

1 : 100
Surfaces EN ISO 1302

For coating system codes (S-01 to S-12) at surface texture flags see corrosion protection specification SP-154.2-00.CO.ON.00.00.00.01-A, chapter 1.1 "Drawings".
Use S-03 or S-05 for all surfaces without individual flags.
Determining corrosibility category is C2 in accordance with EN ISO 12944.

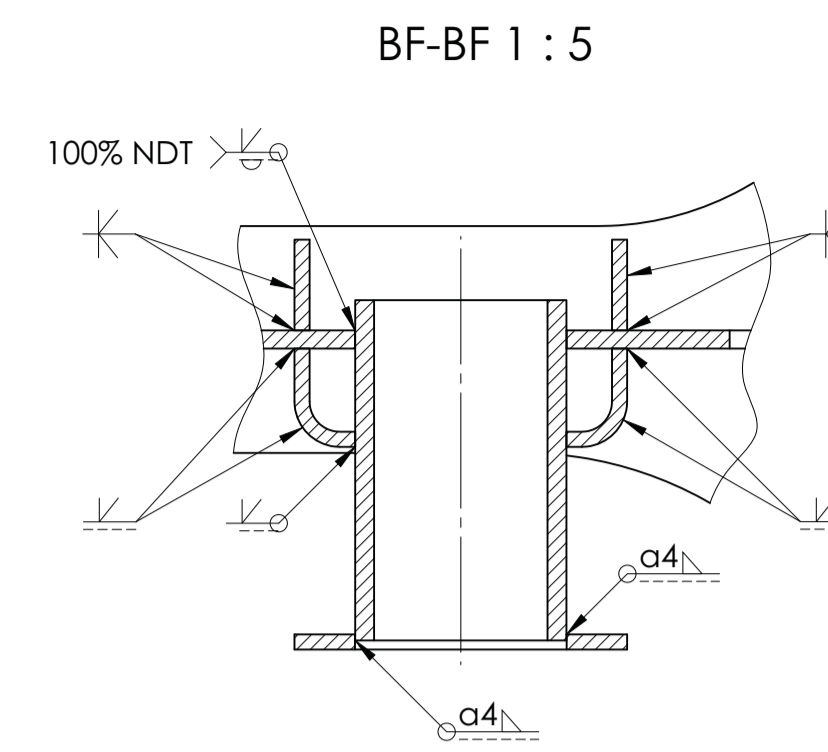
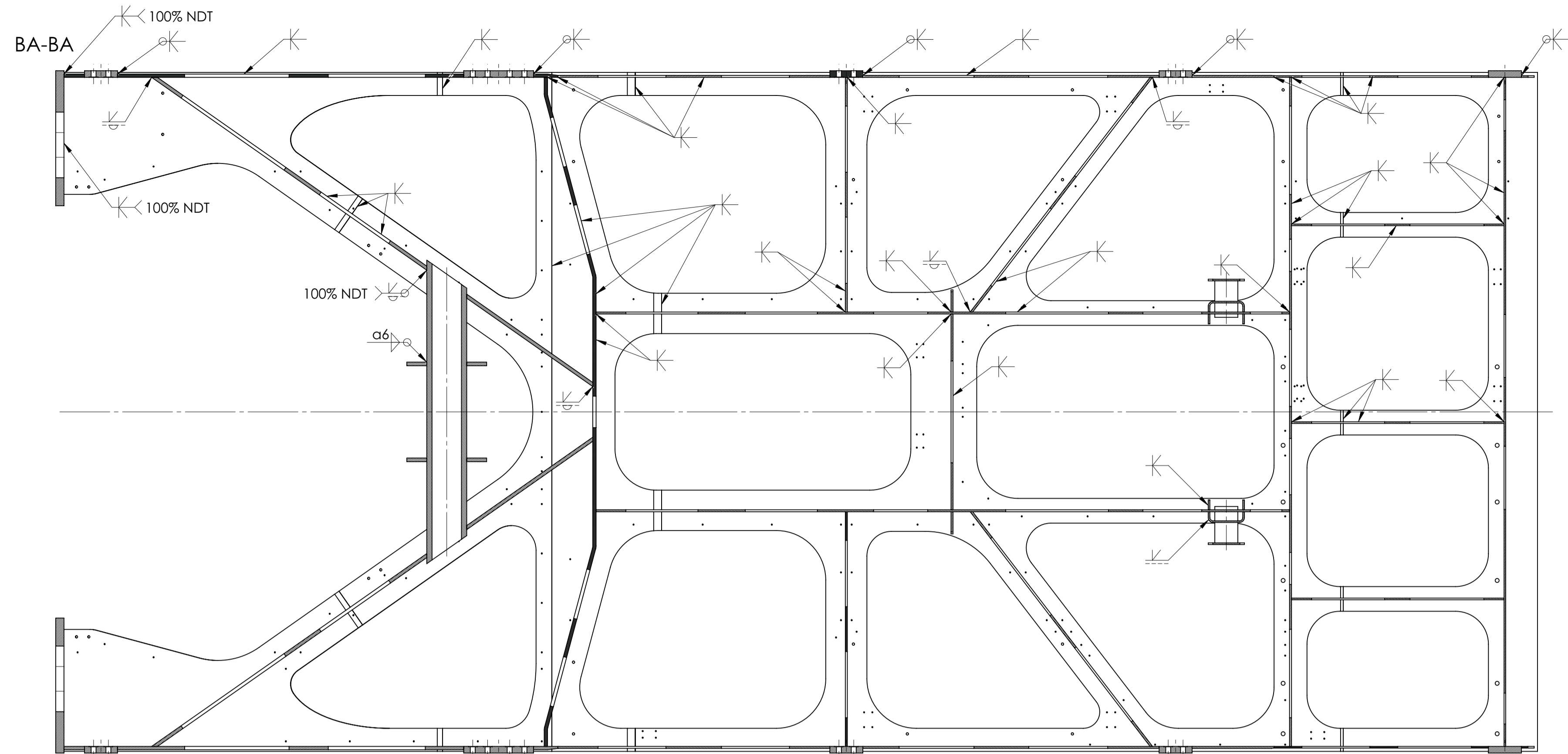
Note:
For present drawing sheet applies ISO 13920 B - general tolerances for welding constructions (instead of ISO 2768 mH)

all missing dimensions and free form shapes in accordance with 3-D model.
