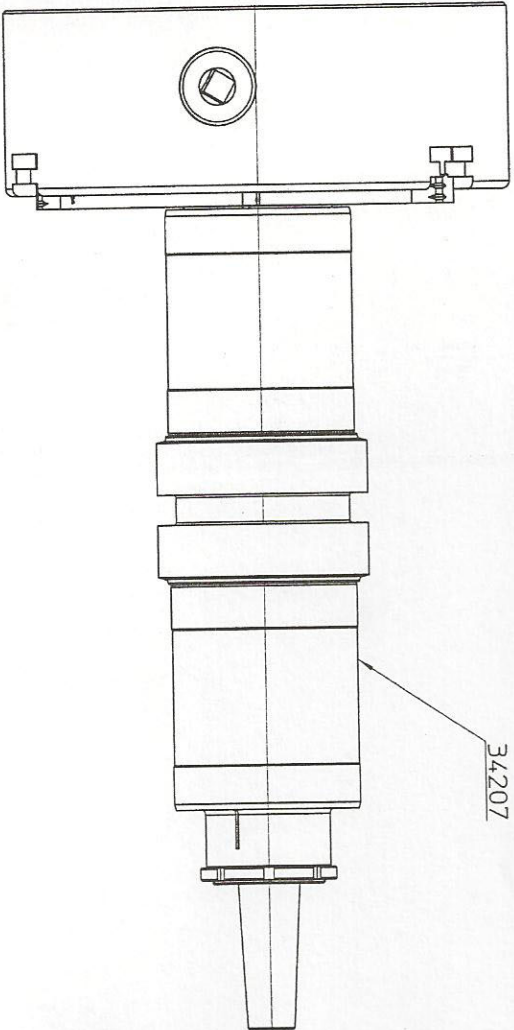


- OPSPANNING 5:
1. BINNENKANT SNAARTAP OPSPANNEN MBV INWENDIGE KLAUW Ø120, ANDERE ZIJDE OPSPANNEN DOOR SPANDOORN Ø120 IN CENTER.
 2. VLAKKEN, LASRAND EN GROEF STUURNAAR DRAAIEN VOLGENS TEKENING 34207.

STAGE 5:

1. INSTALL PART 34207 AT THE INSIDE USING INTERNAL CLAMPS Ø120, USE A FIXTURE Ø120 IN THE CENTER AT THE OPPOSITE SIDE.
2. MACHINE THE OUTER SURFACE AND EDGES ACCORDING TO DRAWING 34207.



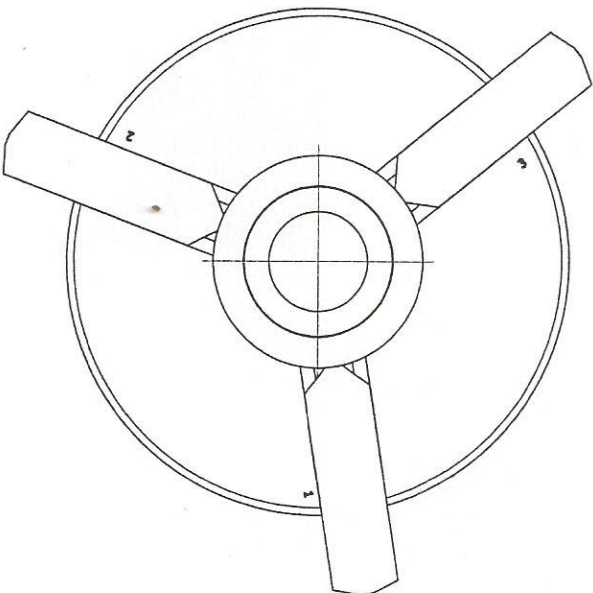
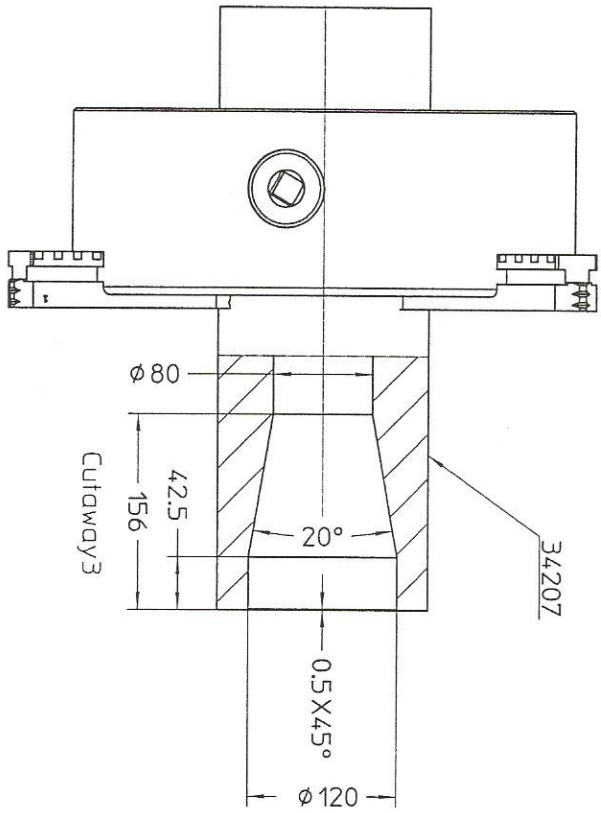
GENERAL MACHINING TOLERANCE ACC. ISO 2769 CL. MEDUW		APPROVAL BY: [Signature]		DATE	
STATUS: released		DATE		NAME	
CREATED	05-07-2016	JWS			
APPROVED	14-09-2016	JWS			
RELEASED	14-09-2016	JWS			
<p>TRIO LIET</p> <p>EXTRA: BEWERKINGSVOLGORDE</p>					
MATERIAL:		TREATMENT:		DIMENSION:	
DESCRIPTION:		NUMBER: 19024_DB		REV: 0	
OPVOERBAND MET SNAAR		TROTALC II CASSETTE		FORMAT A3	

