

Manufacturer: Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
Type: Wheeled Loader

Technical Report

15-TAHP-EK-0087/SRH

According to ISO 3471 and OSHA 1926.1001
Earth-Moving Machinery
Roll-Over Protective Structures

1 General

- | | | |
|-----|---|--|
| 1.1 | Make: | Sanko |
| 1.2 | Type: | MST Bachhoe Loader |
| 1.3 | Name and adress of ROPS manufacturer: | Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
4.Organize Sanayi Bölgesi
83414 Nolu Cad. No:124/1
TR-Şehitkamil / Gaziantep |
| 1.4 | Name(s) of adress(es) of assembly plant(s): | Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
4.Organize Sanayi Bölgesi
83414 Nolu Cad. No:124/1
TR-Şehitkamil / Gaziantep |
| 1.5 | Name and address of vehicle manufacturer: | Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
4.Organize Sanayi Bölgesi
83414 Nolu Cad. No:124/1
TR-Şehitkamil / Gaziantep |

Manufacturer: Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
Type: Wheeled Loader

Test Report

1. Trademark or name of protective structure

MST Backhoe Loader

2. Name and address of manufacturer of protective structure

Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
4.Organize Sanayi Bölgesi
83414 Nolu Cad. No:124/1
TR-Şehitkamil / Gaziantep

3. Name and address of machine manufacturer

Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
4.Organize Sanayi Bölgesi
83414 Nolu Cad. No:124/1
TR-Şehitkamil / Gaziantep

4. Specifications of machine on which the tests are carried out

4.1. Trademark

MST

4.2. Type and commercial description

M642 / M644

4.3. Serial number of ROPS

Not applicable

4.4. Mass of machine fitted with ROPS

9.240 kg

5.1. General arrangement drawing of both protective structure and its attachment to the machine

Refer to drawings.

5.2. Photographs from side and rear showing mounting details

Refer to enclosure.

5.3. Brief description of protective structure including type of construction, details of mounting on the tractor, details of cladding, means of access and escape, details of interior padding, features to prevent continuous rolling and details of heating and ventilation

Roof plate thickness is 4 mm, Bottom plate thickness is 3 mm, A pillar profile is 4,5 mm, B pillar profile is 4,5 mm, C pillar profile is 4,5 mm

Manufacturer: Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
Type: Wheeled Loader

The test was performed with ROPS and machine frame members soaked to 20 °C.
Verification of specification of the charpy V-notch impact strength requirements for ROPS structural metallic members:

Sample	Energy met at -20° C (J)	Energy met at -30° C (J)
6 mm S235JR quality sheet metal	154	160
4 mm shaped profile	68	76

5.4. Dimensions

Refer to drawings.

5.5. Details and quality of materials used, standard used

Refer to drawings

6. Test results

6.1 Loading and crushing tests

Loading tests were made to the middle of the rear, right-hand side, crushing on the top.

6.2. The reference mass used for calculating energy input and crushing forces:

9.240 kg

6.3. The requirements concerning cracks or tears and the protection of the zone of clearance were fulfilled. Protective structure does not interfere to the seat.

6.4. Loading energies and crushing forces according to ISO 3471 and OSHA 1926.1001 standard

Required Energies and Forces	Required Energies and Forces	Test Loads
Lateral loading force:	55440 N	55500 N
Lateral loading energy:	11324 J	11400 J
Vertical load force	181196 N	181392 N
Longitudinal load force:	44352 N	44400 N

6.5. Final permanent deflection measured after each the test

See enclosure for graphs.

7. Report number

Refer to headers.

8. Equipment for measuring and testing

Parameter of the test area

22 °C and %50 Humidity

Manufacturer: Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
Type: Wheeled Loader

9. Calibration Equipments

Test Instrument	Type	Manufacturer	ID - No.	
Loadcell	KHS125-200-AFB	MAG-BIAS	312011	☒
Loadcell	20t	PULSE	HT1 20319	☐
Loadcell	20t	PULSE	HT1 20318	☐
Loadcell	HT1W	PULSE	3028H71	☐
Loadcell	HT5M	PULSE	2910 HT1	☐
Accelometer	--	--	5189683	☐
Accelometer	--	Dytran	--	☒
Accelometer	--	Dytran	--	☒

10. Place and date of testing

BIAS Test Sistemleri
İkitelli Organize Sanayi Bölgesi
Metal İş Sanayi Sitesi 5.Blok No:57-59
34306 Başakşehir / İstanbul (TURKEY) 01.06.2015

11. Final Confirmation

As the result of inspections of Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş. company's sample seat, it has been confirmed that the sample vehicle fulfilled the requirements related to the TS EN ISO 3471 as given.

This report can not be multiplied without written approval of TÜV AUSTRIA.

This technical report consists of 8 pages.

İstanbul

12.07.2015

Recognized Expert
Eren AKDAĞ

Manufacturer: Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
Type: Wheeled Loader

Test Photos and Graphs



(Lateral Position)



(Vertical Position)

Revizyon Tarihi/Revision-Date:	0 / 09.01.2014	Döküman Numarası /Document No:	TUV-FRM-ATR-TUR-110	Sayfa/Page: 5 of 8
--------------------------------	----------------	-----------------------------------	---------------------	--------------------

Test Report
No.: 15-TAHP-EK-0087/SRH
D-Nr.: 19038/0000

TÜV AUSTRIA AUTOMOTIVE GMBH
Krugerstrasse 16, A-1015 Vienna
+43/(0)1/610 91-0 | automotive@tuv.at | www.tuv.at



Manufacturer: Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
Type: Wheeled Loader



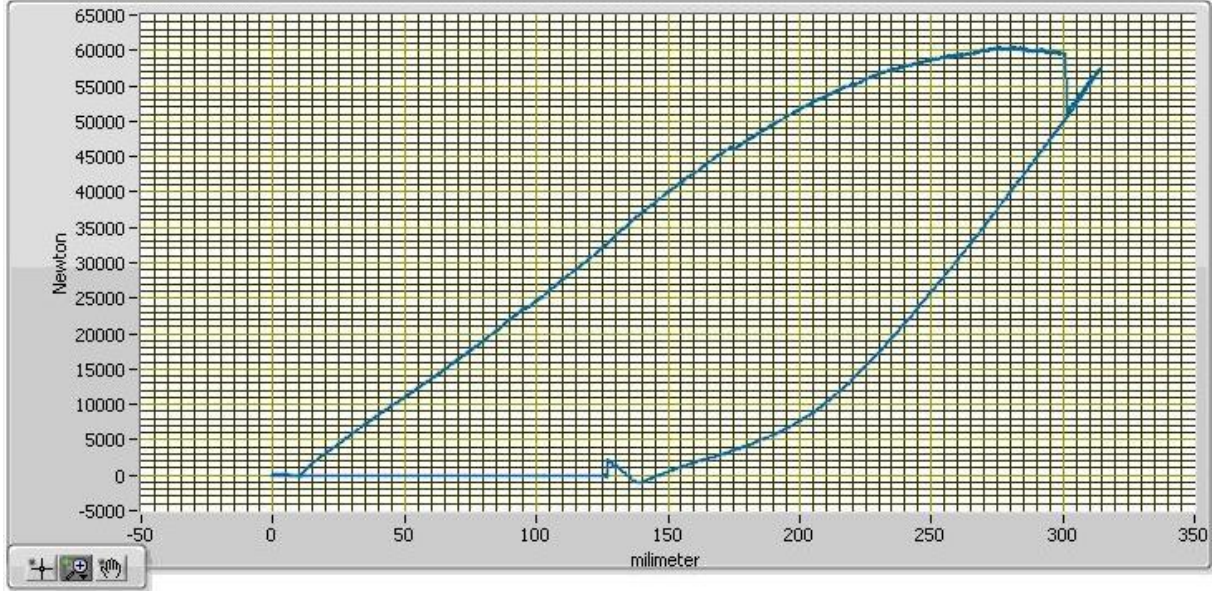
(Longitudinal Position)

Revizyon Tarihi/Revision-Date:	0 / 09.01.2014	Döküman Numarası /Document No:	TUV-FRM-ATR-TUR-110	Sayfa/Page: 6 of 8
--------------------------------	----------------	-----------------------------------	---------------------	--------------------

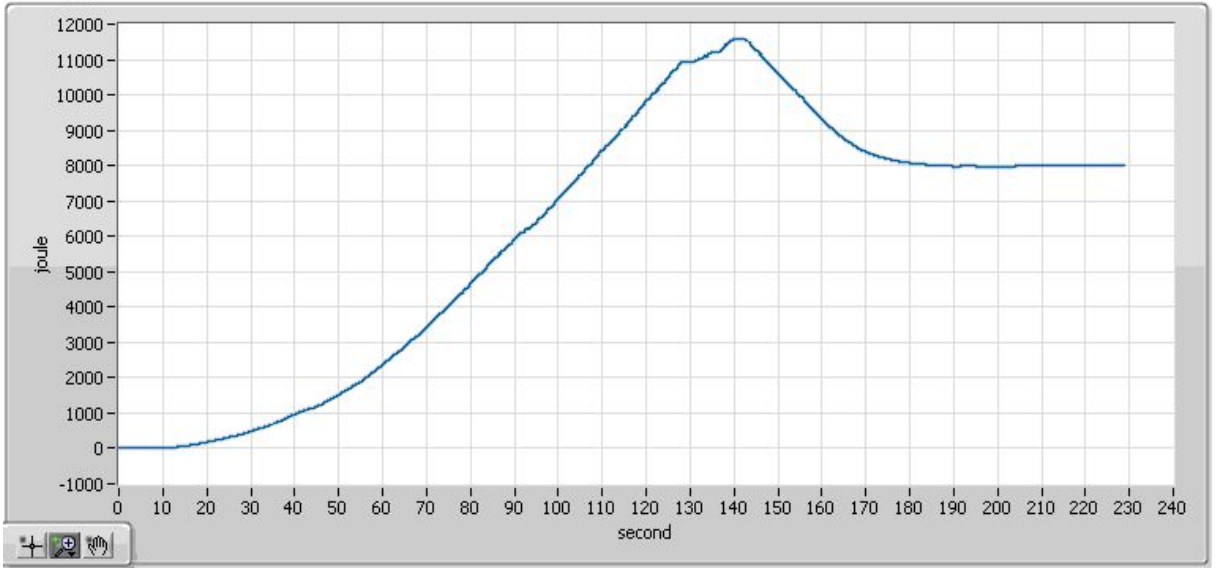
Manufacturer: Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
Type: Wheeled Loader

Lateral Position Test Graphs

Force vs. Position



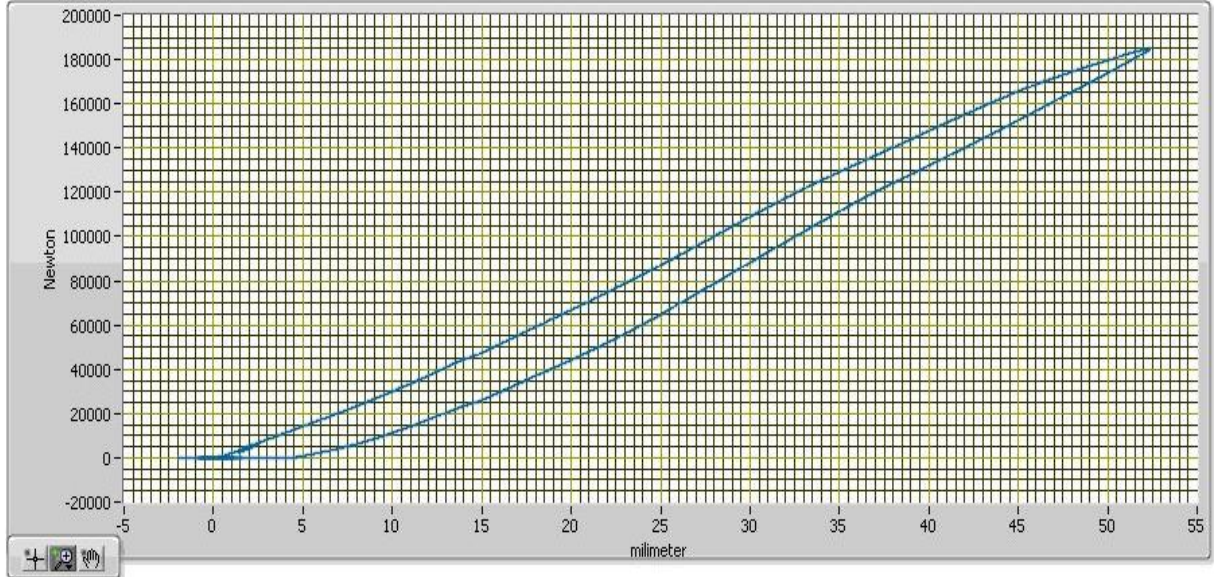
Energy Absorption



Manufacturer: Sanko Tekstil İşletmeleri Sanayi ve Ticaret A.Ş.
Type: Wheeled Loader

