

ITEM	Description	Length / Dia	Width / Dia1	Item	Draw. No.	Weight	Qty
12	PLATE ISO18286   6   1.4301 EN10088-2	420	413	208451080		8,28 kg	10
11	PLATE ISO18286   8   1.4301 EN10088-2	960	527	208451078		32,2 kg	10
10	PLATE ISO18286   8   1.4301 EN10088-2	527	400	208451076		13,4 kg	38
9	PLATE ISO18286   8   1.4301 EN10088-2	940	527	208451081		31,5 kg	10
8	PLATE EN10029   40 A   S235JR EN10025-2	2770	2611	208451073		179 kg	1
7	PLATE EN10029   40 A   S235JR EN10025-2	2770	2611	208451072		187 kg	1
6	PLATE -44-61.5 - 55.5   304/235B   METAL COMPOUND	7969	1300	208451089		3881 kg	1
5	PLATE -44-61.5 - 55.5   304/235B   METAL COMPOUND	7969	1300	208451090		3840 kg	1
4	SCOOP	0	0	206712221	702956733	149 kg	1
3	PLATE ISO18286   20   1.4301 EN10088-2	2497	0	208451071	703248906	415 kg	1
2	PLATE ISO18286   20   1.4301 EN10088-2	2497	0	208451067	703248901	287 kg	2
1	PLATE ISO18286   20   1.4301 EN10088-2	2497	0	208450738	703248631	661 kg	1

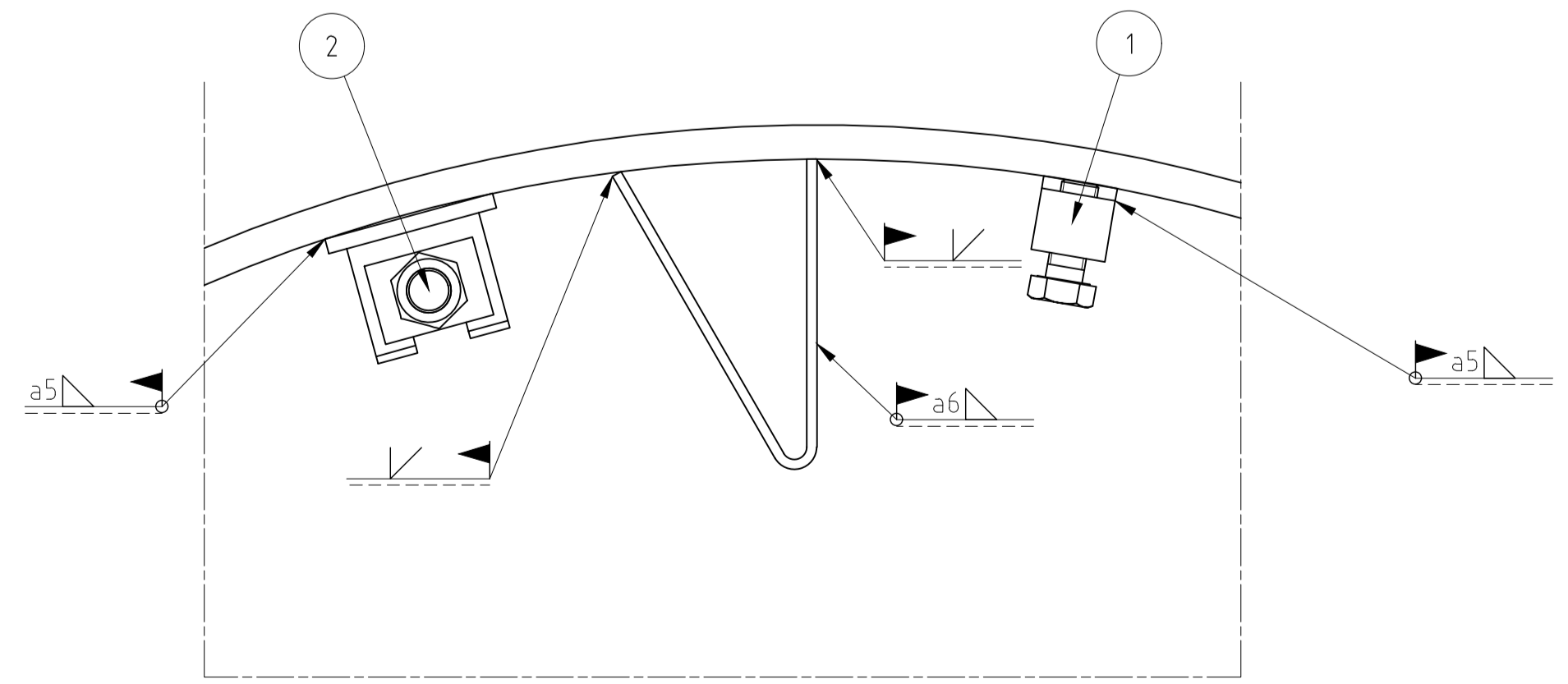
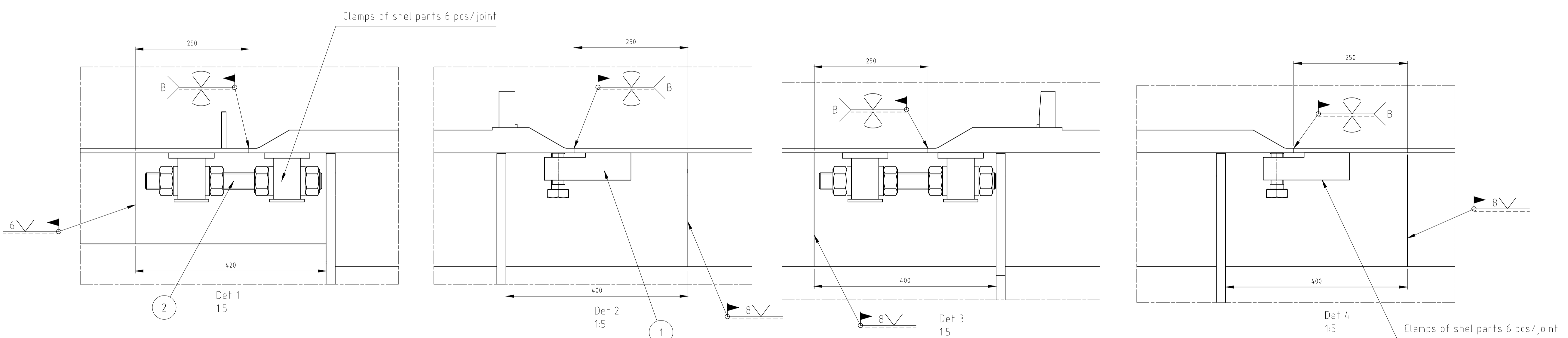
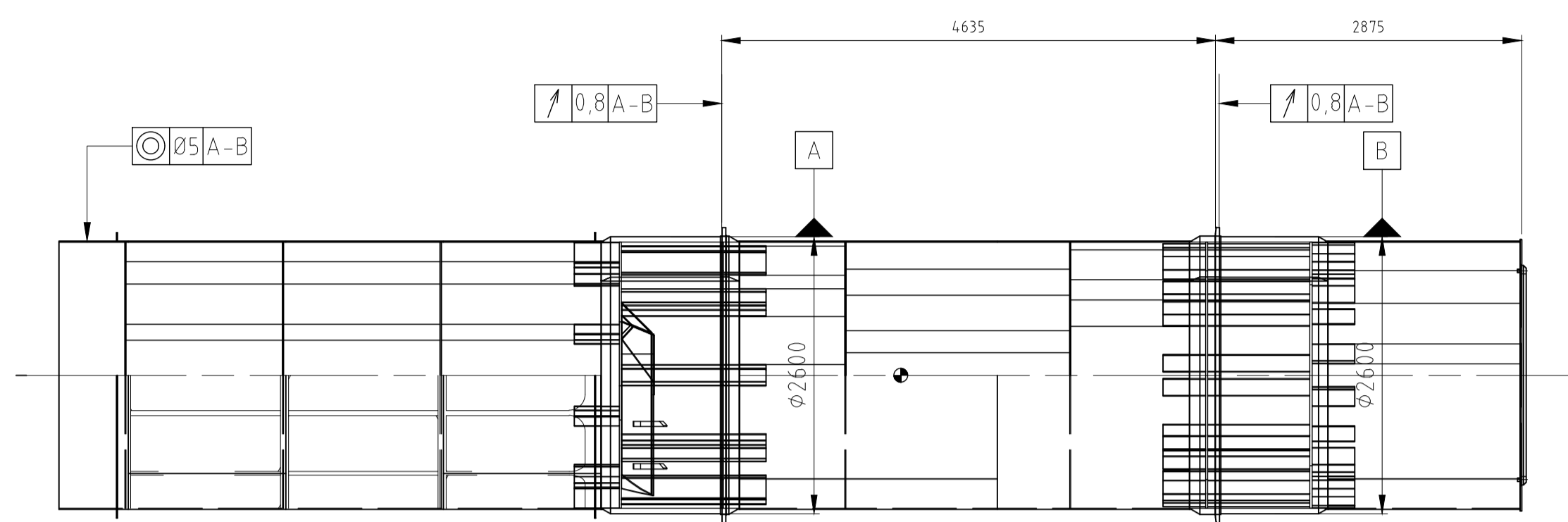
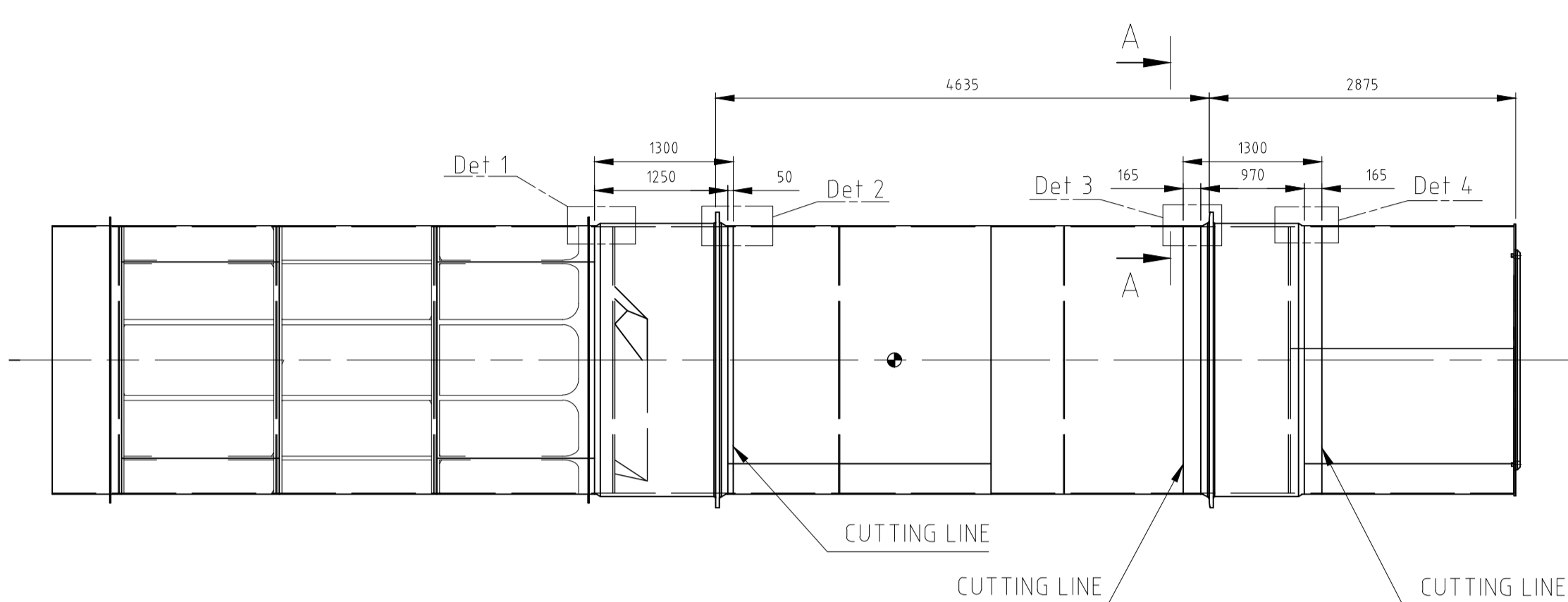
GENERAL TOLERANCES: Normal: ±0.3, Fine: ±0.2, Extra-fine: ±0.1, Very-fine: ±0.05, Super-fine: ±0.025, Ultra-fine: ±0.015, Precision: ±0.0075, High-precision: ±0.005, Super-precision: ±0.0025, Ultra-precision: ±0.0015, Precision: ±0.00075, High-precision: ±0.0005, Super-precision: ±0.00025, Ultra-precision: ±0.00015.