19024-5

- OPSPANNING 3:
1. BUTENZIJDE SNAARTAP OPSPANNEN IN DRIEKLAUW.
 2. INWENDIGE AFSCHUINING DRAAIEN MET PASRAND VOLGENS TEKENING 34207.
 3. SNAARTAP OMDRAAIEN.

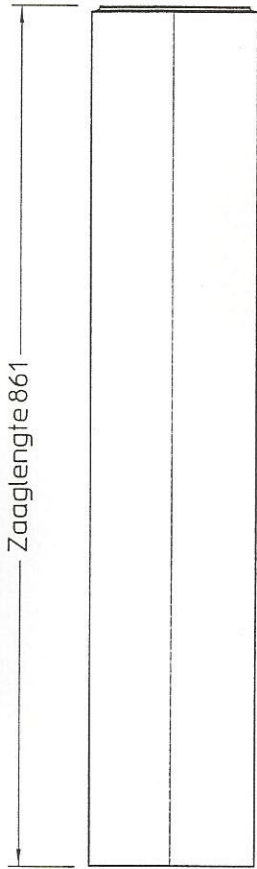
STAGE 3:

1. INSTALL PART 34207 IN THE THREE JAW CHUCK.
2. MACHINE THE INSIDE ACCORDING TO DRAWING 34207.
3. TURN AROUND THE PART.

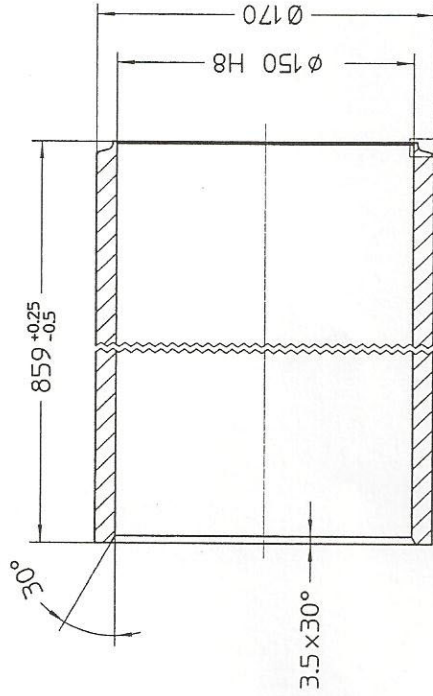


GENERAL MACHINING TOLERANCE A/C ISO 2768 CL "MEDIUM"		GENERAL TRIO LIET REVISIONS REVISIONS	DATE	NAME	DESCRIPTION	REV.
STATUS: released		DATE	NAME	DESCRIPTION	REV.	
CREATED	05-07-2006	JMS				
APPROVED	14-09-2006	JMS				
RELEASED	14-09-2006	JMS				
MATERIAL:						
TREATMENT:						
DIMENSION:						
DESCRIPTION:		OPVEERBAND MET SNAAR				
		TRIO TRAC II CASSETTE				
NUMBER:		19024_DB				
EXTRA: BEWAKINGSVOLGORDE						
		REV: 0				
		FORMAT A3				

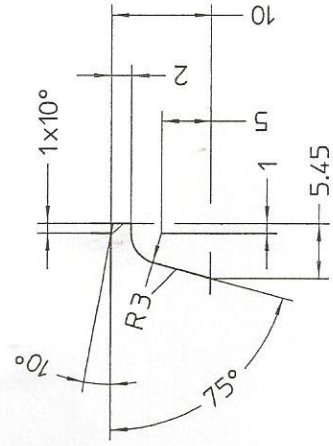
18024-3



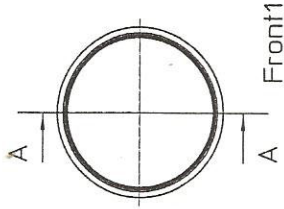
Left1



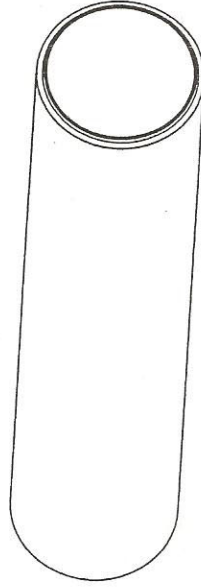
Section A-A see Detail1
Scale 1:2.5



Detail1
Scale 2:1



Front1

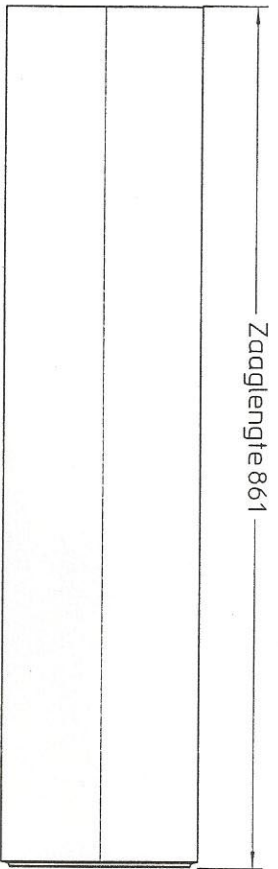


Gen1

1 = NAA106005
2 = gelast.