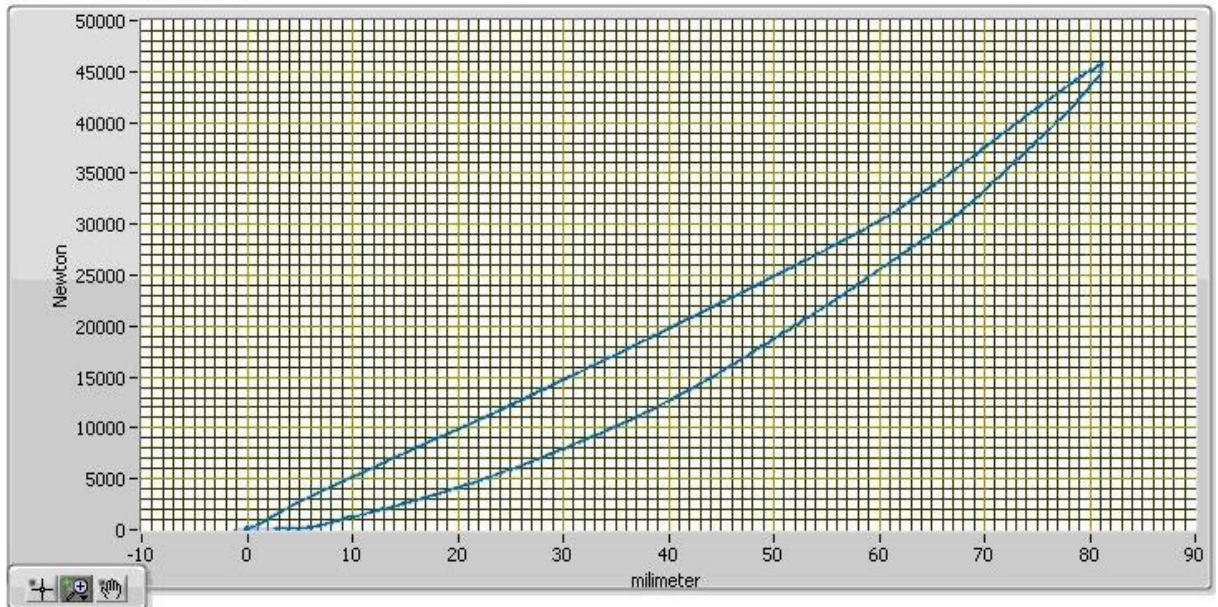
Vertical Position Test Graphs

Force vs. Position



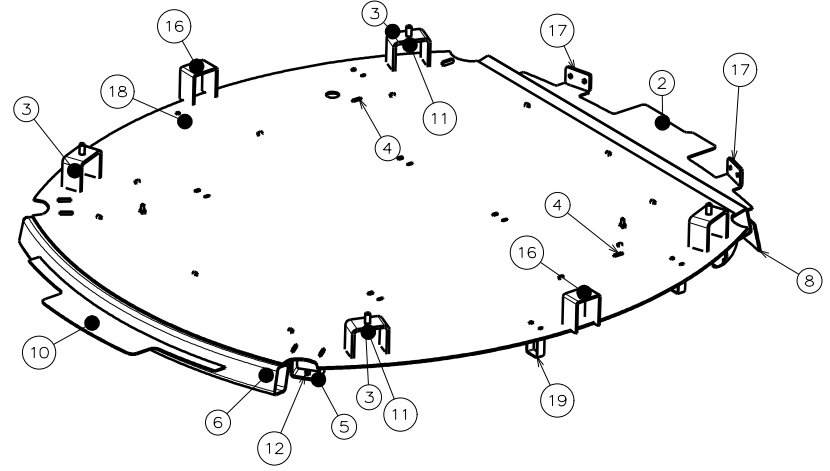
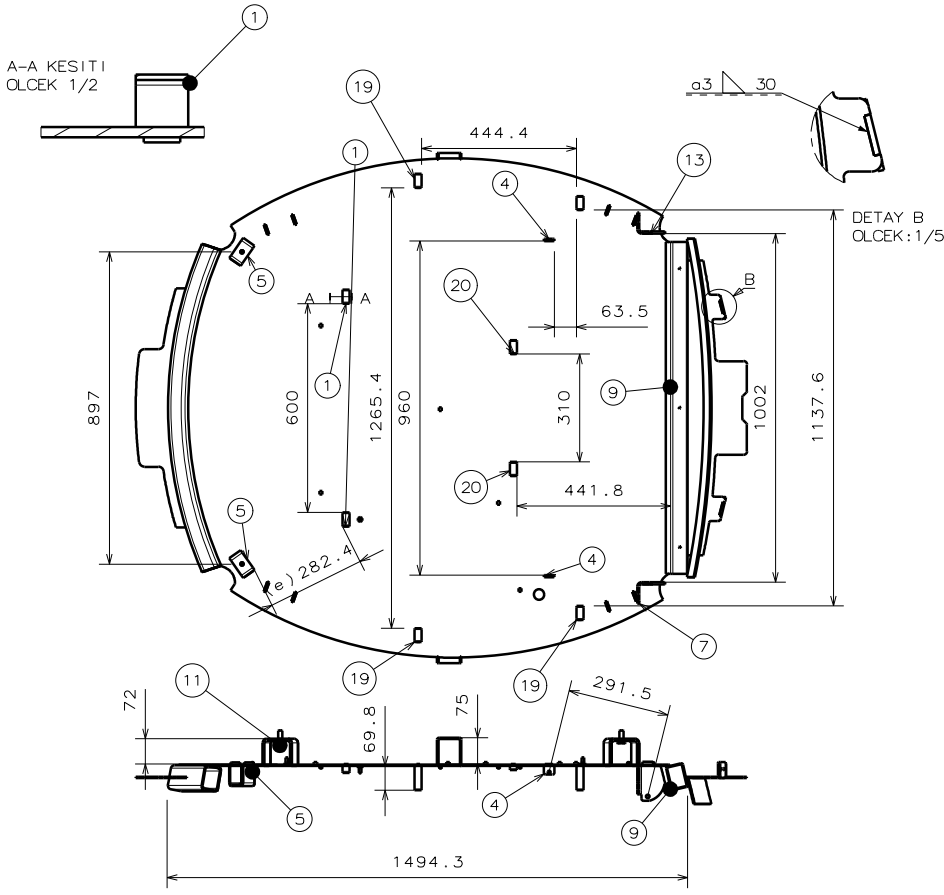
Longitudinal Position Test Graphs

Force vs. Position



REV	DEĞİŞİKLİK	TARİH	İSİM	ONAY
h	172770109,144,121,241,503,529,531 detay parçalara ve 172770064 kaynaklı kompleksine revizyon işlenmiştir.	09.06.2015	E.DOĞAN	A.TOGAY

SANKO
MST 6



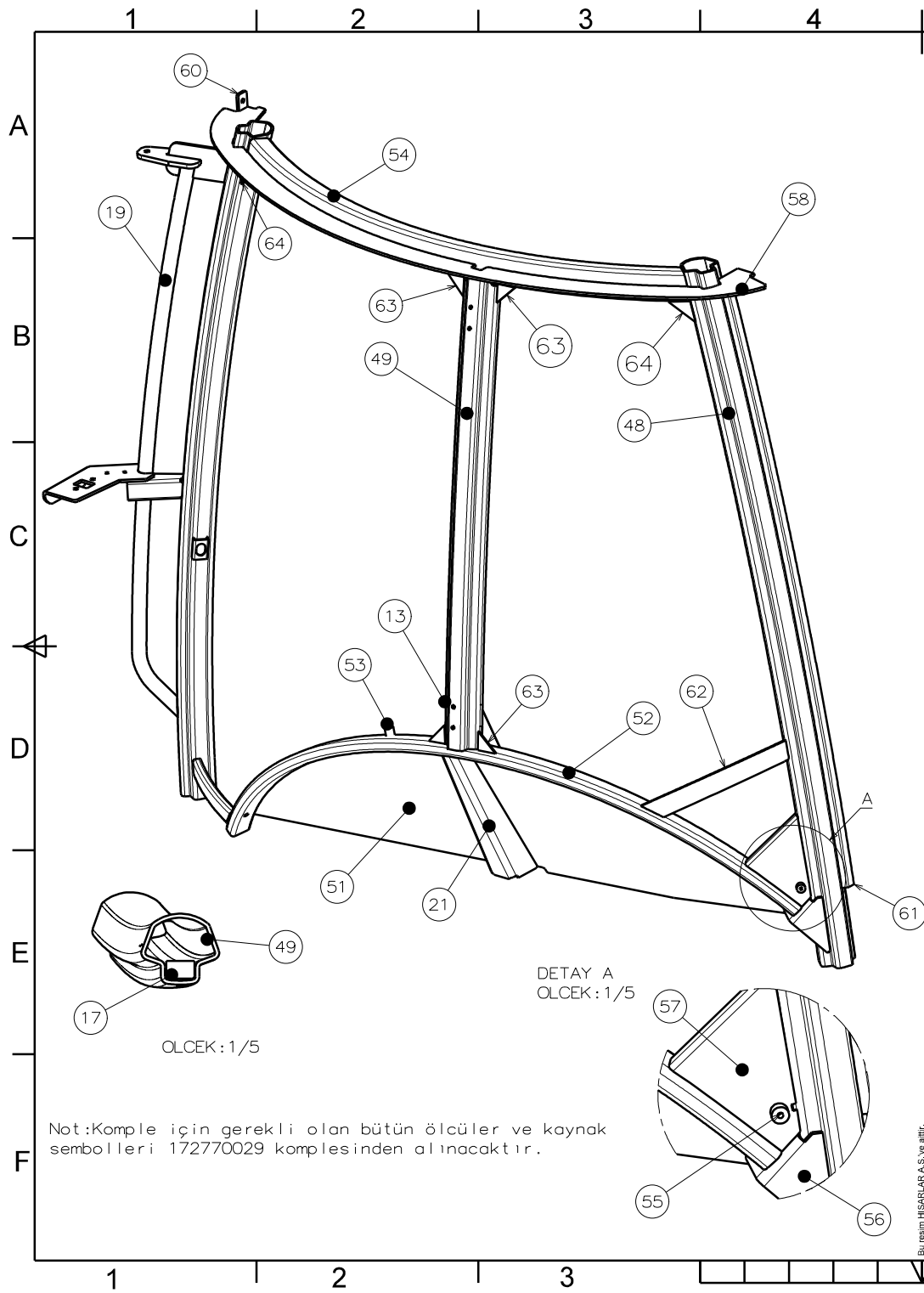
Bill of Material: 172770025

Number	Nomenclature	Quantity	Part Number	Type	Revision
2	TAVAN ARKA SACI	1	172770109	Part	
3	TAVAN DİS TRİM BRAKETİ	4	172770144	Part	
4	ARKA CERÇEVE AMORTİSORU BRAKETİ	2	172770161	Part	
5	TAVAN ÖN İC TRİM BRAKETİ	2	172770163	Part	
6	TAVAN ÖN PROFİLİ	1	172770121	Part	
7	AMORTİSOR BAĞLANTI BRAKETİ SAG	1	172770162	Part	
8	TAVAN ARKA ETEK SACI	1	172770240	Part	
9	TAVAN ARKA PROFİLİ	1	172770241	Part	
10	TAVAN ÖN SACI	1	172770503	Part	
12	M6 SOMUN	2	15013007	Part	
11	M12X35 Cıvata	4	15010313	Part	None
13	AMORTİSOR BAĞLANTI BRAKETİ SOL	1	172770191	Part	
16	TAVAN ORTA DESTEK SACI	2	172770529	Part	
17	TAVAN ARKA FAR BRAKETİ	2	172770531	Part	
1	TAVAN BAĞLANTI STOPERİ	2	172770522	Part	
19	İC DÖŞEME DESTEK PARÇASI-1	4	172770563	Part	
20	İC DÖŞEME DESTEK PARÇASI-2	2	172770564	Part	
18	TAVAN SACI KAYNAKLI KOMPLESİ	1	172770064	Assembly	

GENEL OLCU TOLERANSLARI			TARİH	İSİM	İMZA	HİSARLAR			
DOĞRUSAL	ISO 2768-c	CİZEN	13.07.2012	Emrah DOĞAN		Eskişehir-Bursa yolu 20 km. 26550 Eskişehir / TÜRKİYE Tel : 0.222.411 24 30 Faks : 0.222.411 30 01 http://www.hisarlar.com.tr E-mail : hisarlar@hisarlar.com.tr			
AÇILAR	ISO 2768-c	KONTROL	13.07.2012	Seçil ATILLA					
KONUM	ISO 2768-L	ONAY	13.07.2012	Göksel ÖZKIR					
YÜZEY KALİTESİ	*	PARÇA ADI TAVAN KAYNAKLI KOMPLESİ				RESİM NO	OLCEK	SAYFA	
YÜZEY İŞLEMİ	*					172770025	1/10	1/1	
CAD RESİM ÜZERİNDE ELLE DEĞİŞİKLİK YAPILMAZ OLCU ALINMAZ		MALZEME	MALZEME EBADI		BRUT AĞ/ADET	ADET		A3	
		*	*		*	1			

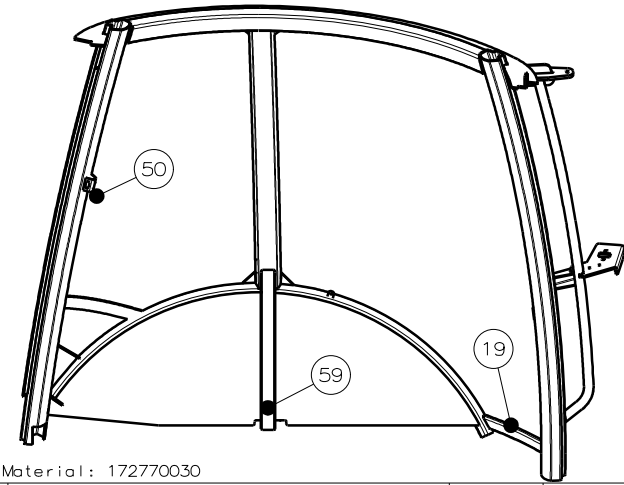
Bu resim HİSARLAR A.Ş.'ye aittir.
HİSARLAR'ın yazılımı olmadan bu resimle
tanımlanan parçaların imalatı yapılamaz, resim
kullanılarak başka bir ürün yapılamaz.
Tüm yasal hakları HİSARLAR A.Ş.'ye aittir.

CAD



REV	DEĞİŞİKLİK	TARİH	İSİM	ONAY
9	172770151,119 ve 565 numaralı parçalara revizyon işlenmiştir. 172770501 numaralı parçanın resmi oluşturulmuştur.	10.06.2015	E.DOĞAN	A.TOGAY

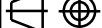
SANKO
MST 6



Bill of Material: 172770030

Number	Nomenclature	Quantity	Part Number	Type	Revision
48	SOL ARKA DIKME PROFİLİ	1	172770110	Part	
49	ORTA DİREK PROFİLİ SOL	1	172770114	Part	
50	KİTLET SACI	1	172770195	Part	
51	CAMURLUK SACI SOL	1	172770151	Part	
52	CAMURLUK PROFİLİ SOL	1	172770125	Part	
53	CAMURLUK BRAKETİ 1	1	172770172	Part	
54	KAPI ÜST PROFİLİ SOL	1	172770119	Part	
55	BRAKET_3	1	172770156	Part	
56	BRAKET_2 SOL	1	172770500	Part	
57	BRAKET_1 SOL	1	172770501	Part	
58	TAVAN YAN SACI	1	172770502	Part	
59	ORTA DİREK DESTEK PROFİLİ SOL	1	172770565	Part	
60	TAVAN ON FAR BRAKETİ	1	172770530	Part	
61	RULMAN ÇALIŞMA SACI SOL	1	172770507	Part	
62	SOL ALT CAM DESTEK SACI	1	172770284	Part	
63	ORTA PROFİL DESTEK SACI	4	172770521	Part	
64	DIKME PROFİLİ DESTEK SACI	2	172770520	Part	
21	CAMURLUK DESTEK SACI SOL	1	172770541	Part	
19	KAPI ALT PROFİLİ SOL	1	172770127	Part	
17	ORTA DİREK KAPAGI	1	172770841	Part	

Tüm yasa ihlalleri HISARLAR A.Ş.'ye aittir.

GENEL ÖLÇÜ TOLERANSLARI			TARİH	İSİM	İMZA	HISARLAR			
		CİZEN	13.08.2012	Emrah DOĞAN					
DOĞRUSAL	ISO 2768-c	KONTROL	13.08.2012	Seçil ATILLA			Eskişehir-Bursa yolu 20 km. 26550 Eskişehir / TÜRKİYE Tel : 0.222.411 24 30 Faks : 0.222.411 30 01 http://www.hisarlar.com.tr E-mail : hisarlar@hisarlar.com.tr		
ACILAR	ISO 2768-c	ONAY	13.08.2012	Göksele ÖZKIR					
KONUM	ISO 2768-L	PARÇA ADI							
YÜZEY KALİTESİ	*	SOL YAN KAYNAKLI KOMPLE				RESİM NO		ÖLÇEK	SAYFA
YÜZEY İŞLEMİ	*					172770030		1/10	1
CAD	RESİM ÜZERİNDE ELLE DEĞİŞİKLİK YAPILMAZ ÖLÇÜ ALINMAZ	MALZEME		MALZEME EBADI		BRUT AĞ/ADET	ADET		A3
		*		*		*	1		

Bu resim HISARLAR A.Ş.'ye aittir.
HISARLAR'ın yazılı izni olmadan bu resimle
ilgili hiçbir şekilde kopya, çoğaltma, yayma
veya başka amaçlarla kullanılması yasaktır.
Tüm yasal hakları HISARLAR A.Ş.'ye aittir.