ANGULAR DIMENSIONS: Welding: ISO 1800-B, Sanding: ISO 2768-c, Machining: ISO 2768-m, Grinding: ISO 2768-n, Polishing: ISO 2768-s, Buffing: ISO 2768-t, Bore grinding: ISO 2768-v, Honing: ISO 2768-w, Super-finishing: ISO 2768-x, Shot peening: ISO 2768-y, Laser shock peening: ISO 2768-z.

FINISHES: Surface roughness: ISO 1302-R, ISO 1101, ISO 1302-A, ISO 1302-B, ISO 1302-C, ISO 1302-D, ISO 1302-E, ISO 1302-F, ISO 1302-G, ISO 1302-H, ISO 1302-I, ISO 1302-J, ISO 1302-K, ISO 1302-L, ISO 1302-M, ISO 1302-N, ISO 1302-O, ISO 1302-P, ISO 1302-Q, ISO 1302-R, ISO 1302-S, ISO 1302-T, ISO 1302-U, ISO 1302-V, ISO 1302-W, ISO 1302-X, ISO 1302-Y, ISO 1302-Z.

WELDING: ISO 1302-R, ISO 1302-A, ISO 1302-B, ISO 1302-C, ISO 1302-D, ISO 1302-E, ISO 1302-F, ISO 1302-G, ISO 1302-H, ISO 1302-I, ISO 1302-J, ISO 1302-K, ISO 1302-L, ISO 1302-M, ISO 1302-N, ISO 1302-O, ISO 1302-P, ISO 1302-Q, ISO 1302-R, ISO 1302-S, ISO 1302-T, ISO 1302-U, ISO 1302-V, ISO 1302-W, ISO 1302-X, ISO 1302-Y, ISO 1302-Z.