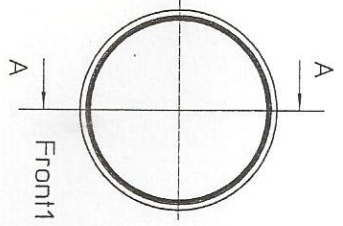
GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. "MEDIUM"		SYMBOLS FOR FINISHES BY MILL FINISHING	SYMBOLS FOR FINISHES BY TURNING AC. 100-1000 RPM	SYMBOLS FOR FINISHES BY GRINDING AC. 10-1000 RPM	SYMBOLS FOR FINISHES BY POLISHING	MATERIAL: EM10305-1-2 E355+SR	
STATUS: released		UNITS: MM	SCALE: 1:5	TREATMENT: Skived roller burnished	DIMENSION: Ø170 x 10 Ø150H8		
REV.	DESCRIPTION	DATE	NAME	CREATED	APPROVED	RELEASED	
				19-03-2015	01-04-2015	01-04-2015	
				GO	GO	GO	
DESCRIPTION: BUIS OMKEERROL OPYOERBAND MET SNAAR TRIOTRAC II CASSETTE							
NUMBER: 34264						REV: 0	FORMAT A3
EXTRA:							



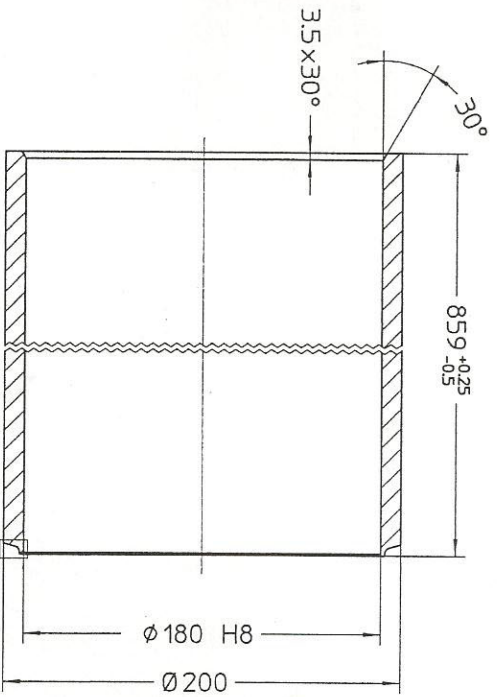


Zaaglengte 861

Left1

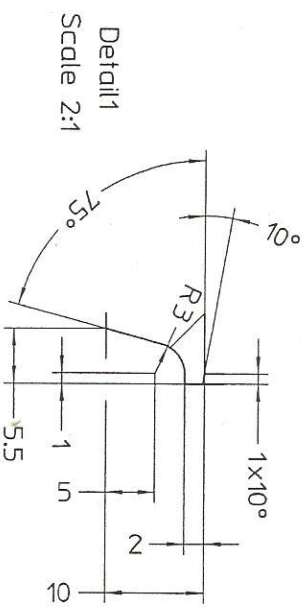


Front1

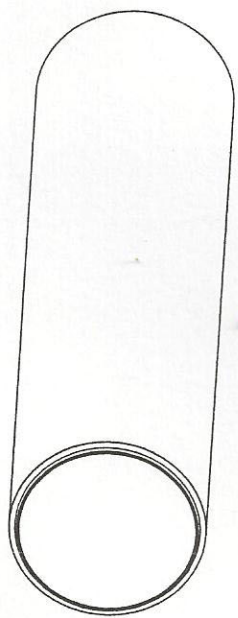