A

B



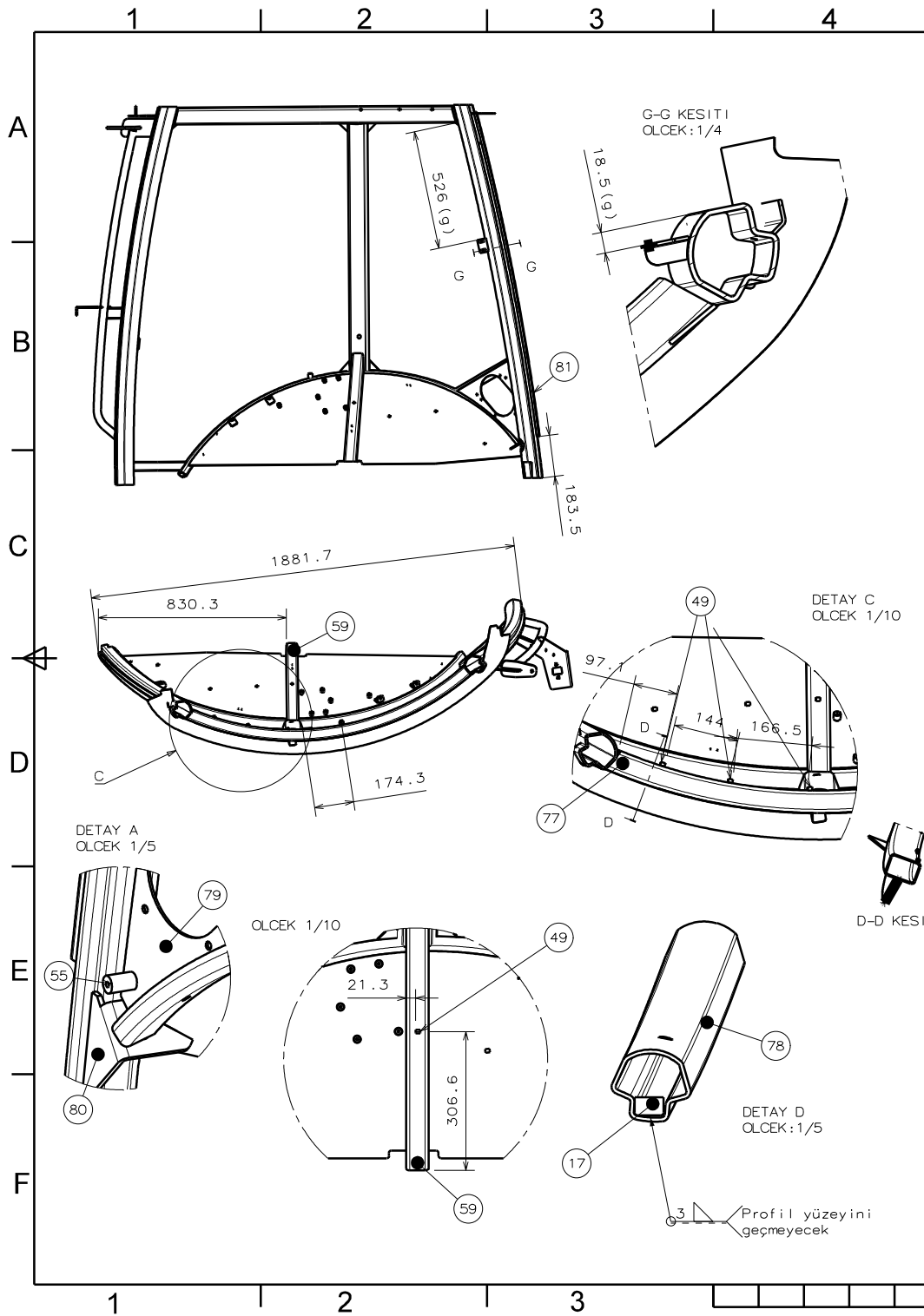
D



F

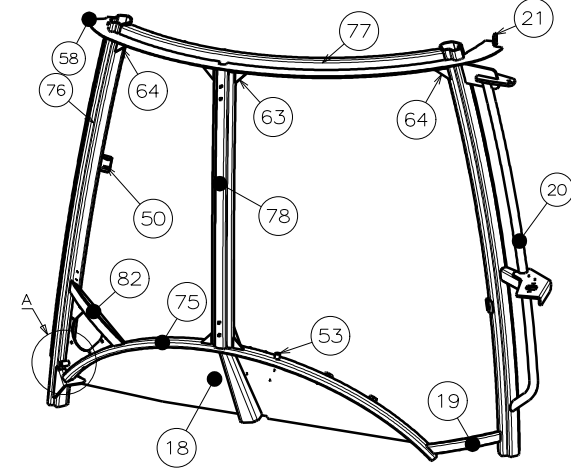
E

Bu resim HİSARLAR A.Ş.'ye aittir. HİSARLAR'ın yazılı izni olmadan bu resimle tanımlanan parçaların imalatı yapılamaz, resim



REV	DEĞİŞİKLİK	TARİH	İSİM	ONAY
h	172770154 ve 156 iptal edilmiştir. 172770612 ve 571 numaralı parçalar eklenmiştir. 172770116,120,502,530 parçaları ile 172770051 kompleksine revizyon işlenmiştir.	10.06,2015	E.DOĞAN	A.TOGAY

SANKO
MST 6



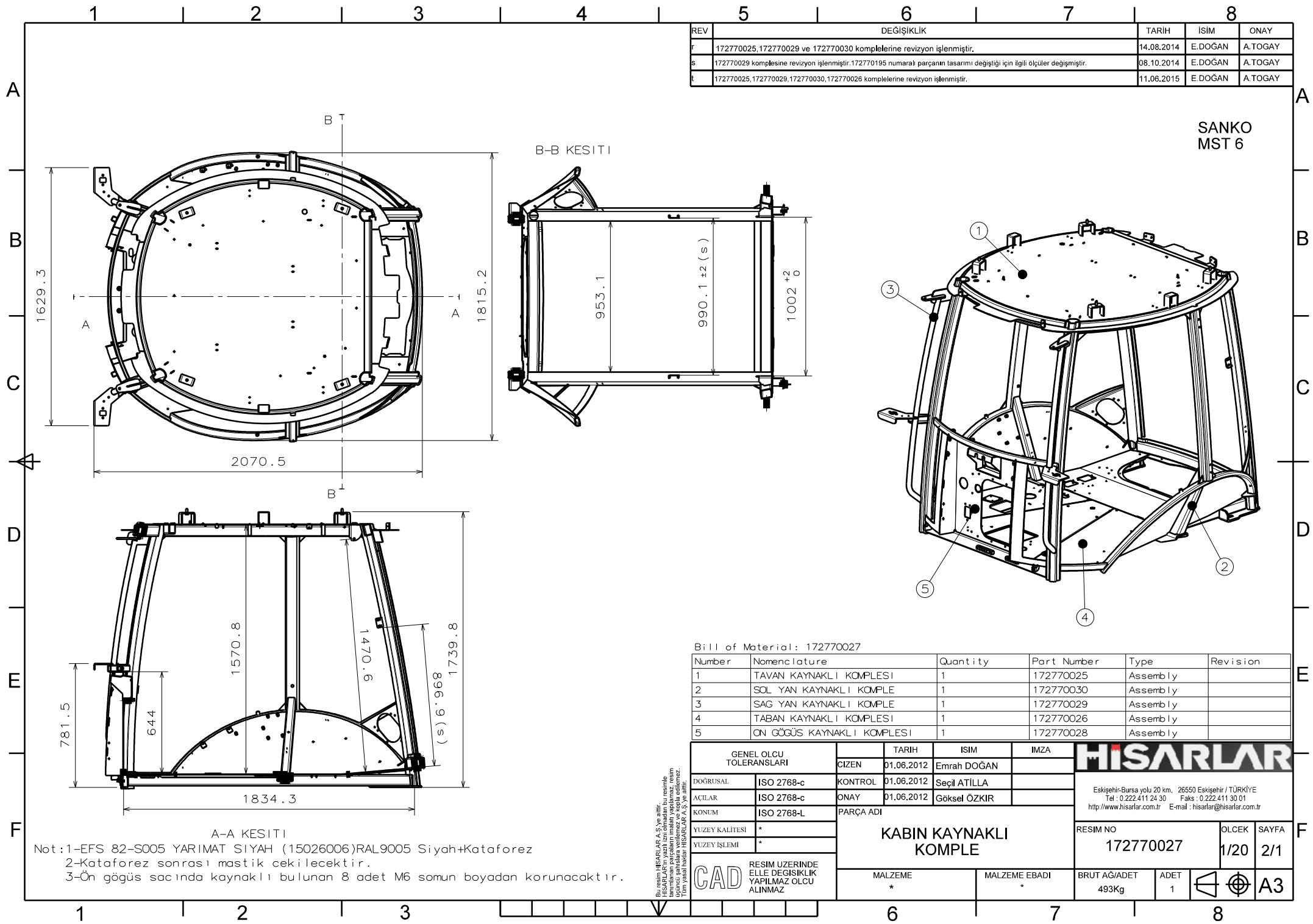
Bill of Material: 172770029

Number	Nomenclature	Quantity	Part Number	Type	Revision
75	CAMURLUK PROFİLİ SAG	1	172770124	Part	
59	ORTA DIREK DESTEK PROFİLİ	1	172770116	Part	
53	CAMURLUK BRAKETİ 1	1	172770172	Part	
76	SAG ARKA DIKME PROFİLİ	1	172770111	Part	
77	KAPI ÜST PROFİLİ SAG	1	172770120	Part	
78	ORTA DIREK PROFİLİ SAG	1	172770115	Part	
79	FİLTRE BAĞLANTI SACI	1	172770612	Part	
80	BRAKET_2 SAG	1	172770155	Part	
55	SAG CAMURLUK SOMUNU	1	172770571	Part	
58	TAVAN YAN SACI	1	172770502	Part	
50	KİTLEK SACI	1	172770195	Part	
81	RULMAN ÇALIŞMA SACI SAG	1	172770508	Part	
82	SAG ALT CAM DESTEK SACI	1	172770285	Part	
64	DIKME PROFİLİ DESTEK SACI	2	172770520	Part	
63	ORTA PROFİL DESTEK SACI	4	172770521	Part	
49	BÖNÜK	4	025-1114	Part	
17	ORTA DIREK KAPAGI	1	172770841	Part	
18	SAG CAMURLUK SACI KAYNAKLI KOMPLE	1	172770051	Assembly	
19	KAPI ALT PROFİLİ SAG	1	172770126	Part	
20	SAG ON DIKME KAYNAKLI KOMPLE	1	172770053	Assembly	
21	TAVAN ON FAR BRAKETİ	1	172770530	Part	

GENEL ÖLÇÜ
TOLERANSLARI

<

Bu resim HISARLAR A.Ş.'ye aittir. Resimdeki tüm ölçüler ve toleranslar, resim üzerindeki parçaların imalatı için geçerlidir. Resim üzerindeki ölçüler, parçaların imalatı için kullanılır. Resim üzerindeki ölçüler, parçaların imalatı için kullanılır. Resim üzerindeki ölçüler, parçaların imalatı için kullanılır.



Bill of Material: 172770027

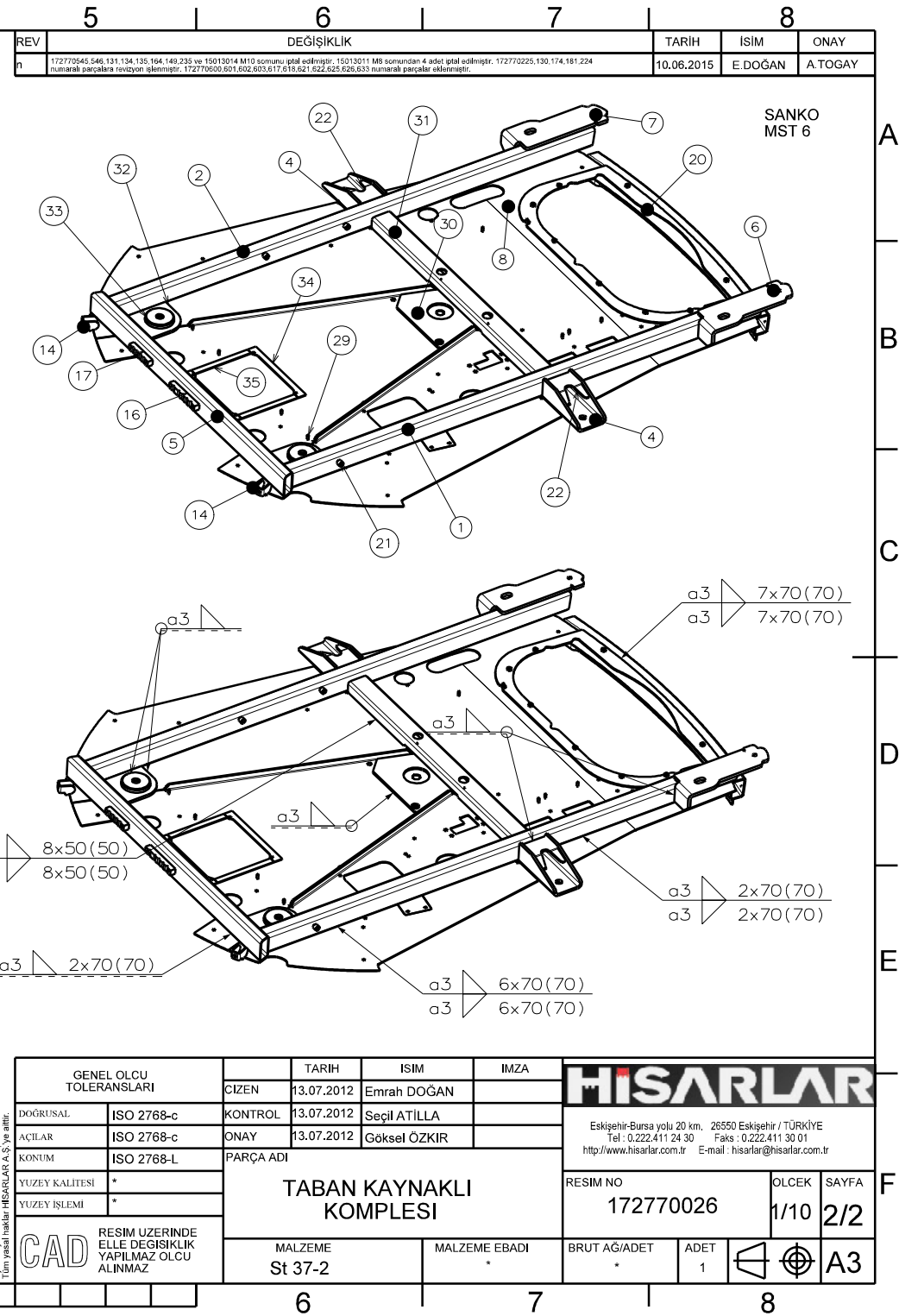
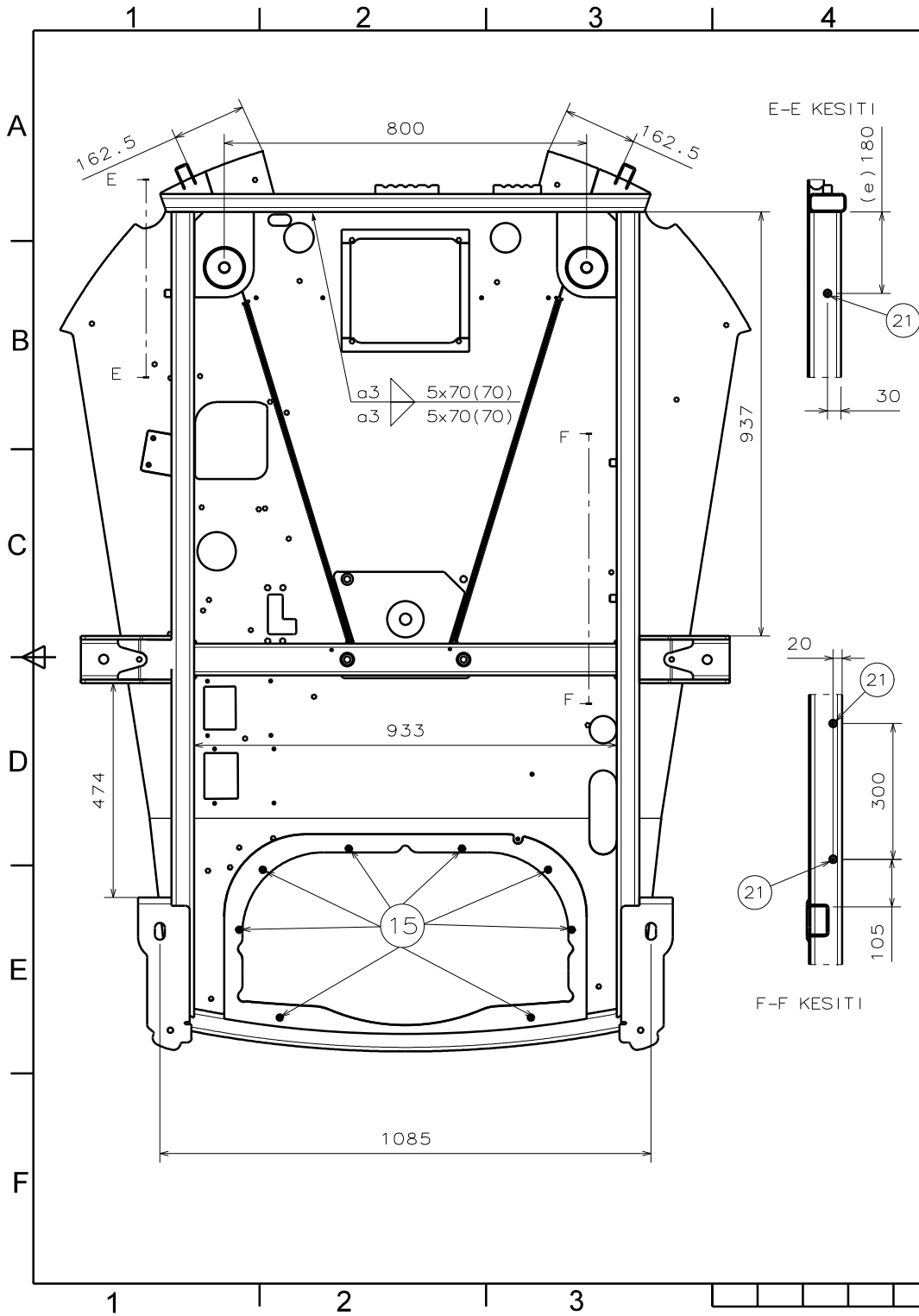
Number	Nomenclature	Quantity	Part Number	Type	Revision
1	TAVAN KAYNAKLI KOMPLESİ	1	172770025	Assembly	
2	SOL YAN KAYNAKLI KOMPLE	1	172770030	Assembly	
3	SAG YAN KAYNAKLI KOMPLE	1	172770029	Assembly	
4	TABAN KAYNAKLI KOMPLESİ	1	172770026	Assembly	
5	ÖN GÖĞÜS KAYNAKLI KOMPLESİ	1	172770028	Assembly	