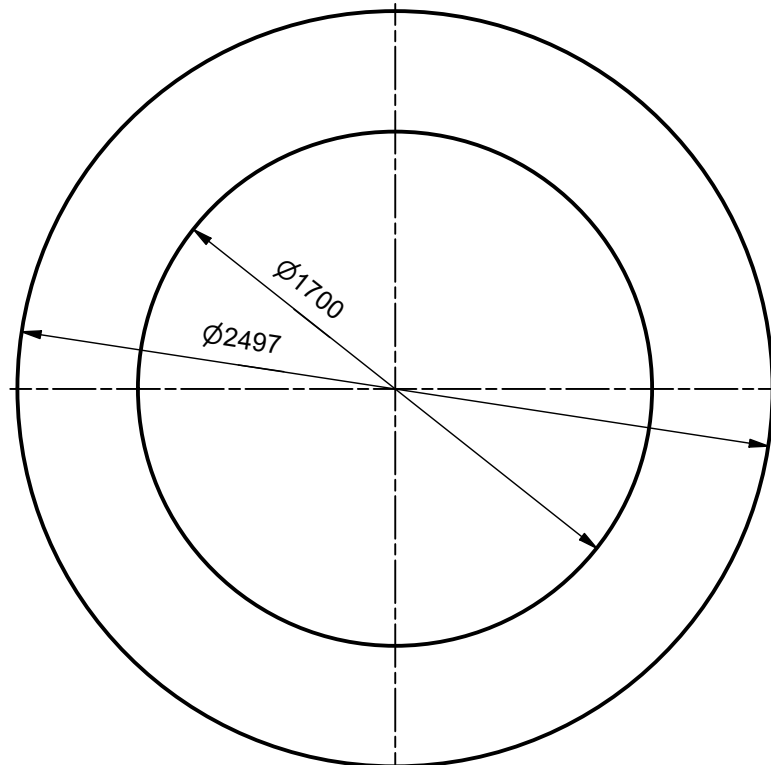
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A - A  
15

2	FIXING LUG M36			0	0			208451613	T03249234	16.3	kg	24
1	ADJUSTMENT LUG			0	0			206458278	T02929825	5.44	kg	24
FW	Description	Basic Material Name	Basic Material Standard	Length	Width	Diameter	Item	Draw No.	Weight	Unit	Qty	
Customer	ANC	Basic Material Name	Basic Material Standard	Length	Width	Diameter	Item	Draw No.	Weight	Unit	Qty	
Part No.	Customer Drawing No.	Description Line 1 (FF)					Designed			Date		
Product Type	Product Code	Description Line 2 (FF)	RUMMUN LIITOS				Drawn			Date		
Size	Scale	Description Line 1 (EN)					Checked			Date		
A1	1:50	Description Line 2 (EN)	DRUM JOINT				Approved			Date		
Division	Prod. name	Description Line 2 (EN)					Approved			Date		
PPP	1022	System	Autocad				Replacement for Drawing	Rev. (Replaced by Drawing)	Rev. Copy from Drawing	Rev.	Sort	
		Item No.	208451243	Reference Drawing	Rev.	Rev.	701879571	Rev.		Rev.	Sheet	
		SAP Main WBS Element					703249238	Rev.		Rev.	Sheet	
											1/1	

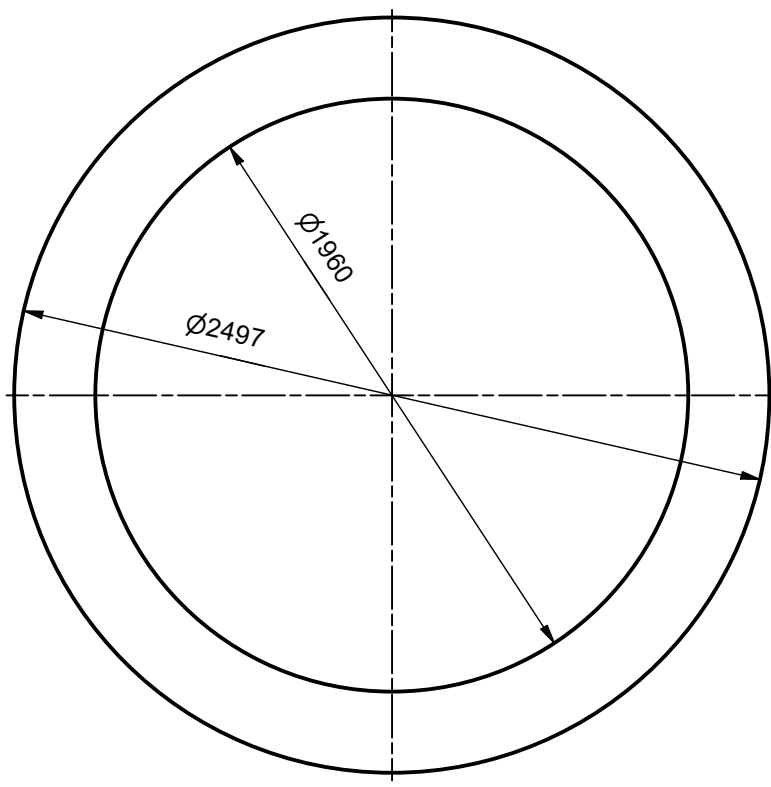
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<b>GENERAL TOLERANCES LINEAR DIMENSIONS</b>		Nominal measure	>0.5 ≤3	>3 ≤6	>6 ≤30	>30 ≤120	>120 ≤400	>400 ≤1000	>1000 ≤2000	>2000 ≤4000	>4000 ≤8000	>8000 ≤12000	>12000 ≤16000	>16000 ≤20000	>20000	- Flame cutting < ISO 9013-332 ISO 9013-432
- Welding	ISO13920-B	±1	±1	±1	±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	- Casting, machine. ISO 8062-DCTG10	
- Machining	ISO 2768-m	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	-	- Casting, handm. ISO 8062-DCTG12	
- Chamfers and radius	ISO 2768-m	±0.2	±0.5	±1.0											- Forgings SFS 3507, DIN 7527	
- Cutting, bending	ISO 2768-c	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8	-		
<b>ANGULAR DIMENSIONS</b>		- Welding ISO13920-B - Bending < ISO 2768-c s<4 - Machining ISO 2768-m - Bending < ISO 2768-v s>4		<b>SYMBOLS</b> - Surface roughness ISO 1302-R - Welding symbols ISO 2553 - Tolerancing ISO 8015				<b>GEOM.TOL.</b> - Symbols ISO 1101 - Welding ISO 13920-G - Machining ISO 2768-K				<b>MISCELLANEOUS</b> - Welding quality ISO 5817-C				



1	PLATE ISO18286   20   1.4301 EN10088-2	2497	0	208451071	703248906	415 kg	1
<b>ITEM</b>	<b>Description</b>	<b>Length / Dia</b>	<b>Width / Dia1</b>	<b>Item</b>	<b>Drw. No.</b>	<b>Weight</b>	<b>Qty</b>
Customer		AMC	Basic Material Name		Basic Material Standard		Net weight kg
Position No.		1051 00 01 000	1.4301		EN10088-2		415
Product type		Description Line 1			Designed		Date
Product Code		Description Line 2			Drawn		Date
Scale		Description Line 1 (EN)			Checked		Date
1 : 25		BAFFLE WALL			J.Laitinen		04.05.2021
Division		Description Line 2 (EN)			Approved		Date
PPF		INVENTOR					
Replacement for Drawing		Rev.	Replaced by Drawing		Rev.	Copy from Drawing	
Item No.		208451071		Reference Drawing		Old Drawing Number	
SAP Main WBS Element				Drawing Number		Rev.	Sheet
				703248906		-	1 / 1

