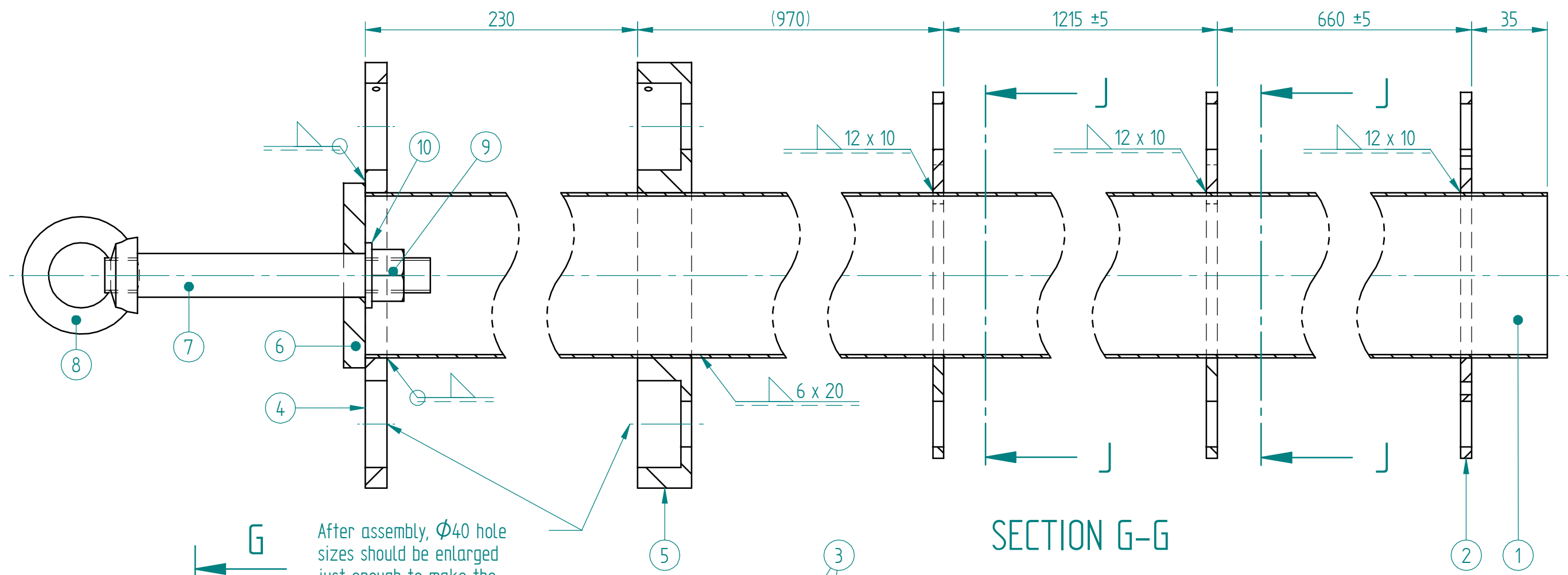


This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party, nor be used for any unauthorized purpose. Contravention will be prosecuted.

The tolerance class in accordance with ISO 2768-mK

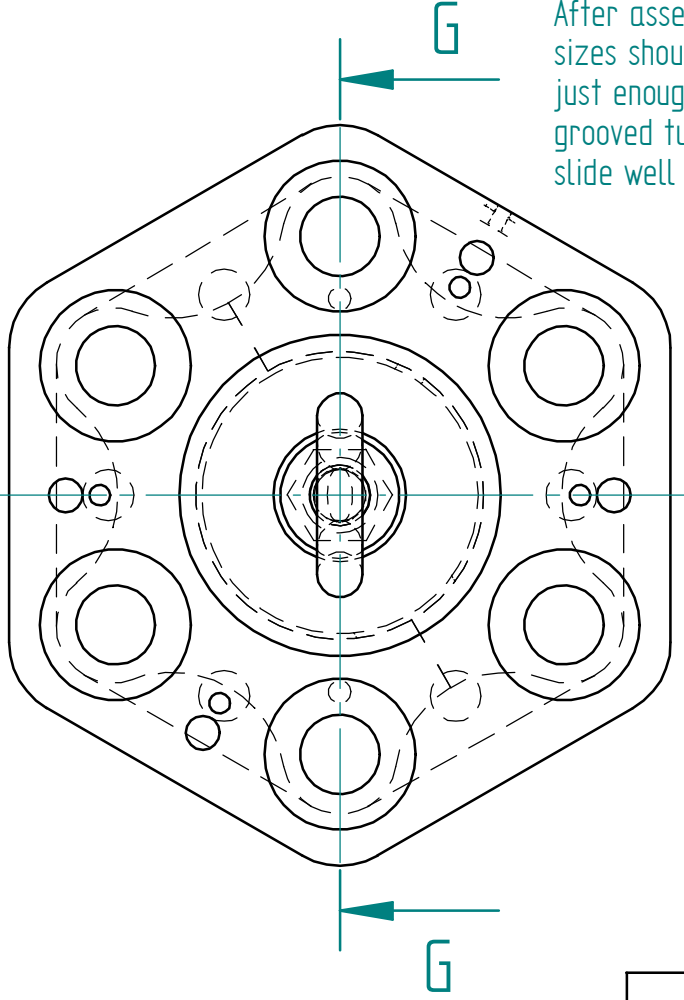
REV. IND	REVISION	APPD	YEAR WEEK

BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-01	REV IND
			SHEET 1/16 CONT



SECTION G-G

After assembly, $\Phi 40$ hole sizes should be enlarged just enough to make the grooved tubes (K00270-09) slide well when fitted in place.



SECTION J-J

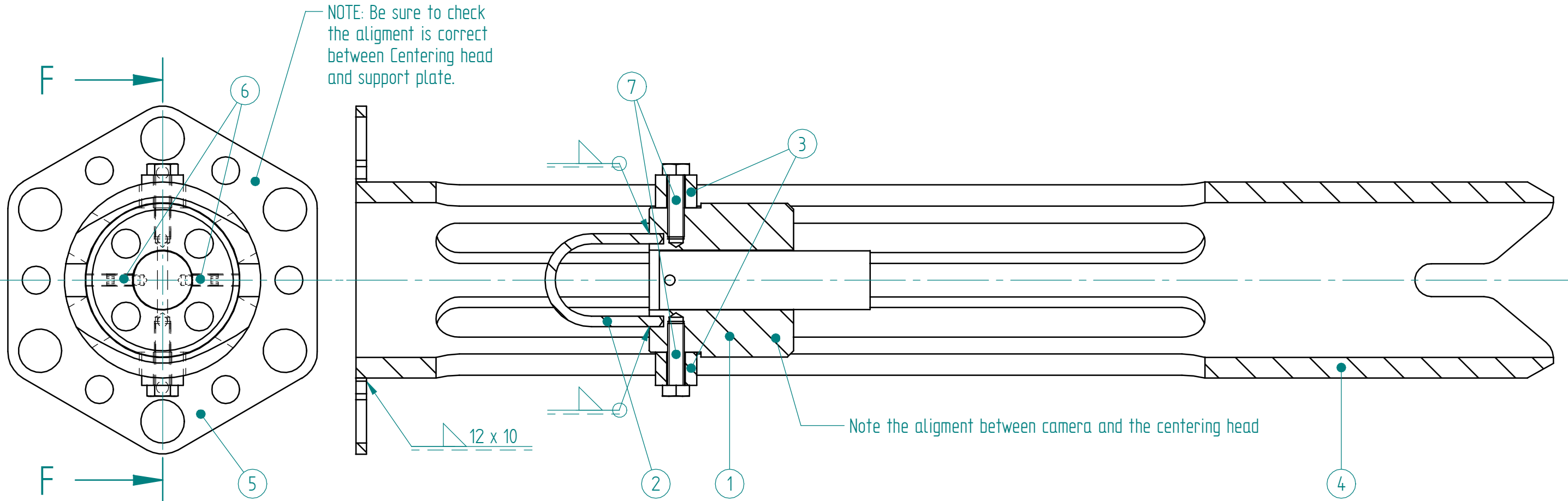
The tolerance class in accordance with ISO 2768-mK

Item no.	Reference	Description	Material	Quantity
10	DIN 125	M16	A2	1
9	DIN 934	M16	A2	1
8	DIN 582	M16	AISI 304 or 316	1
7	K00270-16	Lift axis	AISI 304 or 316	1
6	K00270-16	top end plate	AISI 304 or 316	1
5	K00270-08	Support plate, type 5	AISI 304 or 316	1
4	K00270-08	Support plate, type 4	AISI 304 or 316	1
3	K00270-08	Support plate, type 3	AISI 304 or 316	4
2	K00270-08	Support plate, type 2	AISI 304 or 316	1
1		$\Phi 76,1 \times 1,5 \times 3110$	AISI 304 or 316	1

REV. IND	REVISION	APPO	YEAR	WEEK

BLANK	ISSUE BY DEPT 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-02	REV IND SHEET 2/16 CONT

This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.



