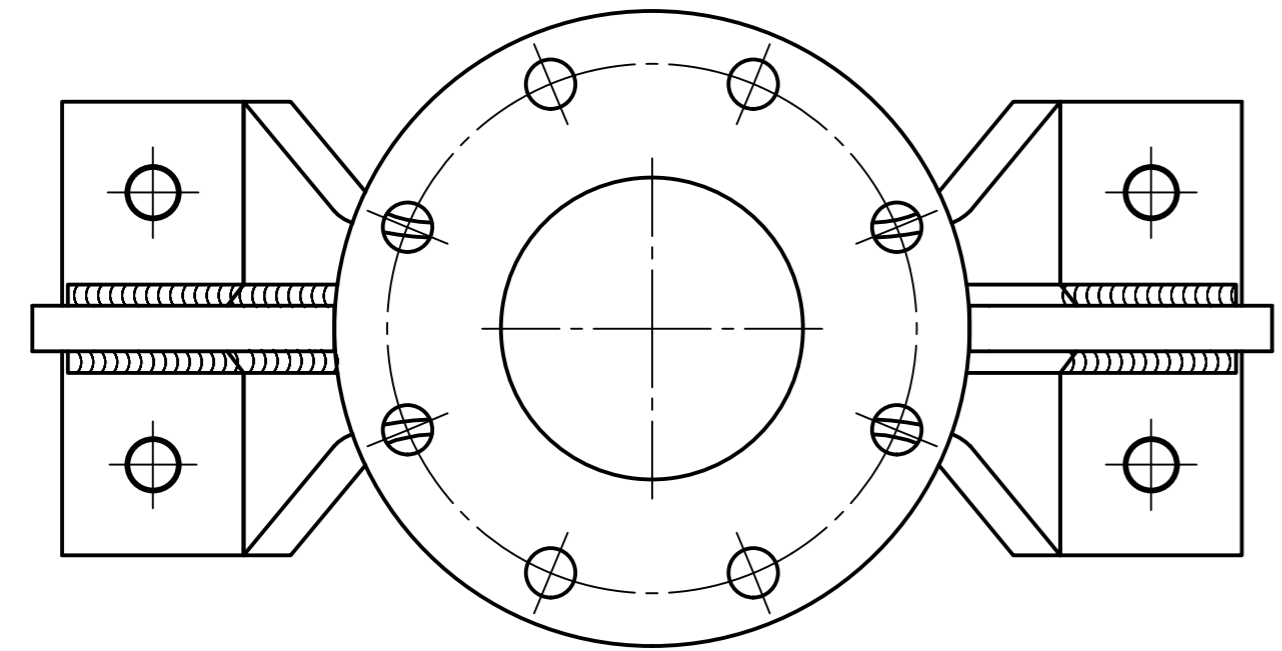
