


- ① - V MISTECH ZACATKU SROUBOVIC SVAR VYNECHAT (SVAR NEMUSI BYT VODOTESNY)
- NO WELDING IN PLACES OF HELICEL SWEEP BEGINING
- ② - KALIBRACE PO NAVARENI CEPU PRED NATAZENIM TRUBKY POZ. 03 (DODRZET PREDEPSANY PRESAH KVULI TUHOSTI VALCE)
- CALIBRATION AFTER SHAFT WELDING. BEFORE PULLING ON OF THE TUBE POS. 03 (KEEP PRESCRIBED TOLERANCE, BECAUSE OF CYLINDER STIFFNES)
- ③ - PLOCHY PRO ODEBIRANI NEVYVYZKU - FREZOVANIM
- MINIMALNI TLOUSTKA STENY 10 mm
- SURFACES FOR TAKE OFF THE UNBALANCED WEIGHTS BY MILLING
- MINIMAL SURFACE THICKNESS 10 mm
- TLAKOVE ZKOUSSET TESNOST SVARU - TLAK 0.3 MPa
- WATER PROOF PRESSURE TEST OF WELDING UNDER 0.3 MPa (3 bar)
- VYBRACNI ODSTRANENI VNITRNIHO PNUTI PO SVARENI
- STRESS RELIEF ANNEALING
- VALEC DYNAMICKY VYVAZEN:
HMOTNOST VALCE: 172.133 kg
PROVOZNI OTACKY: 300 ot/min
VYVAZOVAT VE DVOU KONTROLNICH ROVINACH
PRIPUSTNY CELKOVY NEVYVAZEK: UP=22 604.73 g*mm
PRIPUSTNY NEVYVAZEK 1. VYVAZOVACI ROVINY: UP1=11 464.02 g*mm
PRIPUSTNY NEVYVAZEK 2. VYVAZOVACI ROVINY: UP2=11 140.71 g*mm
- CYLINDER DYNAMICALLY BALANCED:
CYLINDER MASS: 172.133 kg
SERVICES SPEED: 300 rpm
BALANCE IN TWO CONTROL PLANES:
ALLOWED GLOBAL UNBALANCED MASS: UP=22 604.73 g*mm
ALLOWED UNBALANCED MASS IN 1st. CONTROL PLANE: UP1=11 464.02 g*mm
ALLOWED UNBALANCED MASS IN 2nd. CONTROL PLANE: UP2=11 140.71 g*mm

SVÁŘENO

-	-	①	-	MATERIAL	DLE ROZPISKY
-	-	②	-	PRESNOST ISO 2768-mHPOLOTOVAR
-	-	③	-	TOLEROVANI ISO 8015 C. HMOTNOST [kg]	172.133
-	-	④	-		
-	-	⑤	-		
-	-	⑥	-		
-	-	⑦	-		
-	-	⑧	-		
ZMENA		DATUM	INDEX	PODPIS	
KRESLIL	L.Skalicky	DATUM	06.05.11	MERITKO	
PREZKUSOUEL	Podzemsky			1:2	
TECHNOLOG			(A)	
C. SESTAVY	-			PROMITANI	
PODOBNOST	-			CISLO VYKRESU	INDEX ZME
PC DATA	M3624.03-11-10F004			M3624.03-11-10B004	0
				Listu	FORMAT