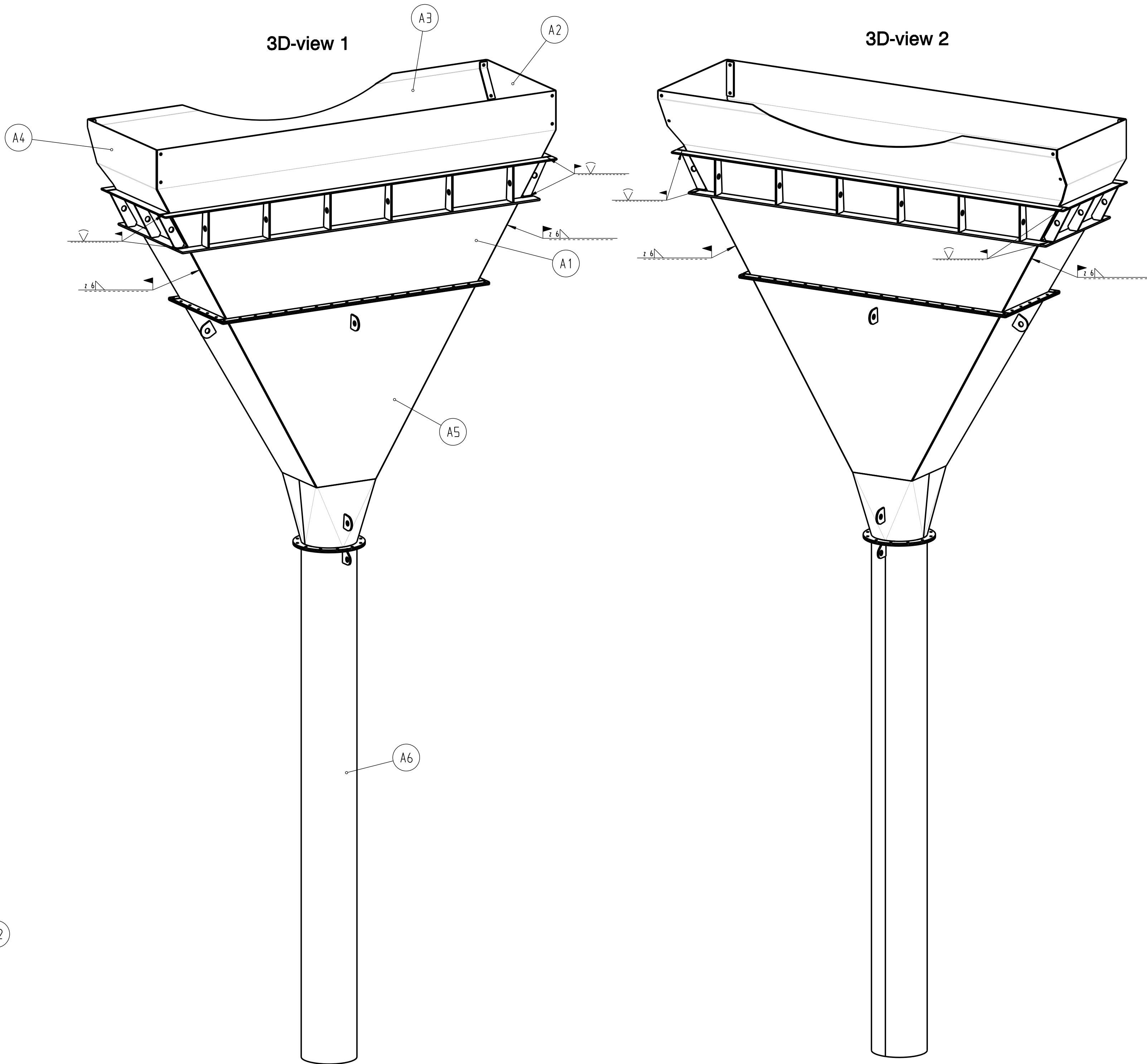
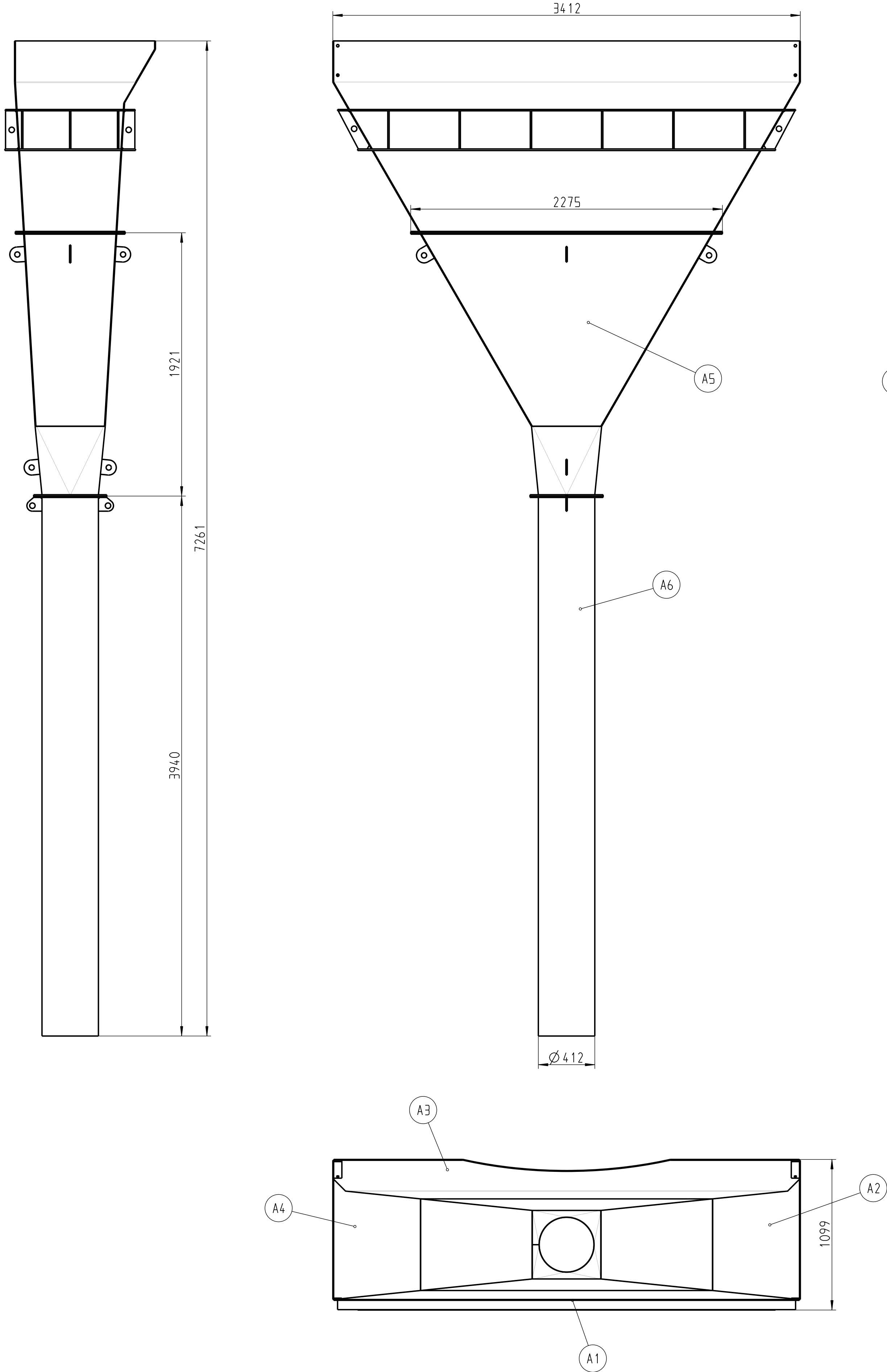