Section A-A
Scale 1:2.5

see Detail1

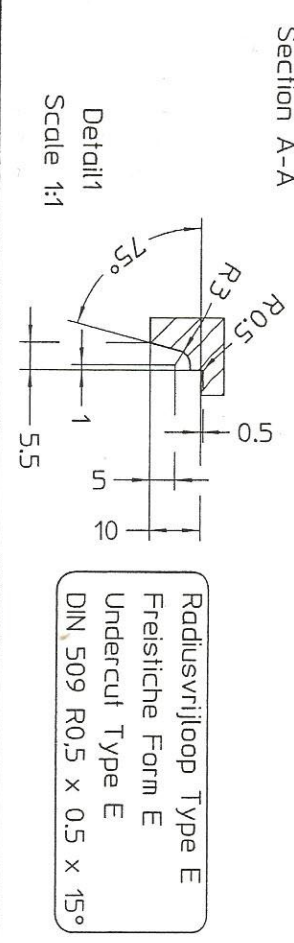
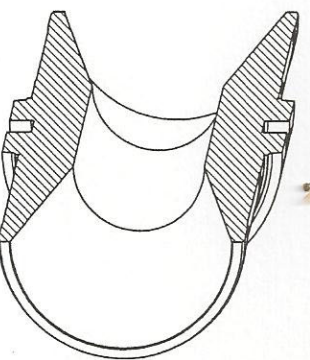
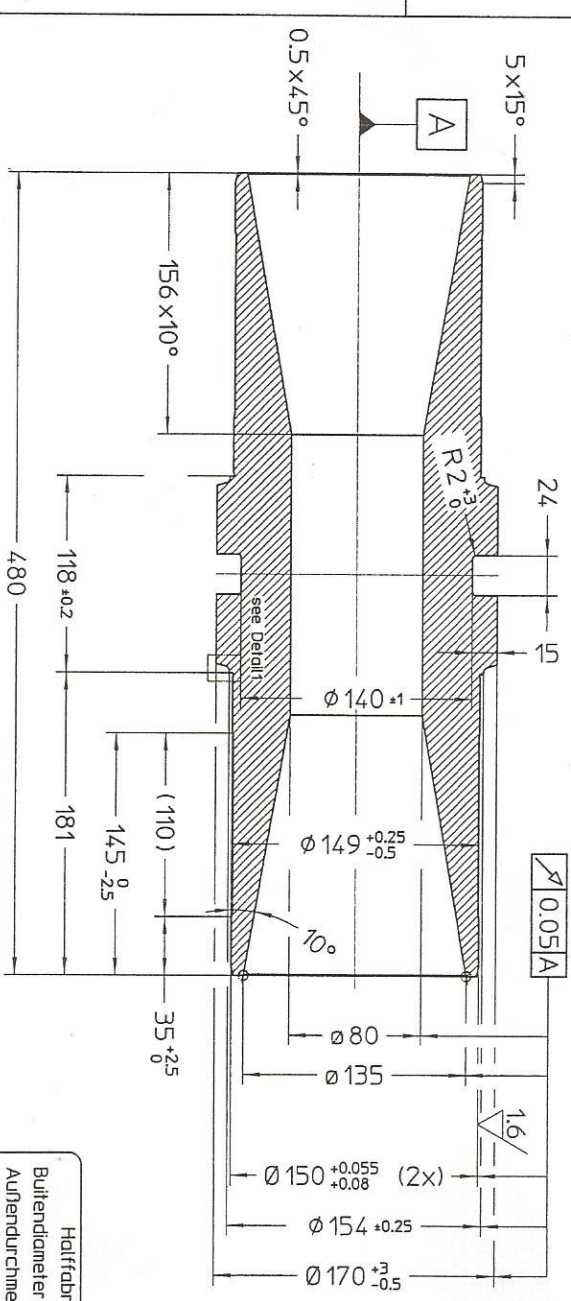
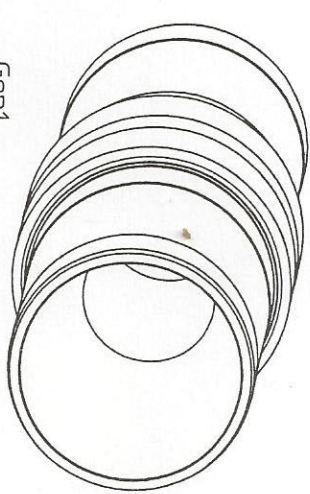
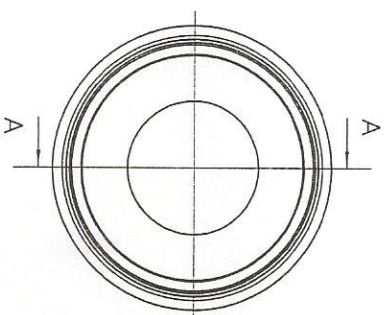
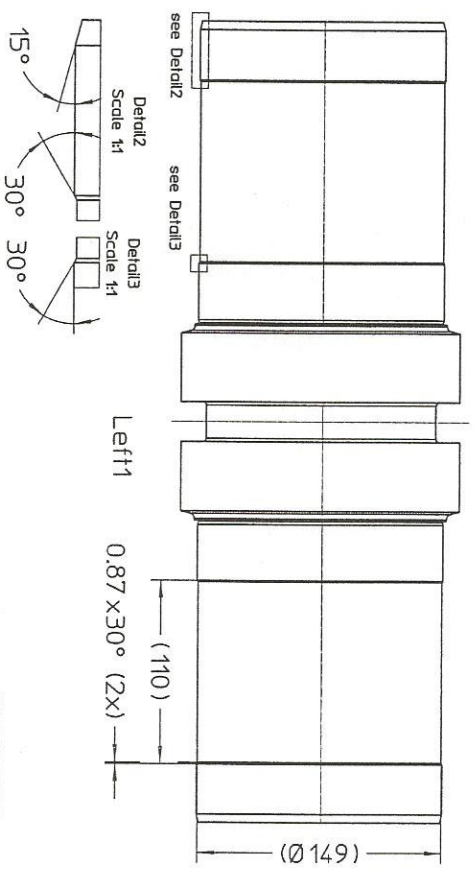


Detail1
Scale 2:1



Gen1

GENERAL MACHINING TOLERANCE ACC. ISO 2769 CL. "MEDIUM"		SPECIFIC TOLERANCES ACC. TO DRAWING		TOLERANCES ACC. TO DRAWING	
STATUS: released		NO MATE FINISH		WAVE FINISH	
REV.	DESCRIPTION	DATE	NAME	CREATED	DATE
				19-03-2015	GO
				APPROVED	01-04-2015
				RELEASED	01-04-2015
MATERIAL: EN10305-1-2 E355-SR		TREATMENT: SKIVED roller burnished		DIMENSION: 200 x 10 180H8	
DESCRIPTION:		L = 861		DESCRIPTION:	
AANDRIJROL OPVOERBAND MET SNAAR		TRIOTRAC II CASSETTE		NUMBER: 34263	
EXTRA:		REV: 0		FORMAT	
				A3	

