 G-Schweißen Böhler DMO	$\phi 2.5$	EN ISO 12536
111 E-Schweißen Böhler EV50	$\phi 3.25$	EN ISO 2560-A
141 WIG-Schweißen Böhler DMO IG	$\phi 2.4$	EN ISO 21952-A
135 MAG-Schweißen Böhler EMK 6	$\phi 1$	EN ISO 636-A

The technical drawing illustrates a mechanical component with the following dimensions and features:

- Total width: 200 ± 2 mm.
- Total height: 125 ± 2 mm.
- Left side height: 95 ± 2 mm.
- Right side height: 95 ± 2 mm.
- Top horizontal slot width: 30 mm.
- Radius at top corner: $R \frac{1}{2}''$.
- Hole diameter: $\phi 22$ mm.
- Bottom slot width: 180 mm.
- Bottom slot length: 155 mm.
- Bottom slot depth: 22.5 mm.
- Bottom slot side clearance: 10 mm.
- Bottom slot center-to-center distance: 33 mm.
- Bottom slot side wall thickness: 5 mm.
- Bottom slot bottom wall thickness: 28 mm.
- Bottom slot side wall angle: 45° .
- Bottom slot bottom wall angle: 45° .
- Bottom slot side wall height: 10 mm.
- Bottom slot bottom wall height: 10 mm.

1	Anschweißende	8	P235GH DN20 geschw.	30 lang			
1	Anschweißende	7	P235GH DN15 geschw.	30 lang			
1	Rohr	6	P235GH DN20 geschw.	62 lang			
1	Rohr	5	P235GH DN15 geschw.	62 lang			
1	Blech	4	S 235 JR	160x120x5			
2	Blech	3	S 235 JR	150x120x5			
2	Blech	2	S 235 JR	200x150x5			
1	Blech	1	S 235 JR	250x150x5			
Stück	Benennung	Teil	Norm - Nr. / Werkstoff	Rohmaße			
				Bemerkung			
Kennnummer: XXX		Arbeitszeit: 6 Stunden					
LEHRLINGSWETTBEWERB							
Maßstab 1:2	Öltank						
Beruf: M6	Zeichnungs - Nr.: M6-2a V4						
Diese Zeichnung ist Eigentum der WIRTSCHAFTSKAMMER - Oberösterreich							
							