



Werksmontagenaht
 Workshop assembly welding seam
 Soudure de montage d'atelier

	Nachlaufrohr/ trailing tube	Gesamtgewicht/ total weight 7800kg
Maschine/ machine	4500kg	
AD/ extension	3300kg	

Wenn nicht anderweitig angegeben, sind metrische Schafschrauben entsprechend den HERRENKNECHT-Anweisungen nach folgender Tabelle anzuziehen
Schrauben-Anzugsmomente in Nm
 nach AA-HKAG-2.5-026
 Reibungskoeffizient $\beta_{ges.} = 0,12$

If not defined otherwise, metric screws have to be tightened in accordance with the prescriptions from HERRENKNECHT in the following table
Screw tightening torques in Nm
 following AA-HKAG-2.5-026
 coefficient of friction $\beta_{tot.} = 0,12$

	5.6	8.8	10.9	12.9
M16	85	180	265	310

X = Schweißnähte druckdicht
 Weld seams pressure-tight

Für die Herstellung des Bauteils gilt folgende Werknorm:
 The following company standard applies for part manufacturing:
WN-HKAG-1.2-010 "Ausführung und Prüfung von Stahlbauteilen"
 "Steelwork workmanship and testing"

Revision	Change	Date	Drawn	Date	Released
The reproduction, distribution and utilization of this document as well as the communication of its contents to others without express authorization is prohibited. Offenders will be held liable for the payment of damages. All rights reserved in the event of the grant of a patent, utility model or design. ISO 16016					General tolerances
Edges of undefined shape	ISO 13715:2000	Drawing type		assembly	
Geometrical product specification	(GPS) EN ISO 1101:2013	Project		M-1939M	
Surface specifications according to	EN ISO 1302:1992	Machine type		AVN1000X-11	
 HERRENKNECHT Tunnelling Systems www.herrenknecht.com					
Name		UPSIZE SHELL AUFDOPPELMANTEL DA1700-NLR			
Drawing number		4410-008.2-006-00	Sheet	Revision	Format
Date		07.03.2022	1/1	-	A3
Drawn	07.03.2022	Name		Hundertpfund Frank	
Released	21.03.2022	Scale	Material no.	Material	Weight/kg
		1:15	40621328		3278.1
					Projection

Baukastenstückliste modular BOM



Projekt
Material 40621328
Bezeichnung 1 AUFDOPPELMANTEL

Zchnng.Nr/ver 4410-008.2-006-00 / -
Gewicht 3.278,120 KG
Werk 1000

project
material 40621328
description 1 UPSIZE SHELL

draw.No/ver 4410-008.2-006-00 / -
weight 3.278,120 KG
plant 1000

Pos.	Typ type	Material	Menge qty	Bezeichnung 1 / Bezeichnung 2	description 1 / description 2	Zchnng.Nr/ver/Bpf draw.No/ver	Gewicht weight
1	L	40621329	1,000 ST	AUFDOPPELMANTEL STAHLBAU	UPSIZESH SHELL STEEL STRUCTURE	4410-008.2-006-01/-	3.267,73 KG
100	L	29900016	2,000 ST	ANSCHLAGPUNKT	LIFTING POINT		3,32 KG
101	L	40220918	1,000 ST	DICHTUNGSPROFIL	SEALING PROFILE		2,20 KG
200	L	24007912	12,000 ST	ZYLINDERSCHRAUBE GVZ M16X50-8.8-DIN912	HEX.SOCKET HEAD CAP SCREW ZP M16X50-8.8-DIN912		0,11 KG
201	L	24007218	4,000 ST	VERSCHLUSSSCHRAUBE M27X3-5.8-DIN906	PLUG SCREW M27X3-5.8-DIN906		30,00 G