1		2								3				4		
<b>GENERAL TOLERANCES LINEAR DIMENSIONS</b>		Nominal measure	>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	>20000	- Flame cutting < ISO 9013-332 ISO 9013-432
- Welding	ISO13920-B	±1	±1	±1	±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	- Casting, machine. ISO 8062-DCTG10	
- Machining	ISO 2768-m	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	-	- Casting, handm. ISO 8062-DCTG12	
- Chamfers and radius	ISO 2768-m	±0.2	±0.5	±1.0											- Forgings SFS 3507, DIN 7527	
- Cutting, bending	ISO 2768-c	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8	-		

ANGULAR DIMENSIONS		SYMBOLS				GEOM.TOL.		MISCELLANEOUS	
- Welding	ISO13920-B	- Surface roughness	ISO 1302-R	- Symbols	ISO 1101	- Welding quality	ISO 5817-C	- Bending	ISO 2768-c s<4 ISO 2768-v s>4
- Machining	ISO 2768-m	- Welding symbols	ISO 2553	- Welding	ISO 13920-G				
		- Tolerancing	ISO 8015	- Machining	ISO 2768-K				



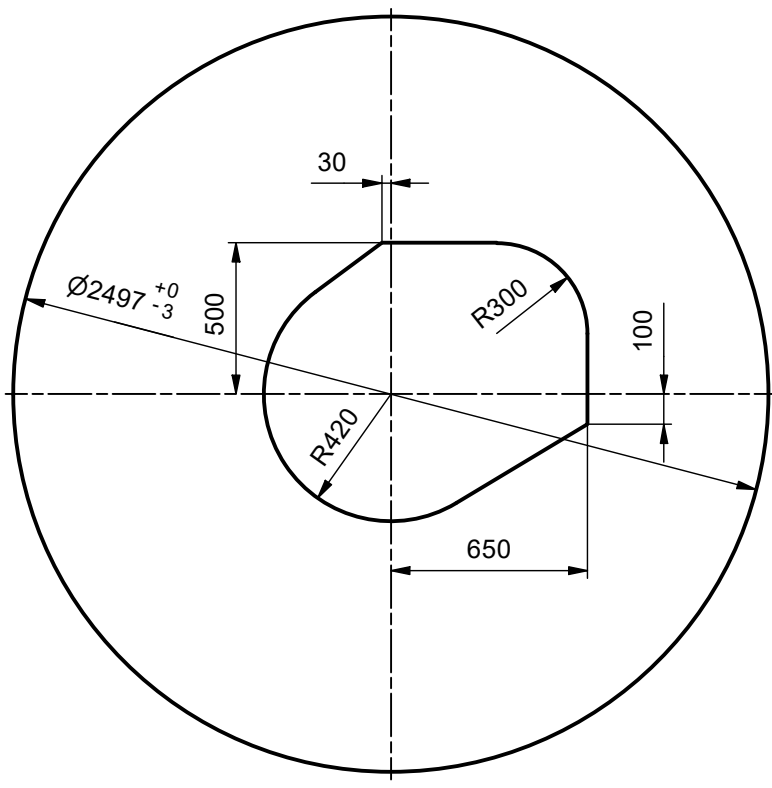
1	PLATE ISO18286   20   1.4301 EN10088-2	2497	0	208451067	703248901	297 kg	1
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ITEM	Description	Length / Dia	Width / Dia1	Item	Drw. No.	Weight	Qty
Customer	AMC	Basic Material Name		Basic Material Standard		Net weight kg	
	1051 00 01 000	1.4301		EN10088-2		297	
Position No.	Customer Drawing No	Description Line 1			Designed	Date	
Product type	Product Code	Description Line 2			Drawn	Date	
					N.Luostarinen	04.05.2021	
Size	Scale	Description Line 1 (EN)			Checked	Date	
A4	1 : 25	BAFFLE WALL			J.Laitinen	04.05.2021	
Division	Prod. Home	Description Line 2 (EN)			Approved	Date	
PPF	1022	INVENTOR					
Replacement for Drawing		Rev.	Replaced by Drawing		Rev.	Copy from Drawing	
						Rev.	Sort
Item No.		Reference Drawing		Old Drawing Number		Rev.	M-File
208451067							
SAP Main WBS Element		Drawing Number		Rev.		Sheet	
		703248901				1 / 1	

1		2								3				4	
<b>GENERAL TOLERANCES LINEAR DIMENSIONS</b>		Nominal measure	>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	>20000
- Welding	ISO13920-B	±1	±1	±1	±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	
- Machining	ISO 2768-m	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	-	
- Chamfers and radius	ISO 2768-m	±0.2	±0.5	±1.0											
- Cutting, bending	ISO 2768-c	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8	-	

- Flame cutting < ISO 9013-332  
ISO 9013-432  
- Casting, machine. ISO 8062-DCTG10  
- Casting, handm. ISO 8062-DCTG12  
- Forgings SFS 3507, DIN 7527

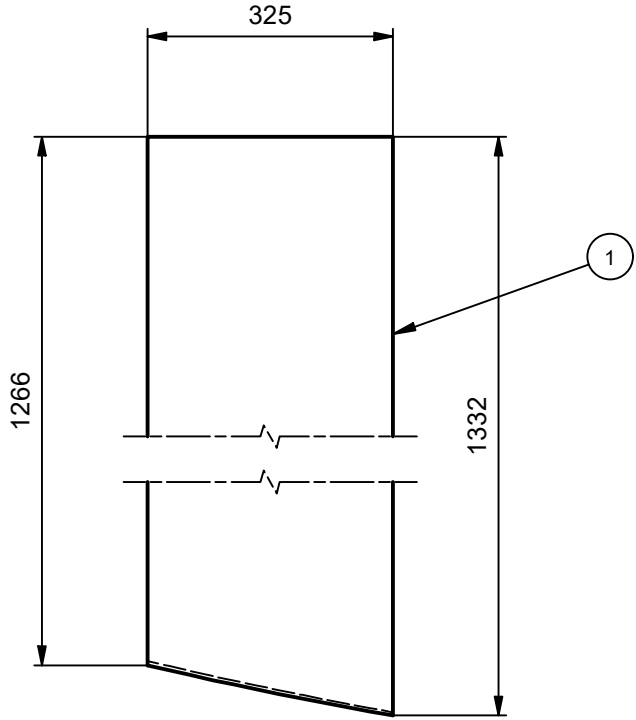
ANGULAR DIMENSIONS		SYMBOLS		GEOM.TOL.		MISCELLANEOUS	
- Welding	ISO13920-B	- Bending	ISO 2768-c s<4 ISO 2768-v s>4	- Surface roughness	ISO 1302-R	- Symbols	ISO 1101
- Machining	ISO 2768-m			- Welding symbols	ISO 2553	- Welding	ISO 13920-G
				- Tolerancing	ISO 8015	- Machining	ISO 2768-K
							- Welding quality ISO 5817-C