GENEL ÖLÇÜ TOLERANSLARI		TARİH	İSİM	İMZA
CİZEN		01.06.2012	Emrah DOĞAN	
KONTROL		01.06.2012	Seçil ATILLA	
ONAY		01.06.2012	Göksel ÖZKIR	
PARÇA ADI				
YÜZEY KALİTESİ				
YÜZEY İŞLEMİ				
RESİM ÜZERİNDE ELLE DEĞİŞİKLİK YAPILMAZ ÖLÇÜ ALINMAZ		KABİN KAYNAKLI KOMPLE		
MALZEME		MALZEME EBADİ		BRUT AĞ/ADET
*		*		493Kg
				ADET
				1
				OLCEK
				1/20
				SAYFA
				2/1
				A3

Eskişehir-Bursa yolu 20 km. 26550 Eskişehir / TÜRKİYE
Tel : 0 222 411 24 30 Faks : 0 222 411 30 01
http://www.hisarlar.com.tr E-mail : hisarlar@hisarlar.com.tr

Bu resim HİSARLAR A.Ş.'ye aittir.
HİSARLAR'ın yazılı izni olmadan bu resimle
başka bir amaçla kullanılamaz, resim
bütünleri parçaları imalatı yapılamaz, resim
Tüm yazılı hakları HİSARLAR A.Ş.'ye aittir.

CAD



GENEL OLCU TOLERANSLARI		TARİH	İSİM	İMZA
DOĞRUSAL	ISO 2768-c	13.07.2012	Emrah DOĞAN	
AÇILAR	ISO 2768-c	KONTROL	13.07.2012	Seçil ATILMA
KONUM	ISO 2768-L	ONAY	13.07.2012	Göksele ÖZKIR
YÜZEY KALİTESİ	*	PARÇA ADI		
YÜZEY İŞLEMİ	*	TABAN KAYNAKLI KOMPLESİ		
CAD		MALZEME	MALZEME EBADİ	BRUT AĞ/ADET
RESİM ÜZERİNDE ELLE DEĞİŞİKLİK YAPILMAZ OLCU ALINMAZ		St 37-2	*	*
HISARLAR		RESİM NO	OLCEK	SAYFA
Eskişehir-Bursa yolu 20 km. 26550 Eskişehir / TÜRKİYE		172770026	1/10	2/2
Tel : 0.222.411 24 30 Faks : 0.222.411 30 01		ADET	1	A3
http://www.hisarlar.com.tr E-mail : hisarlar@hisarlar.com.tr				

DETAY A
OLCEK 1/5

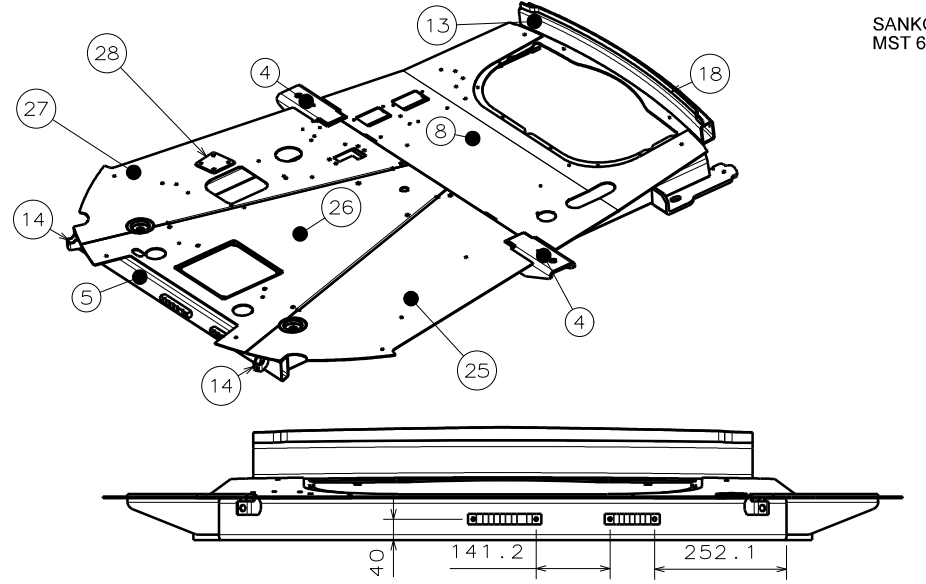
DETAY B
OLCEK 1/5

DETAY C
OLCEK:1/5

G-G KESİTİ
OLCEK:1/5

REV	DEĞİŞİKLİK	TARİH	İSİM	ONAY
1	172770545,546,131,134,135,154,140,235 ve 15013014 M10 sonunu iptal edilmiştir. 15013011 M8 sonundan 4 adet iptal edilmiştir. 172770225,130,174,181,224 numaralı parçalara revizyon uygulanmıştır. 172770600,601,602,603,617,618,621,622,625,626,633 numaralı parçalar eklenmiştir.	10.06.2015	E DOĞAN	A.TOGAY

SANKO
MST 6



Bill of Materials: 172770026

Number	Nomenclature	Quantity	Part Number	Type	Revision
1	TABAN PROFİLİ SAG	1	172770225	Part	
2	TABAN PROFİLİ SOL	1	172770130	Part	
4	PROFİL DESTEK SACI	2	172770132	Part	
5	TABAN ON PROFİLİ	1	172770174	Part	
6	ARKA TABAN DESTEK SACI SAG	1	172770224	Part	
7	ARKA TABAN DESTEK SACI SOL	1	172770181	Part	
13	TABAN ARKA PROFİLİ	1	172770123	Part	
15	DIN934 M8 SOMUN	8	15013010	Part	
16	DİREKSİYON KOLONU BORU KELEPÇESİ	1	172106119	Part	
17	FREN VALF BORU KELEPÇESİ	1	172106111	Part	
18	ARKA ÇERÇEVE ALT FİTİL SACI	1	172770506	Part	
20	ARKA SERVİS KAPAGI ÇERÇEVESİ	1	172770259	Part	
21	SİGORTA BAĞLANTI SOMUNU	3	172770252	Part	
14	ON DİŞ TRİM BAĞLANTI BRAKETİ	2	172770165	Part	
22	ROPS DESTEK SACI	2	172770542	Part	
8	ARKA TABAN SACI	1	172770603	Part	
25	KABİN TABANI ON SOL	1	172770600	Part	
26	KABİN TABANI ORTA SACI	1	172770601	Part	
27	TABAN SACI SAG	1	172770602	Part	
28	REXROTH JOYS. BAĞLANTI Sİ	1	172770633	Part	
29	M6 X30 SEKTSKUR , DİN 913	14	10004032	Part	
30	KOLUK ALT BAĞLANTI Sİ	1	172770625	Part	
31	KABİN ALT DESTEK SACI	1	172770626	Part	
32	KABİN BAĞLANTI DESTEK SACI	2	172770617	Part	
33	ON KABİN TAKOZ BAĞLANTI Sİ	2	172770618	Part	
34	ON ÇERÇEVE SACI-1	2	172770621	Part	
35	ON ÇERÇEVE SACI-2	2	172770622	Part	

GENEL OLCU TOLERANSLARI		TARİH	İSİM	İMZA
DOĞRUSAL	ISO 2768-c	KONTROL	13.07.2012	Emrah DOĞAN
AÇILAR	ISO 2768-c	ONAY	13.07.2012	Seçil ATILLA
KONUM	ISO 2768-L	PARÇA ADI		Göksef ÖZKIR
YÜZEY KALİTESİ	*	TABAN KAYNAKLI KOMPLESİ		
YÜZEY İŞLEMİ	*			
RESİM ÜZERİNDE ELE DEĞİŞİKLİK YAPILMAZ OLCU ALINMAZ		MALZEME	MALZEME EBADI	BRUT AĞ/ADET
		St 37-2	*	*
		ADET	1	A3

HISARLAR

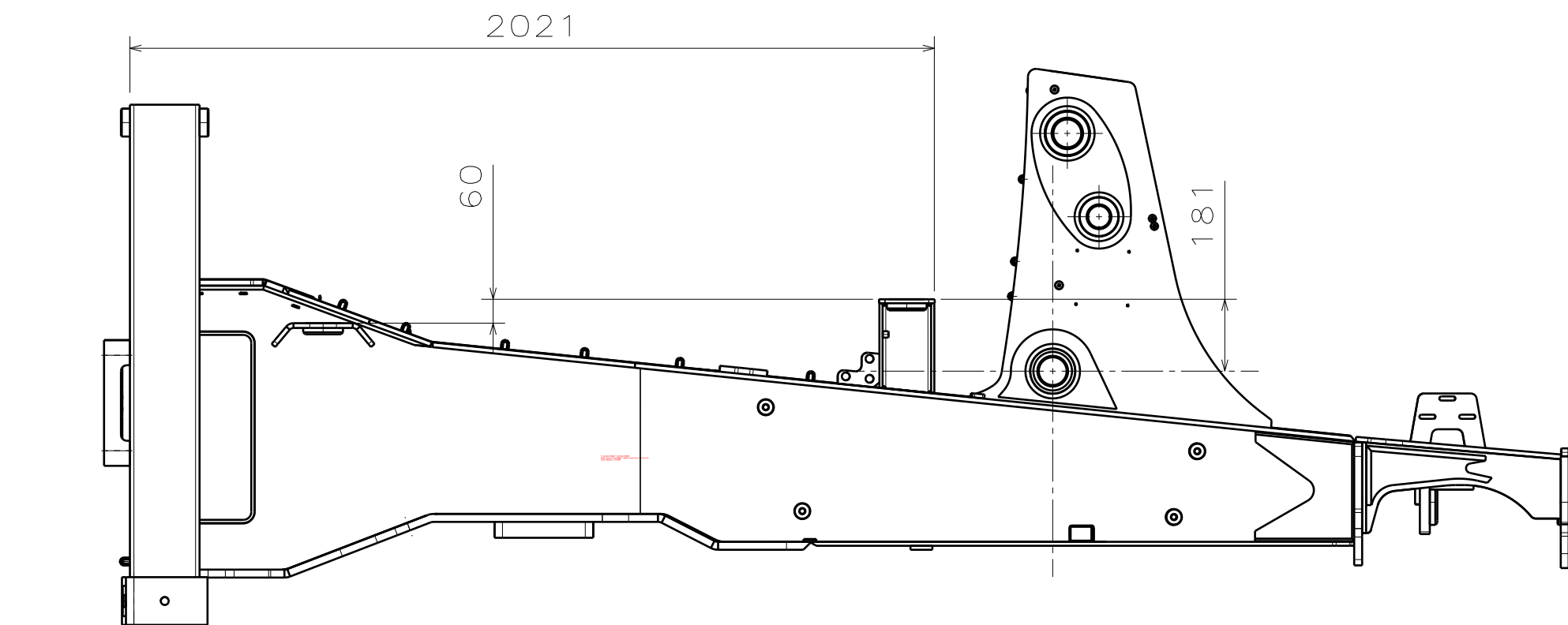
Eskişehir-Bursa yolu 20 km. 26550 Eskişehir / TÜRKİYE
Tel : 0222.411 24 30 Faks : 0222.411 30 01
http://www.hisarlar.com.tr E-mail : hisarlar@hisarlar.com.tr

