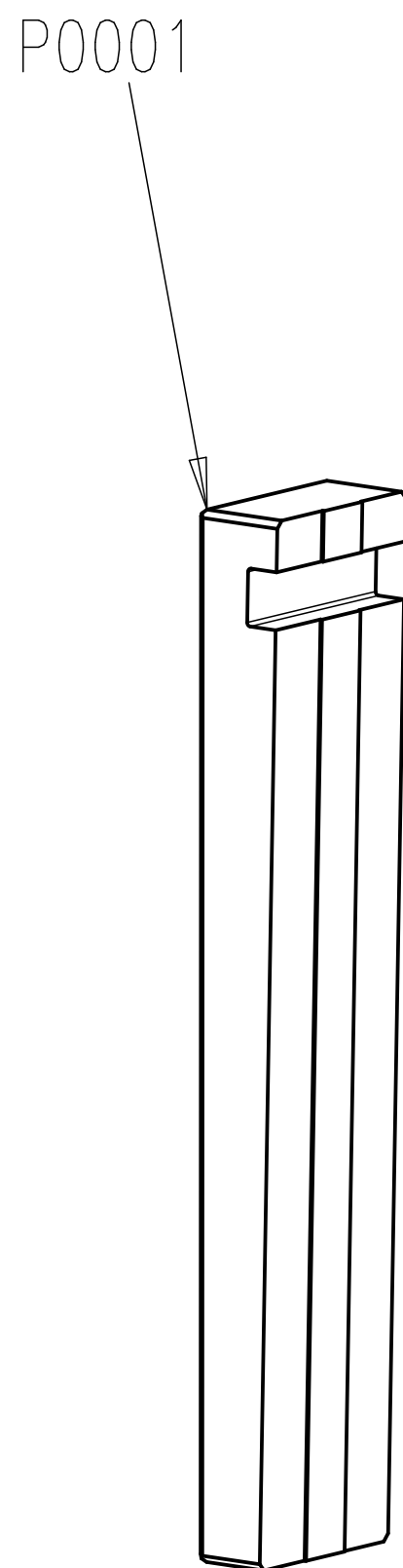
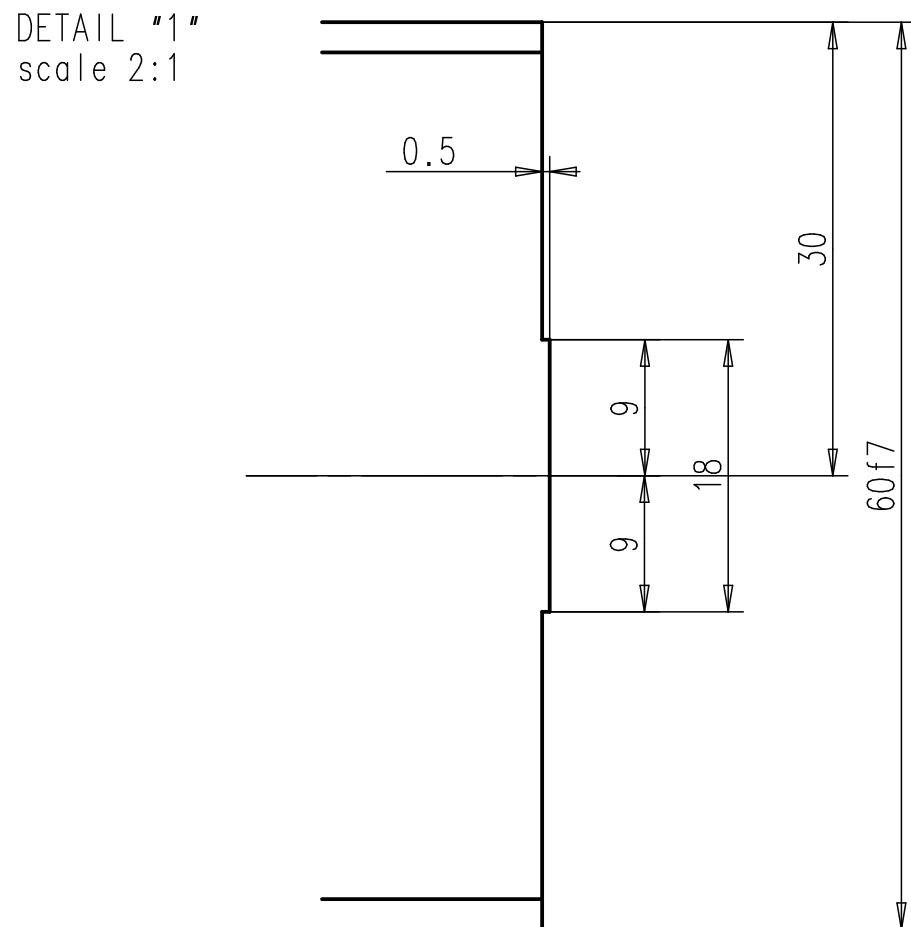
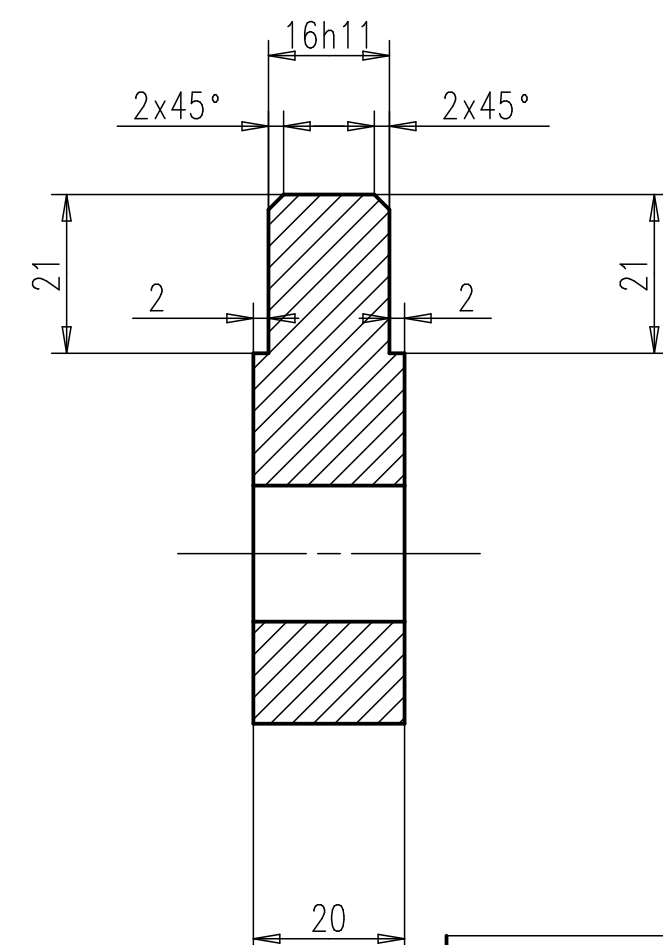