1	PLATE ISO18286   20   1.4301 EN10088-2	2497	0	208450738	703248631	651 kg	1
ITEM	Description	Length / Dia	Width / Dia1	Item	Drw. No.	Weight	Qty
Customer		AMC 1051 00 01 000 Basic Material Name 1.4301		Basic Material Standard EN10088-2		Net weight kg 651	
Position No.		Customer Drawing No		Description Line 1		Designed	
Product type		Product Code		Description Line 2		Drawn N.Luostarinen	
Size A4		Scale 1 : 25		Description Line 1 (EN) BAFFLE WALL		Date 03.05.2021	
Division PPF		Prod. Home 1022		System INVENTOR		Checked J.Laitinen	
						Date 03.05.2021	
		Replacement for Drawing		Rev. Replaced by Drawing		Rev. Copy from Drawing	
		Item No. 208450738		Reference Drawing		Old Drawing Number	
		SAP Main WBS Element		Drawing Number		Rev. Sheet	
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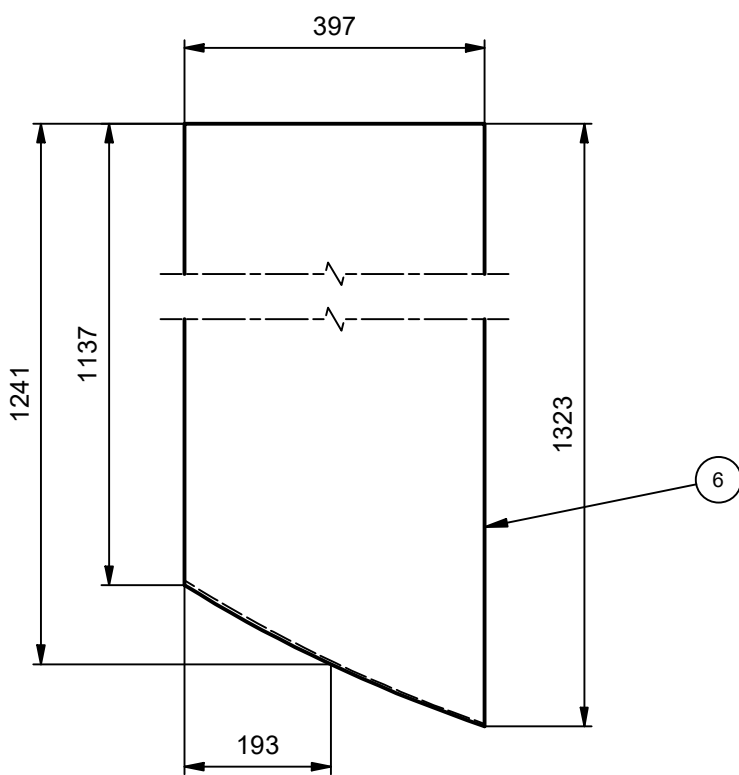


1		2								3				4			
<b>GENERAL TOLERANCES LINEAR DIMENSIONS</b>		Nominal measure	>0.5 ≤3	>3 ≤6	>6 ≤30	>30 ≤120	>120 ≤400	>400 ≤1000	>1000 ≤2000	>2000 ≤4000	>4000 ≤8000	>8000 ≤12000	>12000 ≤16000	>16000 ≤20000	>20000	- Flame cutting <	ISO 9013-IIB ISO 9013-IIG
- Welding	ISO13920-B	±1	±1	±1	±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	- Casting, machine.	ISO 8062-CT10	
- Machining	ISO 2768-m	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	-	- Casting, handm.	ISO 8062-CT12	
- Chamfers and radius	ISO 2768-m	±0.2	±0.5	±1.0											- Forgings	SFS 3507, DIN 7527	
- Cutting, bending	ISO 2768-c	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8	-			
<b>ANGULAR DIMENSIONS</b>		- Welding ISO13920-B	- Bending <	ISO 2768-c s<4		<b>SYMBOLS</b>				- Surface roughness ISO 1302-Ra	<b>GEOM.TOL.</b>		- Symbols ISO 1101	<b>MISCELLANEOUS</b>			
- Machining ISO 2768-m			ISO 2768-v s>4			- Welding symbols ISO 2553			- Tolerancing ISO 8015		- Welding ISO 13920-G		- Weldinglass C (min.), EN25817				
											- Machining ISO 2768-K						



Customer		AMC	Basic Material Name		Basic Material Standard		Net weight kg 149		
Position No.		Customer Drawing No	Description Line 1			Designed		Date	
Product type		Product Code	Description Line 2			Drawn N.Luostarinen		Date 25.03.2019	
Size		Scale	Description Line 1 (EN) SCOOP			Checked J.Laitinen		Date 01.04.2019	
Division PPF	Prod. Home 1022	System INVENTOR	Description Line 2 (EN) FF-250 LH			Approved		Date	
F		Replacement for Drawing		Rev.	Replaced by Drawing		Rev.	Copy from Drawing 702943243	
		Item No. 206712221		Reference Drawing		Old Drawing Number		Rev.	M-Film
		SAP Main WBS Element		Drawing Number 702956733		Rev.	Sheet 2 / 9		

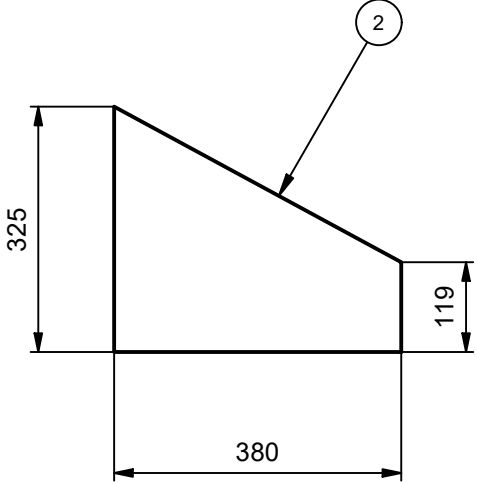
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<b>GENERAL TOLERANCES LINEAR DIMENSIONS</b>		Nominal measure	>0.5 ≤3	>3 ≤6	>6 ≤30	>30 ≤120	>120 ≤400	>400 ≤1000	>1000 ≤2000	>2000 ≤4000	>4000 ≤8000	>8000 ≤12000	>12000 ≤16000	>16000 ≤20000	>20000	- Flame cutting <	ISO 9013-IIB ISO 9013-IIG
- Welding	ISO13920-B	±1	±1	±1	±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	- Casting, machine.	ISO 8062-CT10	
- Machining	ISO 2768-m	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	-	- Casting, handm.	ISO 8062-CT12	
- Chamfers and radius	ISO 2768-m	±0.2	±0.5	±1.0											- Forgings	SFS 3507, DIN 7527	
- Cutting, bending	ISO 2768-c	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8	-			
<b>ANGULAR DIMENSIONS</b>		- Welding ISO13920-B	- Bending <	ISO 2768-c s<4	<b>SYMBOLS</b>				- Surface roughness ISO 1302-Ra	<b>GEOM.TOL.</b>			- Symbols ISO 1101	<b>MISCELLANEOUS</b>			
- Machining ISO 2768-m			ISO 2768-v s>4					- Welding symbols ISO 2553				- Welding ISO 13920-G					
								- Tolerancing ISO 8015				- Machining ISO 2768-K					



Customer		AMC	Basic Material Name		Basic Material Standard		Net weight kg 149			
Position No.		Customer Drawing No	Description Line 1			Designed		Date		
Product type		Product Code	Description Line 2			Drawn N.Luostarinen		Date 25.03.2019		
Size		Scale	Description Line 1 (EN) SCOOP			Checked J.Laitinen		Date 01.04.2019		
Division PPF	Prod. Home 1022	System INVENTOR	Description Line 2 (EN) FF-250 LH			Approved		Date		
F		Replacement for Drawing		Rev.	Replaced by Drawing		Rev.	Copy from Drawing 702943243	Rev.	Sort
		Item No. 206712221		Reference Drawing		Old Drawing Number		Rev.		M-File
		SAP Main WBS Element		Drawing Number 702956733		Rev.		Sheet 3 / 9		



