

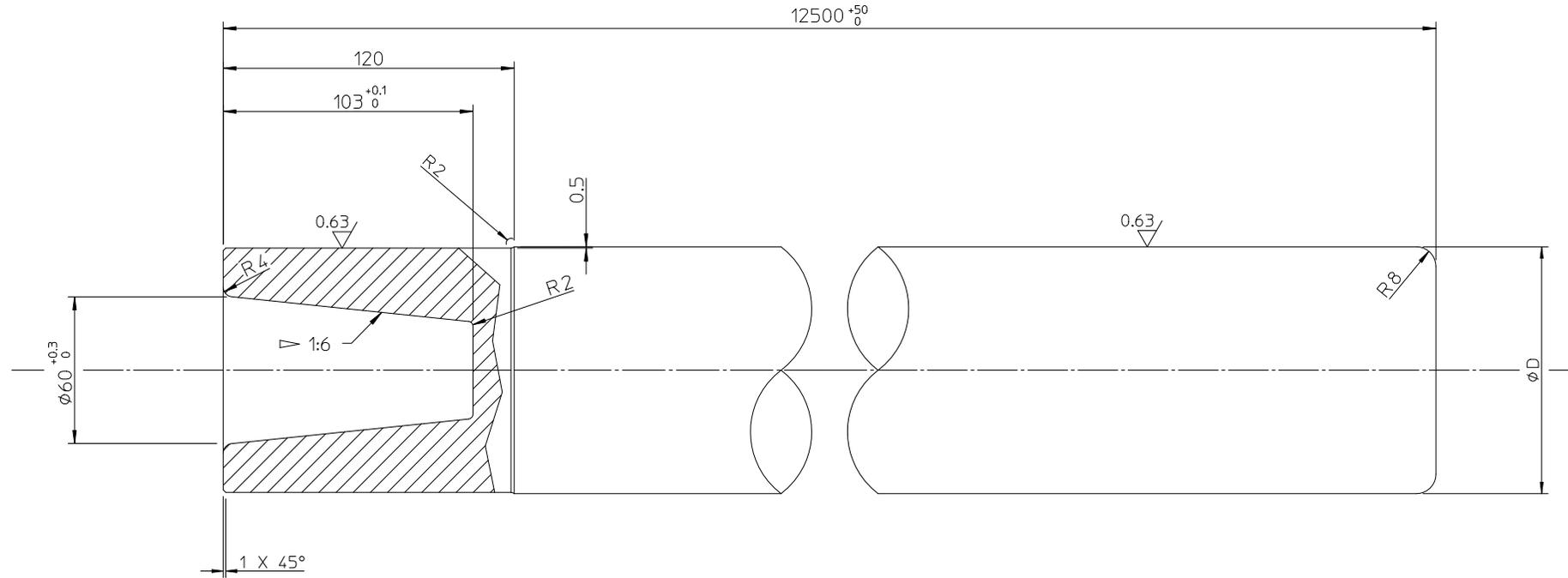
Unless otherwise stated the following British Standards are to be worked to:-
 DRAWING OFFICE PRACTICE:- BS8888:2008
 WELDING PRACTICE:- BS 5135
 WELDING SYMBOLS:- BS 499 Pt 2
 SCREW THREADS:- BS 3643 Pt 1-2-3
 SURFACE FINISH:- BS 1134

DO NOT SCALE
 IF IN DOUBT, ASK!

NOTES:-

30	20	10	ITEM No.	INDEX	DESCRIPTION	MATL	REMARKS	CODE No.	UOM	QTY.
.	.	.	AQ550-050	.	ROLLER MANDREL	STL	SEE NOTE	.	.	.

D	MASS
∅104 ^{+0.05} / _{-0.05}	834kg
∅105 ^{+0.05} / _{-0.05}	850kg
∅106 ^{+0.05} / _{-0.05}	866kg



NOTE:-
 MATERIAL TO BE 28NiCrMoV10 (THERMOTHERM 2740)
 ROLL HARDEN & TEMPER TO ACHIEVE 1000-1200Nm/mm²
 DESCALE, STRAIGHTEN AND MACHINE TO FINISHED DIMENSIONS

材质: 28NiCrMoV10
 硬化回火达到1000~1200Nm/mm²
 除锈, 矫直, 加工至最终尺寸
 数量: D=105 24根
 D=106 24根

5/ (0.63/)

MODEL REF.	ORIGINAL REVISION	A	B	Checked MSB Apprd Date 27/03/2020	*	Checked Apprd Date	*	Checked Apprd Date	MACHINE WHERE INDICATED ✓ Ra SERIES	ALL DIMENSIONS IN MILLIMETRES UNLESS STATED OTHERWISE		
REFERENCE DWG. WR-514/H001/31 SIMILAR PART	THIRD ANGLE PROJECTION		TOLERANCES & ALLOWANCES TO BE AS BELOW UNLESS STATED OTHERWISE (mm). DRILLING MACHINING HOLES FABRICATION CASTINGS P.C.DIA. +/- 1 UP TO 100 +/- 0.15 ALL DRILLED HOLES UP TO 500 +/- 2 UP TO 600 +/- 3 FITCH +/- 1 100 TO 1000 +/- 0.25 +0.15 500 TO 1500 +/- 3 ABOVE 600 +/- 5 RUNOUT 1.5/100 ABOVE 2000 +/- 0.5 -0.05 1500 TO 3000 +/- 4 WALL THICK +/- 12.5% ABOVE 3000 +/- 5 MACH. ALLOWANCE + S			DRN	LWD	CHKD	DATE	8.7.2013	APPD	DATE
PROJECT FIRST USED						ROLLER MANDREL ∅104, ∅105 & ∅106				AQ550-050	Revision B	

* NOTE:- RESTRICTED MODIFICATION (CAD)