RESİM NO
172770026

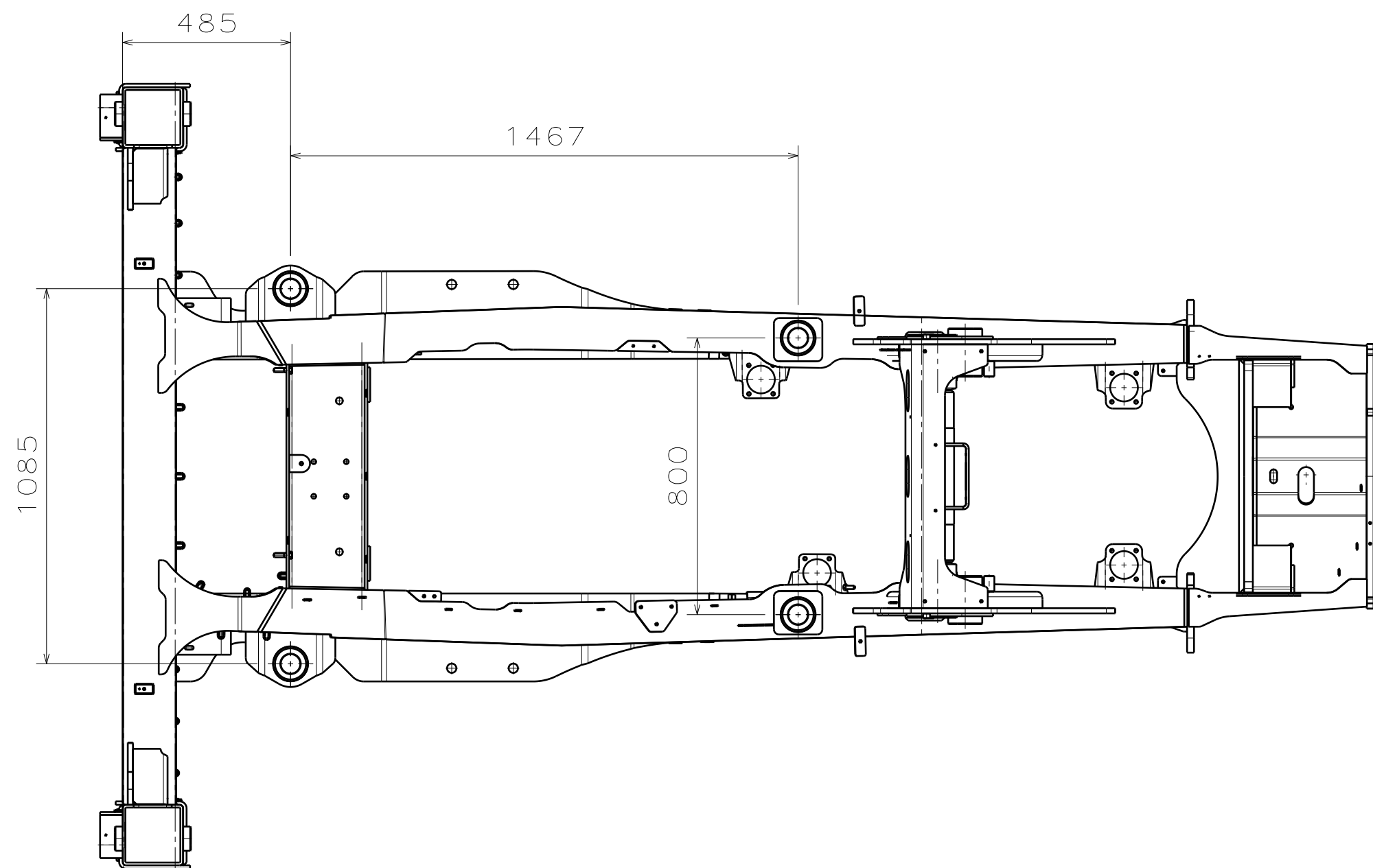
OLCEK
1/10

SAYFA
2/1

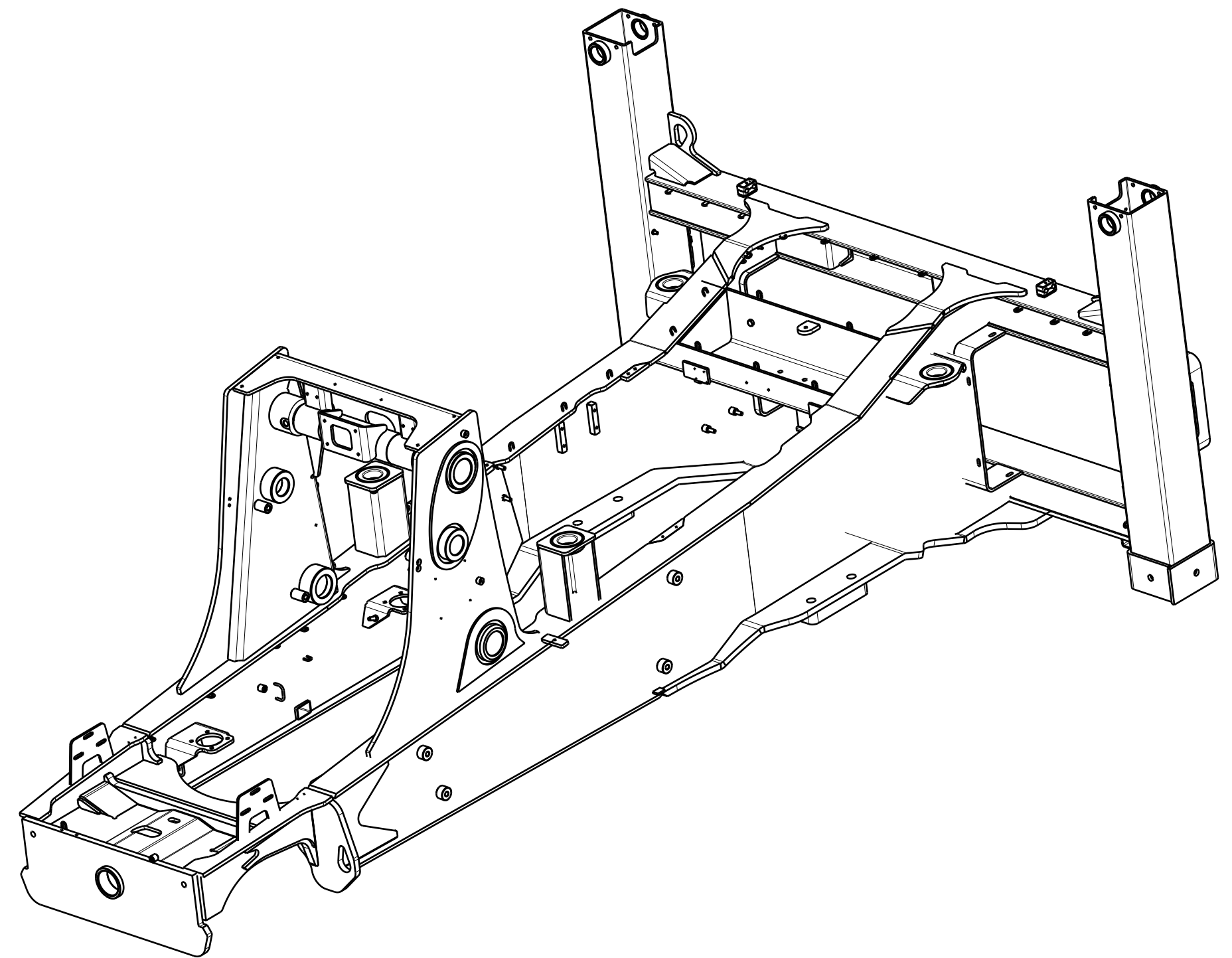
A3



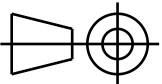
Front view
Scale: 1:15

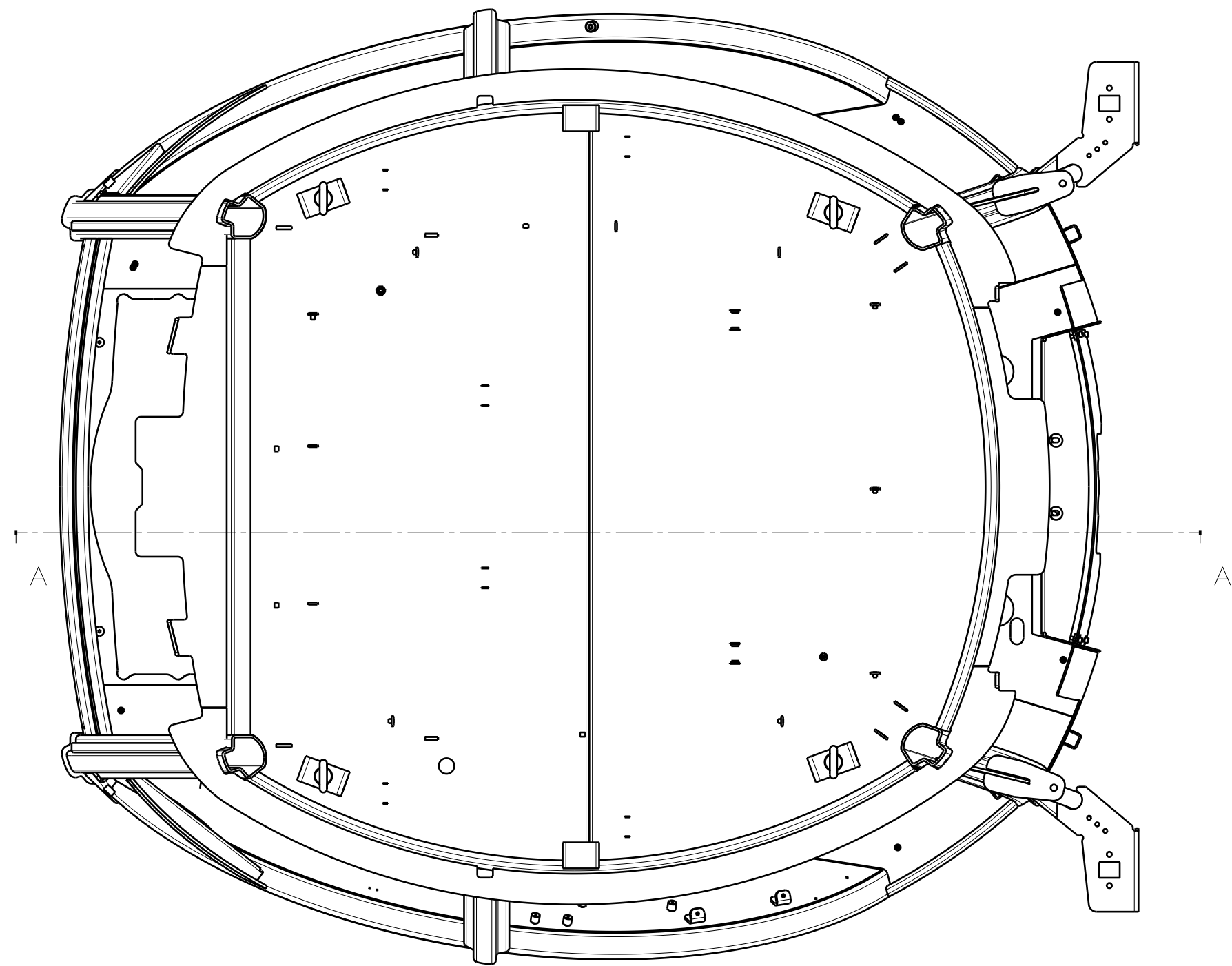


Top view
Scale: 1:15

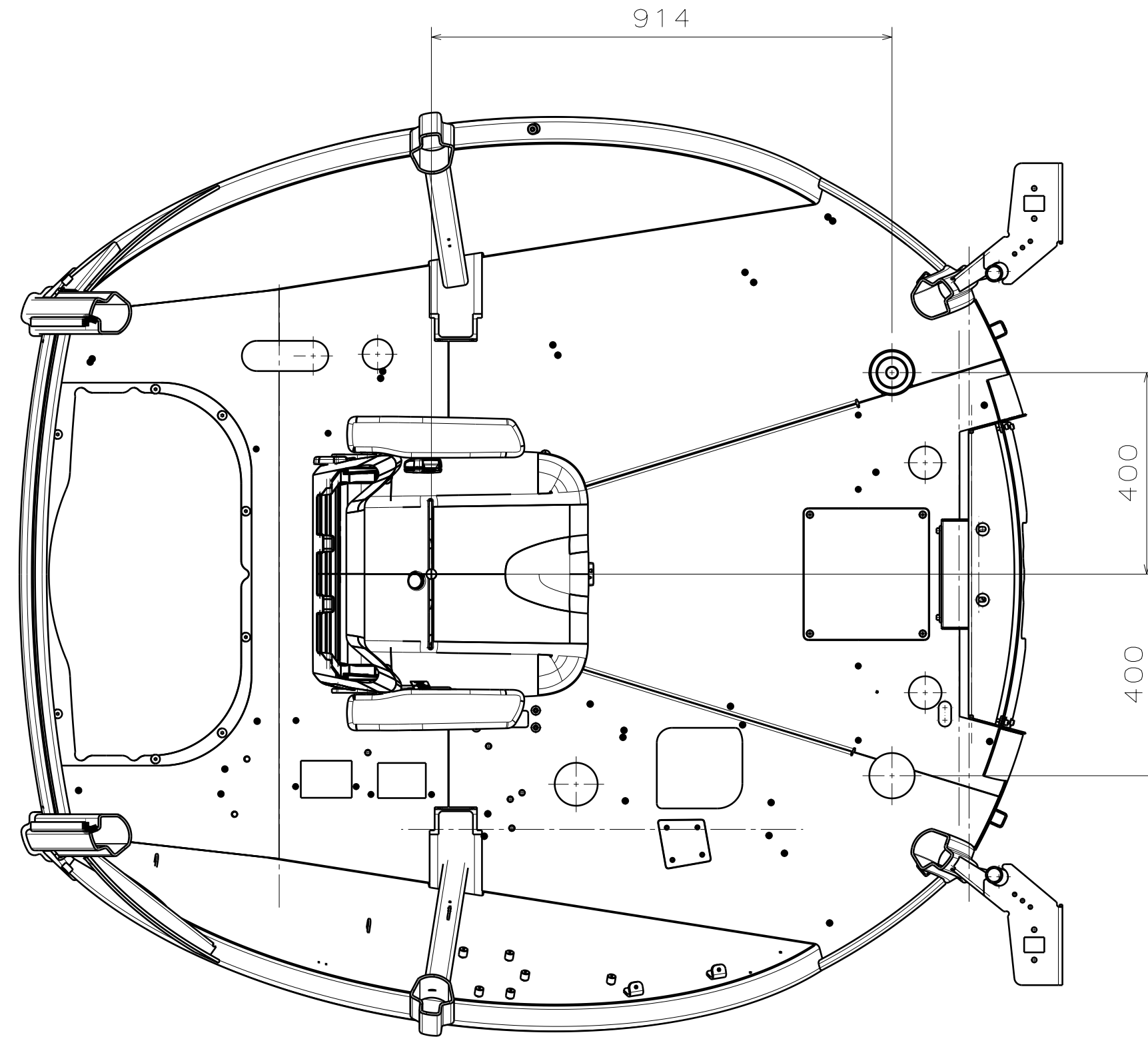


Isometric view
Scale: 1:15

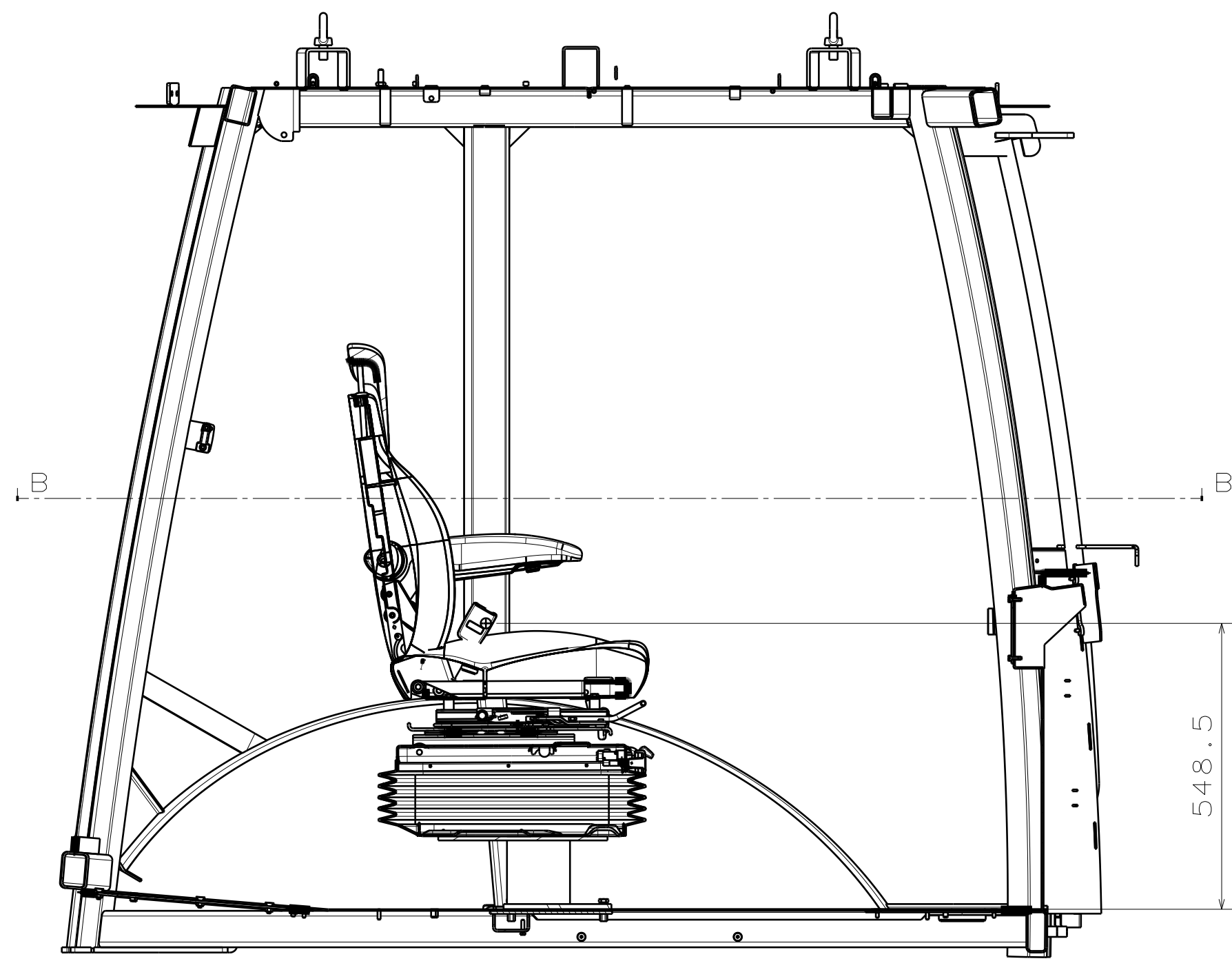
DESIGNED BY: S.MEMIKBESE		DATE: 27.05.2015	CHECKED BY: M.SONMEZ	APPROVED BY: L.KIRILANGIC	UR-GE DEPARTMAN I	
TOTAL EFFECTIVE CASE DEPTH			SCALE 1:15	Weight (Kg) 1.051,14		
HARDNESS			QUANTITY			
			UOUNU ACI METODU			
HOMOLOGATION		MATERIAL St 52-3:		ÖLÇÜLER mm DİR	 THIRD ANGLE METHOD DIMENSIONS IN mm	
CORE	SURF.	REFERENCE				
HEAT TREATMENT			UNSPECIFIED TOLERANCES		DRAWING NAME MST 644 PLUS SASE	A2
