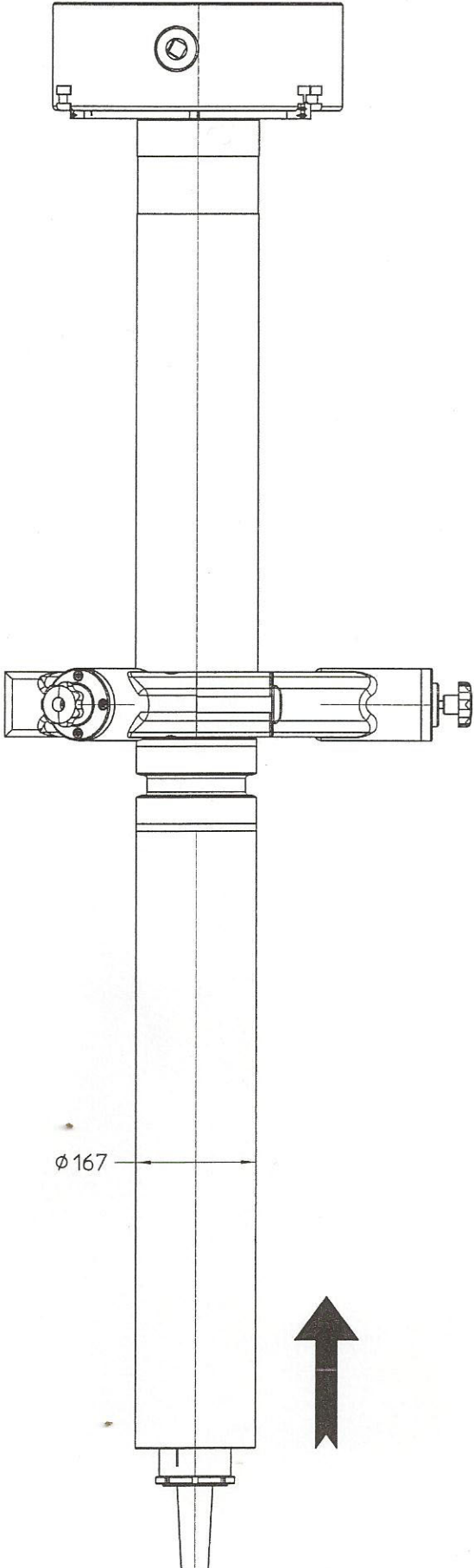


- OPSPANNING 10:
1. BRIL VERSCHUIVEN NAAR LINKSE BRILRAND IN HET MIDDEN VAN DE ROL ANDERE ZIJDE OPSPANNEN DOOR SPANDOORN IN CENTER.
 2. BUITENKANT EN STUURSNAARGROEF DRAAIEN IN EÉN OPSPANNING VOLGENS TEKENING 19024. VOORKOM TRILLINGEN DOOR PASSENDE VOEDING EN SNEDEDEPTE.

- STAGE 10:
1. MOVE THE FIXED STAY TO THE LEFT MACHINED SURFACE AT MIDDLE OF THE ASSEMBLY
 2. MACHINE THE OUTER SURFACE AND V-GROOVE ALL AT ONCE ACCORDING TO DRAWING 19024.