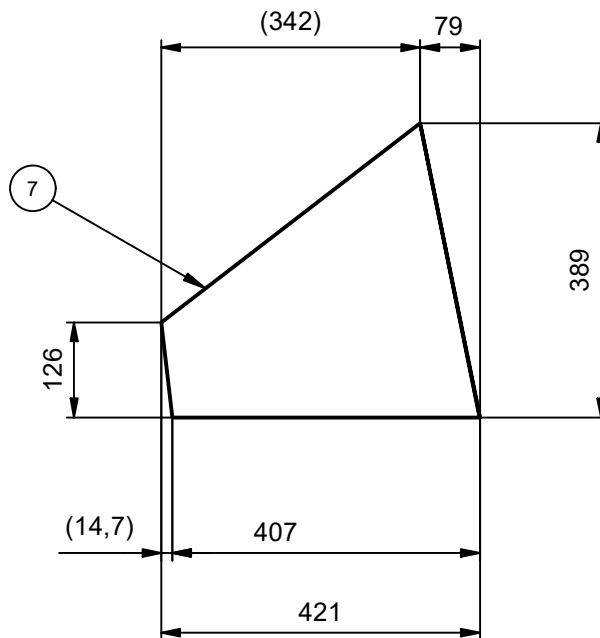
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<b>GENERAL TOLERANCES LINEAR DIMENSIONS</b>		Nominal measure	>0.5 ≤3	>3 ≤6	>6 ≤30	>30 ≤120	>120 ≤400	>400 ≤1000	>1000 ≤2000	>2000 ≤4000	>4000 ≤8000	>8000 ≤12000	>12000 ≤16000	>16000 ≤20000	>20000	- Flame cutting <	ISO 9013-IIB ISO 9013-IIG
- Welding	ISO13920-B	±1	±1	±1	±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	- Casting, machine.	ISO 8062-CT10	
- Machining	ISO 2768-m	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	-	- Casting, handm.	ISO 8062-CT12	
- Chamfers and radius	ISO 2768-m	±0.2	±0.5	±1.0											- Forgings	SFS 3507, DIN 7527	
- Cutting, bending	ISO 2768-c	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8	-			
<b>ANGULAR DIMENSIONS</b>		- Welding ISO13920-B - Bending < ISO 2768-c s<4 - Machining ISO 2768-m - Bending > ISO 2768-v s>4		<b>SYMBOLS</b> - Surface roughness ISO 1302-Ra - Welding symbols ISO 2553 - Tolerancing ISO 8015					<b>GEOM.TOL.</b> - Symbols ISO 1101 - Welding ISO 13920-G - Machining ISO 2768-K				<b>MISCELLANEOUS</b> - Weldingglass C (min.), EN25817				



Customer		AMC	Basic Material Name		Basic Material Standard		Net weight kg 149	
Position No.		Customer Drawing No	Description Line 1			Designed		Date
Product type		Product Code	Description Line 2			Drawn N.Luostarinen		Date 25.03.2019
Size		Scale	Description Line 1 (EN) SCOOP			Checked J.Laitinen		Date 01.04.2019
Division PPF	Prod. Home 1022	System INVENTOR	Description Line 2 (EN) FF-250 LH			Approved		Date
Replacement for Drawing		Rev.	Replaced by Drawing		Rev.	Copy from Drawing 702943243		Rev.   Sort
Item No. 206712221		Reference Drawing			Old Drawing Number		Rev.	M-Film
SAP Main WBS Element		Drawing Number 702956733			Rev.	Sheet 4 / 9		

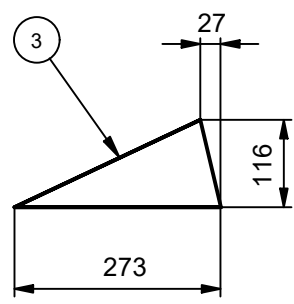
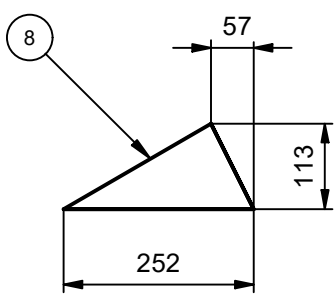
1		2										3				4	
<b>GENERAL TOLERANCES LINEAR DIMENSIONS</b>		Nominal measure	>0.5 ≤3	>3 ≤6	>6 ≤30	>30 ≤120	>120 ≤400	>400 ≤1000	>1000 ≤2000	>2000 ≤4000	>4000 ≤8000	>8000 ≤12000	>12000 ≤16000	>16000 ≤20000	>20000	- Flame cutting	ISO 9013-IIB ISO 9013-IIG
- Welding	ISO13920-B	±1	±1	±1	±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	- Casting, machine.	ISO 8062-CT10	
- Machining	ISO 2768-m	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	-	- Casting, handm.	ISO 8062-CT12	
- Chamfers and radius	ISO 2768-m	±0.2	±0.5	±1.0											- Forgings	SFS 3507, DIN 7527	
- Cutting, bending	ISO 2768-c	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8	-			

ANGULAR DIMENSIONS		SYMBOLS				GEOM.TOL.				MISCELLANEOUS			
- Welding	ISO13920-B	- Bending	ISO 2768-c	s<4	- Surface roughness	ISO 1302-Ra	- Symbols	ISO 1101	- Welding	ISO 13920-G	- Welding	ISO 1101	
- Machining	ISO 2768-m		ISO 2768-v	s>4	- Welding symbols	ISO 2553	- Welding	ISO 13920-G	- Machining	ISO 2768-K	- Machining	ISO 2768-K	
					- Tolerancing	ISO 8015						- Welding	glass C (min.), EN25817



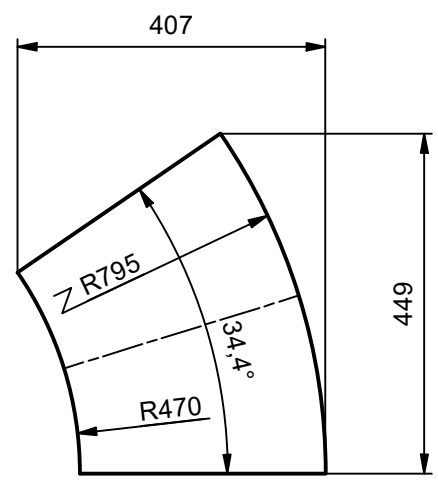
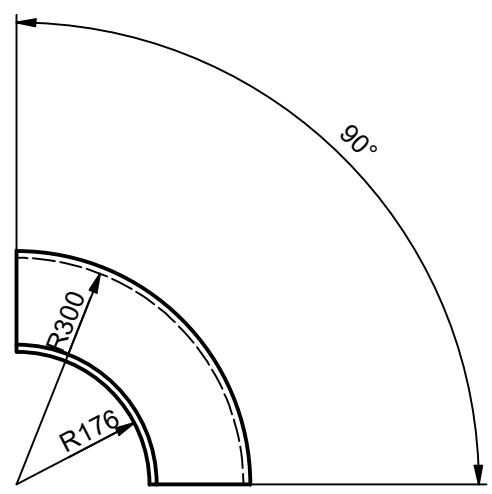
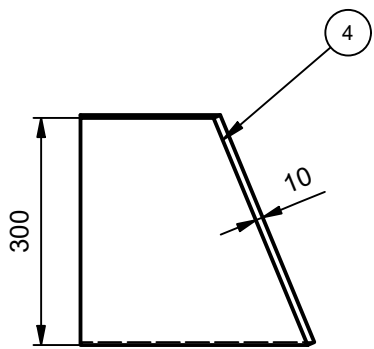
Customer		AMC	Basic Material Name		Basic Material Standard		Net weight kg 149	
Position No.		Customer Drawing No	Description Line 1			Designed		Date
Product type		Product Code	Description Line 2			Drawn N.Luostarinen		Date 25.03.2019
Size		Scale	Description Line 1 (EN) SCOOP			Checked J.Laitinen		Date 01.04.2019
Division PPF	Prod. Home 1022	System INVENTOR	Description Line 2 (EN) FF-250 LH			Approved		Date
Replacement for Drawing		Rev.	Replaced by Drawing		Rev.	Copy from Drawing 702943243		Rev.   Sort
Item No. 206712221		Reference Drawing			Old Drawing Number		Rev.	M-Film
SAP Main WBS Element		Drawing Number 702956733			Rev.	Sheet 5 / 9		