FINISH			DIN EN 10025-94		DRAWING NUMBER 174631003	SIZE A2



Front view
Scale: 1:10

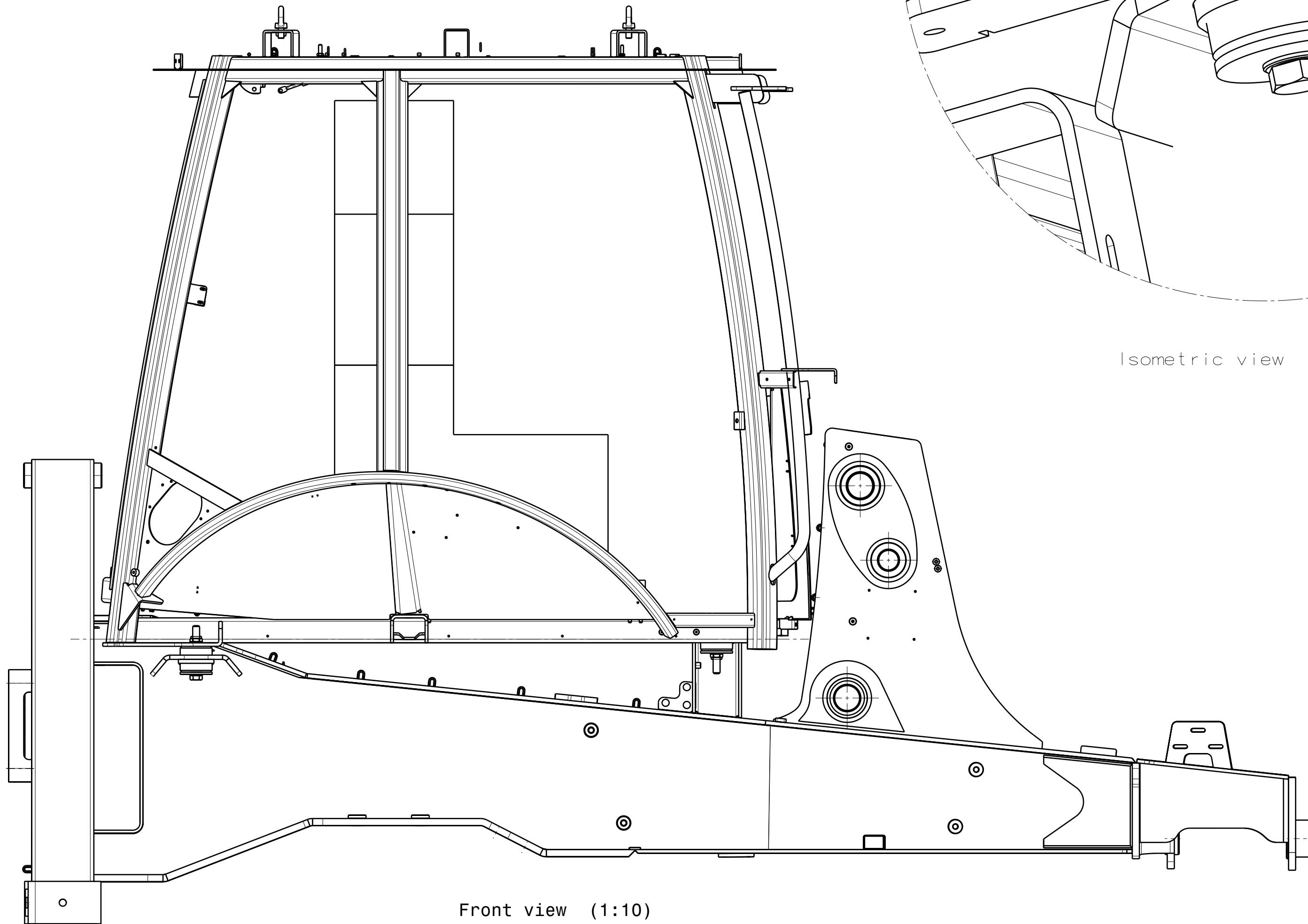


Section view B-B
Scale: 1:10

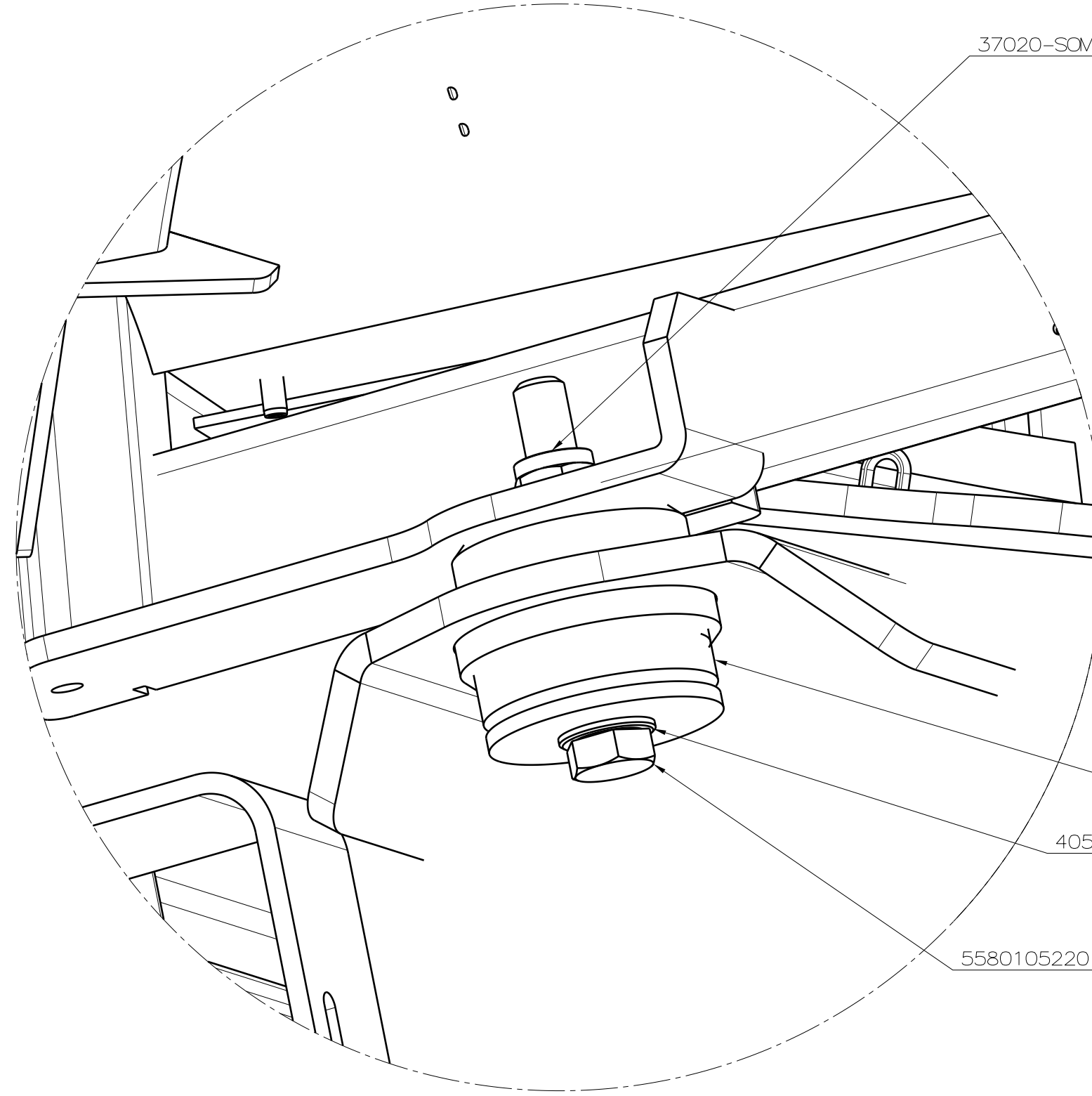


Section view A-A
Scale: 1:10

DESIGNED BY: S. MENTREBESZ	DATE: 27.05.2015	CHECKED BY: M. SOMÉZ	APPROVED BY: L. KRZEMINSKI	UR-GE DEPARTMAN I	
TOTAL EFFECTIVE CASE DEPTH	SCALE: 1:10	Weight (kg): 1.994,01	QUANTITY		
HARDNESS	POSITION	MATERIAL: St 52-3	REFERENCE	THIRD ANGLE METHOD DIMENSIONS IN mm	DRAWING NAME: MST 6 PLUS KABIN
CORE	SURF.				
HEAT TREATMENT	UNSPECIFIED TOLERANCES	DIN EN 10025-94	DRAWING NUMBER: 172770020	SIZE: A1	
FINISH					



Front view (1:10)



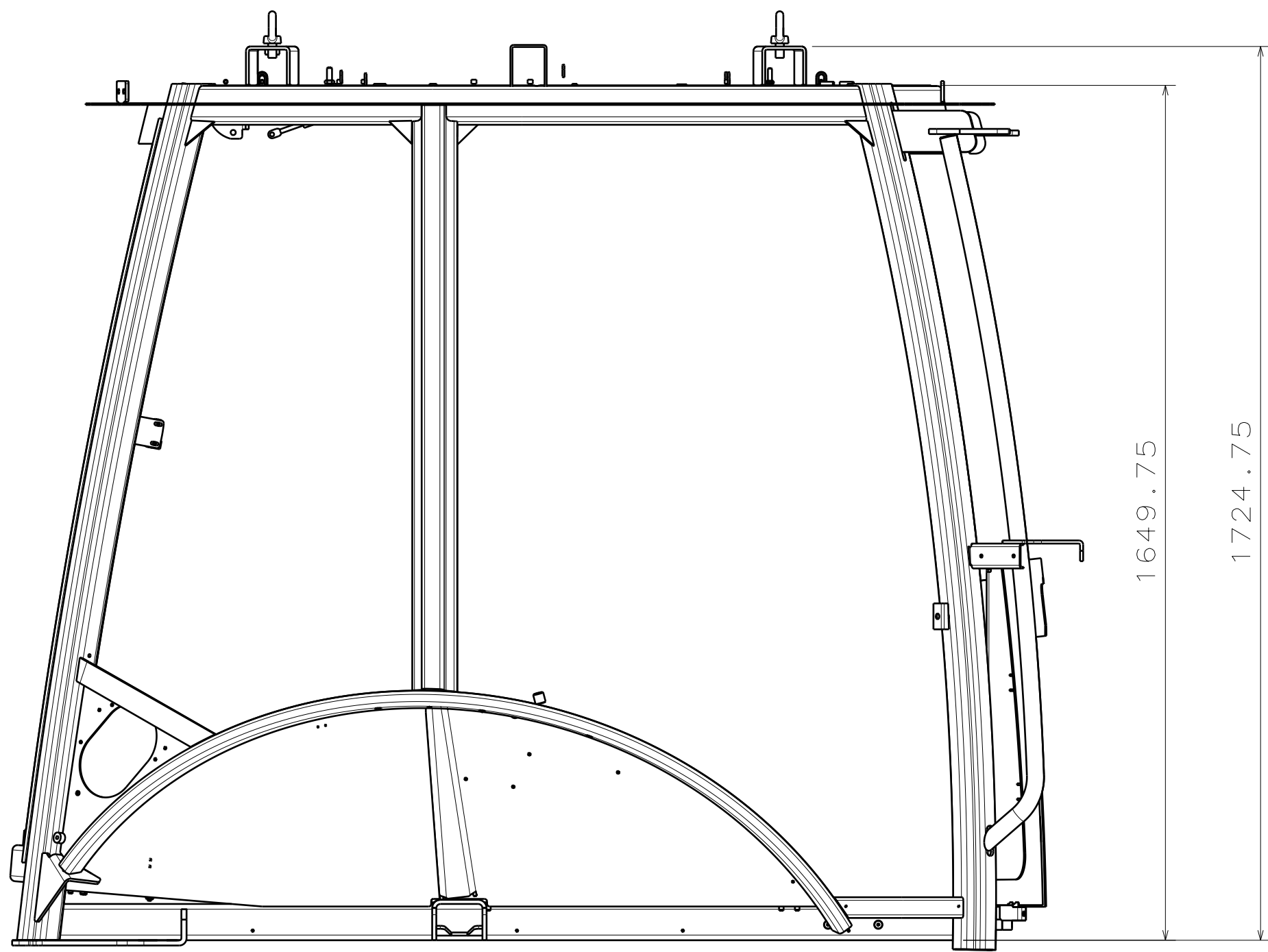
Isometric view (1:2)

37020-SOMUN, DIN 985, 10, M20, GVZ (AKB Fiberli)