DC-154.2-MF.GE.CT.01.00.00.01-A-A

All machining and drilling has to be done after welding of the complete frame.
All single part dimensions have to be double checked by the manufacturer.
At single part views the welding preparation and the machining allowance has not been considered.

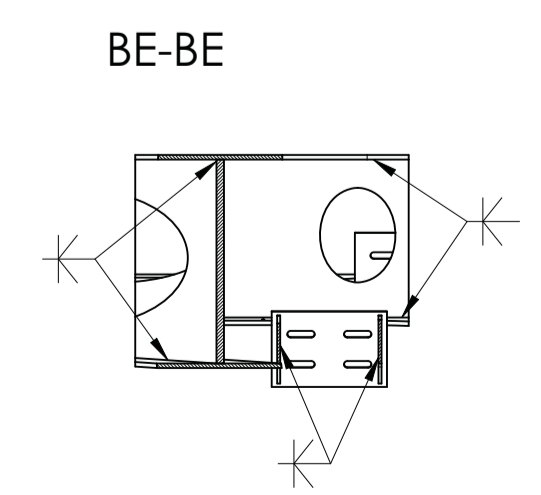
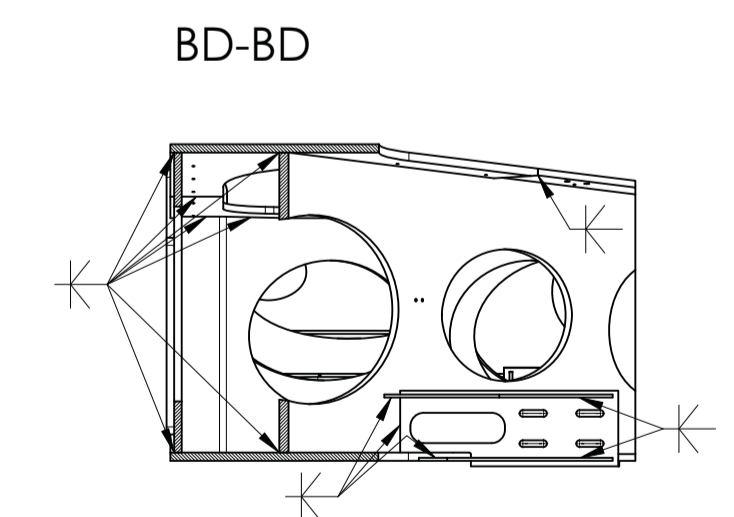
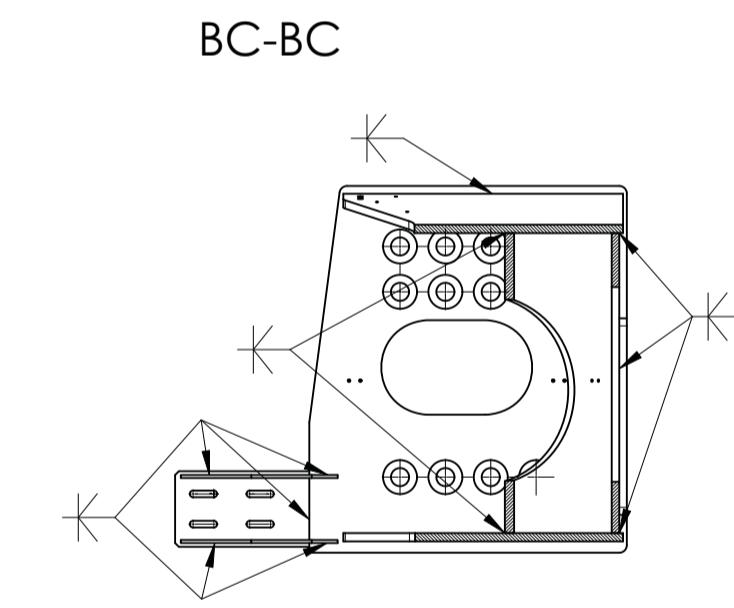
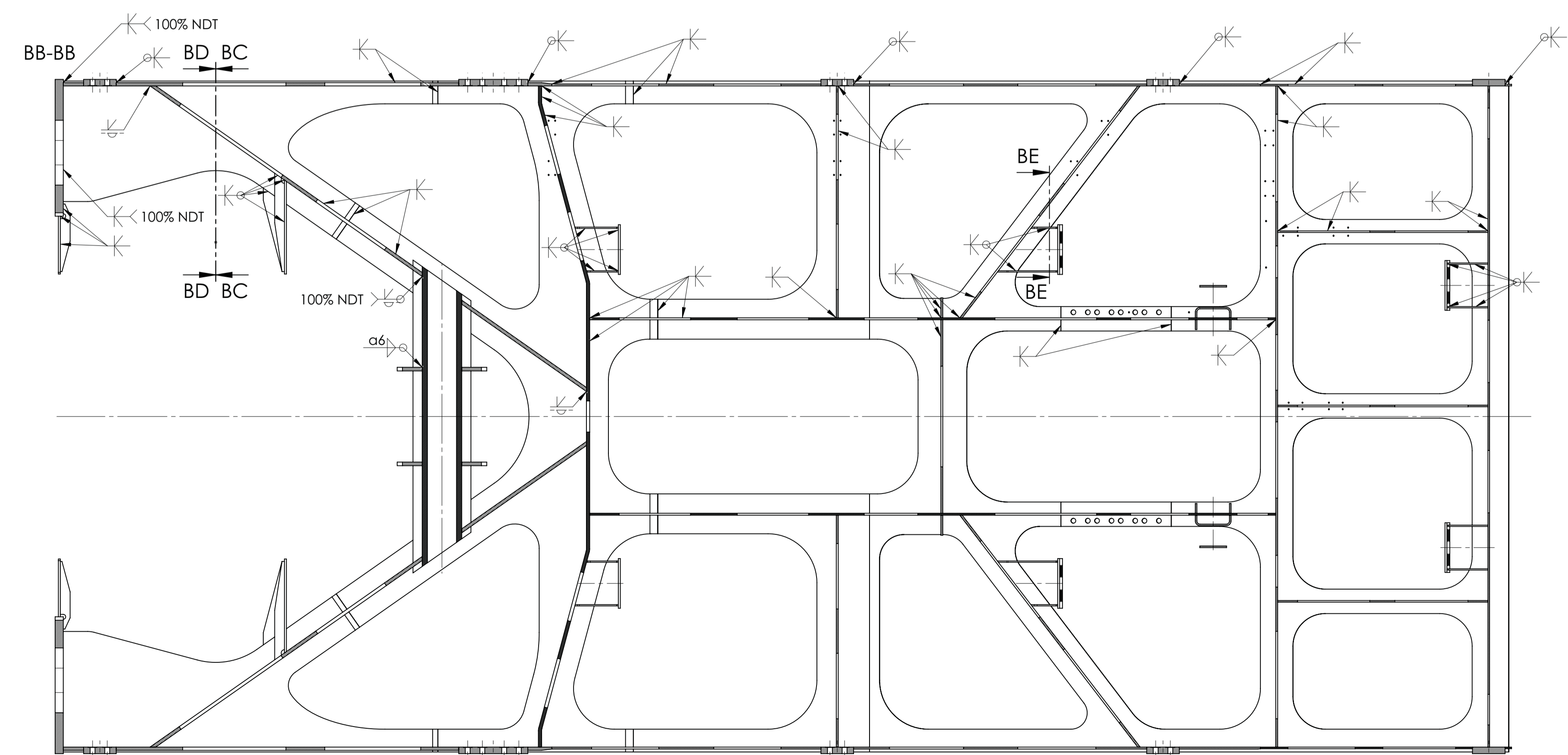
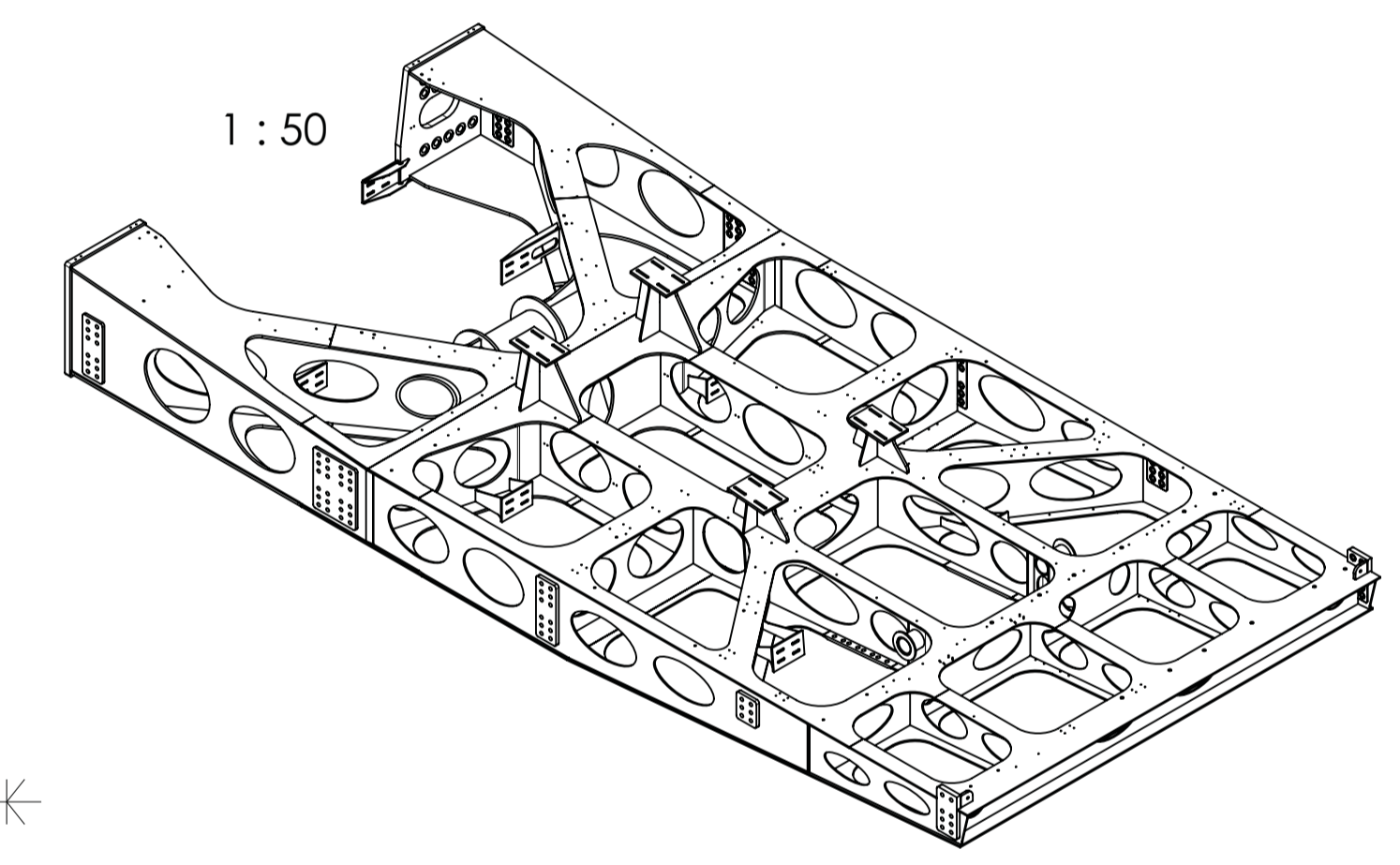
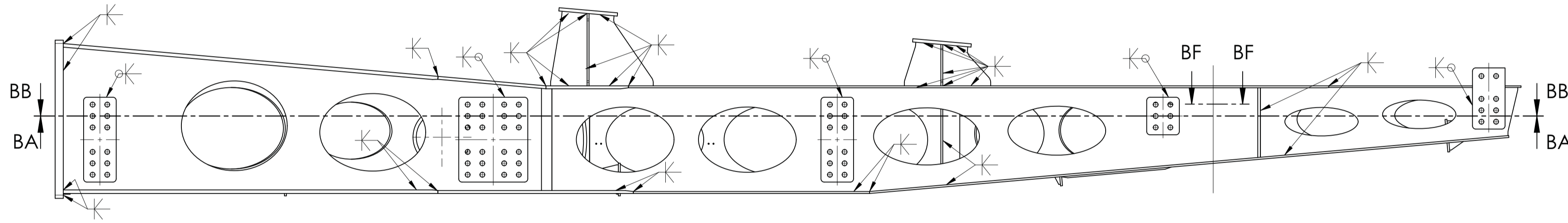
Heat treatment must be applied according to the "Manufacturing of Welded Parts" specification SP-154.2-00.MA.00.00.00.01-A, chapter 3.3 "Post Treatment of Welded Structure"

Revision	Drawn	Checked	Project Manager	Management	Material	Date
01						2022-07-06
Title Description						Scale
Tolerance ISO 8015						1:20
DIN ISO 2768 - mH						Weight
ISO 13715						6986 kg
Generator Frame						
Project						Rev.