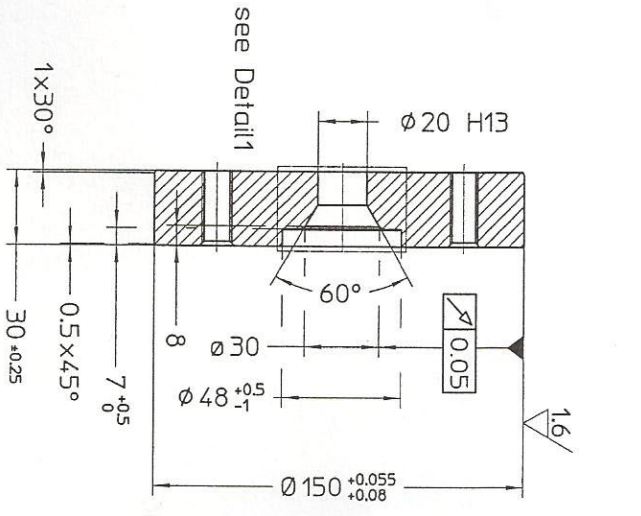


Radiusvrijloop Type E
 Freistriche Form E
 Undercut Type E
 DIN 509 R0,5 x 0,5 x 15°

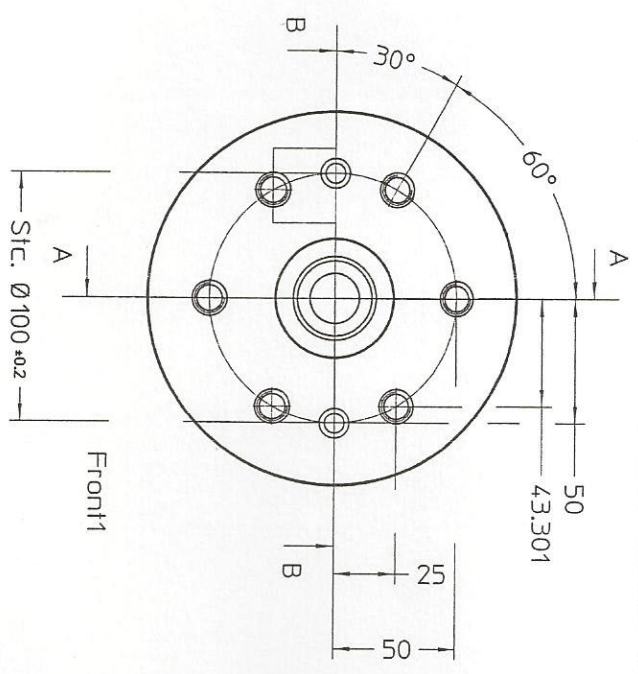
Halfabriekaat / Halbzeug / semi manufacture
 Buitendiameter en groeivorm draaien op tolerantie na het lassen in de rol
 Außendurchmesser und Groove-Form Drehen auf Toleranz nach dem Schweißen in der Rolle
 Outer diameter and Groove form Turning on tolerance after welding in the role

GENERAL MACHINING TOLERANCE ACC. ISO 2768 (L, MEDIAN)		GENERAL TOLERANCE ACC. ISO 2768 (L, MEDIAN)		GENERAL TOLERANCE ACC. ISO 2768 (L, MEDIAN)	
STATUS: released		UNITS: MM		SCALE: 1:3	
CREATED	DATE	APPROVED	DATE	RELEASED	DATE
GO	16-03-2015	GO	16-03-2015	JM	04-07-2016
MATERIAL: S355JR		TREATMENT:		DIMENSION: Ø170	
DESCRIPTION:		V-SNAARTAP		L= 480	
AANDRIJFROL		TRIOTRAC II CASSETTE		NUMBER: 34207	
EXTRA:		REV: 1		FORMAT	
				A3	