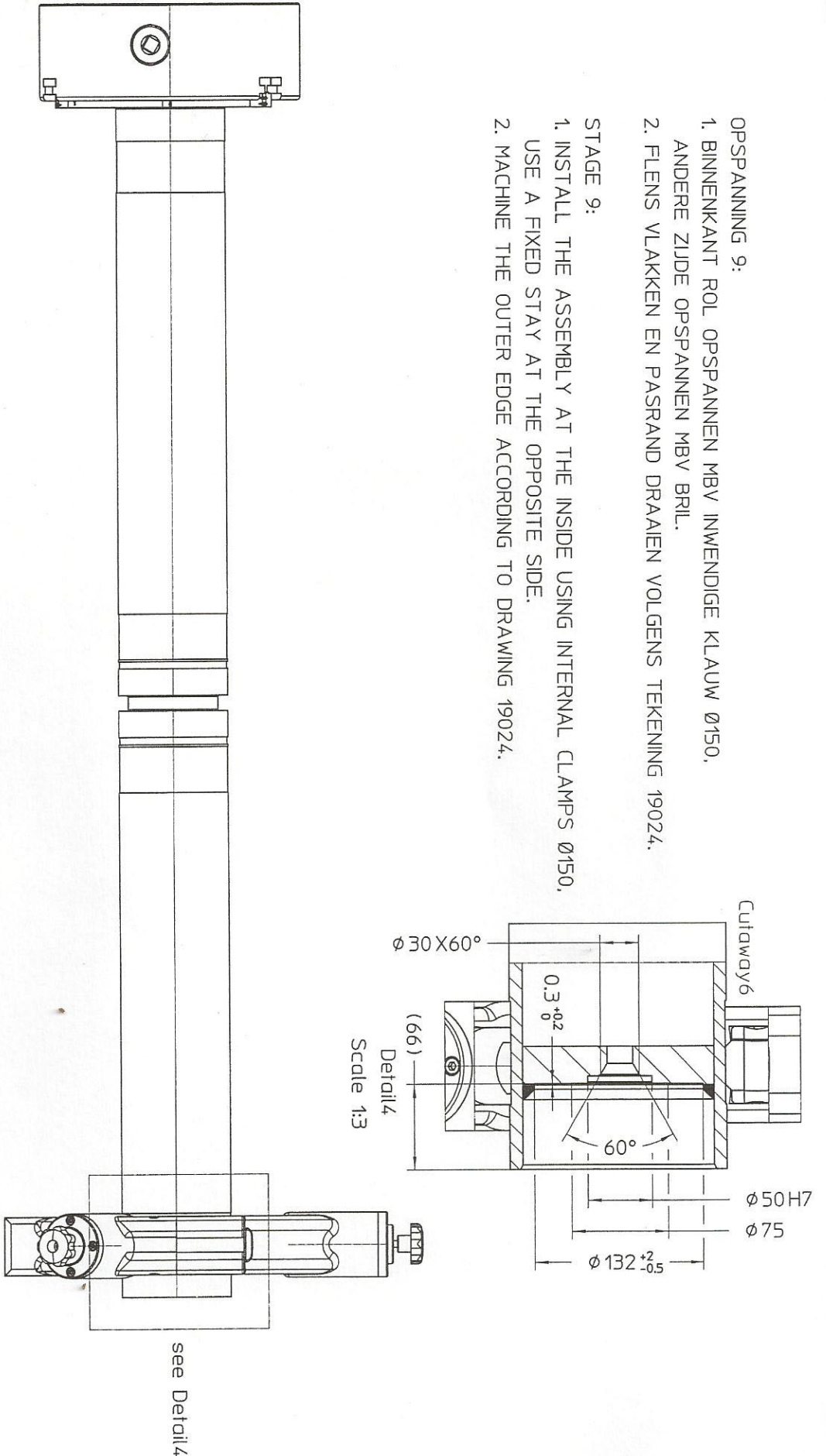


GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. MEDIUM				GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. MEDIUM		GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. MEDIUM		GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. MEDIUM	
STATUS: released				STATUS: released		STATUS: released		STATUS: released	
REV.	DESCRIPTION	DATE	NAME	NO. OF PROJECTIONS	DATE	NAME	NO. OF PROJECTIONS	DATE	NAME
TRIO LIET				TRIO LIET		TRIO LIET		TRIO LIET	
NUMMER: 19024_DB		REV: 0		FORMAAT: A3		EXTRA: BEWERKINGSVOLGORDE			

19024-10

- OPSPANNING 9:
1. BINNENKANT ROL OPSPANNEN MBV INWENDIGE KLAUW Ø150.
ANDERE ZIJDE OPSPANNEN MBV BRIL.
 2. FLENS VLAKKEN EN PASRAND DRAAIEN VOLGENS TEKENING 19024.

- STAGE 9:
1. INSTALL THE ASSEMBLY AT THE INSIDE USING INTERNAL CLAMPS Ø150.
USE A FIXED STAY AT THE OPPOSITE SIDE.
 2. MACHINE THE OUTER EDGE ACCORDING TO DRAWING 19024.