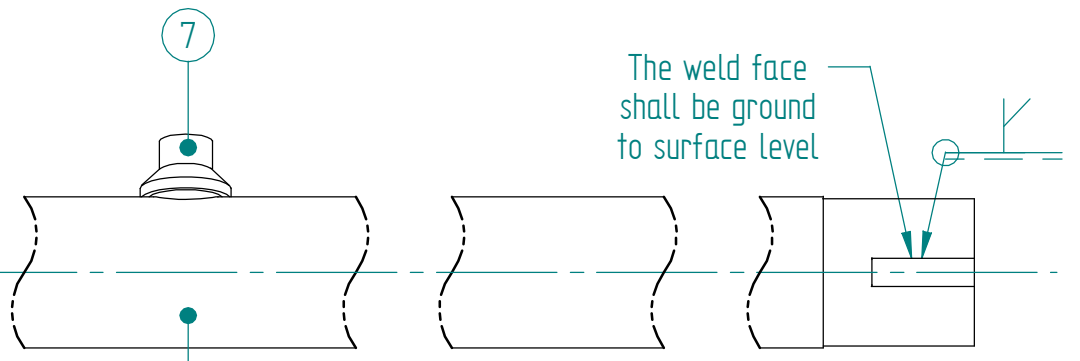
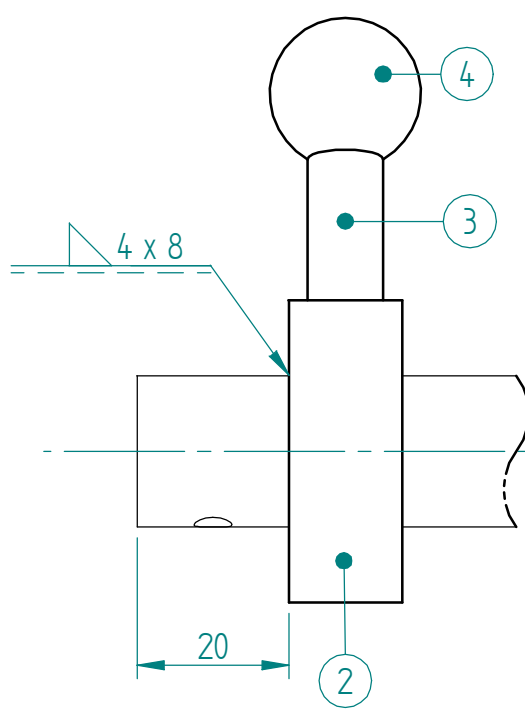
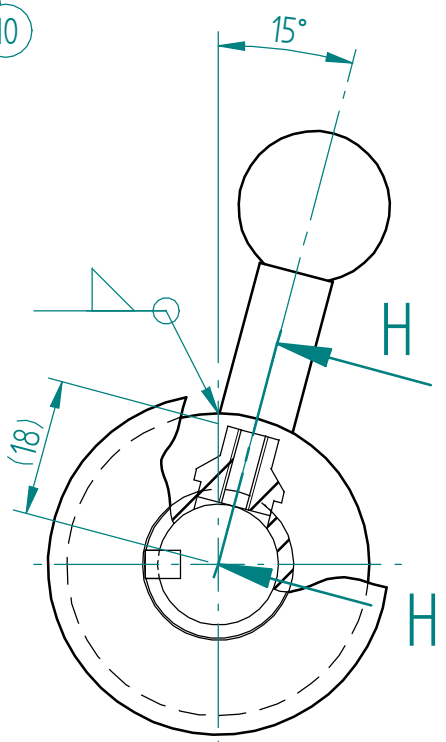
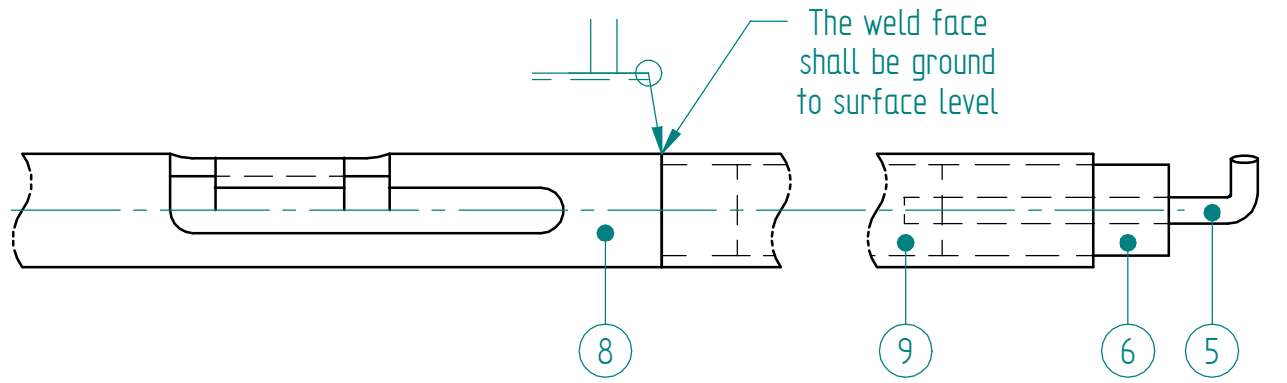
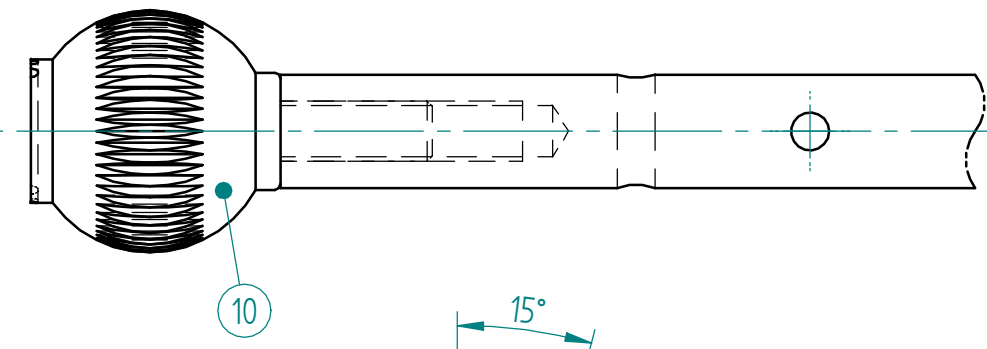
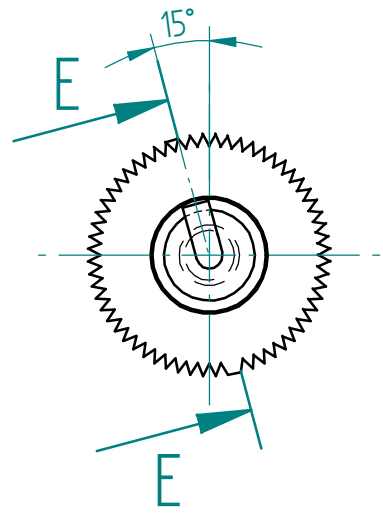
This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.

7	DIN 933	M8 x 30	A2	2
6	DIN 915	M6 x 16	A4	2
5	K00270-008	Support plate, type 1	AISI 304 or 316	1
4	K00270-005	Centering head	AISI 304 or 316	1
3		Tracer TS-506PSC camera		1
3	K00270-010	Camera support guide	AISI 304 or 316	2
2	K00270-010	Camera support lifting loop	AISI 304 or 316	1
1	K00270-010	Camera support	AISI 304 or 316	1
Item no.	Reference	Description	Material	Quantity

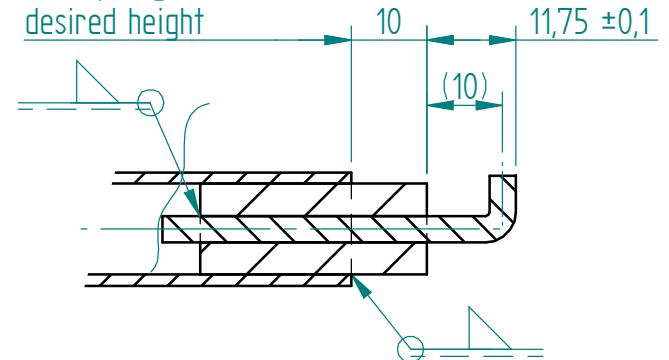
The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPO	YEAR WEEK

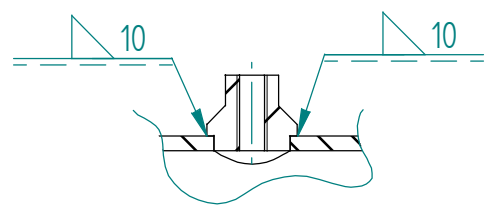
BLANK	ISSUE BY DEPT	MM/DD/YY	DESCRIPTION (ENGLISH)	ASSEMBLY DRAWING
		08/30/05	Interchange tool	
DRAWING CHECKED BY	DRAWN BY		DESCRIPTION (FINNISH)	
	JEL		Vaihtotyökalu	
			K00270-03	REV IND SHEET 3/16 CONT



This length shall be checked prior to welding to get the P-shaped groove at desired height



SECTION E-E



SECTION H-H
1:1

The tolerance class in accordance with ISO 2768-mK

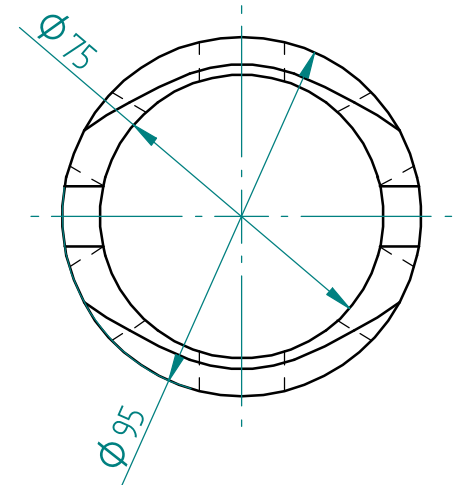
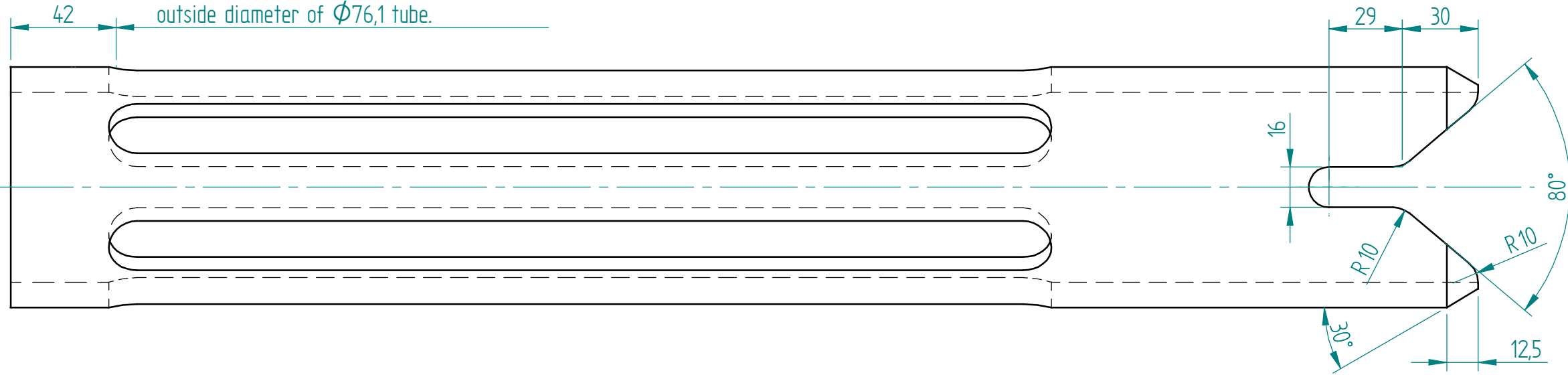
Item no.	Reference	Description	Material	Quantity
10		KIPP, Novo Grip, Grip Ball, external thread M8 x 20	A2	1
9		Ø15 x 1,5 x 3230	AISI 304 or 316	1
8	K00270-07	Inner operating rod top end	AISI 304 or 316	1
7	K00270-15	Groove pin base	AISI 304 or 316	1
6	K00270-15	Prehensile hook mount	AISI 304 or 316	1
5	K00270-15	Prehensile hook	AISI 304 or 316	1
4		Ball knob female thread M8		1
3	K00270-15	Operating handle, shaft	AISI 304 or 316	1
2	K00270-15	Operating handle, body	AISI 304 or 316	1
1	K00270-06	Outer operating rod tube	AISI 304 or 316	1

BLANK	ISSUE BY DEPT	MM/DD/YY	DESCRIPTION (ENGLISH)	ASSEMBLY DRAWING
		08/30/05	Interchange tool	
DRAWING CHECKED BY	DRAWN BY		DESCRIPTION (FINNISH)	
	JEL		Vaihtotyökalu	
			K00270-04	REV IND SHEET 4/16 CONT

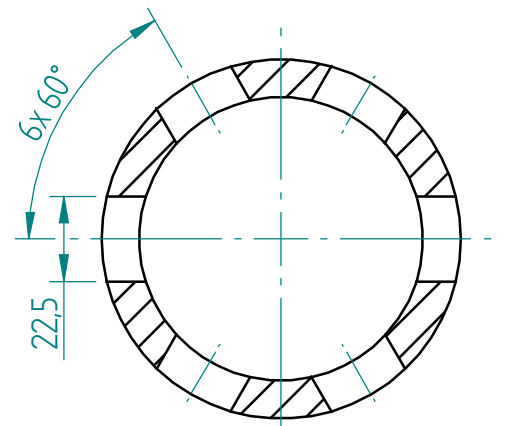
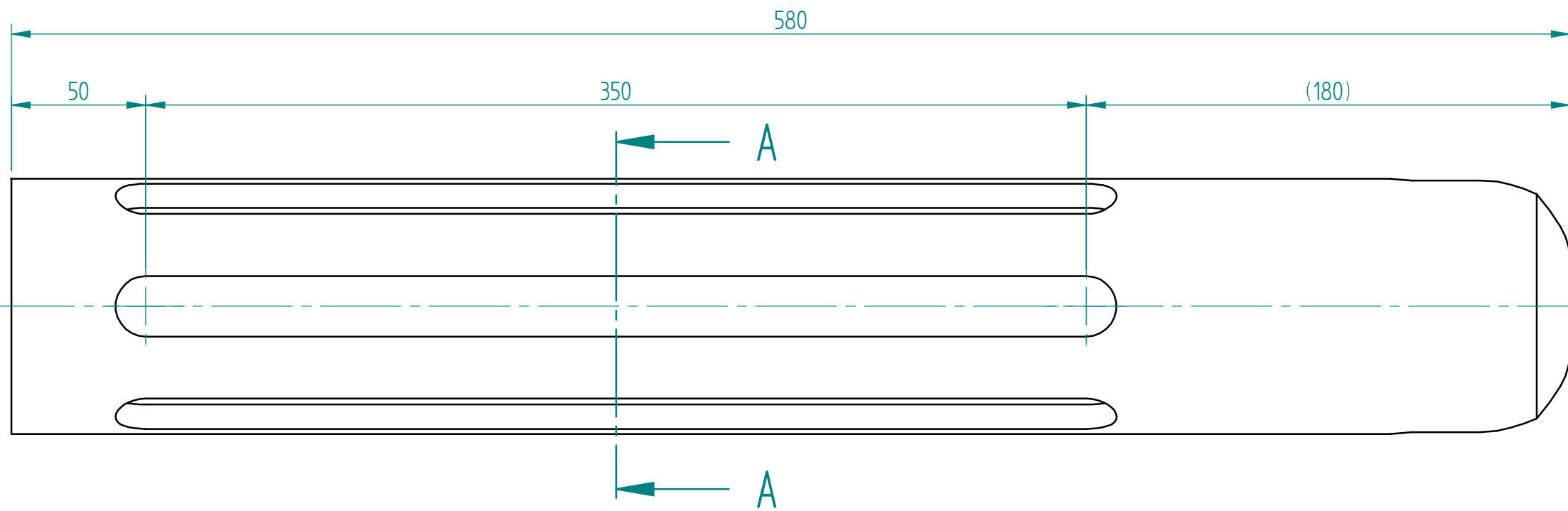
REV. IND	REVISION	APPD	YEAR WEEK

This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.