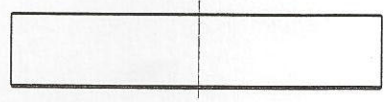




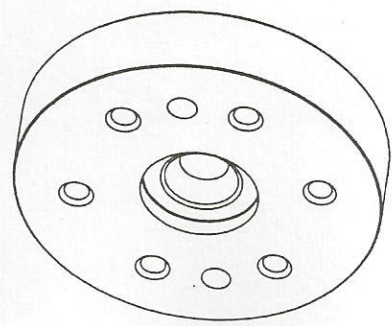
Section A-A



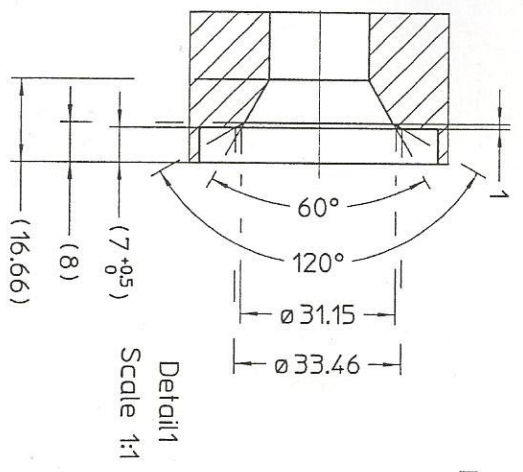
Front1



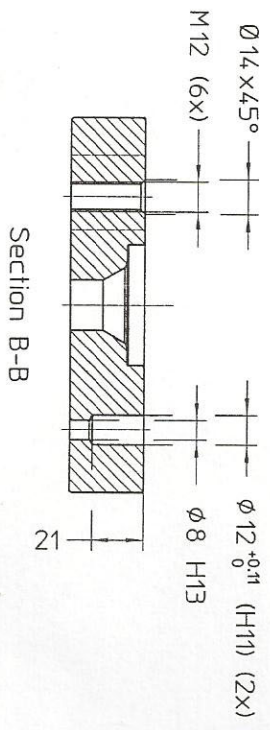
Right1



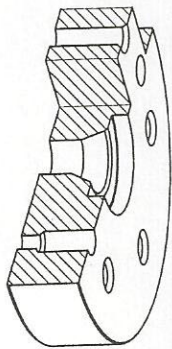
Gen1



Detail1
Scale 1:1



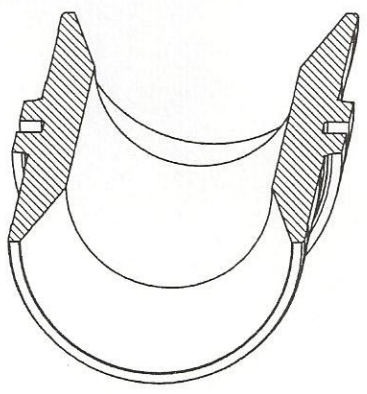
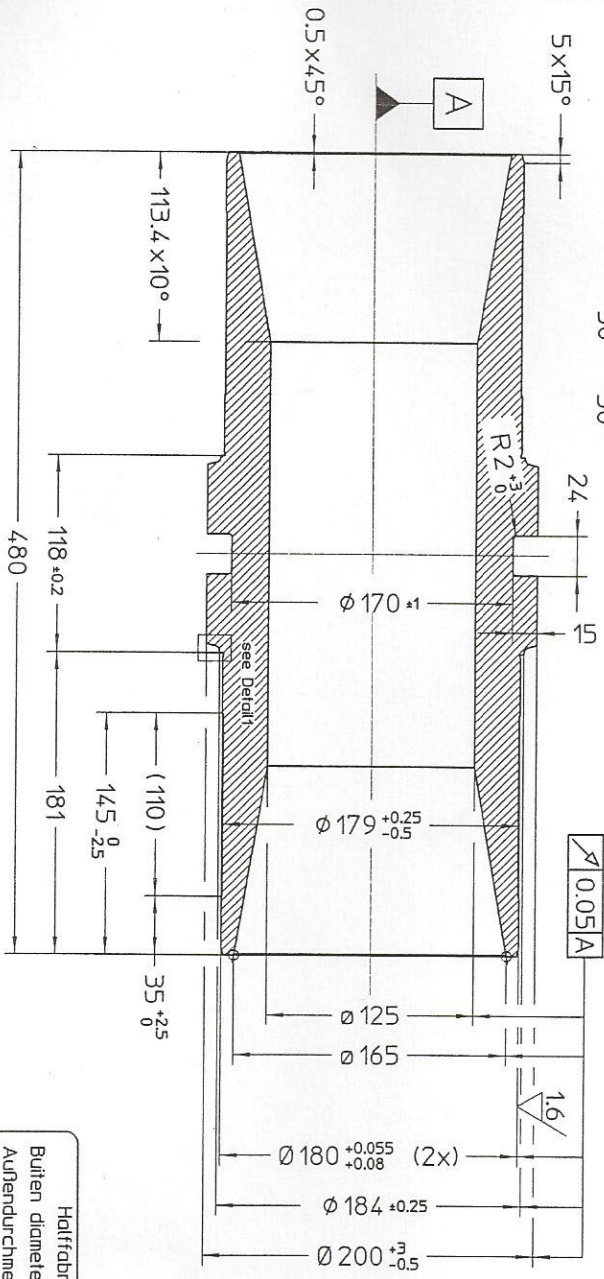
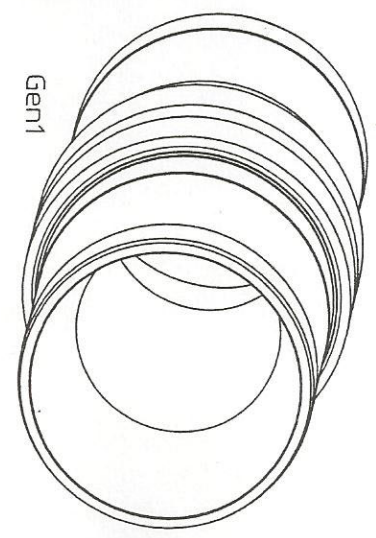
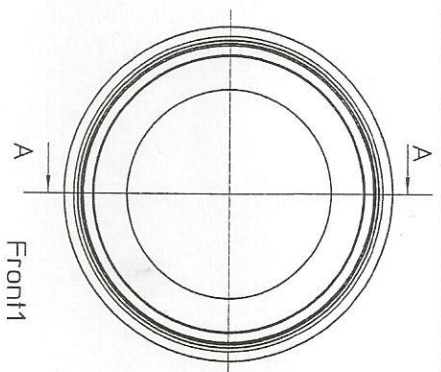
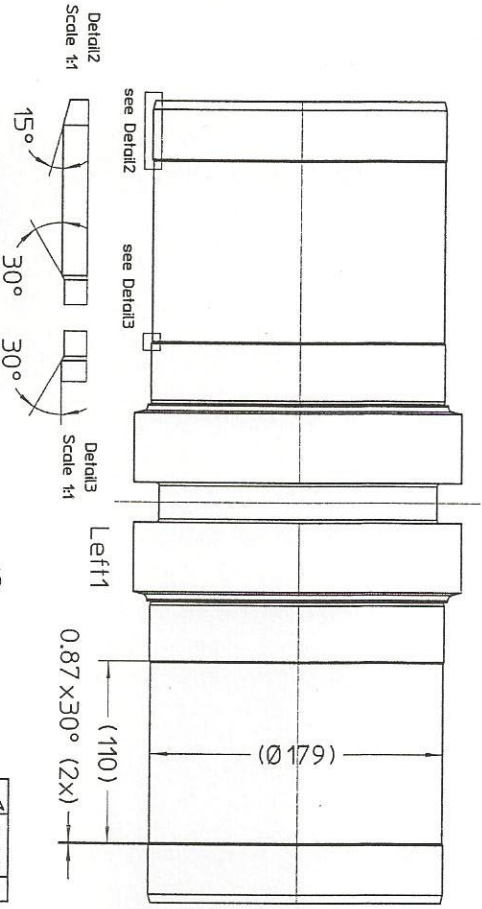
Section B-B



