

Design of frame

Used are sheet metals acc. to DIN EN10029 S355J2G3 (quality standard DIN EN10025) and hot-rolled hollow steel profiles made of S275J2G3 or S355J2H acc. to DIN EN 10210.

After welding, the parts are machined to dimension.
The welding work must only be done by welders holding a valid test certificate acc. to DIN EN ISO 9606 for the respective welding procedure.

The parts are sandblasted after drilling in order to achieve a better adhesion of the varnish. Residue of drilling emulsion must be removed by the blasting.
Irregularities that built up during production must be removed before sandblasting.

The threaded and fit holes must be kept free from varnish during varnishing or threaded holes must be re-cut after varnishing.

Machined surfaces shall be protected against corrosion by a primer of 20 µm.

For layer thickness and hue refer to the DAT sheet surface finish (DAT-0003).

The cylinder screws that shall be provided must be secured with washers (*shape VS, article 88121*) by the company Schnorr.

Dirt and chips must be removed from hollow spaces.

Machine frame Design specification

Observe proprietary note acc. to DIN 34

Change index: K

signed: 08.01.16 Norman Kirst

checked: 08.01.16 Carsten Grebien



KROENERT GmbH & Co. KG
Schützenstraße 105, 22761 Hamburg

Replacement for:

Drawing No.: **DAT-0007**