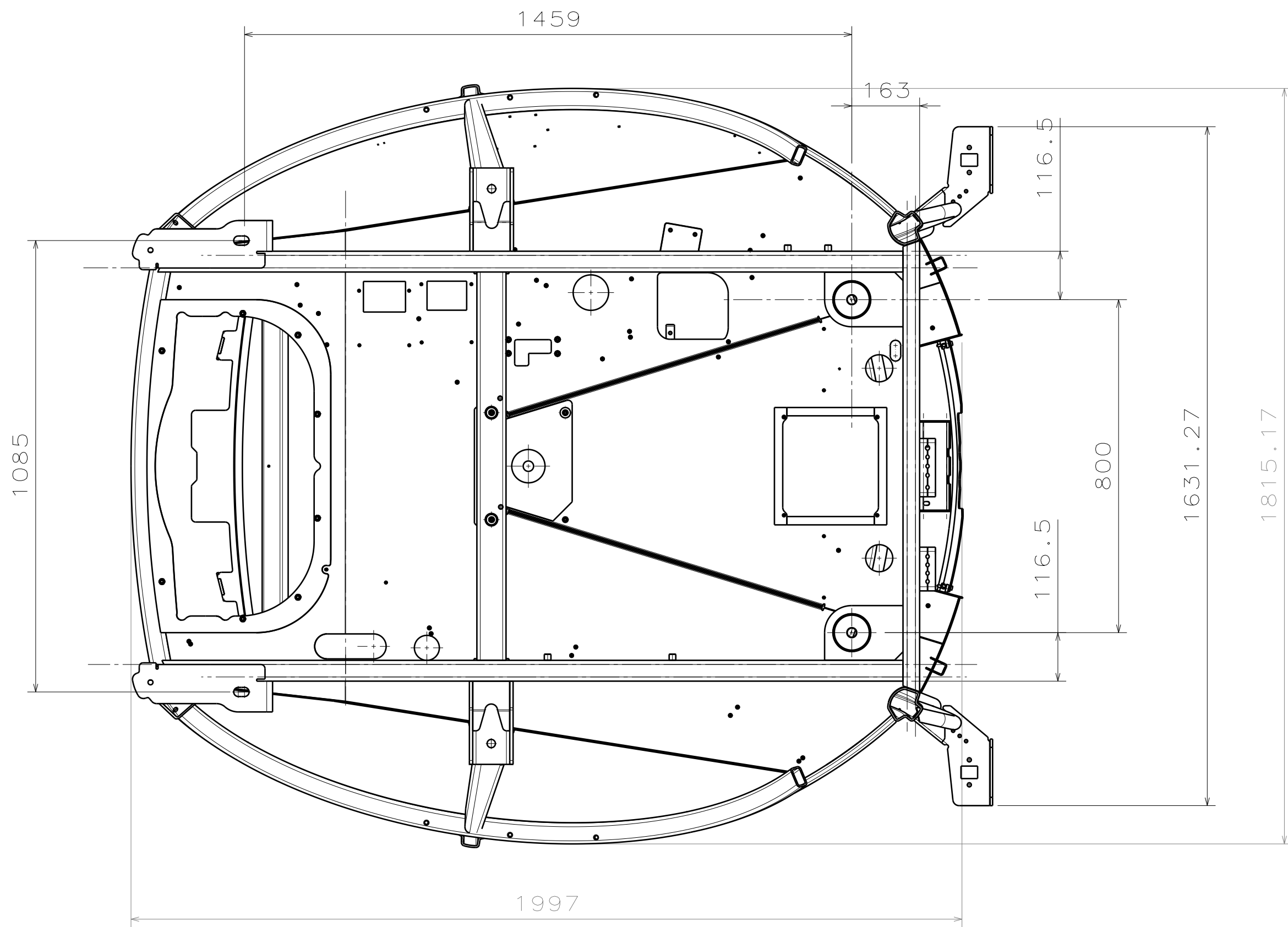
174770272-KABIN TAKOZU

40520-RONDELA, DIN 125, M20, SIYAH

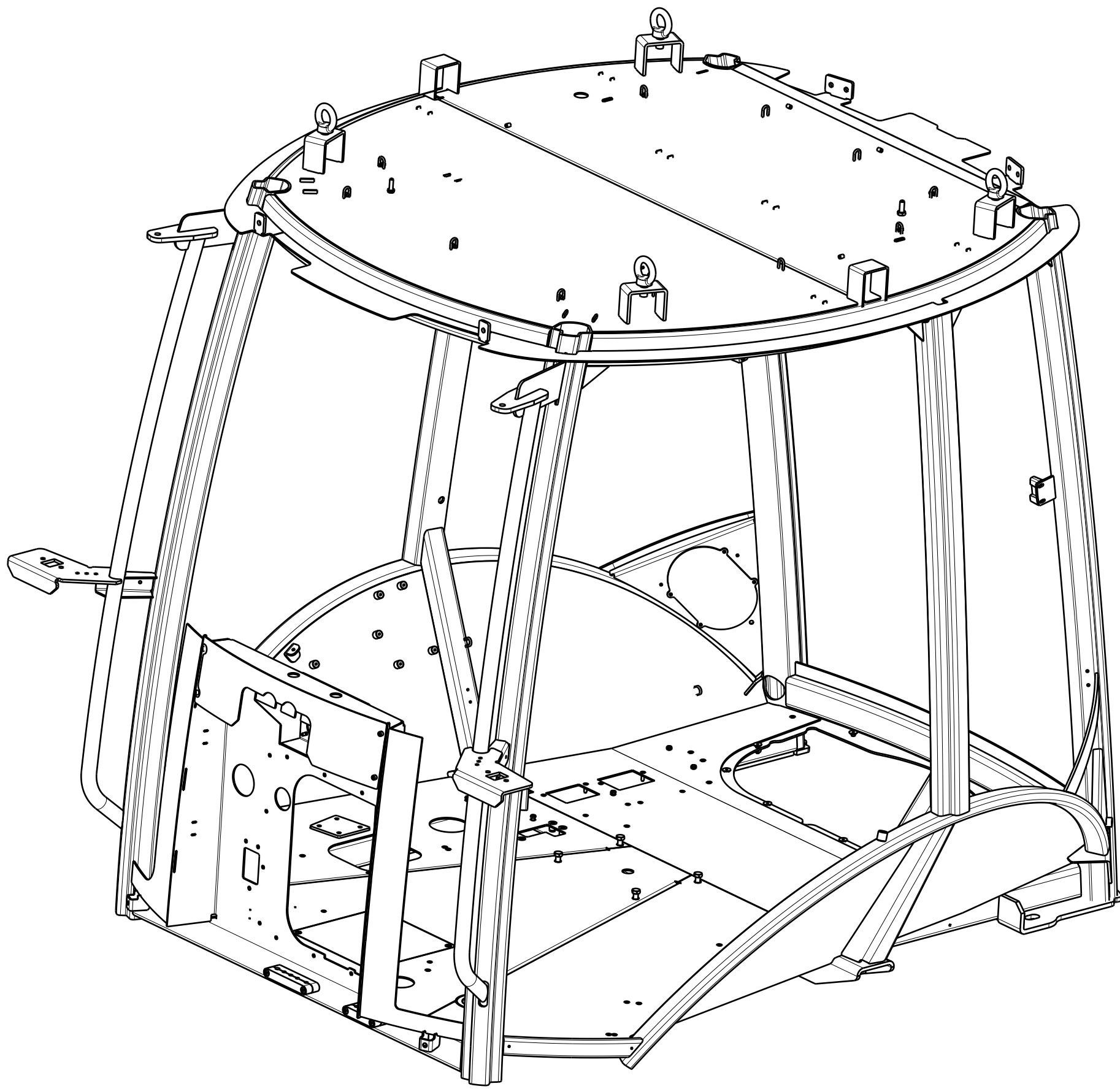
5580105220140000-CIVATA, DIN 931, 10.9, M20x140, GVZ