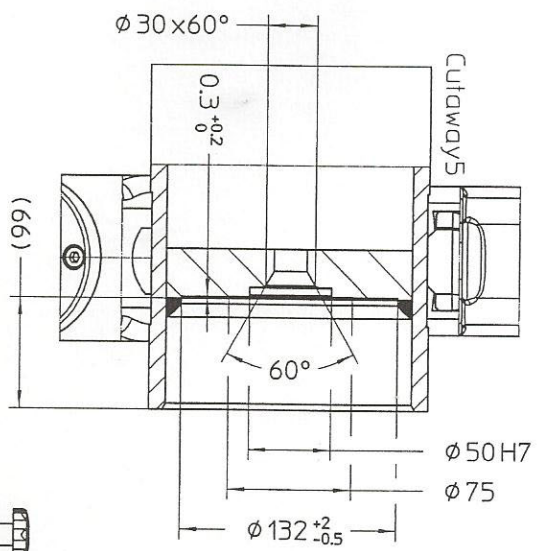


GENERAL MACHINING TOLERANCE ACC ISO 2768 CL 'MEDII'		GENERAL TOLERANCE ISO 2768		MATERIAL: TREATMENT:	
STATUS: released		UNITS MM		SCALE 1:3	
CREATED	05-07-2016	DATE	JWS	DESCRIPTION:	
APPROVED	14-09-2016	DATE	JWS	OPVOERBAND MET SNAAR	
RELEASED	14-09-2016	DATE	JWS	TRIOTRAC II CASSETTE	
NUMBER: 19024_DB		NUMBER: 19024_DB		EXTRA: BEWERKINGSVOEGHOE	
REV: 0		REV: 0		FORMAT A3	
REV. DESCRIPTION		DATE		NAME	

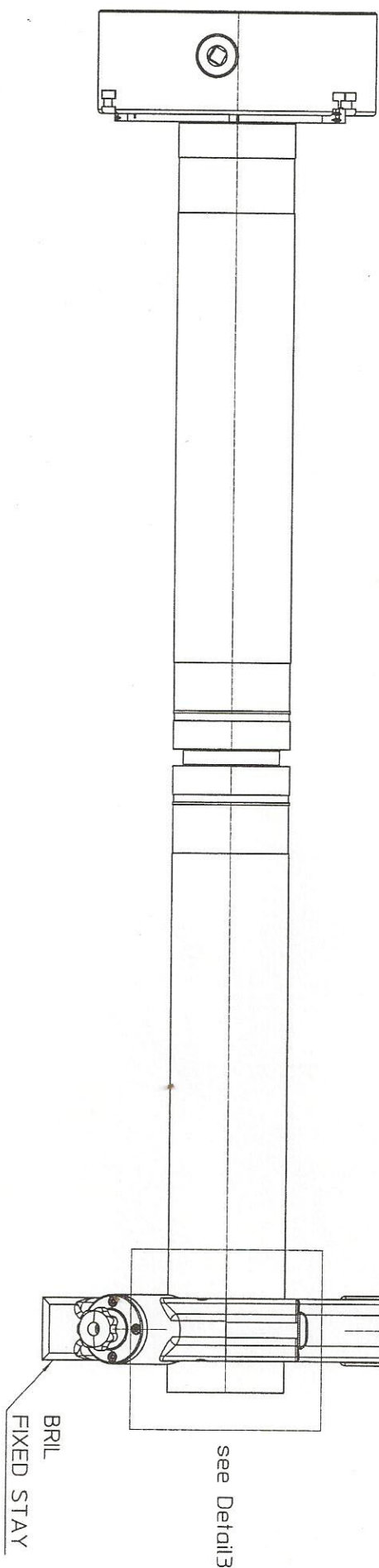
19024-8

- OPSPANNING 8:
1. SPANDOORN Ø150 VERVANGEN DOOR BRIL.
 2. FLENS VLAKKEN EN PASRAND DRAAIEN VOLGENS TEKENING 19024.
 3. ROL OMDRAAIEN.

- STAGE 8:
1. REPLACE THE FIXTURE Ø150 THE FIXED STAY.
 2. MACHINE THE OUTER END ACCORDING TO DRAWING 19024.
 3. TURN AROUND THE ASSEMBLY