Gen2 of Section B

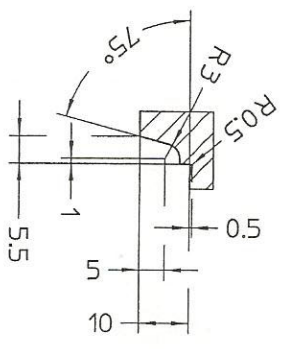
Perspassing / Presssitz / Press Fit
Buis / Rohr / Tube Ø150 H8

GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. 'MEDIUM'		WORKING UNIT mm		MATERIAL: S355JR	
STATUS: released		DATE: 02-02-2015		TREATMENT: 30	
CREATED: 02-02-2015		DATE: 02-02-2015		DESCRIPTION: Ø150	
APPROVED: 25-11-2015		DATE: 25-11-2015		DIMENSION: Ø150	
RELEASED: 25-11-2015		DATE: 25-11-2015		FLANS	
DRAWN: JMS		DATE: 25-11-2015		ØKKEERROL OPVOERBAND	
CHECKED: JMS		DATE: 25-11-2015		TRIOTRAC II CASSETTE	
NUMBER: 34206		DATE: 25-11-2015		ØKKEERROL OPVOERBAND	
EXTRA:		DATE: 25-11-2015		TRIOTRAC II CASSETTE	
REV. 1		DATE: 25-11-2015		ØKKEERROL OPVOERBAND	
FORMAT: A3		DATE: 25-11-2015		TRIOTRAC II CASSETTE	



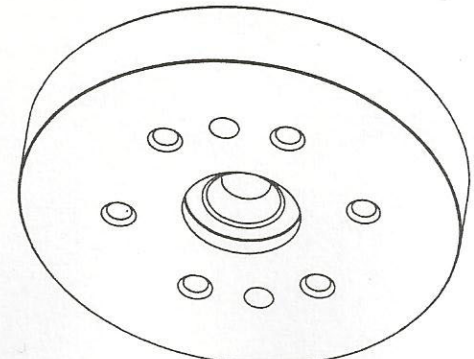
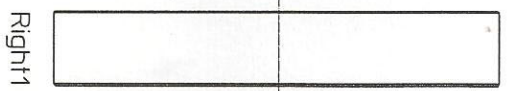
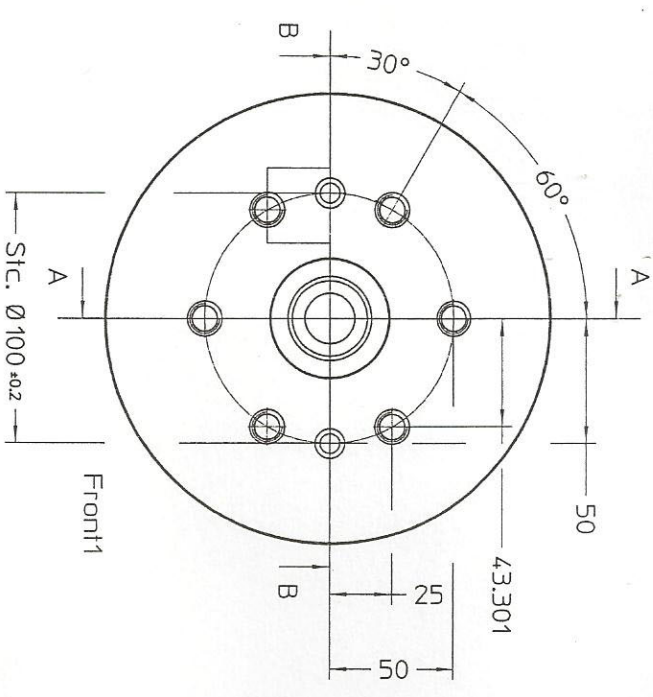
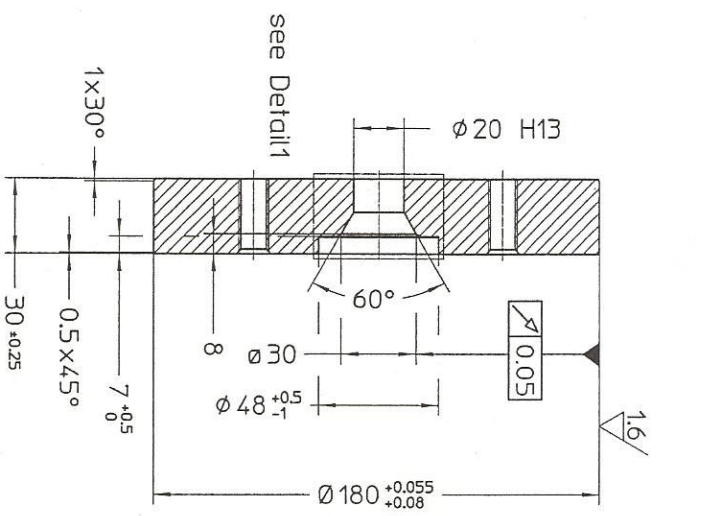
Halfafabriek / Halbzug / semi manufacture
 Buiten diameter en groetvorm draaien op tolerantie na het lassen in de rol
 Außendurchmesser und Groove-Form Drehen auf Toleranz nach dem Schweißen in der Rolle
 Outer diameter and Groove form Turning on tolerance after welding in the role