1		2								3				4			
<b>GENERAL TOLERANCES LINEAR DIMENSIONS</b>		Nominal measure	>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	>20000	- Flame cutting <	ISO 9013-IIB ISO 9013-IIG
- Welding	ISO13920-B	±1	±1	±1	±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	- Casting, machine.	ISO 8062-CT10	
- Machining	ISO 2768-m	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	-	- Casting, handm.	ISO 8062-CT12	
- Chamfers and radius	ISO 2768-m	±0.2	±0.5	±1.0											- Forgings	SFS 3507, DIN 7527	
- Cutting, bending	ISO 2768-c	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8	-			
<b>ANGULAR DIMENSIONS</b>		- Welding ISO13920-B - Bending < ISO 2768-c s<4 - Machining ISO 2768-m - Bending > ISO 2768-v s>4		<b>SYMBOLS</b>				- Surface roughness ISO 1302-Ra - Welding symbols ISO 2553 - Tolerancing ISO 8015	<b>GEOM.TOL.</b>				- Symbols ISO 1101 - Welding ISO 13920-G - Machining ISO 2768-K	<b>MISCELLANEOUS</b>		- Weldingglass C (min.), EN25817	



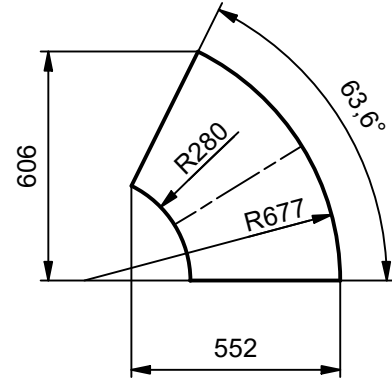
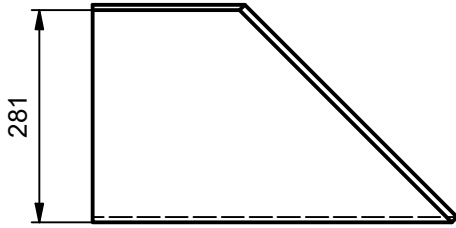
Customer		AMC	Basic Material Name		Basic Material Standard		Net weight kg 149	
Position No.		Customer Drawing No	Description Line 1			Designed		Date
Product type		Product Code	Description Line 2			Drawn N.Luostarinen		Date 25.03.2019
Size		Scale	Description Line 1 (EN) SCOOP			Checked J.Laitinen		Date 01.04.2019
Division PPF	Prod. Home 1022	System INVENTOR	Description Line 2 (EN) FF-250 LH			Approved		Date
F		Replacement for Drawing		Rev.	Replaced by Drawing		Rev.	Copy from Drawing
		Item No.		206712221		Reference Drawing		Old Drawing Number
		SAP Main WBS Element				Drawing Number		702943243
						Rev.		Sort
						Rev.		M-Film
						Rev.		Sheet
						Rev.		6 / 9
						Drawing Number		702956733

1		2								3				4			
<b>GENERAL TOLERANCES LINEAR DIMENSIONS</b>		Nominal measure	>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	>20000	- Flame cutting <	ISO 9013-IIB ISO 9013-IIG
- Welding	ISO13920-B	±1	±1	±1	±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	- Casting, machine.	ISO 8062-CT10	
- Machining	ISO 2768-m	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	-	- Casting, handm.	ISO 8062-CT12	
- Chamfers and radius	ISO 2768-m	±0.2	±0.5	±1.0											- Forgings	SFS 3507, DIN 7527	
- Cutting, bending	ISO 2768-c	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8	-			
<b>ANGULAR DIMENSIONS</b>		- Welding ISO13920-B		- Bending < ISO 2768-c s<4 ISO 2768-v s>4		<b>SYMBOLS</b>				- Surface roughness ISO 1302-Ra		<b>GEOM.TOL.</b>		- Symbols ISO 1101		<b>MISCELLANEOUS</b>	
- Machining ISO 2768-m						- Welding symbols ISO 2553				- Welding ISO 13920-G		- Machining ISO 2768-K		- Weldinglass C (min.), EN25817			
						- Tolerancing ISO 8015											

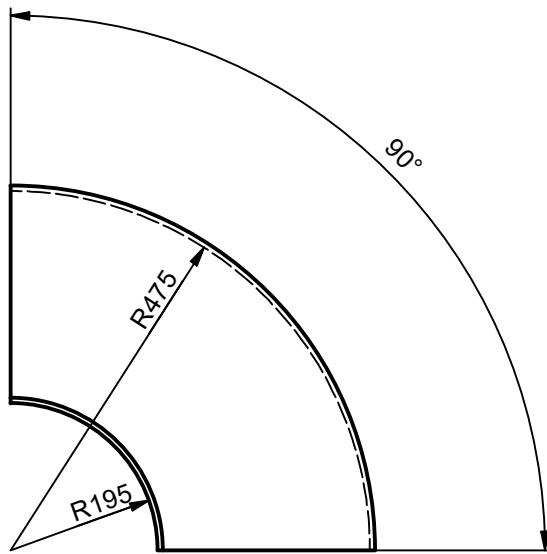


Customer		AMC		Basic Material Name		Basic Material Standard		Net weight kg 149	
Position No.		Customer Drawing No		Description Line 1		Designed		Date	
Product type		Product Code		Description Line 2		Drawn N.Luostarinen		Date 25.03.2019	
Size		Scale		Description Line 1 (EN) SCOOP		Checked J.Laitinen		Date 01.04.2019	
Division PPF	Prod. Home 1022	System INVENTOR		Description Line 2 (EN) FF-250 LH		Approved		Date	
F		Replacement for Drawing		Rev.	Replaced by Drawing		Rev.	Copy from Drawing 702943243	
		Item No. 206712221		Reference Drawing		Old Drawing Number		Rev.	M-Film
		SAP Main WBS Element		Drawing Number 702956733		Rev.	Sheet 7 / 9		