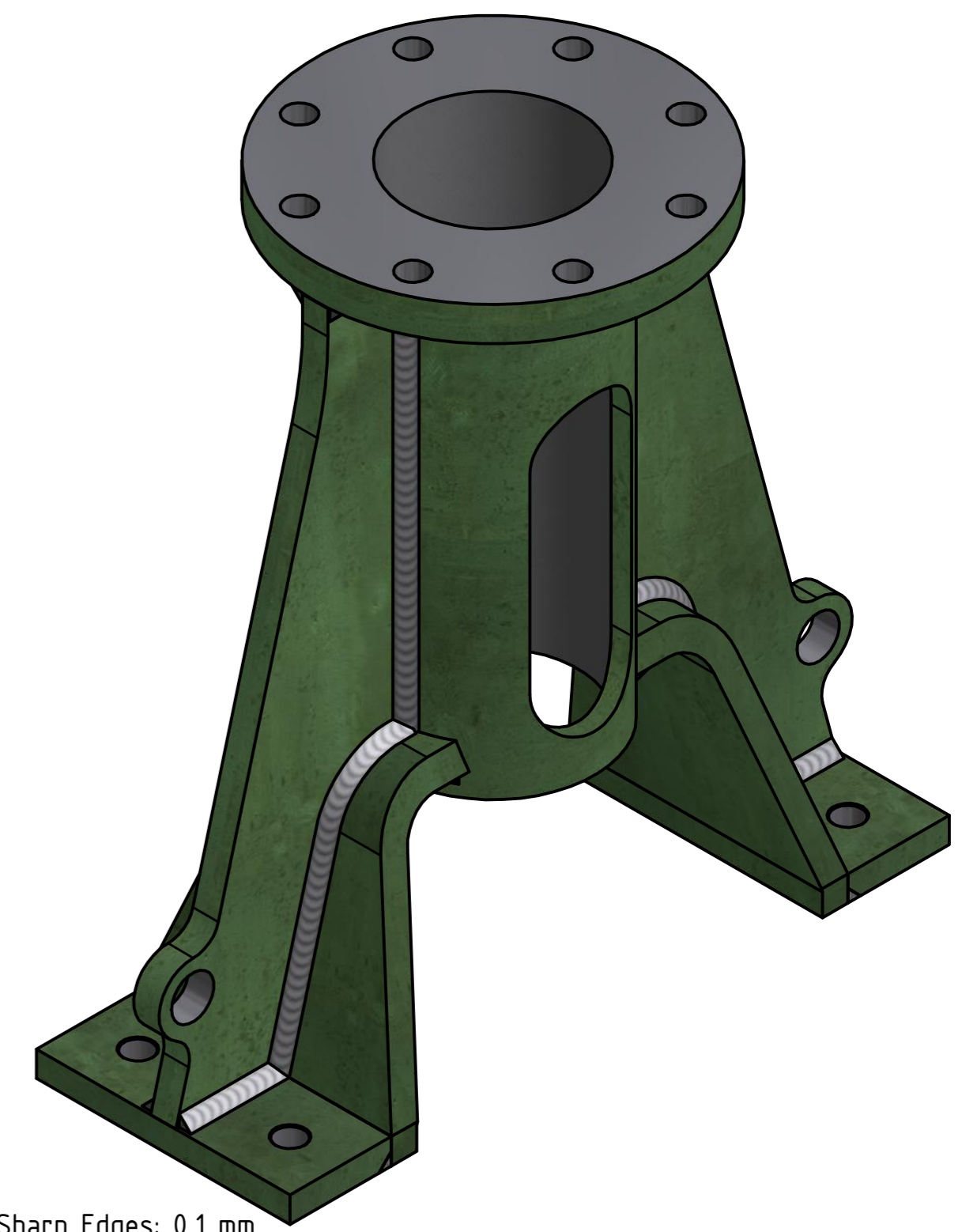
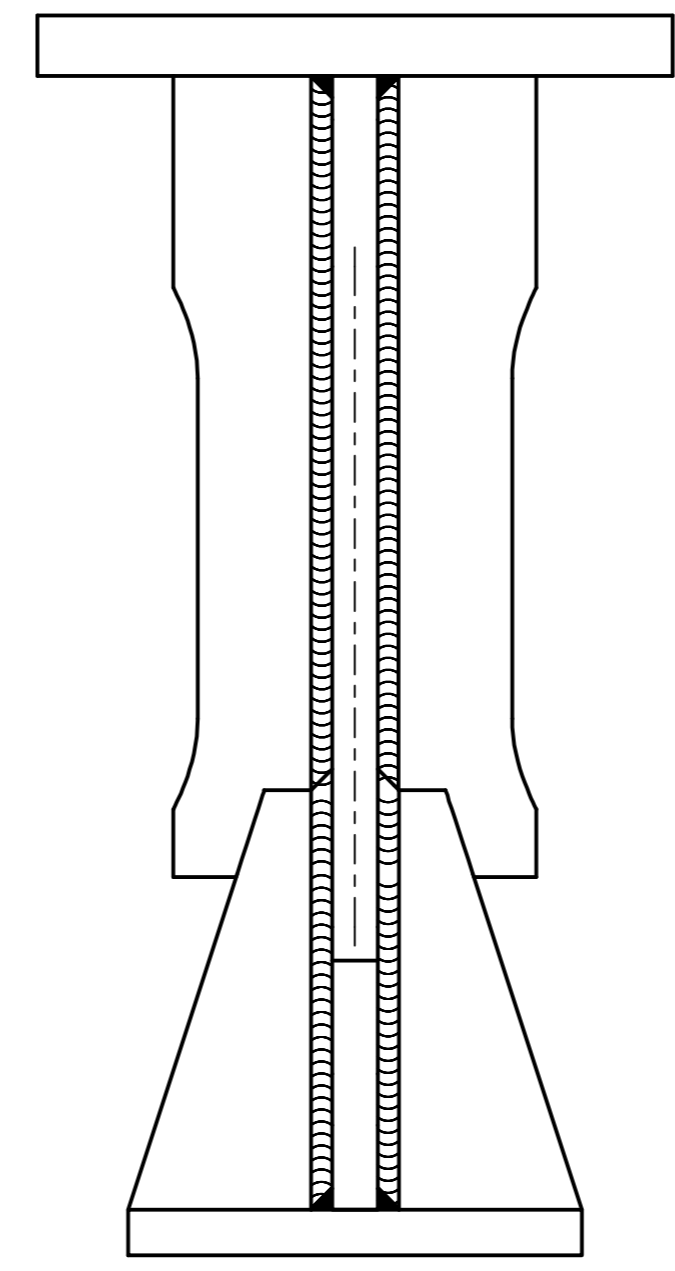