Detail 3
Scale 1:3



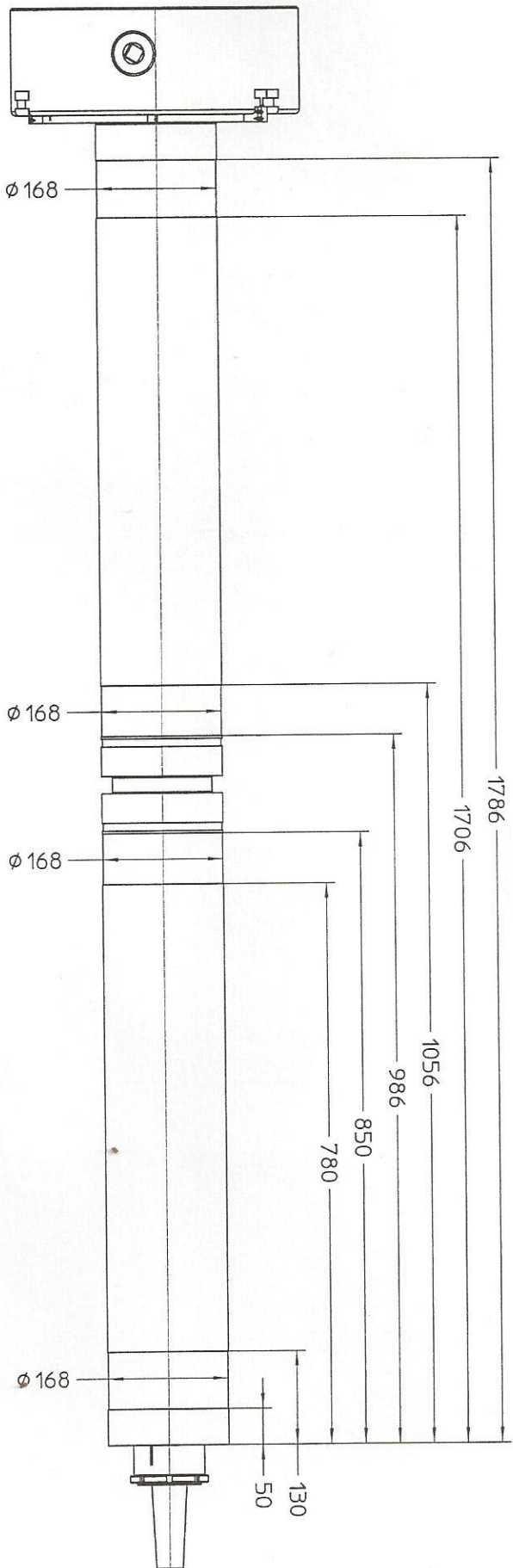
GENERAL MACHINING TOLERANCE A1C ISO 2768 CL. MEDIUM		GENERAL TOLERANCE A1C ISO 2768 CL. MEDIUM		GENERAL TOLERANCE A1C ISO 2768 CL. MEDIUM		GENERAL TOLERANCE A1C ISO 2768 CL. MEDIUM	
STATUS: released		NO SCALE		DATE		NAME	
CREATED	05-07-2016	JWS		APPROVED	14-09-2016	JWS	
RELEASED	14-09-2016	JWS					
DESCRIPTION:		MATERIAL:		TREATMENT:		DIMENSION:	
OPVOERBAND MET SNAAR		TRIOTRAC II CASSETTE					
NUMBER: 19024_DB		EXTRA: BEVEKINGSVOLGORDE		REV: 0		FORMAT A3	

19024-8

- OPSPANNING 7:
1. BINNENKANT ROL OPSPANNEN MBV INWENDIGE KLAUW Ø150,
 - ANDERE ZIJDE OPSPANNEN DOOR SPANDOORN Ø150 IN CENTER.
 2. 4x BRILRAND DRAAIEN.

STAGE 7:

1. INSTALL THE ASSEMBLY AT THE INSIDE USING INTERNAL CLAMPS Ø150,
- USE A FIXTURE Ø150 IN THE CENTER AT THE OPPOSITE SIDE.
2. MACHINE THE FOUR SURFACES Ø168 FOR THE FIXED STAY.



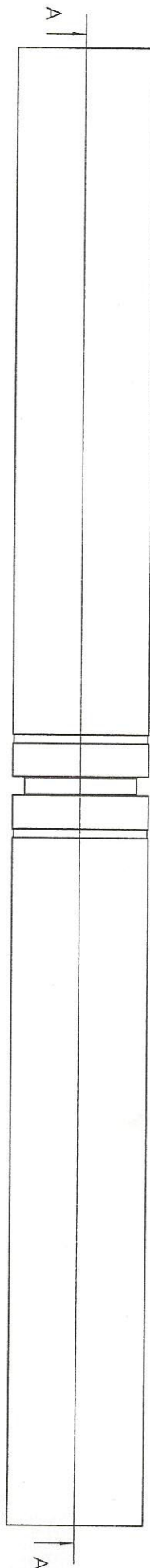
GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. "MEDIUM"		DIMENSIONAL TOLERANCES UNLESS OTHERWISE SPECIFIED: MM		DIMENSIONAL TOLERANCES UNLESS OTHERWISE SPECIFIED: INCHES	
STATUS: released		UNITS: MM		SCALE: 1:1	
CREATED: 05-07-2016		DATE:		NAME: JWS	
APPROVED: 14-09-2016		DATE:		NAME: JWS	
RELEASED: 14-09-2016		DATE:		NAME: JWS	