Inside diameter for this depth (40mm) should be the same (tolerance +0 -0,5) as the actual outside diameter of $\Phi 76,1$ tube.



This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party, nor be used for any unauthorized purpose. Contravention will be prosecuted.

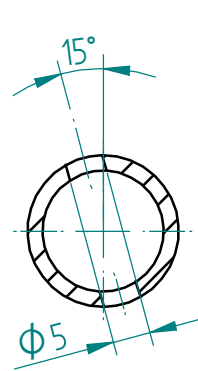
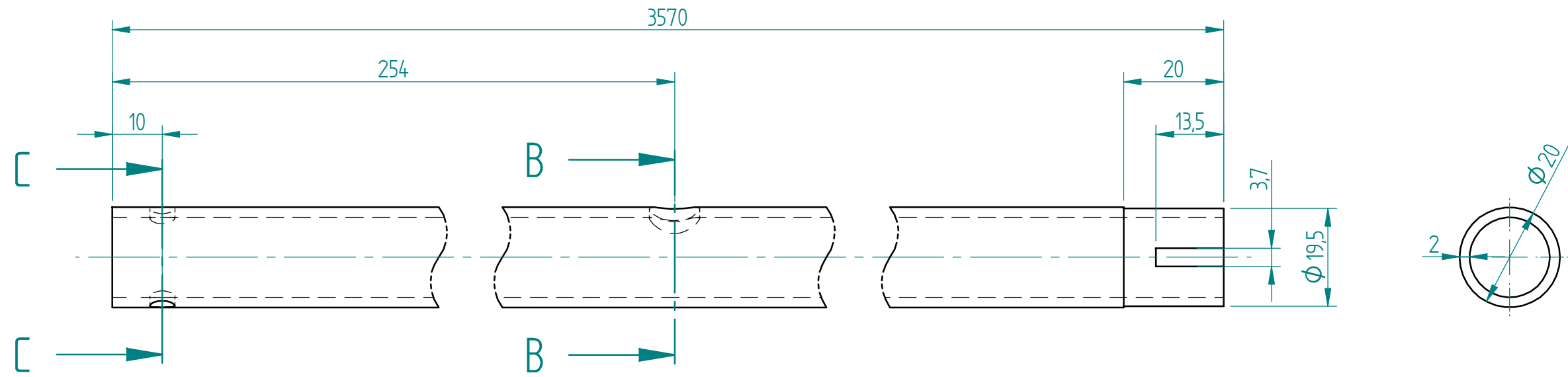


SECTION A-A

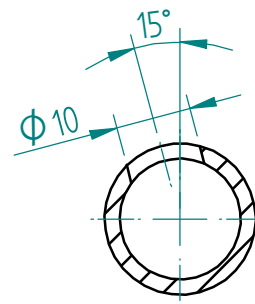
The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPD	YEAR WEEK

BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-05	REV IND
			SHEET 5/16 CONT



SECTION C-C



SECTION B-B

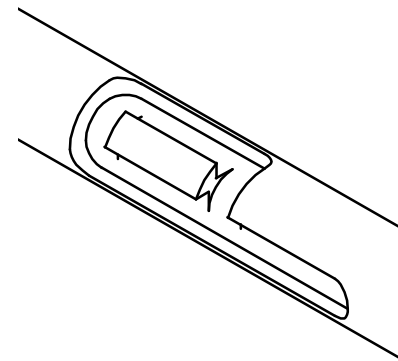
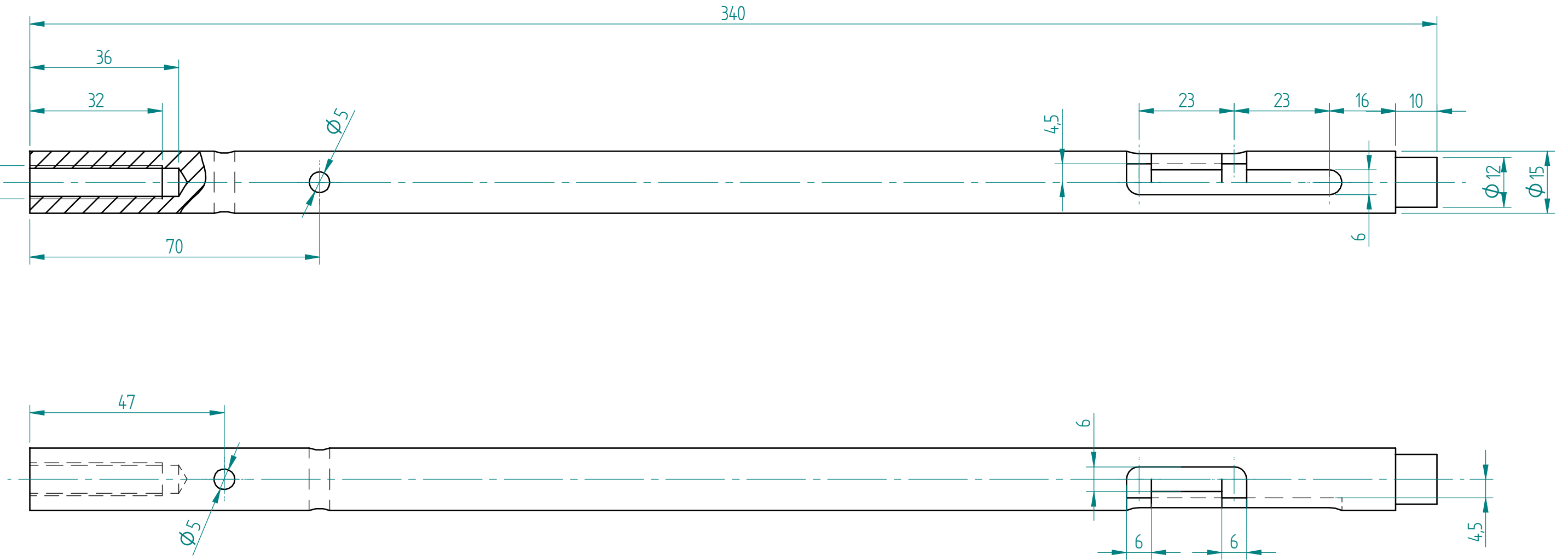
This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.

The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPO	YEAR WEEK

BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-06	REV IND
			SHEET 6/16 CONT

This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.

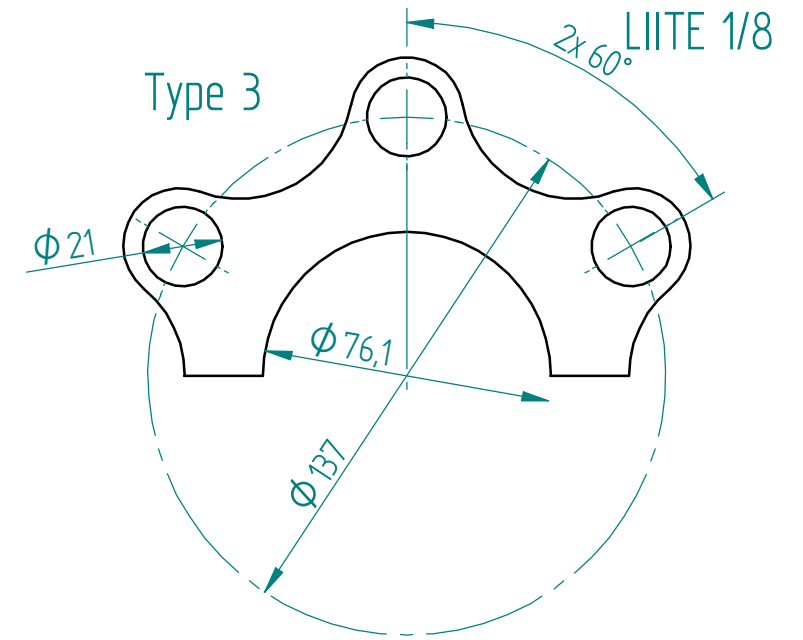
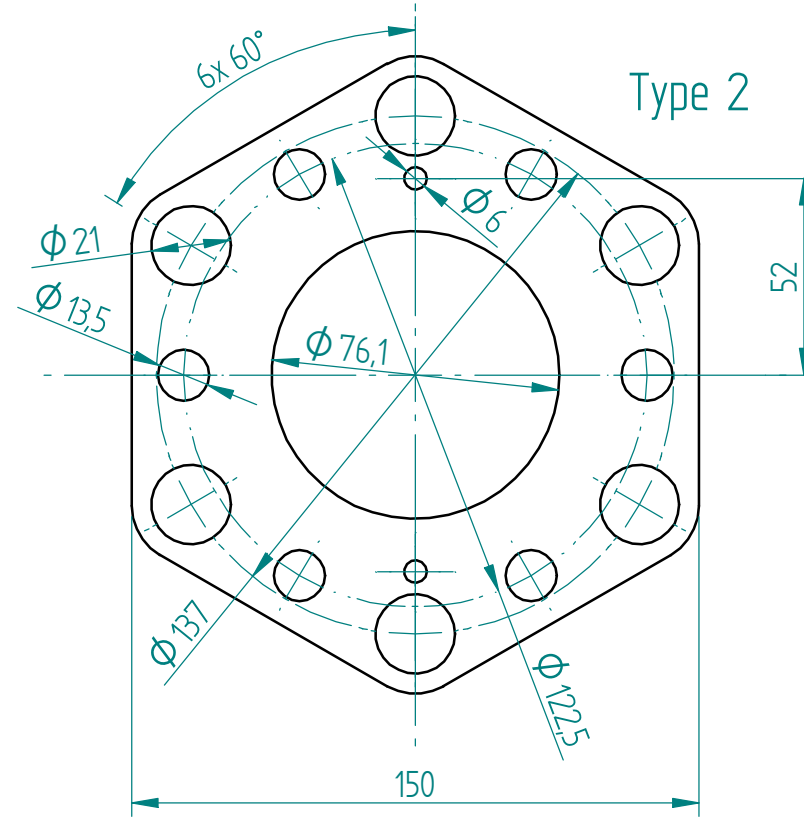
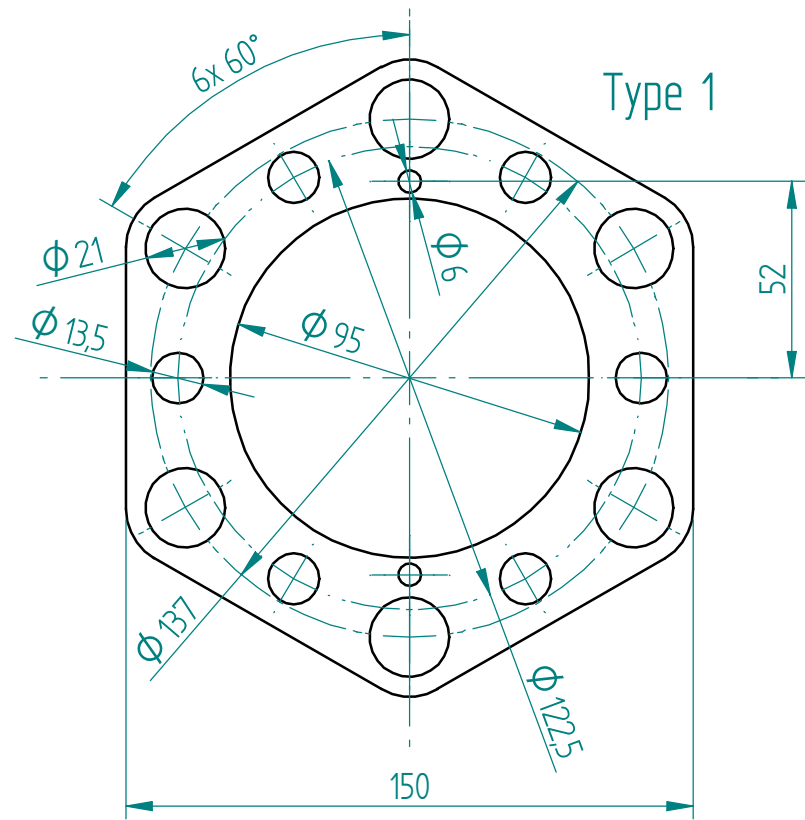