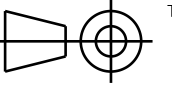
Front view
Scale: 1:10

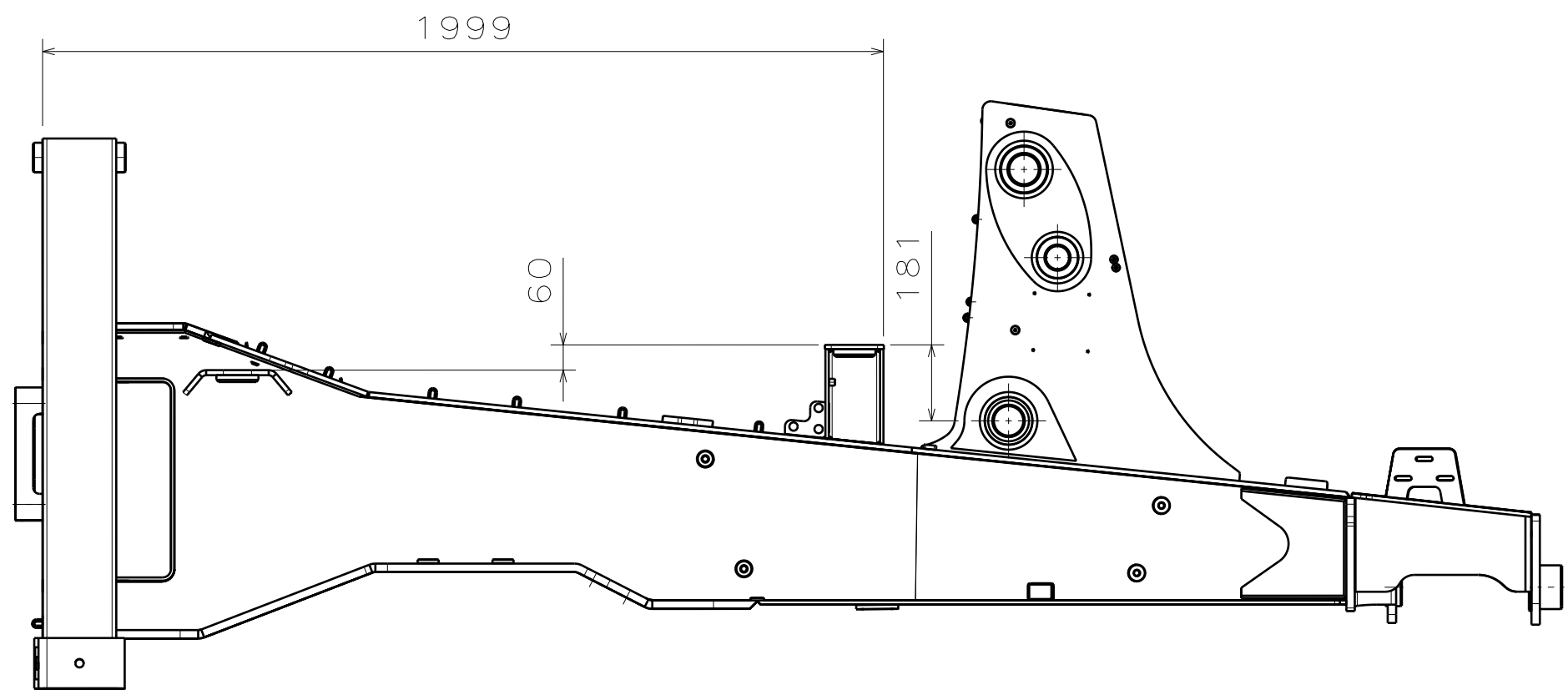


Bottom view
Scale: 1:10

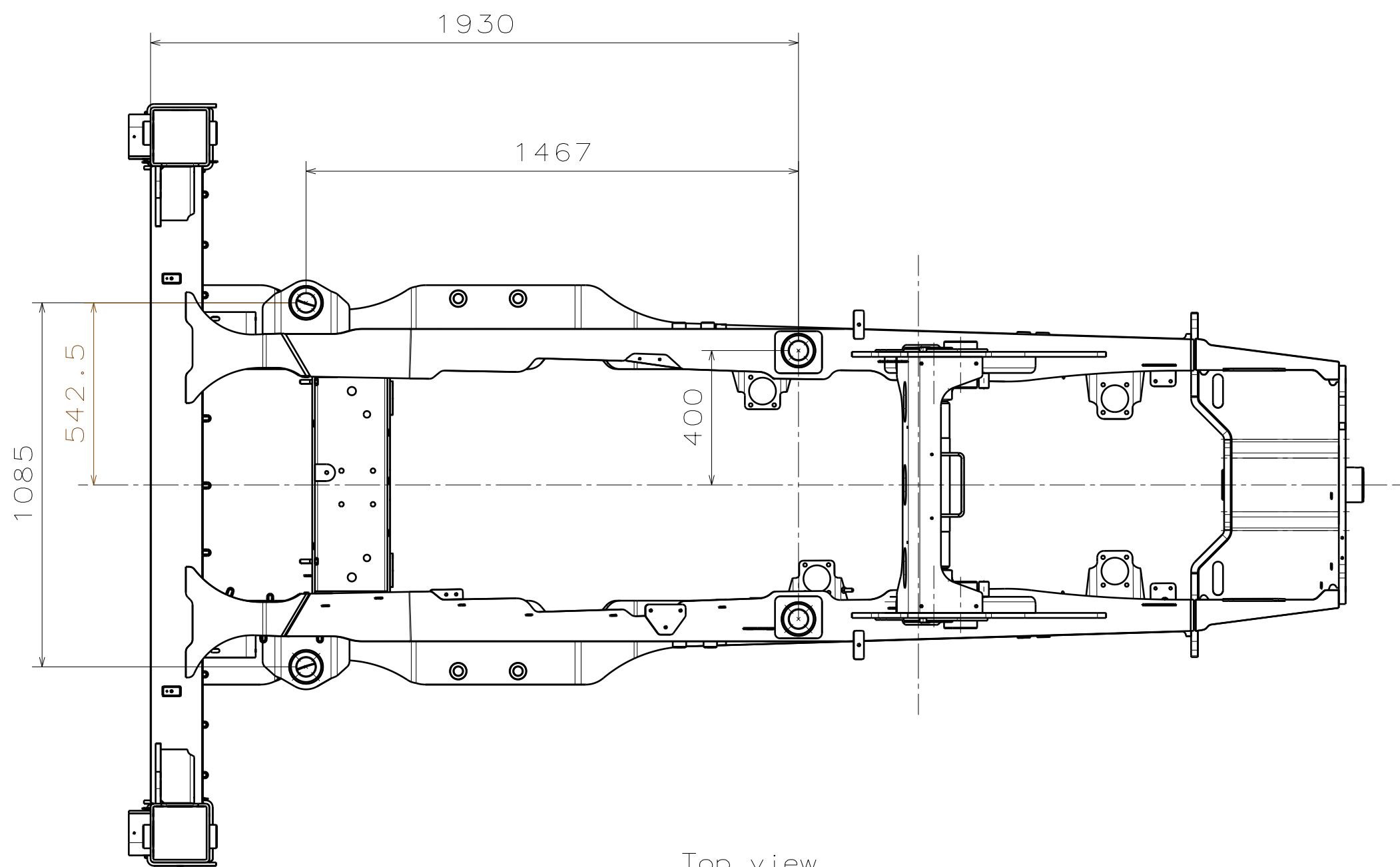


Isometric view
Scale: 1:10

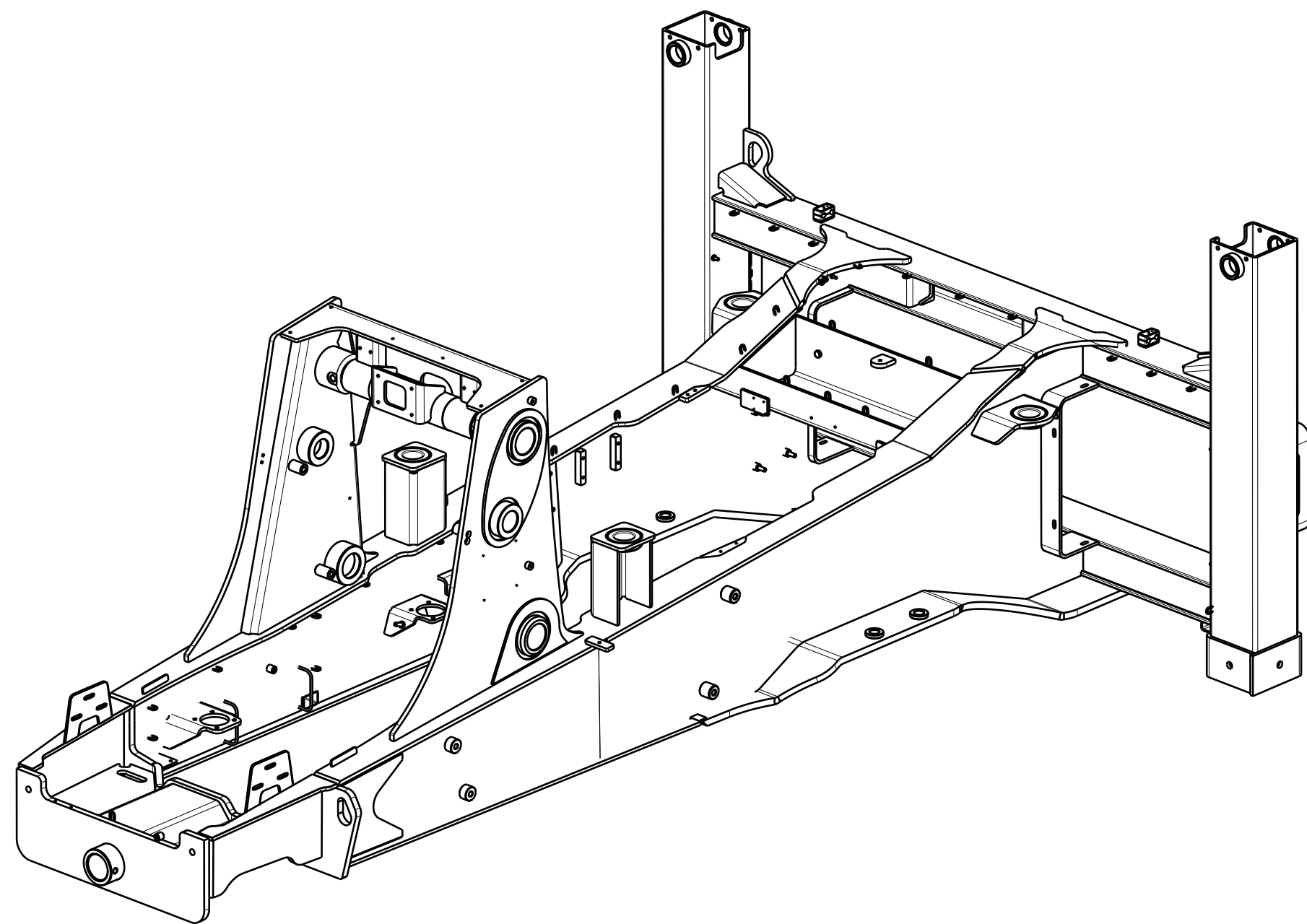
DESIGNED BY: S. MENTRIBESE	DATE: 27.05.2015	CHECKED BY: M. SZYMIEZ	APPROVED BY: L. KRZEMINSKI	UR-GE DEPARTMAN I	 THIRD ANGLE METHOD DIMENSIONS IN mm
TOTAL EFFECTIVE CASE DEPTH	SCALE: 1:10	WEIGHT (kg): 1.994,01	QUANTITY		
HARDNESS	POSITION	MATERIAL: St 52-3	REFERENCE		
CORE	SURF.	HEAT TREATMENT	UNSPECIFIED TOLERANCES	DRAWING NAME: MST 6 PLUS KABIN	A1
FINISH		DIN EN 10025-94	DRAWING NUMBER: 172770020	SIZE: A1	



Front view
Scale: 1:15



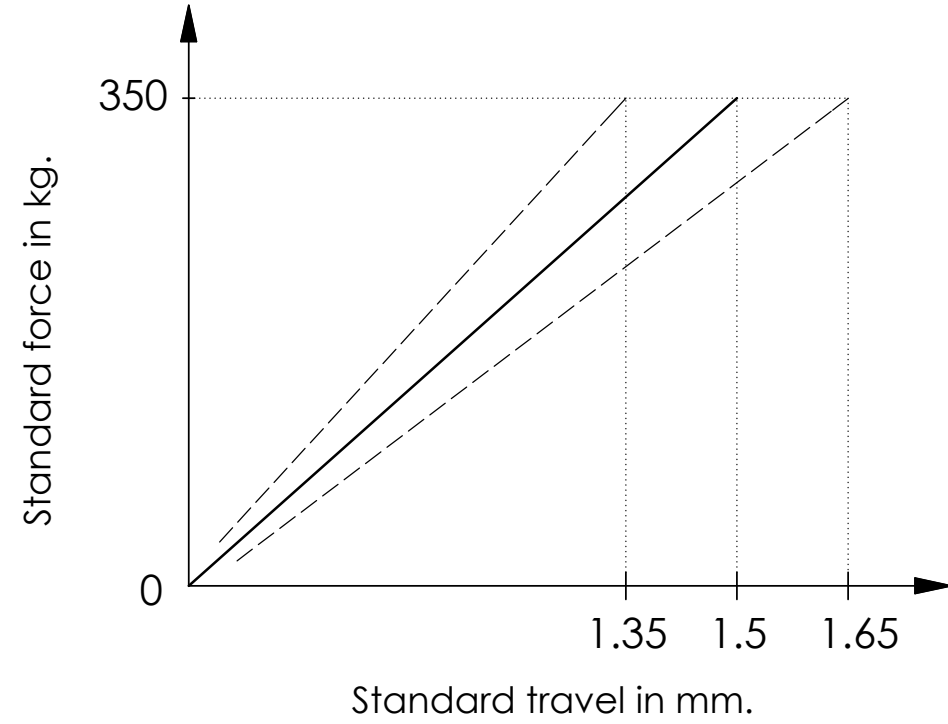
Top view
Scale: 1:15



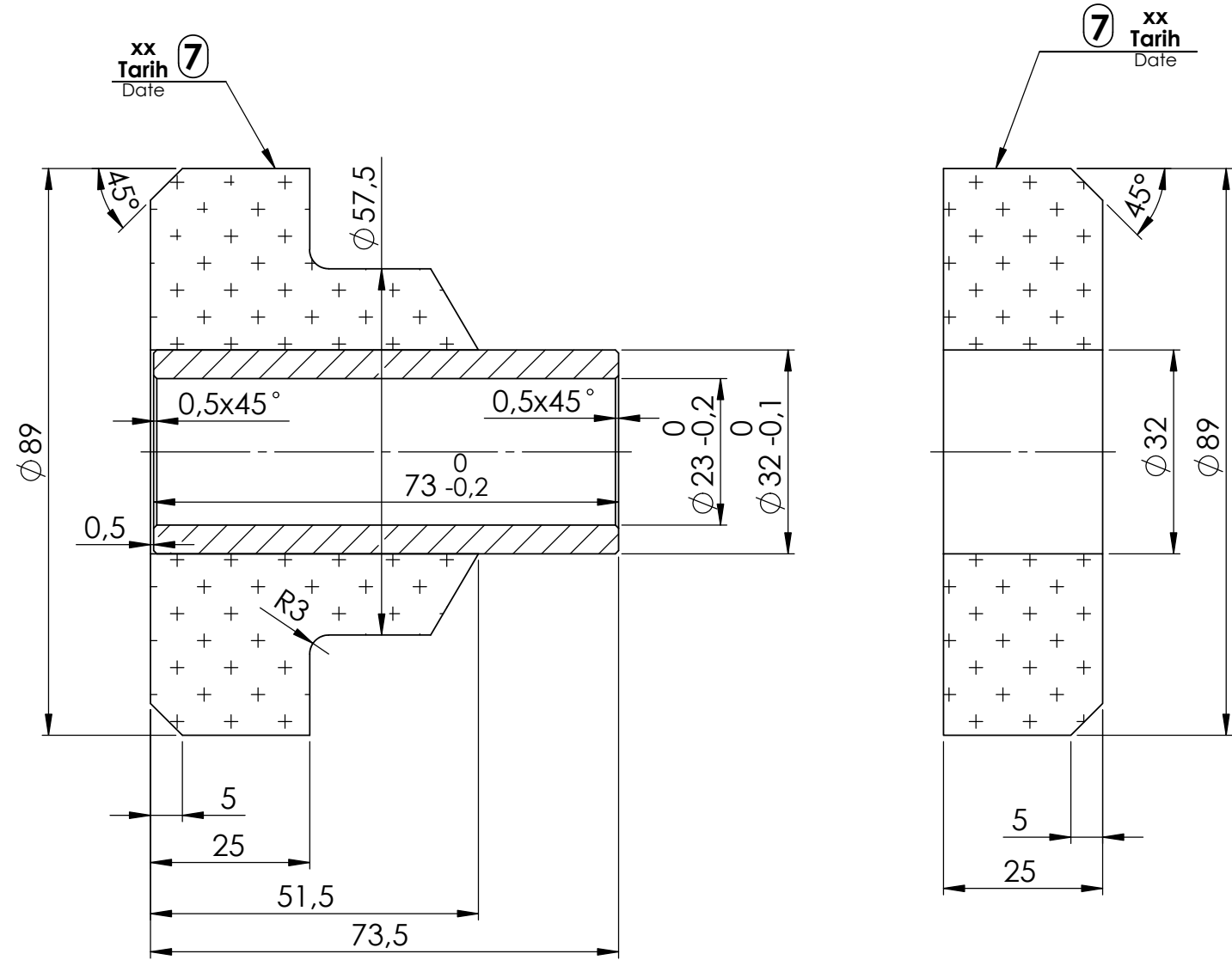
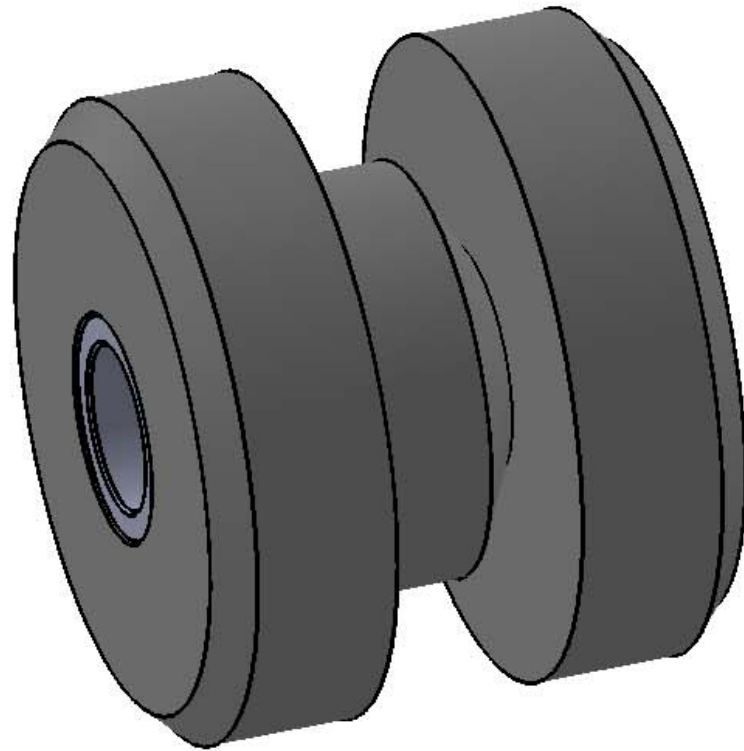
Isometric view
Scale: 1:15

DESIGNED BY:		DATE:		CHECKED BY:		APPROVED BY:		UR-GE DEPARTMAN I	
S.MEMTRBESE		27.05.2015		M.SONMEZ		L.KIRILANGIC			
TOTAL EFFECTIVE CASE DEPTH				SCALE		Weight (Kg)			
				1:15		1.132,79			
				QUANTITY					
HARDNESS		HOMOLOGATION		UCUNU ACI METODU					
				ÖLÇÜLER mm DİR					
				REFERENCE					
CORE	SURF.			MATERIAL					
				WELDING ASSY					
HEAT TREATMENT				UNSPECIFIED TOLERANCES					
				MST6 2 WS PLUS SASI A2					
FINISH									
				DIN EN 10025-94					
				DRAWING NUMBER 172631003					
				SIZE A2					

STATİK TEST GRAFİĞİ STATIC TEST CURVE

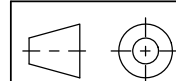


İZOMETRİK GÖRÜNÜŞ ISOMETRIC APPEARANCE



İÇ BORU YÜZEY KORUMA : Zn (Cr+3) SARI KAPLAMA
INNER PIPE SURFACE PROTECTION : Zn (Cr+3) YELLOW COATED
(B): 13-60 Sertlik NR 60±3 Shore A
13-60 Hardness NR 60±3 Shore A
(A): EN 10305-2 E 235+C

3	YAN LASTİK	RUBBER	1	3	(B)	1236/2	
2	LASTİK HAMURU	RUBBER COMPOUND	1	2	(B)	1236/1B	
1	İÇ BORU	INNER PIPE	1	1	(A)	1236/1A	
SIRA Sequence	PARÇANIN ADI Part Name	ADET Quantity	MONTAJ NO Assembly Nr.	MALZEME Material	RESİM NO Drawing Nr.	AĞIRLIK Weight	
Desing : Design	SEM NO Sem Nr. 1236	ÇİZEN Drawn by HÜLYA KONAK	TARİH Date 26.04.2013	İMZA Signature			
	REFERANS NO Reference Nr.	KONTROL Controlled by SERKAN GÖMEÇ	TARİH Date 26.04.2013	İMZA Signature			
	MALZEME Material	ONAY Approved by AYHAN TOKAY	TARİH Date 26.04.2013	İMZA Signature			
	RESİM NO Drawing Nr. 1236	ÖLÇEK Scale 1:1	PARÇA ADI Part Name	KABİN TAKOZU CABIN MOUNTING			



RESİMDE VERİLMEDİĞİ TAKTİRDE
IF NOT GIVEN IN THE DRAWING
UYGULANACAK OLAN TOLERANS NORMU
TOLERANCE FROM TO BE USED

DIN ISO 2768 mK
DIN ISO 3302-1M3

İS BU DÖKÜMANIN KULLANMA ve UYGULANMASI İLE İLGİLİ HER TÜRLÜ HAKLARI SEM LASTİK SAN.TİC.A.Ş.'NE AİTTİR.İZİNSİZ KOPYA EDİLEMEZ.ÜÇÜNCÜ SAHİSLAR TARAFINDAN BASKA MAKSATLA KULLANDIRILAMAZ.
ALL RIGHTS RELATING TO USE AND APPLICATION OF THIS DOCUMENT BELONGS TO SEM LASTİK SAN.TİC.A.Ş. IT CAN NOT BE ALLOWED USING OF BY THIRD PEOPLE.IT CAN NOT BE COPIED WITHOUT OUR WRITTEN PERMISSION.

SEM

SEM LASTİK
SAN.TİC.A.Ş.

Yeni Yalova Yolu
13.Km. Ovaakça
BURSA / TÜRKİYE
Tel:(0224) 267 05 41