REV.	DESCRIPTION	DATE	NAME	MATERIAL:	TREATMENT:	DESCRIPTION:
				TRIOIET		OPVOERBAND MET SNAAR TRIOIET II CASSETTE
				NUMBER: 19024_DB	REVISION: 0	FORMAT: A3
				EXTRA: BEMERKINGSVOLGORDE		

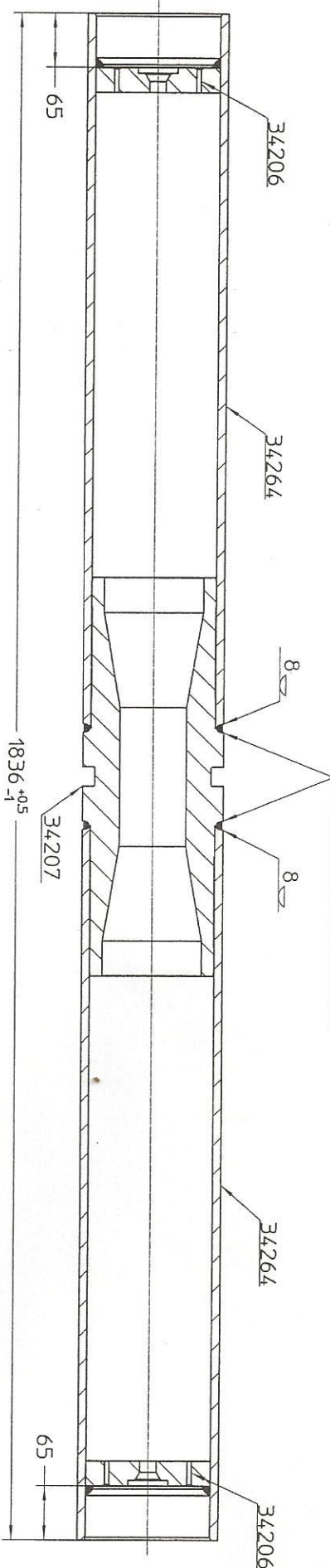
19024-7

- OPSPANNING 6:
- 1. SNAARTAP, BIJZEN EN FLENSSEN IN ELKAAR PERSEN
 - 2. DELEN LASSEN VOLGENS TEKENING 19024.

- STAGE 6:
- 1. PRESS THE PARTS 34206, 34207 & 34264 TOGETHER.
 - 2. WELD THE PARTS ACCORDING TO DRAWING 19024.