The tolerance class in accordance with ISO 2768-mK

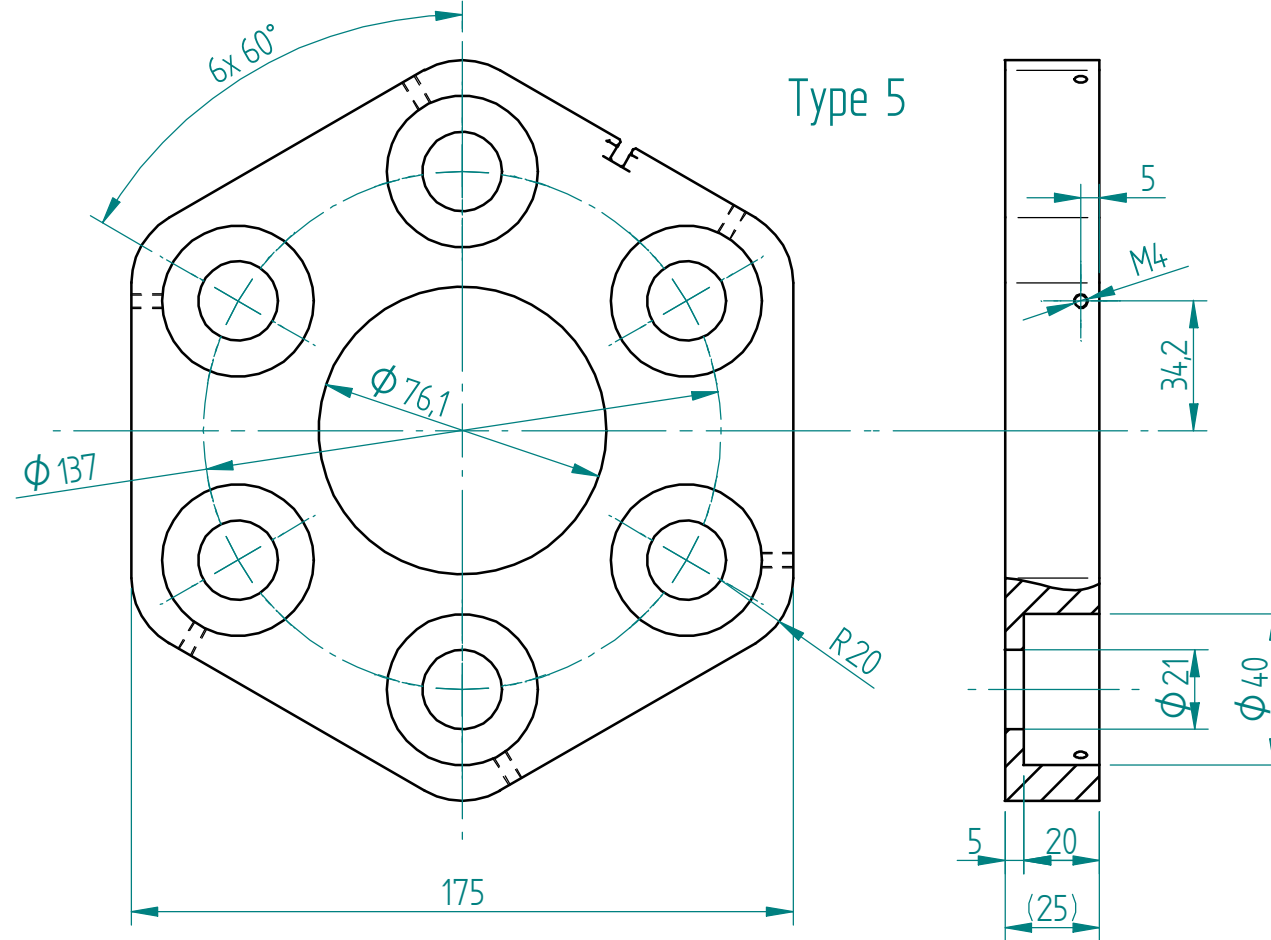
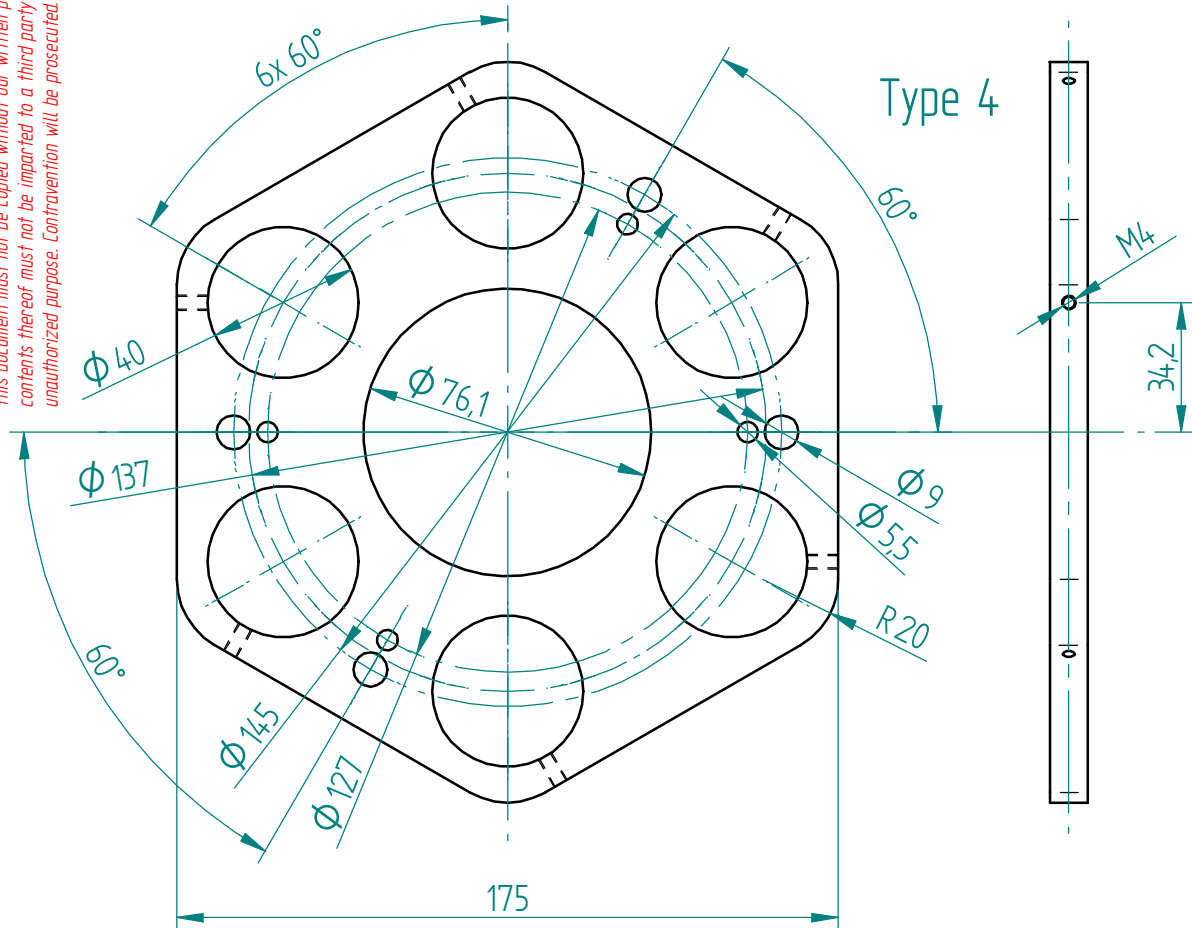
REV. IND	REVISION	APPD	YEAR WEEK

BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-07	REV IND
			SHEET 7/16 CONT

This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.



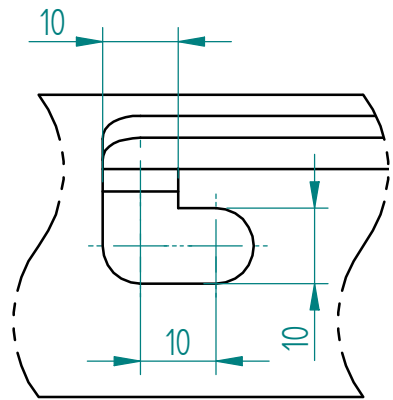
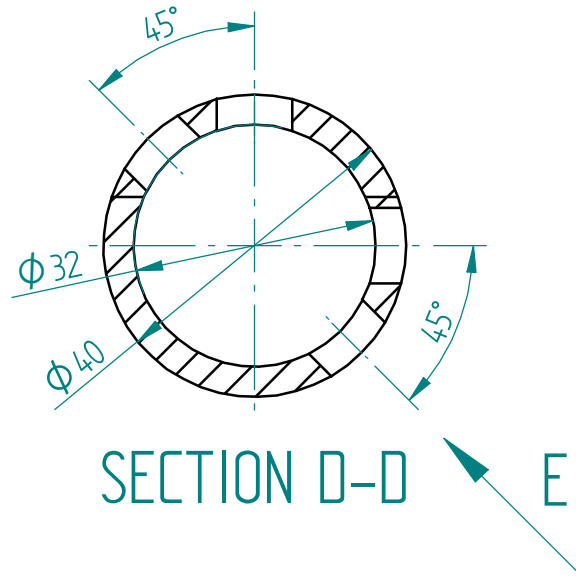
NOTE: Sharp outside edges of all parts shall be rounded.