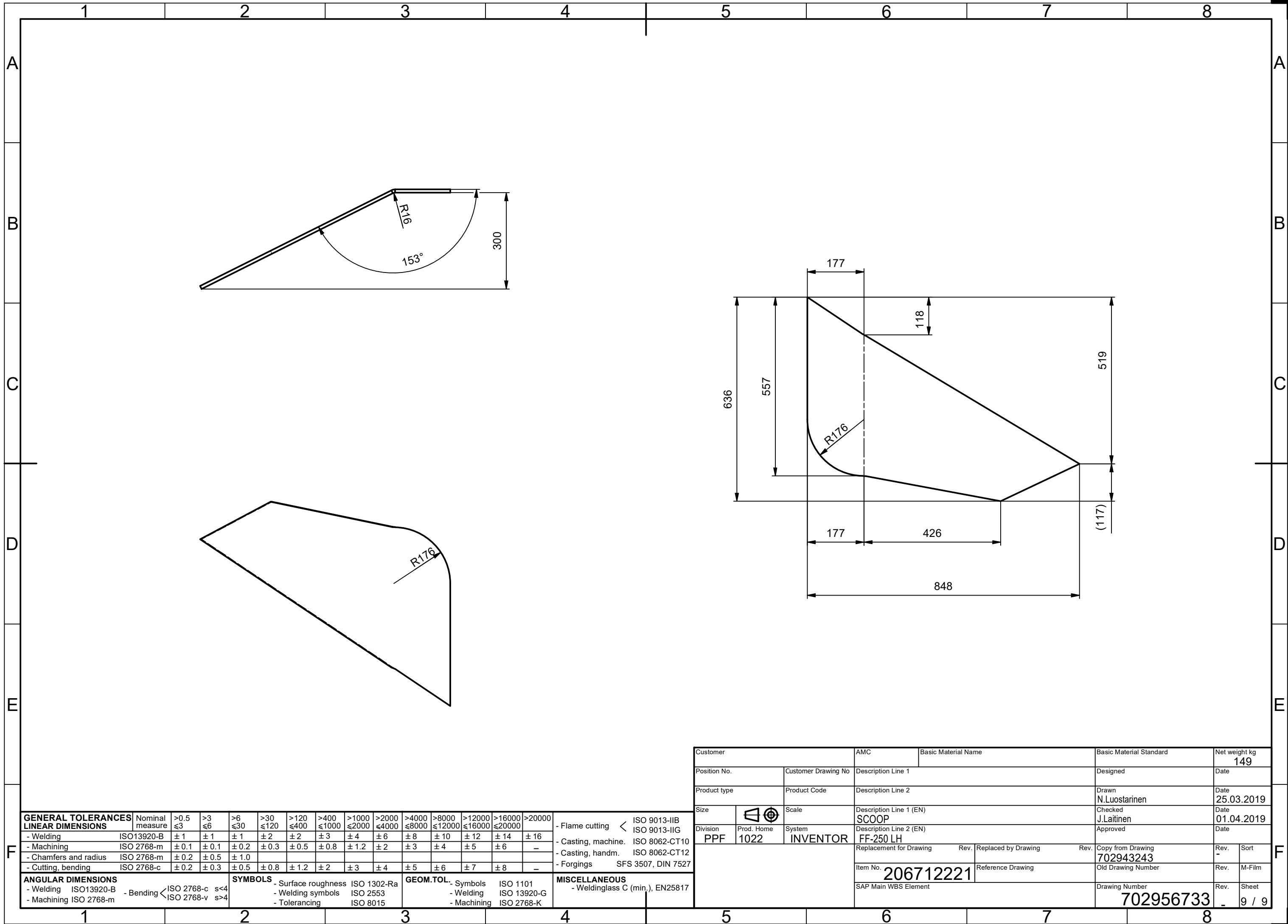
1		2								3				4			
<b>GENERAL TOLERANCES LINEAR DIMENSIONS</b>		Nominal measure	>0.5 ≤3	>3 ≤6	>6 ≤30	>30 ≤120	>120 ≤400	>400 ≤1000	>1000 ≤2000	>2000 ≤4000	>4000 ≤8000	>8000 ≤12000	>12000 ≤16000	>16000 ≤20000	>20000	- Flame cutting	ISO 9013-IB ISO 9013-IIG
- Welding	ISO13920-B	±1	±1	±1	±2	±2	±3	±4	±6	±8	±10	±12	±14	±16	- Casting, machine.	ISO 8062-CT10	
- Machining	ISO 2768-m	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	-	- Casting, handm.	ISO 8062-CT12	
- Chamfers and radius	ISO 2768-m	±0.2	±0.5	±1.0											- Forgings	SFS 3507, DIN 7527	
- Cutting, bending	ISO 2768-c	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6	±7	±8	-			
<b>ANGULAR DIMENSIONS</b>																	
- Welding	ISO13920-B																
- Machining	ISO 2768-m																
		- Bending	ISO 2768-c	s<4													
			ISO 2768-v	s>4													
		<b>SYMBOLS</b>				- Surface roughness ISO 1302-Ra				<b>GEOM.TOL.</b>				- Symbols ISO 1101			
						- Welding symbols ISO 2553				- Welding ISO 13920-G				- Weldingglass C (min.), EN25817			
						- Tolerancing ISO 8015				- Machining ISO 2768-K							



( 1 : 20 )



Customer		AMC		Basic Material Name				Basic Material Standard		Net weight kg 149	
Position No.		Customer Drawing No		Description Line 1				Designed		Date	
Product type		Product Code		Description Line 2				Drawn N.Luostarinen		Date 25.03.2019	
Size		Scale		Description Line 1 (EN) SCOOP				Checked J.Laitinen		Date 01.04.2019	
Division PPF	Prod. Home 1022	System INVENTOR		Description Line 2 (EN) FF-250 LH				Approved		Date	
		Replacement for Drawing		Rev.	Replaced by Drawing		Rev.	Copy from Drawing 702943243		Rev.	Sort
		Item No. 206712221		Reference Drawing		Old Drawing Number		Drawing Number 702956733		Rev.	M-File
		SAP Main WBS Element						Sheet 8 / 9			



GENERAL TOLERANCES		Nominal measure	>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	>20000
- Welding	ISO13920-B	± 1	± 1	± 1	± 2	± 2	± 3	± 4	± 6	± 8	± 10	± 12	± 14	± 16	-
- Machining	ISO 2768-m	± 0.1	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 3	± 4	± 5	± 6	-	-
- Chamfers and radius	ISO 2768-m	± 0.2	± 0.5	± 1.0											
- Cutting, bending	ISO 2768-c	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 3	± 4	± 5	± 6	± 7	± 8	-	-

ANGULAR DIMENSIONS		Nominal measure	s<4	s>4
- Welding	ISO13920-B	± 0.5	± 0.5	± 0.5
- Machining	ISO 2768-m	± 0.5	± 0.5	± 0.5

SYMBOLS		ISO 1302-Ra	ISO 2553	ISO 8015
- Surface roughness	ISO 1302-Ra			
- Welding symbols	ISO 2553			
- Tolerancing	ISO 8015			

GEOM.TOL.		ISO 1101	ISO 13920-G	ISO 2768-K
- Symbols	ISO 1101			
- Welding	ISO 13920-G			
- Machining	ISO 2768-K			

MISCELLANEOUS		EN25817
- Welding	EN25817	
- Machining	EN25817	

Customer		AMC	Basic Material Name		Basic Material Standard		Net weight kg	
Position No.		Customer Drawing No	Description Line 1		Designed		Date	
Product type		Product Code	Description Line 2		Drawn		Date	
Size		Scale	Description Line 1 (EN)		Checked		Date	
Division		Prod. Home	System		Approved		Date	
PPF		1022	INVENTOR		FF-250 LH		01.04.2019	
Replacement for Drawing		Rev.	Replaced by Drawing		Rev.		Copy from Drawing	
Item No.		206712221		Reference Drawing		702943243		Rev.
SAP Main WBS Element				Old Drawing Number		Rev.		M-Film
Drawing Number		702956733		Rev.		Sheet		
								9 / 9