START SECOND WELD 180° ROTATED
TWEDE LAS 180° VERDRAAID BEGINNEN



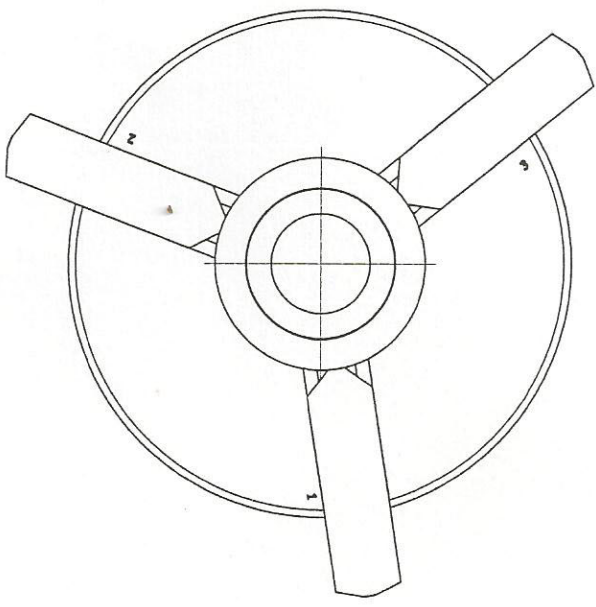
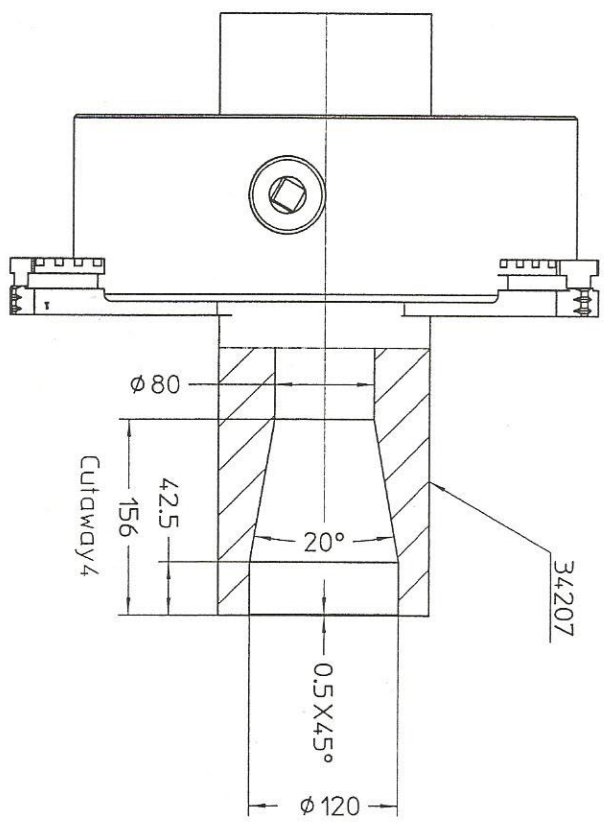
Section A-A

GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. MED/SH	STATU: released	GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. MED/SH	TOLERANCE MM	TOLERANCE MM	TOLERANCE MM	MATERIAL:
DATE	NAME	DATE	NAME	DATE	NAME	TREATMENT:
CREATED	APPROVED	RELEASED	JMS	JMS	JMS	DIMENSION:
06-07-2016	14-09-2016	14-09-2016	15	15	15	DESCRIPTION:
RELEASED			JMS			OPVOERBRAND MET SNAAR
						TROTTRAC II CASSETTE
						NUMBER: 19024_DB
						EXTRA: BEWERSKISSIEN, GOROE
						REV: 0
						FORMAT A3

19024-6

- OPSPANNING 4:
1. BUITENZIDE SNAARTAP OPSPANNEN IN DRIEKLAUW.
 2. INWENDIGE AFSCHIJNING DRAAIEN MET PASRAND VOLGENS TEKENING 34207.

- STAGE 4:
1. INSTALL THE OTHER SIDE OF PART 34207 IN THE THREE JAW CHUCK.
 2. MACHINE THE INSIDE ACCORDING TO DRAWING 34207.



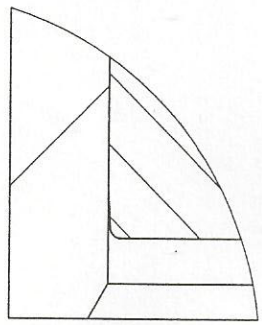
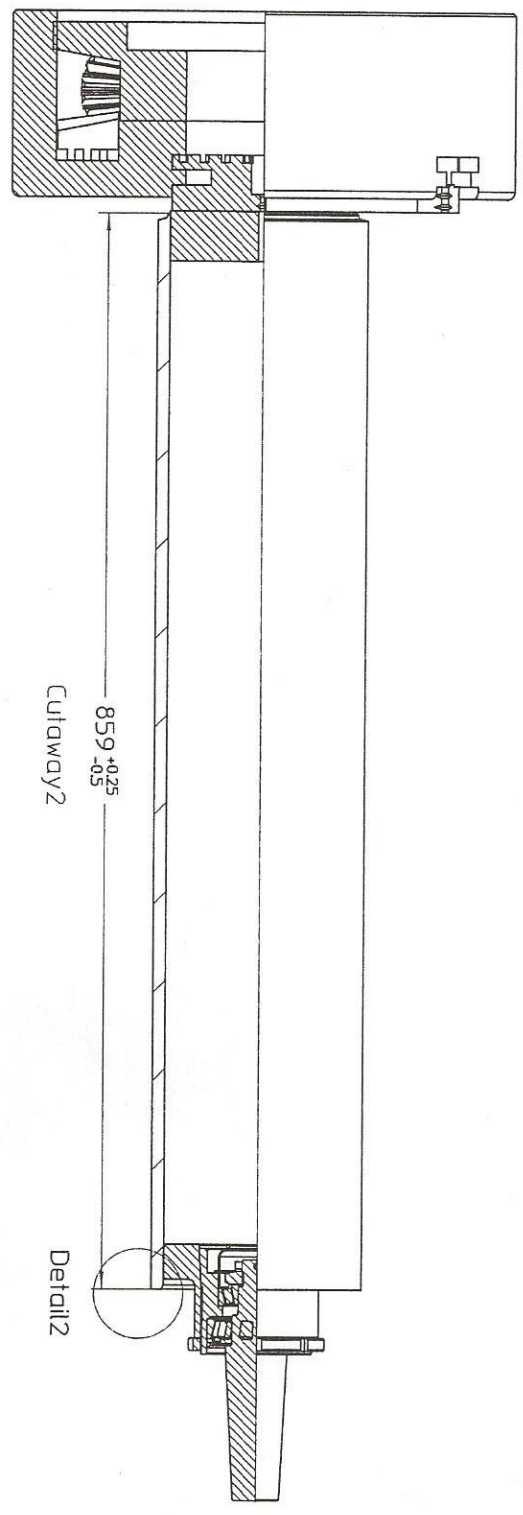
GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. MEDUW		REVISIONS NO. DATE REVISION BY		REVISIONS NO. DATE REVISION BY	
STATUS: released		APPROVED DATE: 05-07-2016 BY: JWS		APPROVED DATE: 14-09-2016 BY: JWS	
REV.	DESCRIPTION	DATE	NAME	REV.	DESCRIPTION
MATERIAL: TRIOLET			DESCRIPTION: OPVOERBAND MET SMAAR		
TREATMENT:			DIMENSION:		
NUMBER: 19024_DB			EXTRA: BEVEERKENSYVL.GORDE		
REV: 0			FORMAT: A3		