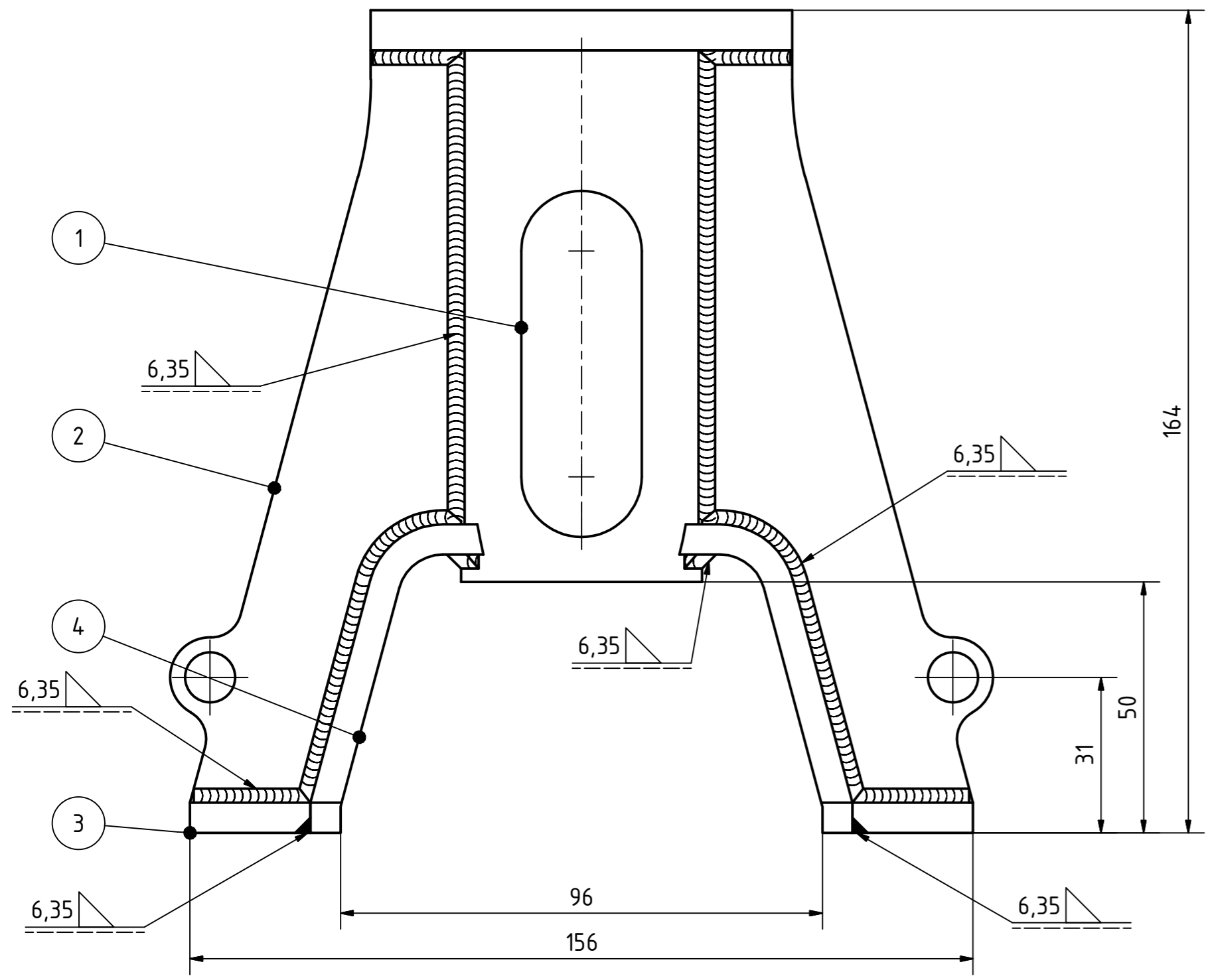