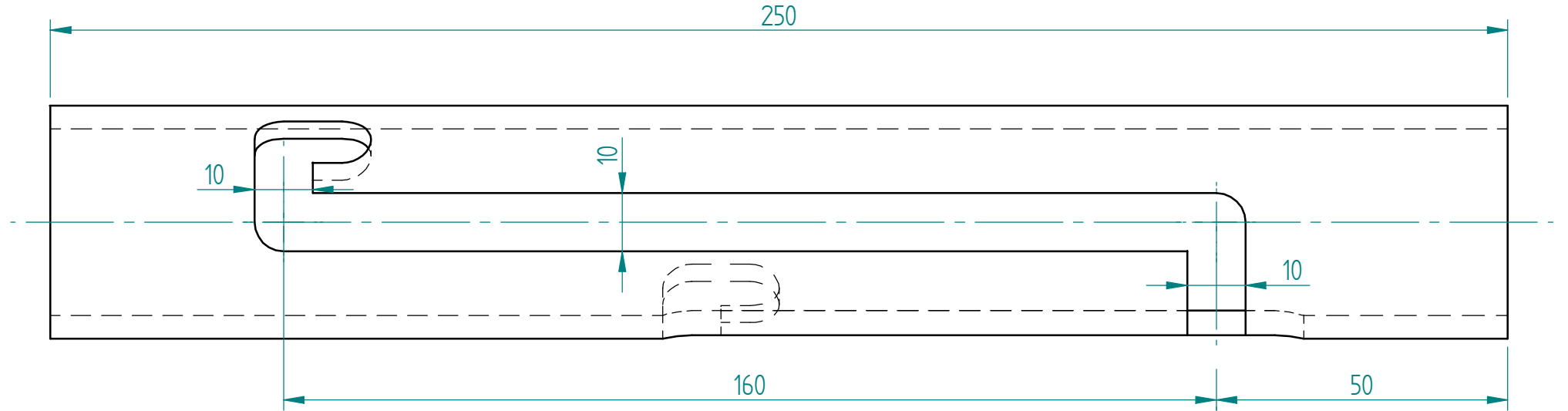
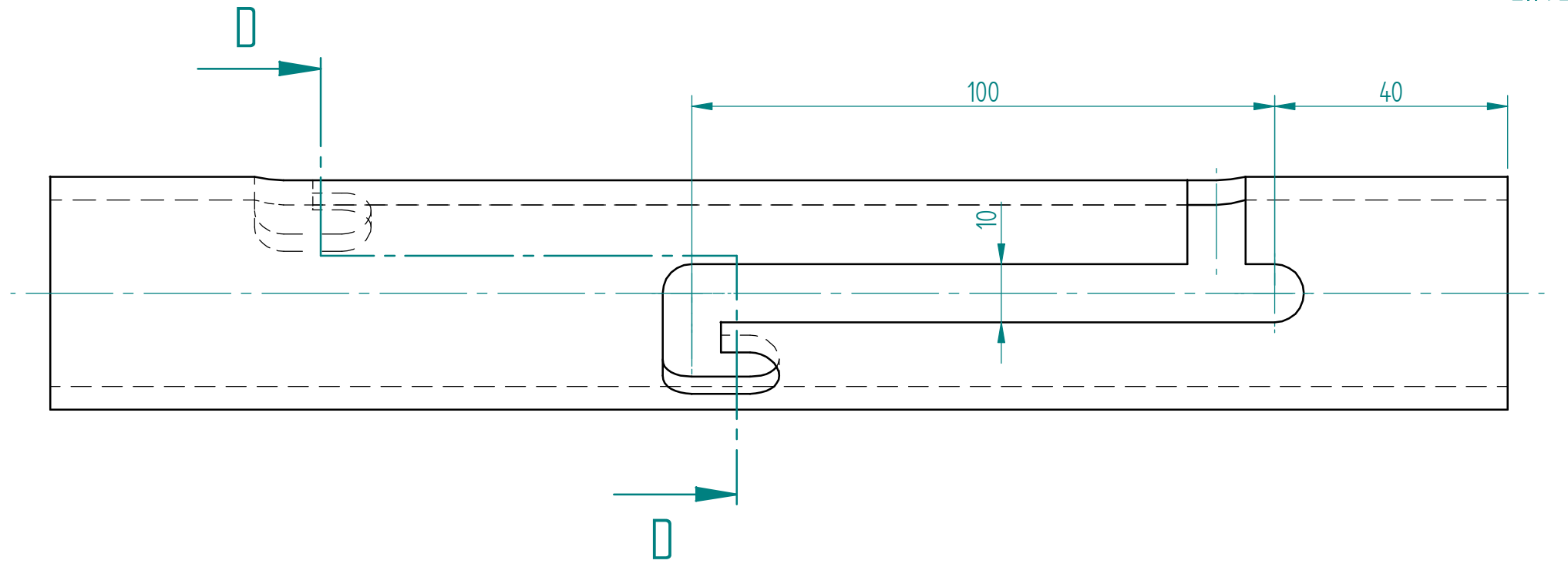
The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPO	YEAR	WEEK

BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
metso		K00270-08	REV IND SHEET 8/16 CONT



VIEW E

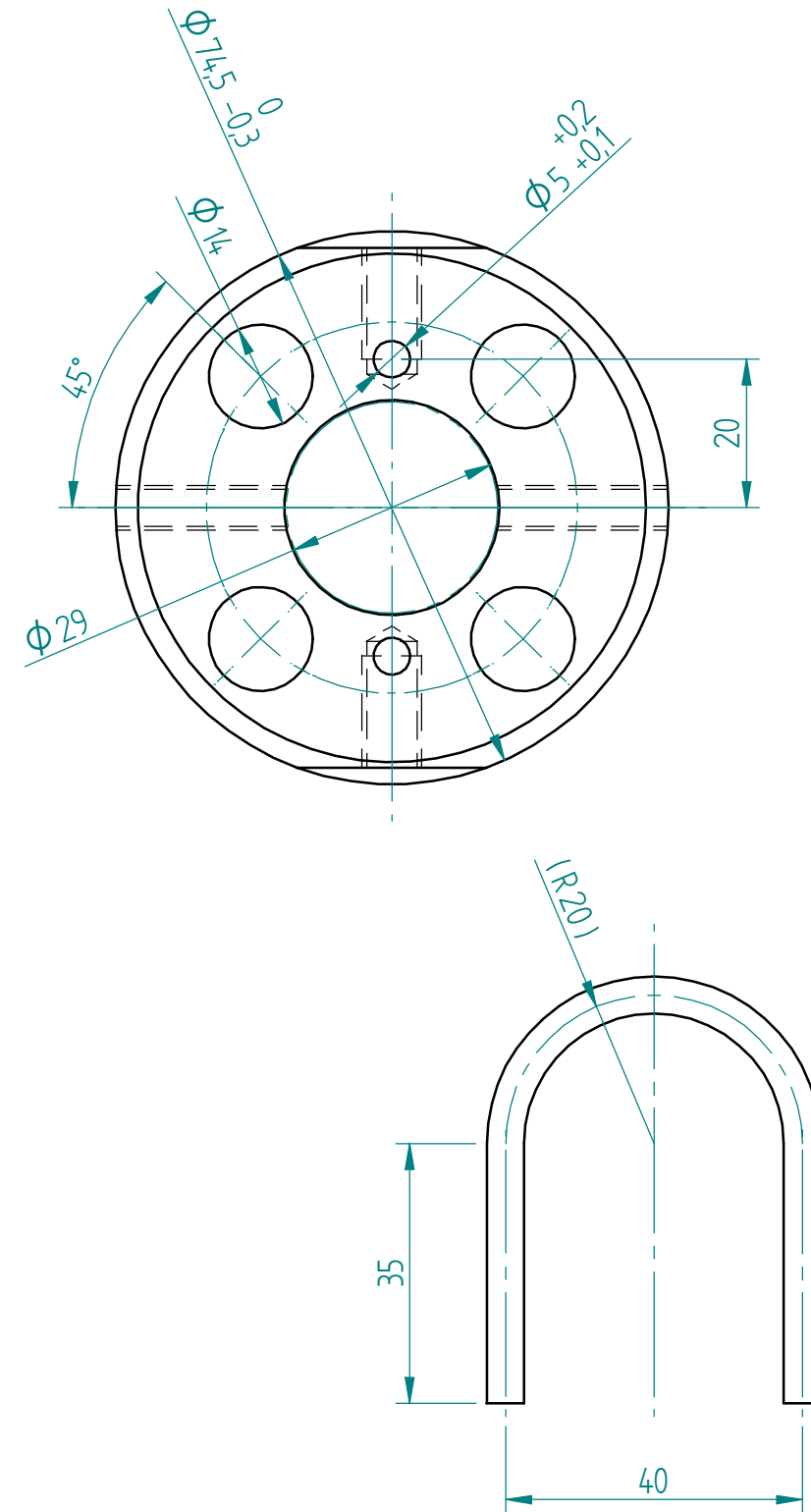
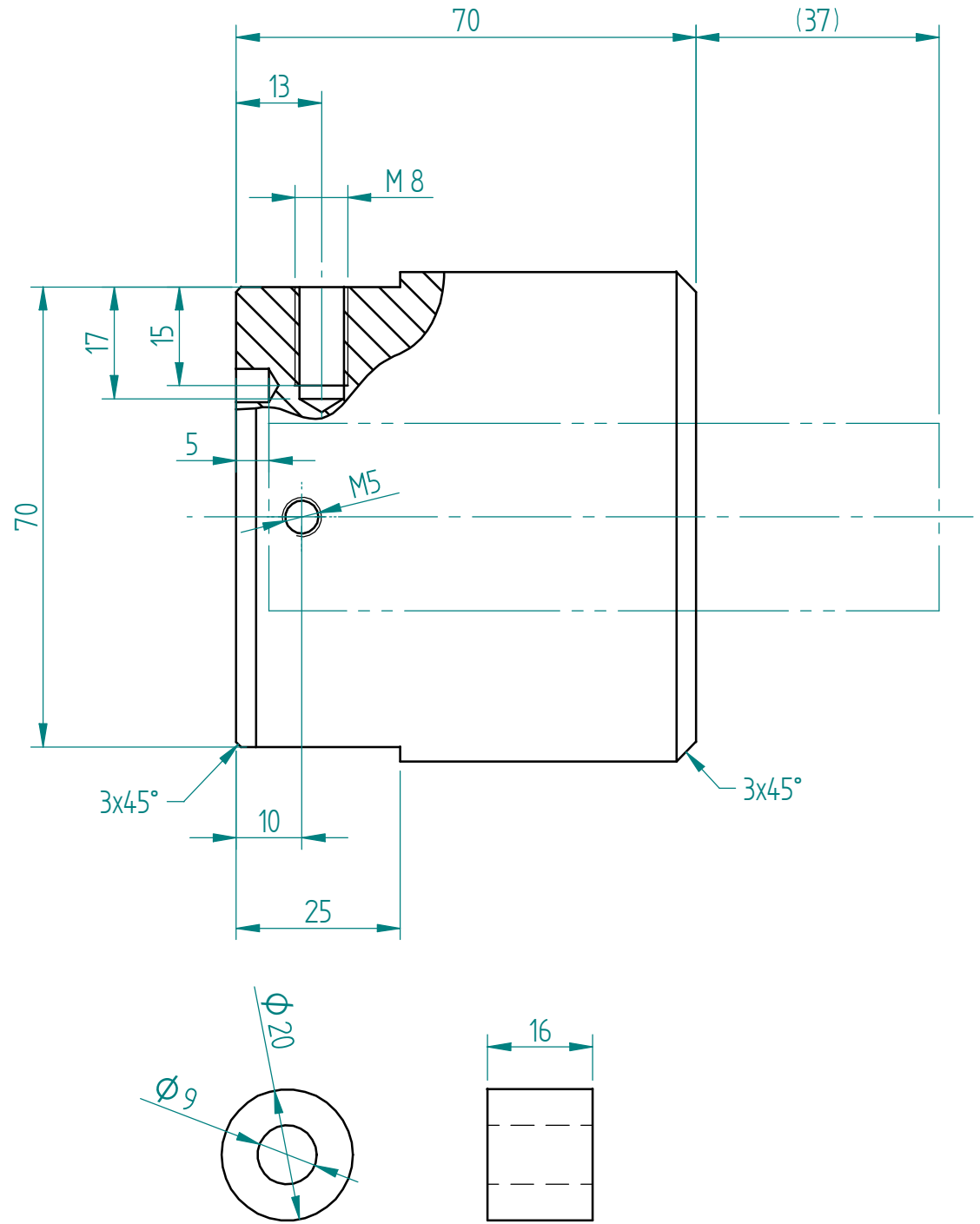


This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party, nor be used for any unauthorized purpose. Contravention will be prosecuted.

