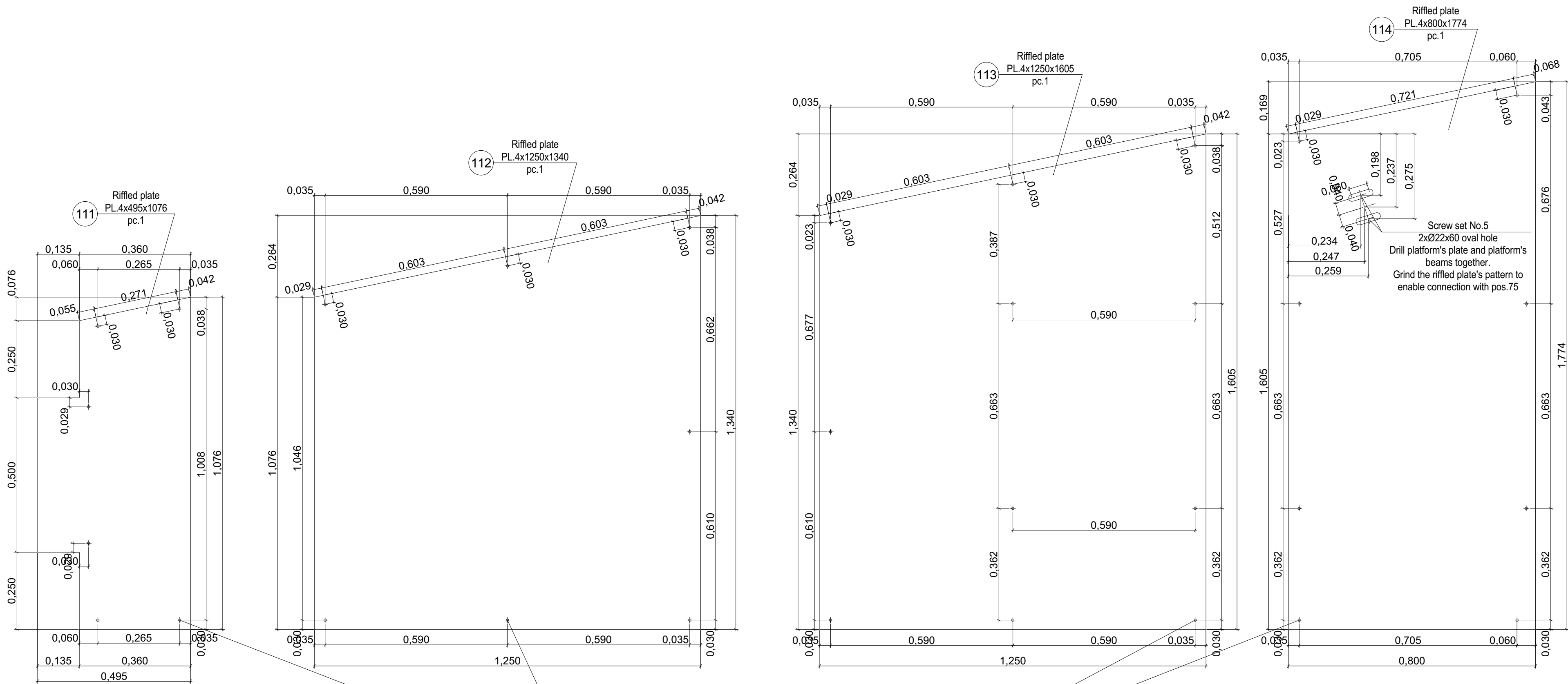


PLATFORM PLATE Pp1

Drill the plate together with platform's beams U140, HEB140

For each hole in the rifled plate drill hole in platform's beams - check the beams before hot dip galvanizing
Execute a trial assembly



Ø8 holes for M6x35-DIN7991 screws, 32pcs.
Screwhole acc. to DIN 74 for screws with socket flat heads.
Drill platform's plate and platform's beams together.
Screw set No.8A and 8B
For the connection with UPN use Wedge washer d8,4 DIN434.

8	Hot dip galvanizing
A	Screw M6x30 DIN7991 Washer d6,4-DIN125 Nut M6-DIN934
8	Hot dip galvanizing
B	Screw M6x30 DIN7991 Wedge Washer d6,4-DIN434 Nut M6-DIN934

5	Hot dip galvanized
	Screw M20x60-8.8-DIN933 Washer d22-DIN125 Spring washer d20,2-DIN127 Nut M20(8)-DIN934

- NOTE:
- Materials:
 - Steel: S235JRG2.
 - Bolts: class 8.8, nuts: class 8.
 - Tolerances:
 - Tolerances for welded construction PN-EN ISO 13920 class B/F.
 - Tolerances for welds according to PN-EN 5817 class C.
 - Welding:
 - All welds shall be 100% visually inspected.
 - Butt weld perform a full penetration.
 - Corrosion protection:
 - All welds shall be tight.
 - Hot-dip galvanizing according to PN-EN ISO 1461.
 - Provide vent and drain holes for the flow of zinc - max. Ø25mm (to be plugged).
 - Provide drainage holes - max. Ø7mm (not to be plugged).
 - Sharp edges shall be rounded.
 - The construction is subjected to live loads. Execute according to PN-EN 1090.
 - Welding method: MAG, E.
 - Perform a trial assembly.
 - For additional comments see "Technical description".

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