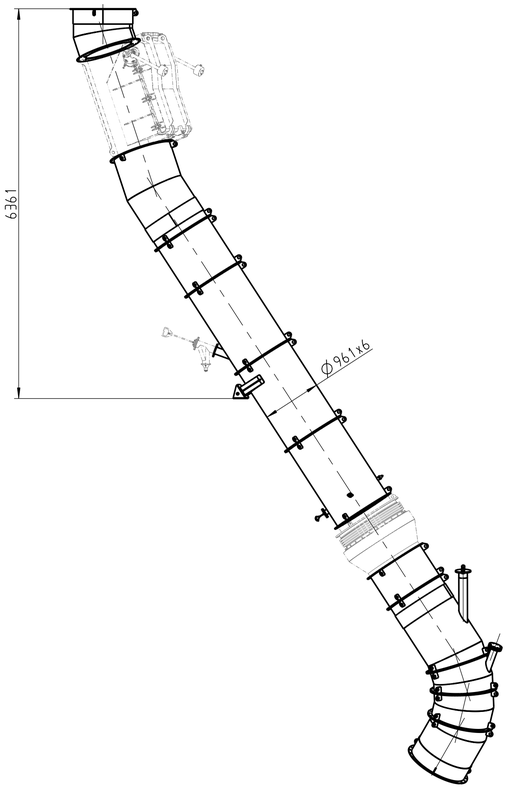
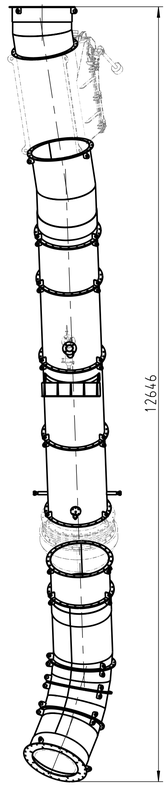
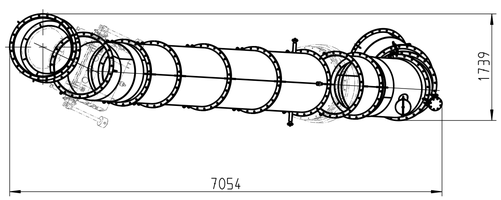
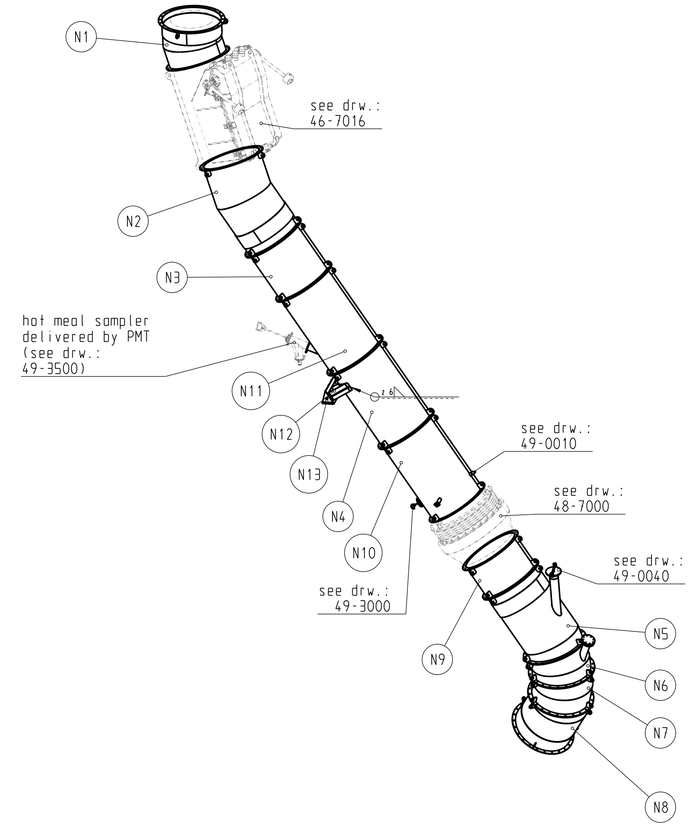
AMOUNT	DESIGNATION	POS.	MATERIAL	WEIGHT/ AMOUNT	NORM	REMARK
1	welding group "N1"	N1	1.0038	166kg		see: 49-1501.00
1	welding group "N2"	N2	1.0038	286kg		see: 49-1502.00
1	welding group "N3"	N3	1.0038	177kg		see: 49-1503.00
1	welding group "N4"	N4	1.0038	262kg		see: 49-1504.00
1	welding group "N5"	N5	1.0038	286kg		see: 49-1505.00
1	welding group "N6"	N6	1.0038	128kg		see: 49-1506.00
1	welding group "N7"	N7	1.0038	124kg		see: 49-1507.00
1	welding group "N8"	N8	1.0038	193kg		see: 49-1508.00
1	welding group "N9"	N9	1.0038	135kg		see: 49-1509.00
1	welding group "N10"	N10	1.0038	264kg		see: 49-1510.00
1	welding group "N11"	N11	1.0038	272kg		see: 49-1511.00
1	welding group "N12"	N12	1.0038	40kg		see: 49-1512.00
1	welding group "N13"	N13	1.0038	42kg		see: 49-1513.00







3D- view



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
  tabel 1: tolerance class A, table 2: tolerance class A and
  tabel 3: tolerance class E

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PM-Technologies GmbH

Rev.	DATE	NAME	
a	29.01.25	Six	welding group N10 changed

	DATE	NAME	PROJECT-No.
DESIGNED	15.10.24	Nistelberger	P.CEO.011
CHECKED			

PROJECTION METHODE

ALL DIMENSIONS IN MILLIMETERS UNLESS NOTED!

TITLE: overview mealchute 4

Cementownia ODRA S.A.

SCALE	WEIGHT	MATERIAL	DRAWING-No.
1:50	~2 380kg	1.0045	P.CEO.011/49-1500.00a

PM-Technologies GmbH
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A1