19024-4

- OPSPANNING 2:
1. BINNENKANT CLINDERBUIS OPSPANNEN MBV INWENDIGE KLAUW Ø150, ANDERE ZIJDE OPSPANNEN DOOR SPANDOORN Ø150 IN CENTER.
 2. VLAKKEN EN AFSCHUINING DRAAIEN VOLGENS TEKENING 34264.

STAGE 2:

1. INSTALL THE TUBE AT THE INSIDE USING INTERNAL CLAMPS Ø150, USE A FIXTURE Ø150 IN THE CENTER AT THE OPPOSITE SIDE.
2. MACHINE THE SURFACE AND EDGES ACCORDING TO DRAWING 34264.



Detail2
Scale 2:1

GENERAL MACHINING TOLERANCE K.C. ISO 2768 CL. MED/H		SPECIFIC TOLERANCES AC K.C. ISO 2768 CL. MED/H		SPECIFIC TOLERANCES AC K.C. ISO 2768 CL. MED/H		SPECIFIC TOLERANCES AC K.C. ISO 2768 CL. MED/H		MATERIAL:	
STATUS: released		NO FILED INJECTION		UNITS MM		SCALE 1:4		TREATMENT:	
REV.	DESCRIPTION	DATE	NAME	CREATED	DATE	NAME	DESCRIPTION:	NUMBER:	REV:
				APPROVED	14-09-2016	JWS	OPVOERBAND MET SNAAR	19024_DB	0
				RELEASED	14-09-2016	JWS	TRIOTRAC II CASSETTE	EXTRA: BEVERINGSVOLGORDE	
								FORMAT	
								A3	

