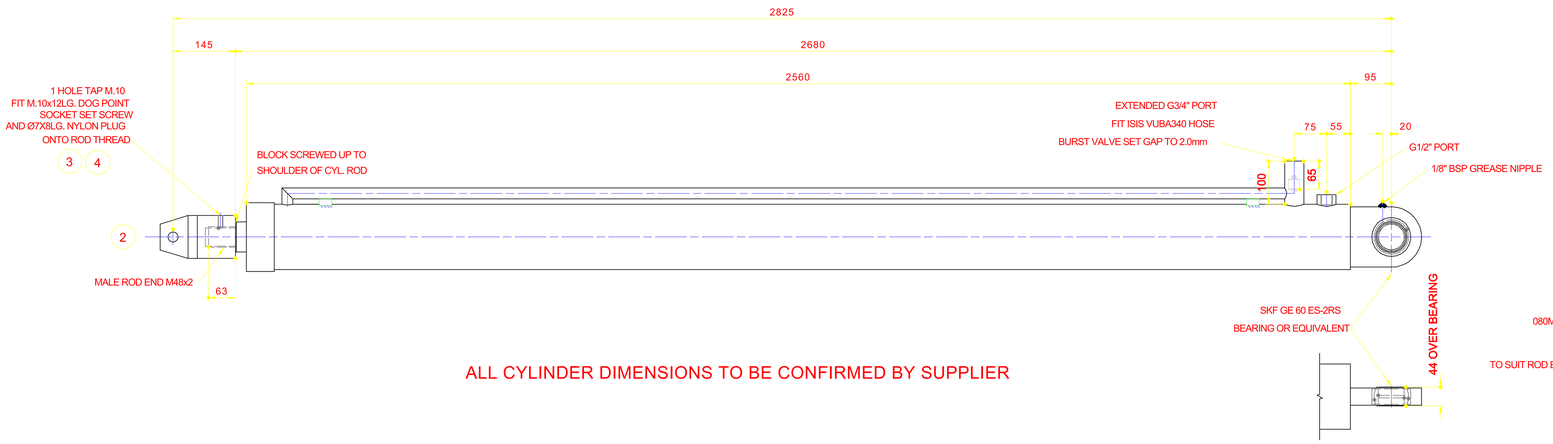
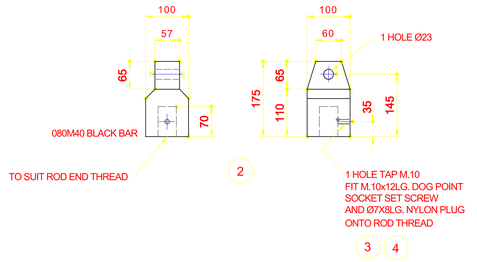



ALL CYLINDER DIMENSIONS TO BE CONFIRMED BY SUPPLIER




1

125 BORE x 70 ROD x 2300 STROKE
2825 CLOSED CENTRE DIMENSION
DOUBLE ACTING NON-CUSHIONED
PISTON ROD TERMINATING THREAD M48x2 TO BE CONFIRMED
FULL BORE AND ANNULUS FEED THROUGH CYLINDER BARREL
PISTON ROD HARD CHROME PLATED 0.025mm THICK
REAR EYE FITTED WITH SPHERICAL PLAIN BEARING
SKF REF:-GE 60 ES-2RS OR EQUIVALENT
WORKING MECHANICAL PRESSURE = 90 BAR
DESIGN STALL PRESSURE = 120 BAR
TEST PRESSURE = 180 BAR
HYDRAULIC FLUID - PHOSPHATE ESTER TYPE
ALL SEALS TO BE VITON.
MAXIMUM SPEED 5308MM/MIN.
LOAD ON ANNULUS ONLY

CHROME CAN BE MULTILAYERED BUT EACH LAYER MUST BE DEPOSITED IN ONE PASS (IE NOT "TOPPED AND TAILED"). PROOF OF CHROME THICKNESS TO BE TRACEABLE TO NATIONAL STANDARDS.

CYLINDERS TO BE TESTED IN ACCORDANCE WITH MECHATHERM INTERNATIONAL LTD STANDARD TESTING OF HYDRAULIC CYLINDERS - MIS-002-ISSUE A REV 3.
CLEANLINESS OF HYDRAULIC OIL USED DURING TEST PROCEDURE MUST BE PROVEN TO BE A MINIMUM OF 18/13 IN ACCORDANCE WITH BS5540 PT 4 (ISO 4406).
TEST CERTIFICATION MUST BE SUPPLIED AS OBJECTIVE EVIDENCE OF OIL CLEANLINESS.
TEST CERTIFICATE MUST BE SUPPLIED FOR PRESSURE AND FUNCTIONAL TEST.

2 CYLINDERS REQUIRED.
2 ROD END CHAIN CONNECTORS REQUIRED.

PAINT SPEC & COLOUR T.B.C

THIS DRAWING HAS BEEN PRODUCED ON A CAD SYSTEM AND MUST NOT BE ALTERED BY ANY OTHER MEANS
DESIGNER RIGHT MECHATHERM INTERNATIONAL LTD - AS DRAWING DATE -

FIRST ANGLE PROJECTION

| SURFACE FINISH | Чистота поверхности | UNTOLERANCED DIMENSIONS | | | | | | |
|---|---|---|---|---|---|---|---|---|
| 0.8 FINE M/C | 0.8 Фрезерная чистота | Непереносные размеры | | | | | | |
| 1.6 SMOOTH M/C | 1.6 Высокочистовая обработка | DRILLED HOLE CENTRES ±1 | UP TO 120 (>=120) | OVER 120 UP TO 315 (>120 <=315) | OVER 315 UP TO 1000 (>315 <=1000) | OVER 1000 UP TO 2000 (>1000 <=2000) | 2000 AND OVER (>2000) |
| 3.2 MEDIUM M/C | 3.2 Чистовая механическая обработка | Центры отверстий ±0.2 | | | | | |
| 12.5 ROUGH M/C | 12.5 Черновая механическая обработка | MACHINED | ±0.2 | ±0.5 | ±0.8 | ±1 | ±1 |
| CAST SMOOTH | Гладкое литьё | FABRICATED | ±2 | ±2 | ±2 | ±2 | ±2 |

ALL SHARP EDGES AND BURRS TO BE REMOVED
SHARP FILLETS AND UNDERCUTS TO BE 1mm RADIUS UNLESS OTHERWISE STATED

DENOTES ITEM 'A' DRAWING 'B'

| REV. | DRAWN BY | DATE | DESCRIPTION | CHECKED/ APPROVED BY | DATE | REV. | DRAWN BY | DATE | DESCRIPTION | CHECKED/ APPROVED BY | DATE |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | XXXXXXX | | |

DRAWING STATUS

| | |
|---|---|
| PROVISIONAL | P |
| MANUFACTURE | M |
| AS BUILT | A |

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ALCO ABELAYA KALITVA LINE #7
60T STATIC MELTING FURNACE
HYDRAULIC DOOR CYLINDER DETAILS

XXXXX
XXXXX
XXXXX
XXXXX

| SCALE | SIZE |
|---|---|
| 1:4 | A0 |
| DRAWN BY | DATE |
| OST | 08/01/07 |
| CHECKED BY | DATE |
| OST | 08/01/07 |
| APPROVED BY | DATE |
| OST | 08/01/07 |

DRG.No. 34181-007 | REV. 0 | STATUS P | CUSTOMER DRG.No.