The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPD	YEAR WEEK

BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-09	REV IND
			SHEET 9/16 CONT



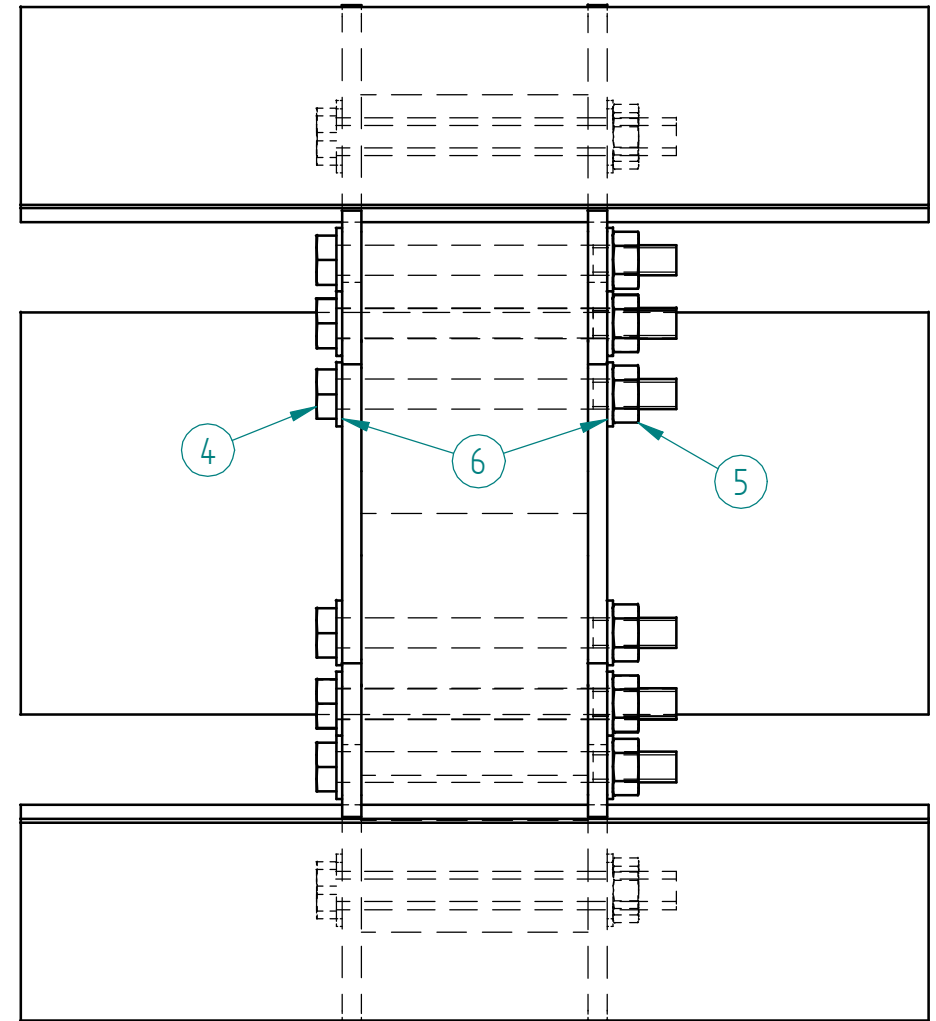
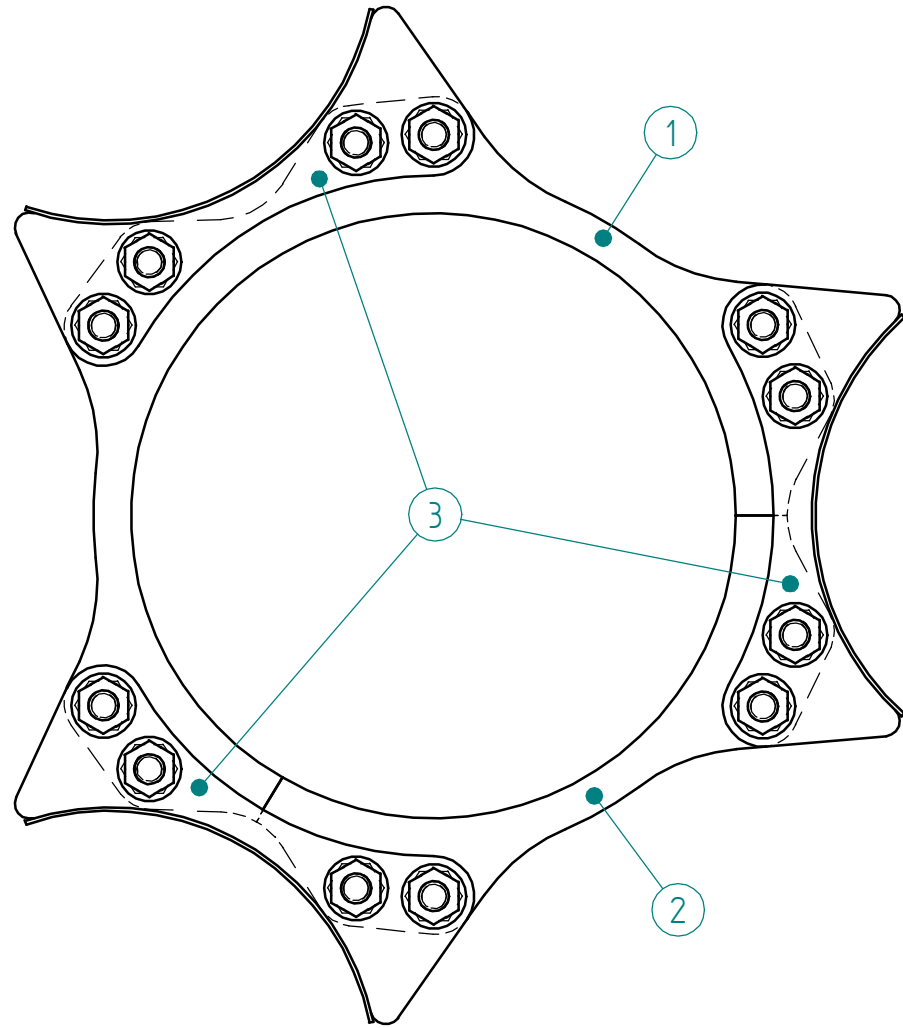
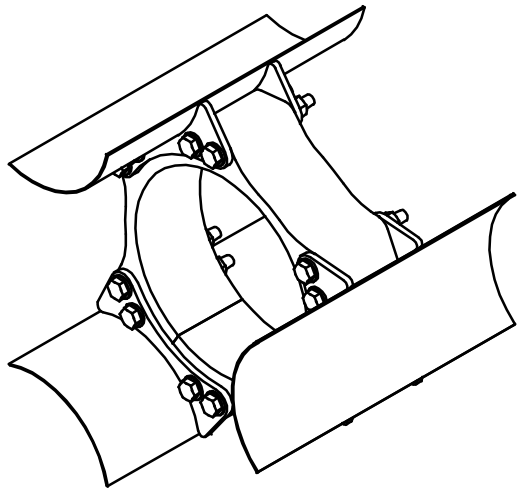
This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.

The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPD	YEAR WEEK

BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-010	REV IND
			SHEET 10/16 CONT

This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party, nor be used for any unauthorized purpose. Contravention will be prosecuted.



Note: Support shall be assembled surround with the main frame. Can't be installed in place, if assembled beforehand

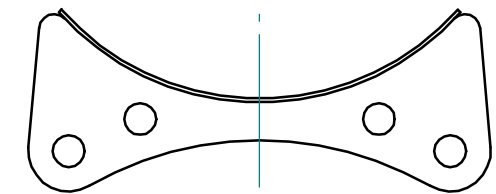
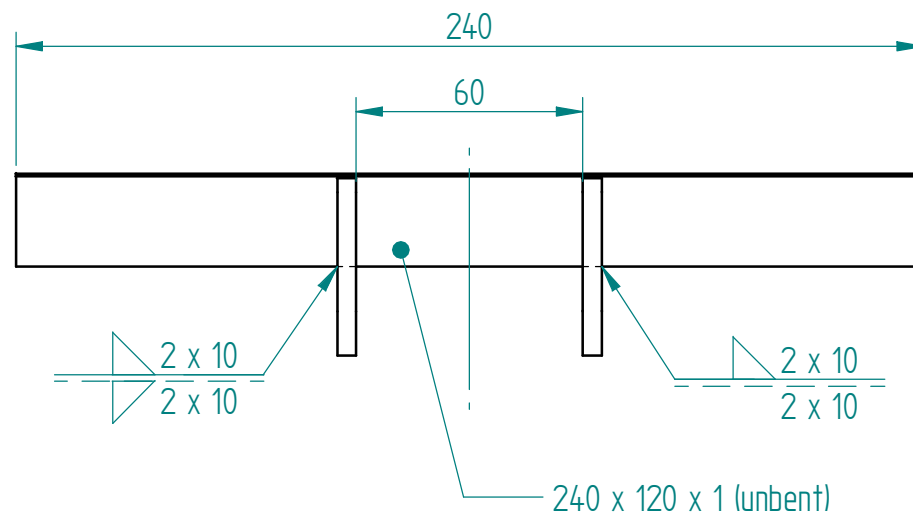
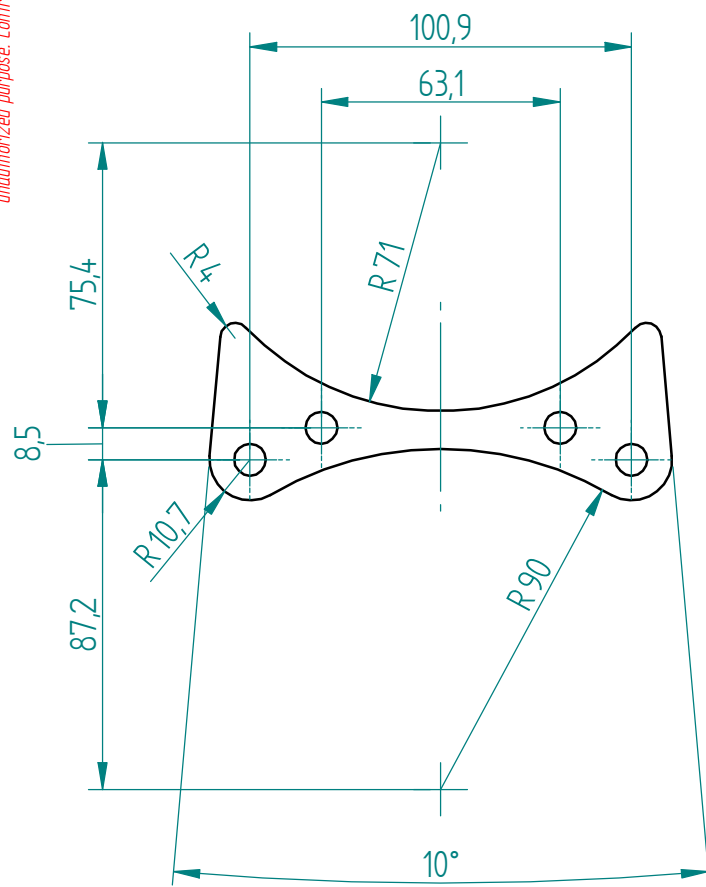
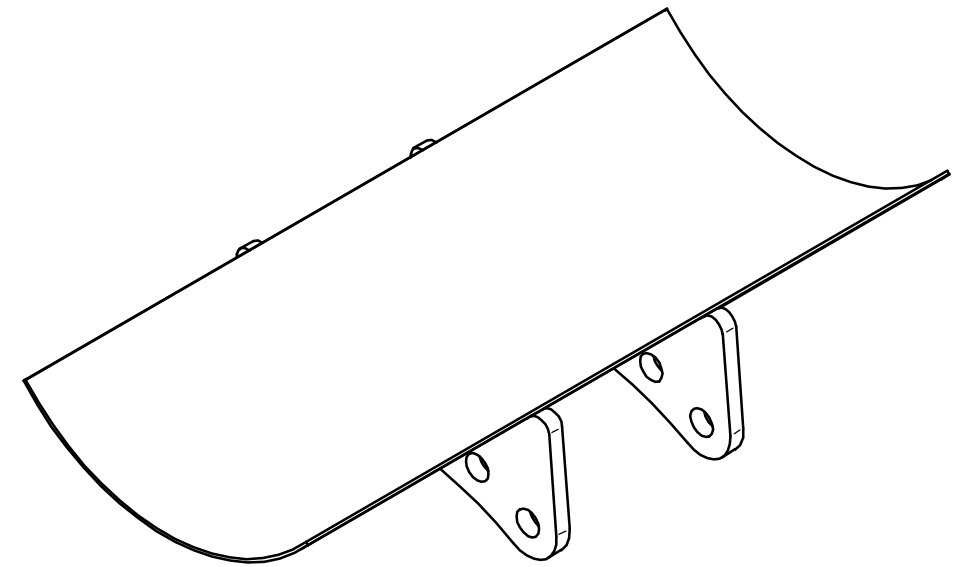
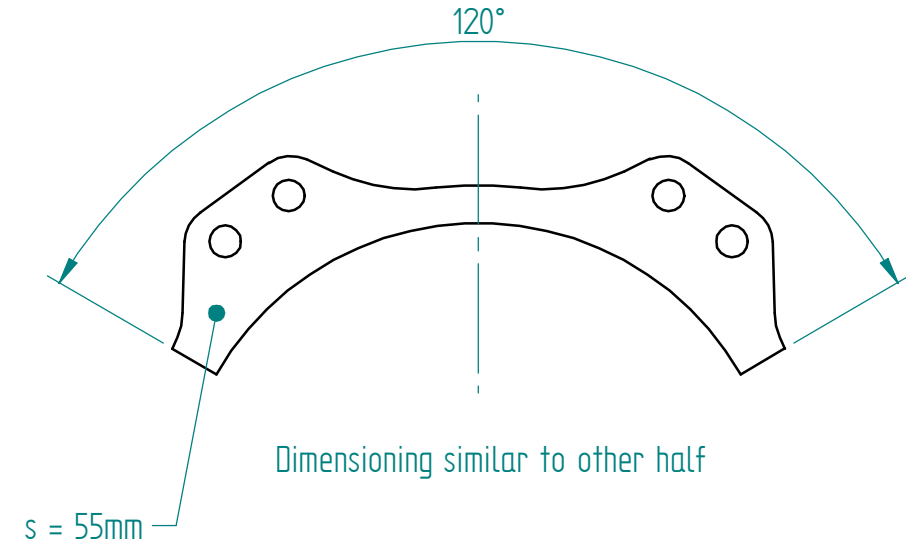
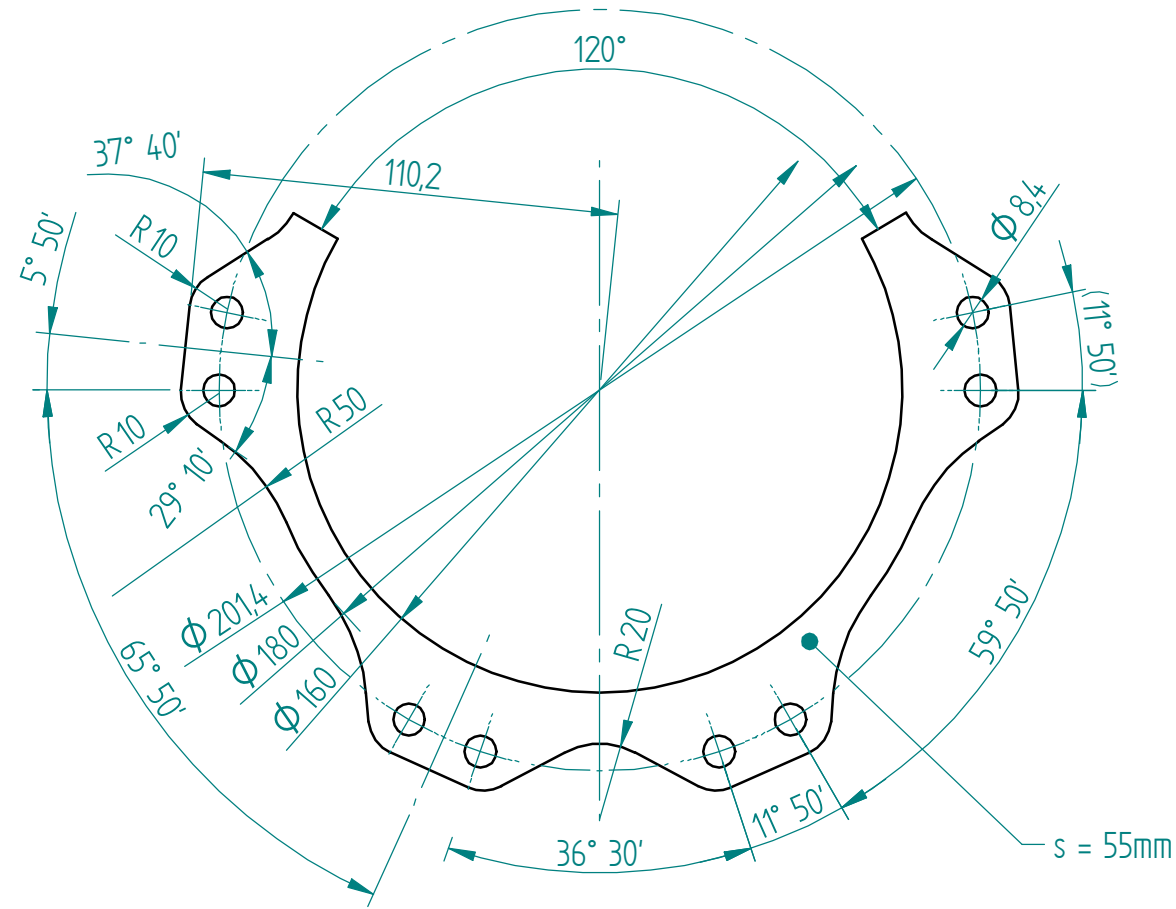
Item no.	Reference	Description	Material	Quantity
6	DIN 125	M8 flat washer	A2	24
5	DIN 934	M8	A2	12
4	DIN 931	M8 x 90	A2	12
3	K00270-012	Float support	AISI 306 or 314	3
2	K00270-012	Float support body, 1/3	PE-1000	1
1	K00270-012	Float support body, 2/3	PE-1000	1