TEMPORARY PROTECTION OF MACHINED SURFACES ACCORDING TO NBA V 10001

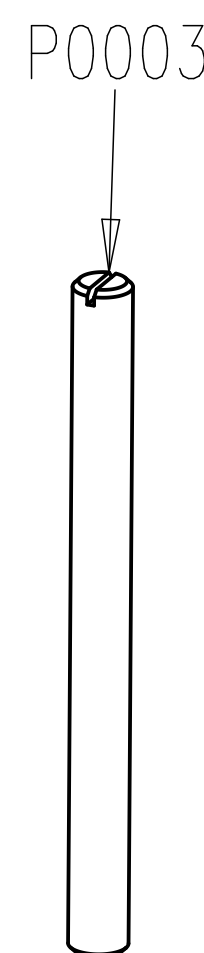
PT4	APPLICATION OF WAXY FILM OF A TEMPORARY PROTECTION PRODUCT
	MINIMAL THICKNESS OF A DRY COAT : 30 TO 60 μm
	DRYING TIME : 2h
	LIFETIME : OUTSIDE 12 TO 24 MONTHS.



ADJUSTING PLATE
MATERIAL S275JR (EN10025)
WEIGHT 0.58kg
ALL MACHINING : 

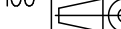
TEMPORARY PROTECTION OF MACHINED SURFACES ACCORDING TO NBA V 10001

PT4 APPLICATION OF WAXY FILM OF A TEMPORARY PROTECTION PRODUCT
MINIMAL THICKNESS OF A DRY COAT : 30 to 60 μm
DRYING TIME : 2h
LIFETIME : OUTSIDE 12 to 24 MONTHS.



STUD BOLT
ZINC BICHROMATE
MATERIAL : CL 4-6 (ISO4017/4032/4014)
WEIGHT : 0.29kg

☐ PROCEED WITHOUT CHANGE		DATES :		NAME :		REFERENCE :	
☐ PROCEED AS CORRECTED		COMMENTS :					
☐ REVISE AND RESUBMIT							
☐ REJECTED							
SIGN							
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REV	ESTABLISHED	CHECKED	APPROVED	DATE	MODIFICATION		
THE PEOPLE'S REPUBLIC OF CHINA HUIZHOU PUMPED STORAGE POWER STATION CONTRACT N° : 041JBJGB/011132FR 2 x (4 x 300MW) – STATIONS A & B							
CLIENT :			ENGINEER :		CONTRACTOR :		
GPSC			GPD I		ALSTOM		
GENERATOR-MOTOR KEY							
SCALE:		SUBCONTRACTOR :			ALSTOM Hydro Power Products		
1:1							
AHG HZHO1			DOCUMENT NO.			REV. :	SHEET :
			HGHZ313119			-	1
						NO. OF SH. :	1

Prepared:	Derived from:	Sep. Pt. name no. ☐	auth. no. ☐	Scale:	Doc. type:	Format:
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-						1
		Hydro Power Products		Document no.	Sheet:	
				HGHZ313119	1	

General tolerances for cutting and non-cutting machining for length and angle dimensions corresponding to ISO 2768 bzw. DIN 7168													Roughness symbol corresponding to DIN ISO 1302									
Nominal dimension range	> 0.5 ... 3	> 3 ... 6	> 6 ... 30	> 30 ... 120	> 120 ... 400	> 400 ... 1000	> 1000 ... 2000	> 2000 ... 4000	> 4000 ... 8000	> 8000 ... 12000	> 12000 ... 16000	> 16000 ... 20000	Machining: if necessary ✓ prescribed ✓ forbidden ✓									
Deviation range: coarse	±0.15	±0.2	±0.5	±0.8	±1.2	± 2	± 3	± 4	± 5	± 6	± 7	± 8	Roughness class	N11	N10	N9	N8	N7	N6	N5	N4	
Deviation range: medium	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	± 2	± 3	± 4	± 5	± 6	Max. Roughness R _a (µm)	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	
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GHGZ313119

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