PARTS LIST				
ITEM	QTY	PART NUMBER	DESCRIPTION	MATERIAL
1	1	Standard Cylinder		Steel
2	2	Standard Rib		Steel
3	2	Standard Socle		Steel
4	2	Standard Foot		Steel



TOLERANCES FOR WELDED CONSTRUCTIONS (ISO 13920)														
Accuracy class (3)	For measurements (1) in mm and angles (4) in ° and '													
	Nominal dimensions in mm								Bordsize Δα max.		Bordsize † max. (mm/m)			
	2 to 30	>30 to 120	>120 to 400	>400 to 1000	>1000 to 2000	>2000 to 4000	>4000 to 8000	>8000 to 12000	to 400 (2)	>400 to 1000 (2)	to 400 (2)	>400 to 1000 (2)		
A (fine)	±1	±1	±1	±2	±3	±4	±5	±6	±20'	±15'	±10'	±6	±4,5	±3
B (medium)	±1	±2	±2	±3	±4	±6	±8	±10	±45'	±30'	±20'	±13	±9	±6
C (rough)	±1	±3	±4	±6	±8	±11	±14	±18	±1°	±45'	±30'	±18	±13	±9
D (very rough)	±1	±4	±7	±9	±12	±16	±21	±27	±1°30'	±1°15'	±1°	±26	±22	±18

(1) for ranges bigger than 20.000 - consult the standard
(2) length of the shortest leg
(3) in special cases, the general tolerances can be held with only 50% of the tol. Class A = Class Z
(4) also apply to 90° corners or angles of regular polygons that are not subtended

Corresponding symbols	▽	▽	▽	▽	▽	▽	▽	
Roughness Classes (NBN 88-02) (ISO 1302)	N11	N10	N9	N8	N7	N6	N5	N4
Roughness Value "Ra" in μm (NBN 88-02) (ISO 1302)	25	12,5	6,3	3,2	1,6	0,8	0,4	0,2

Break Sharp Edges: 0,1 mm

Revision	Date	Description

Engineered by:	Name:	Date:	Scale: 1:1
	Designer: Galba, J.	13/02/2010	SheetSize: A2
	Approved: Galba, J.	13/02/2010	

Project:	Material: Welded Steel Mild
Miniature Steam Engine	Total Mass: 1,424 kg

Title:		Vertical Twin Steam Engine with Reverse Gear Welding Assembly Standard	
Drawingnumber:		Sheet:	0001
Design State:	Released	Drawing made with Autodesk Inventor Revisions only permitted by CAD	

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