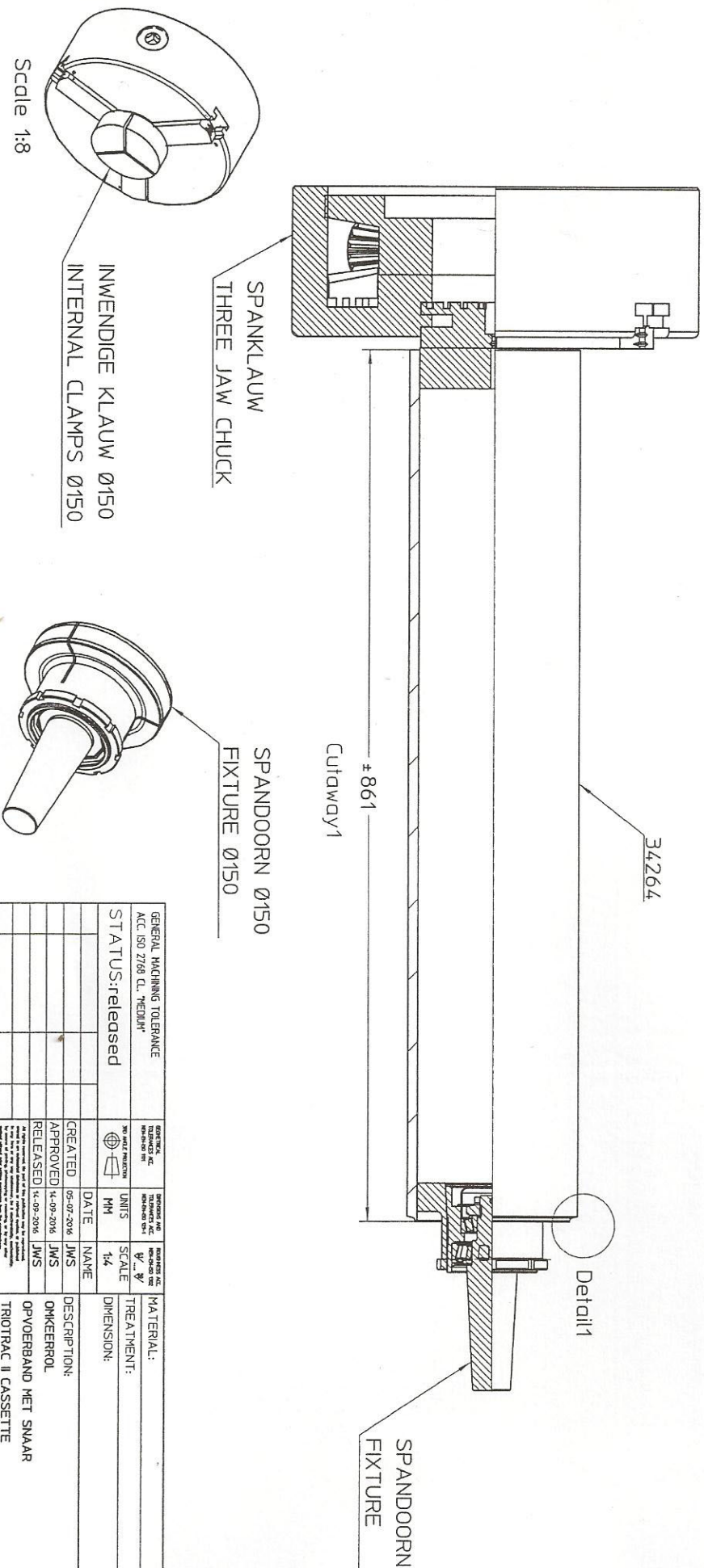
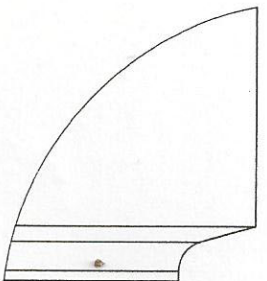
19024-2

- OPSPANNING 1:
1. BINNENKANT CILINDERBUIS OPSPANNEN MBV INWENDIGE KLAUW Ø150, ANDERE ZIJDE OPSPANNEN DOOR SPANDOORN Ø150 IN CENTER.
 2. VLAKKEN, ZOEKRAND EN LASRAND DRAAIEN VOLGENS TEKENING 34264.
 3. BUIS OMDRAAIEN.

STAGE 1:

1. INSTALL THE TUBE AT THE INSIDE USING INTERNAL CLAMPS Ø150,
2. USE A FIXTURE Ø150 IN THE CENTER AT THE OPPOSITE SIDE.
3. TURN AROUND THE TUBE.

Detail 1
Scale 2:1



GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. 'MED'		GENERAL TOLERANCE ACC. ISO 2768 CL. 'MED'		MATERIAL: TREATMENT:	
STATUS: released	NO HOLE POSITION	UNITS MM	SCALE 1:4	DIMENSION:	
	CREATED 05-07-2008	DATE	NAME	DESCRIPTION:	
	APPROVED 14-09-2008	DATE	NAME	OPVOERBAND MET SNAAR	
	RELEASED 14-09-2008	DATE	NAME	TRIOTRAC II CASSETTE	
REV.	DESCRIPTION	DATE	NAME	NUMBER: 19024_DB	
				EXTRA: BEWERKINGSVOLGORDE	
				REV: 0	
				FORMAT A3	

19024-1