Section A-A
 Detail1
 Scale 1:1



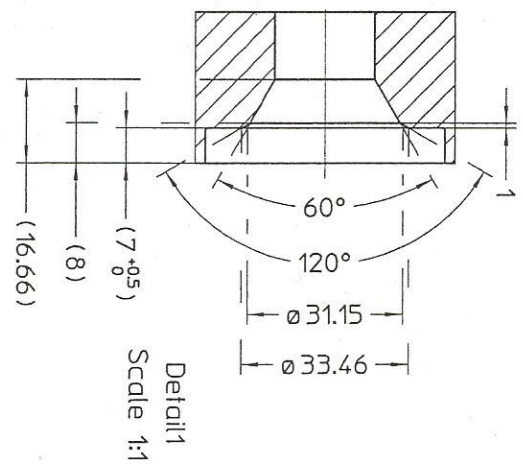
Radiusvrijloop Type E
 Freistriche Form E
 Undercut Type E
 DIN 509 R0.5 x 0.5 x 15°

GENERAL MACHINING TOLERANCE ACC. ISO 2768 CL. 'MEDUW'		TOLERANCE CLASSIFICATION ACC. ISO 2768 CL. 'MEDUW'	
STATUS: released		TREATMENT: L= 480	
1	CREAT V-SMAART BEIJER	DATE	04-07-2016
REV.	DESCRIPTION	DATE	NAME
MATERIAL: S355JR		DESCRIPTION: V-SMAARTAP	
DIMENSION: Ø200		AANDRIJROL	
TREATMENT: L= 480		TRIOTRAC II CASSETTE	
NUMBER: 34202		EXTRA:	
REV: 1		FORMAT	
A3			



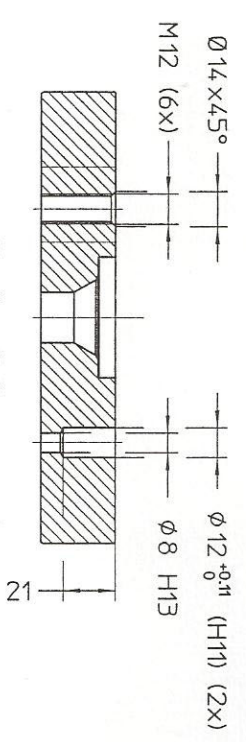
Gen1

Section A-A

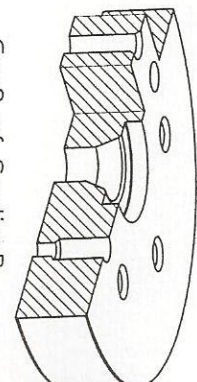


Detail1
Scale 1:1

Section B-B



Gen2 of Section B



Perspassing / Presssitz / Press Fit
Buis / Rohr / Tube Ø180 H8

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	
1	REV. DESCRIPTION	1-03-2015	DATE	GO	NAME	1	REV. DESCRIPTION
TRIO LIET		TRIO LIET		TRIO LIET		TRIO LIET	
MATERIAL: S355JR		MATERIAL: S355JR		MATERIAL: S355JR		MATERIAL: S355JR	
TREATMENT:		TREATMENT:		TREATMENT:		TREATMENT:	
DIMENSION: Ø180		DIMENSION: Ø180		DIMENSION: Ø180		DIMENSION: Ø180	
30		30		30		30	
DESCRIPTION:		DESCRIPTION:		DESCRIPTION:		DESCRIPTION:	
FLANS		FLANS		FLANS		FLANS	
AANDRIJFROL OPVOERBAND		AANDRIJFROL OPVOERBAND		AANDRIJFROL OPVOERBAND		AANDRIJFROL OPVOERBAND	
TRIO TRAC II CASSETTE		TRIO TRAC II CASSETTE		TRIO TRAC II CASSETTE		TRIO TRAC II CASSETTE	
NUMBER: 34201		NUMBER: 34201		NUMBER: 34201		NUMBER: 34201	
EXTRA:		EXTRA:		EXTRA:		EXTRA:	
REV: 1		REV: 1		REV: 1		REV: 1	
FORMAT		FORMAT		FORMAT		FORMAT	
A3		A3		A3		A3	