The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPD	YEAR WEEK

BLANK	ISSUE BY DEPT	MM/DD/YY	DESCRIPTION (ENGLISH)	ASSEMBLY DRAWING
		08/30/05	Interchange tool	
DRAWING CHECKED BY	DRAWN BY		DESCRIPTION (FINNISH)	
	JEL		Vaihtotyökalu	
			K00270-011	REV IND SHEET 11/16
				CONT

This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.

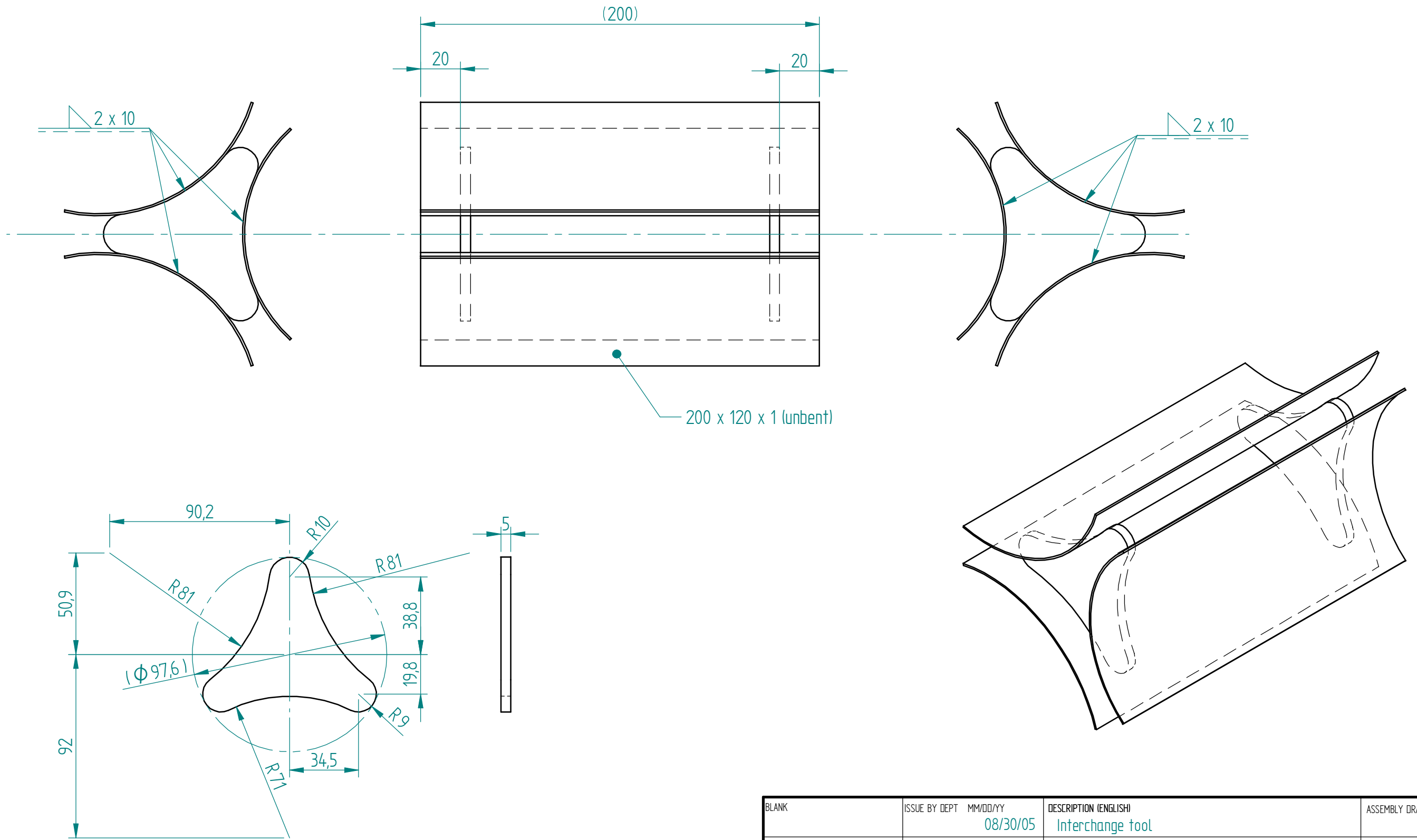


The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPO	YEAR WEEK

BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-012	REV IND
			SHEET 12/16 CONT

This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party, nor be used for any unauthorized purpose. Contravention will be prosecuted.

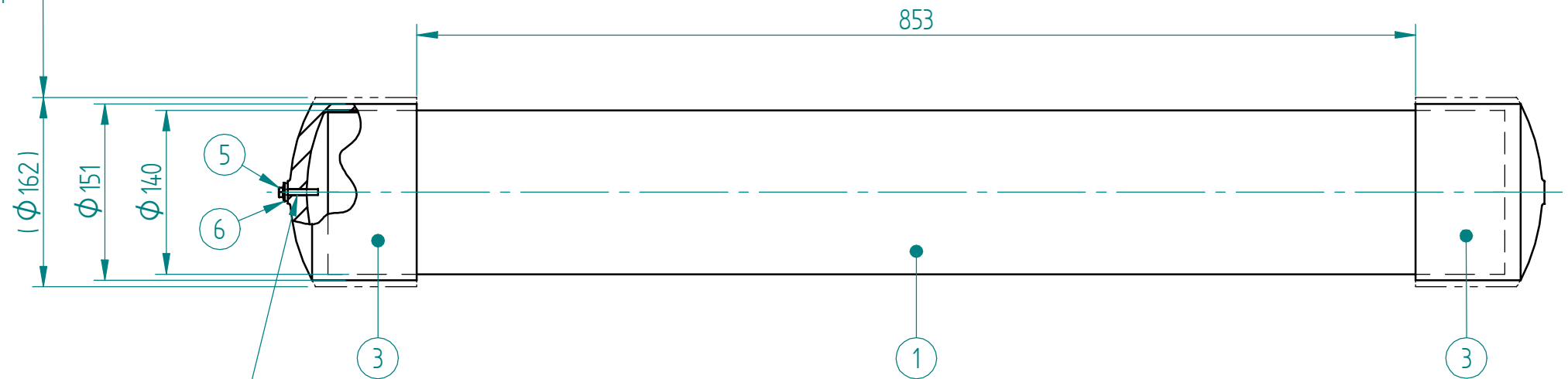


The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPD	YEAR WEEK

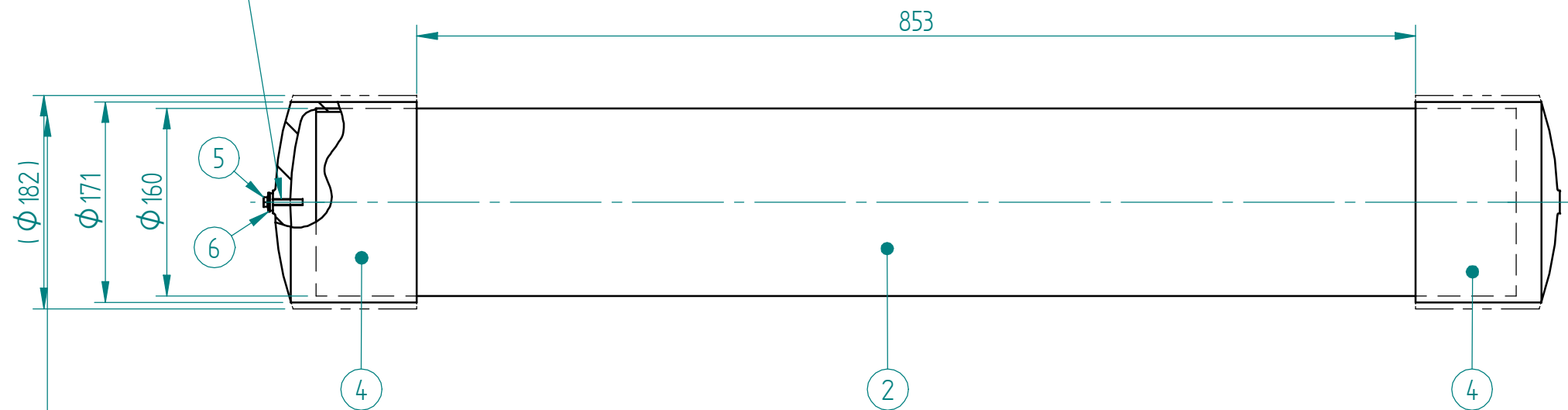
BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-013	REV IND SHEET 13/16 CONT