AMOUNT	DESIGNATION	POS.	MATERIAL	WEIGHT/ AMOUNT	REMARK
1	welding group "A1"	A1	1.0045	263kg	see: 49-0101.00
1	welding group "A2"	A2	1.0045	81kg	see: 49-0102.00
1	welding group "A3"	A3	1.0045	262kg	see: 49-0103.00
1	welding group "A4"	A4	1.0045	81kg	see: 49-0104.00
1	welding group "A5"	A5	1.0045	343kg	see: 49-0105.00
1	welding group "A6"	A6	1.0045	245kg	see: 49-0106.00



MANUFACTURING & INSTALLATION INSTRUCTIONS (IF THERE ARE NO OTHER STATEMENTS)


- The welder must be certified according to EN 287 - part 1.
- Weld seam classification in accordance with EN ISO 5817 - table 1, assessment group C.
- All weld seams to be carried out in accordance with the instructions of the filler's manufacturer in respect to the properties of the base material.
- All weld seams to be carried out to fit to the sheet metal thickness.
- All butt-welds must be melt-through.
- All flanges to be welded in-place as the hole pattern shown on the drawing.
- All inside laid weld seams to be ground to a smooth transition to base metal (undercuts to be avoided).
- Overall weld dimensional tolerances in accordance with EN ISO 13920

label 1: tolerance class A, label 2: tolerance class A and label 3: tolerance class E

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PM-Technologies GmbH

DESIGNED	DATE	NAME	PROJECT-No.
CHECKED	20.02.25	Hdd1	P.CEO.011
PROJECTION METHOD	TITLE		
ALL DIMENSIONS IN MILLIMETERS UNLESS NOTED	overview sampler below sealTEQ		
SCALE	1:50	WEIGHT	~1270kg
		MATERIAL	1.0045
		DRAWING-No.	P.CEO.011/49-0100.00



PM-Technologies GmbH
A-8200 Gleisdorf
Neugasse 111