Cap outside diameter at both ends machined to $\phi 151$



Note: M5 hole shall be added to the other end

NOTE: use Griffon 100-UNI for glueing the caps



Cap outside diameter at both ends machined to $\phi 171$

6		Bonded washer $\phi 4,8 \times \phi 16$	A2+EPDM	2
5	DIN 933	M5 x 30	A2	2
4		cap for $\phi 160$ pipe	PVC	2
3		cap for $\phi 140$ pipe	PVC	2
2		pipe $\phi 160 \times 1,8 \times 1005$	PVC	1
1		pipe $\phi 140 \times 1,8 \times 1025$	PVC	1
Item no.	Reference	Description	Material	Quantity

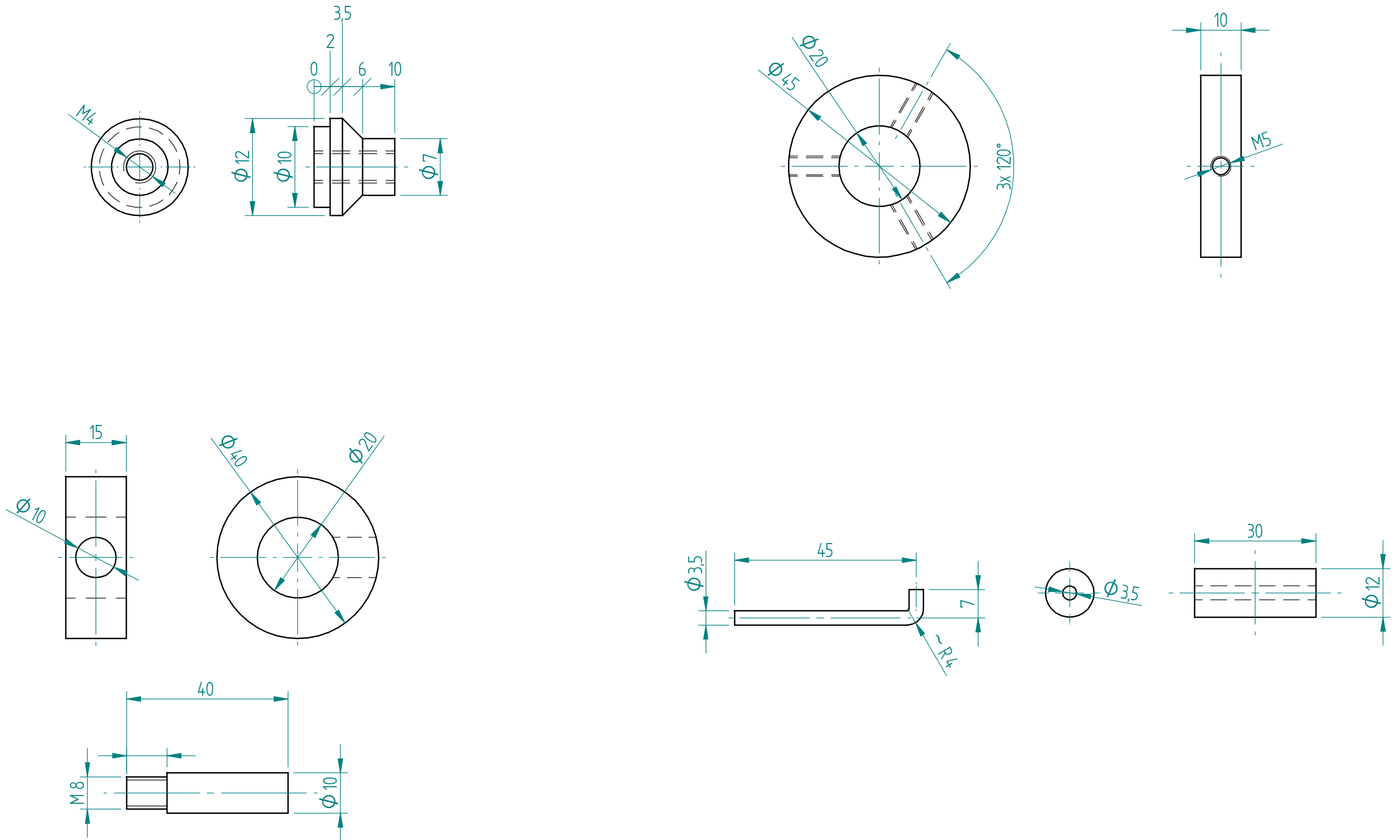
The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPO	YEAR WEEK

BLANK	ISSUE BY DEPT	MM/DD/YY	DESCRIPTION (ENGLISH)	ASSEMBLY DRAWING
		08/30/05	Interchange tool	
DRAWING CHECKED BY	DRAWN BY		DESCRIPTION (FINNISH)	
	JEL		Vaihtotyökalu	
			K00270-014	REV IND SHEET 14/16 CONT

This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.

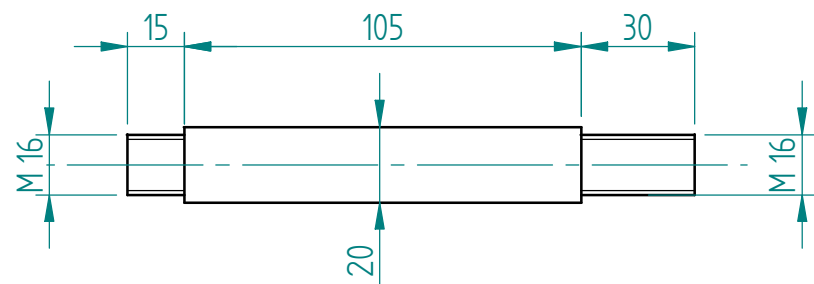
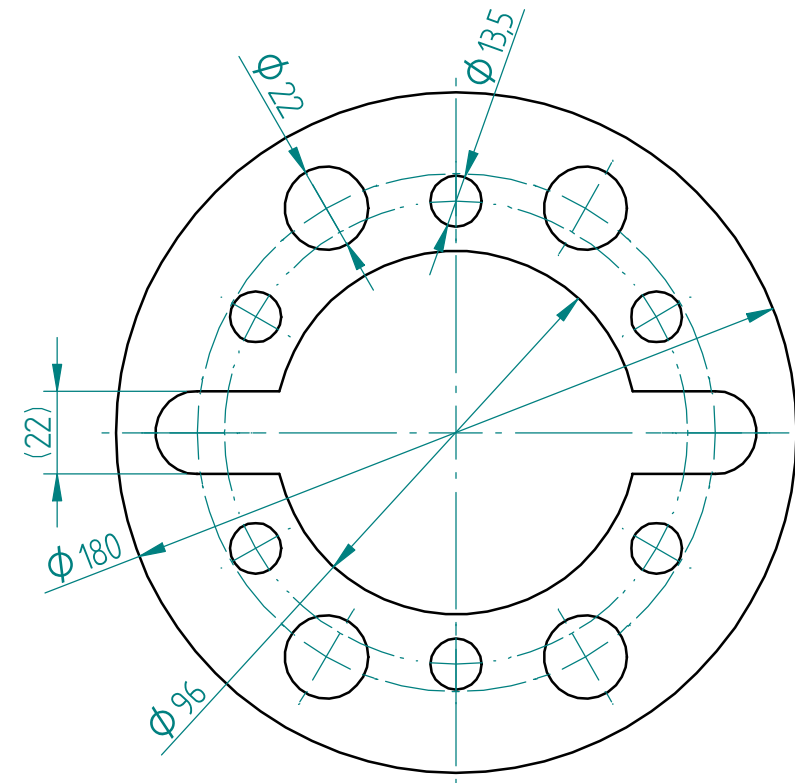
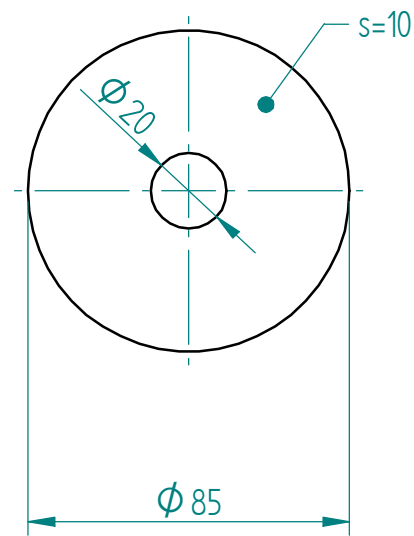
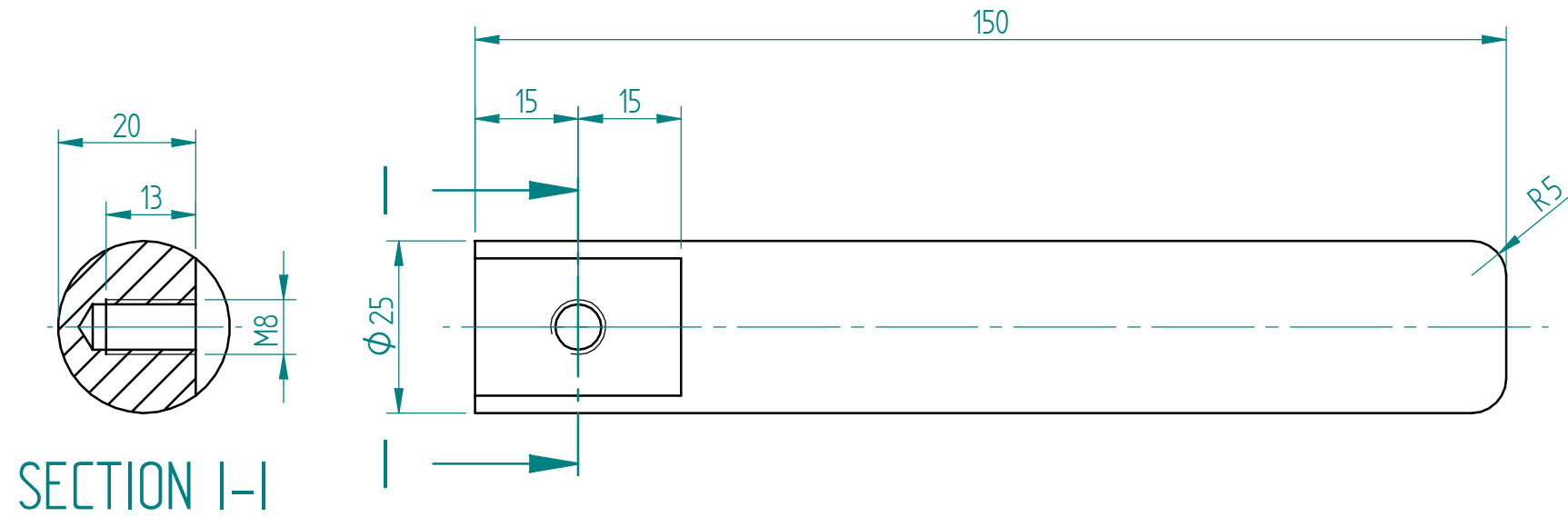
This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.



The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPD	YEAR WEEK

BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-015	REV IND
			SHEET 15/16 CONT



SECTION I-I

The tolerance class in accordance with ISO 2768-mK

REV. IND	REVISION	APPD	YEAR WEEK

BLANK	ISSUE BY DEPT MM/DD/YY 08/30/05	DESCRIPTION (ENGLISH) Interchange tool	ASSEMBLY DRAWING
DRAWING CHECKED BY	DRAWN BY JEL	DESCRIPTION (FINNISH) Vaihtotyökalu	
		K00270-016	REV IND SHEET 16/16 CONT

This document must not be copied without our written permission, and the contents thereof must not be imparted to a third party nor be used for any unauthorized purpose. Contravention will be prosecuted.