DP-154.2-MF.GE.CT.01.00.00.01-A						A
Specification Number						Level
SP-154.2-00.MA.00.00.00.01-A						1/B
ECN Number						
Copyright reserved						
Refer to protection notice (S2 1816)						
DP-154.2-MF.GE.CT.01.00.00.01-A-A.pdf						
SolidWorks®						



All machining and drilling has to be done after welding of the complete frame.
 All single part dimensions have to be double checked by the manufacturer.
 At single part views the welding preparation and the machining allowance has not been considered.

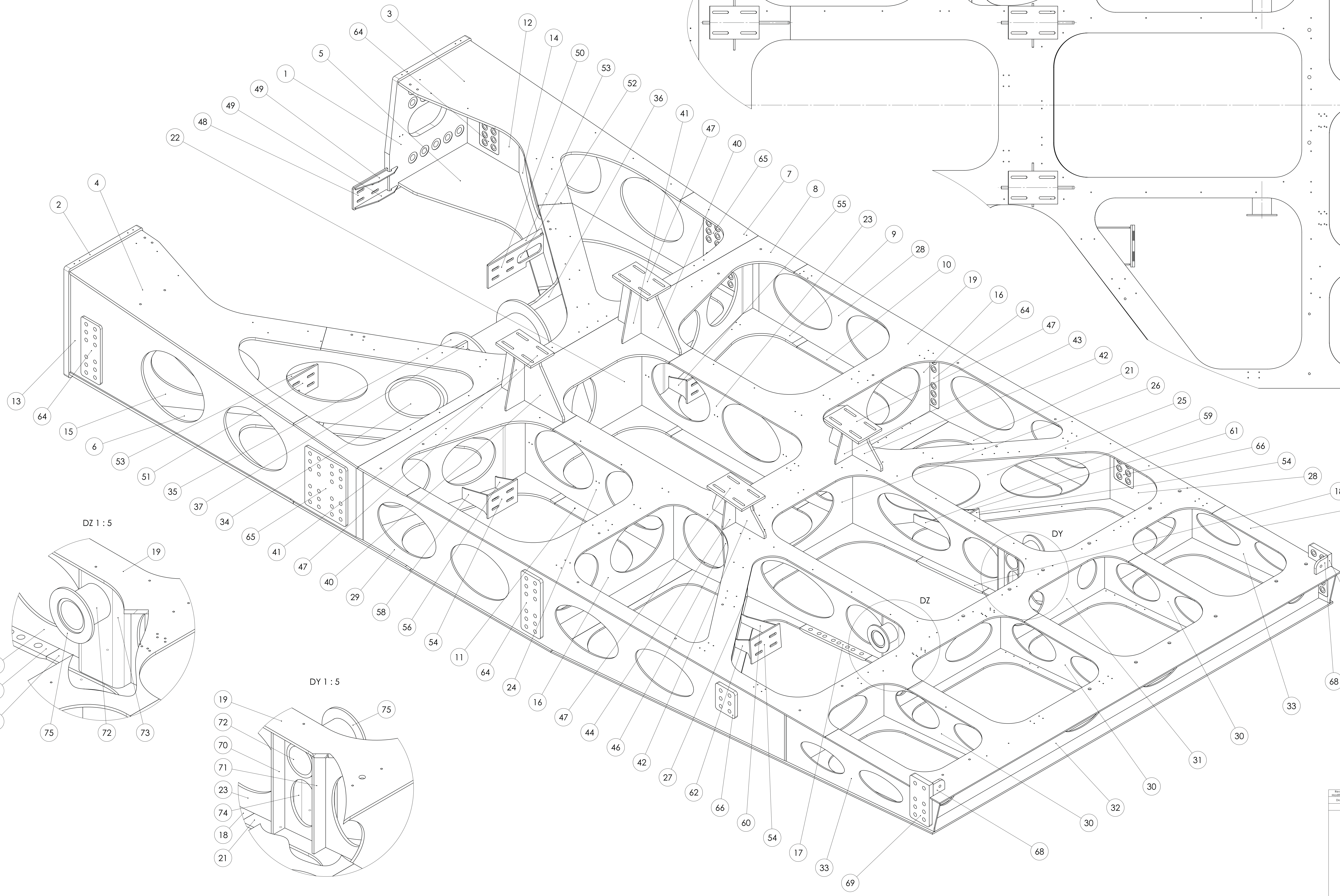
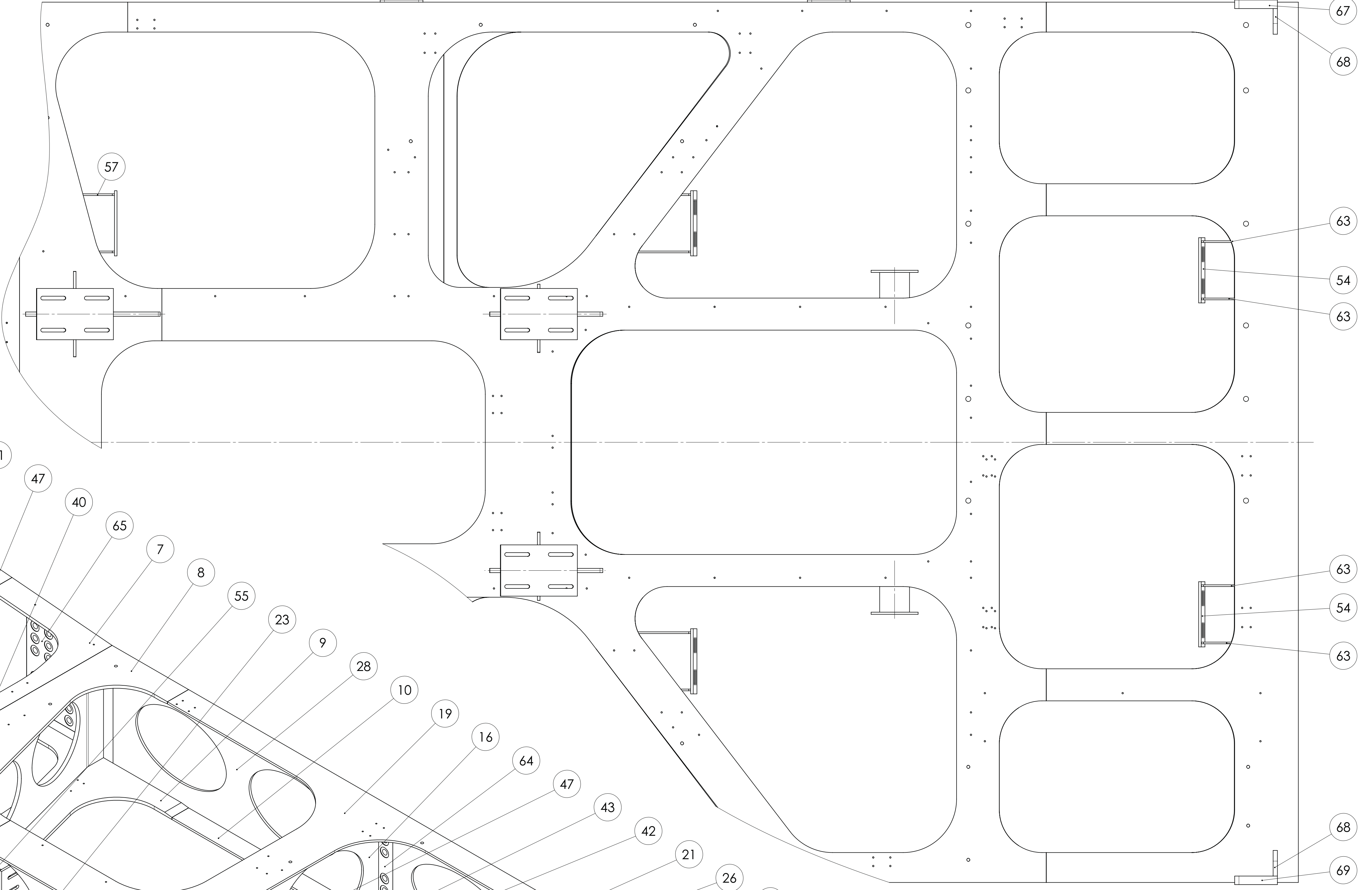
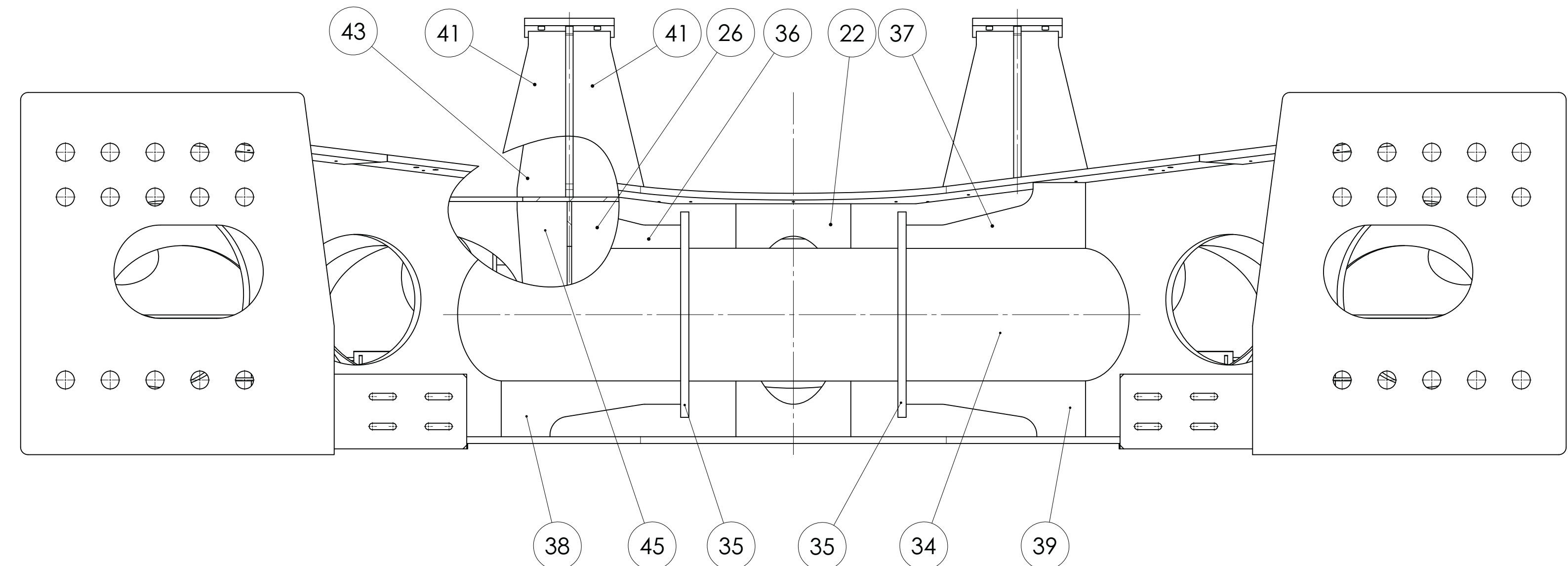
Heat treatment must be applied according to the "Manufacturing of Welded Parts" specification **SP-154.2-00.MA.00.00.00.01-A**, chapter 3.3 "Post Treatment of Welded Structure"



✓ ($\sqrt{Rz 25}$)
 Surfaces EN ISO 1302
 For coating system codes (S-01 to S-12) at surface texture flags see corrosion protection specification **SP-154.2-00.CO.ON.00.00.01-A**, chapter 1.1 "Drawings".
 Use **S-03** or **S-05** for all surfaces without individual flags.
 Determining corrosibility category is **C2** in accordance with **EN ISO 12944**

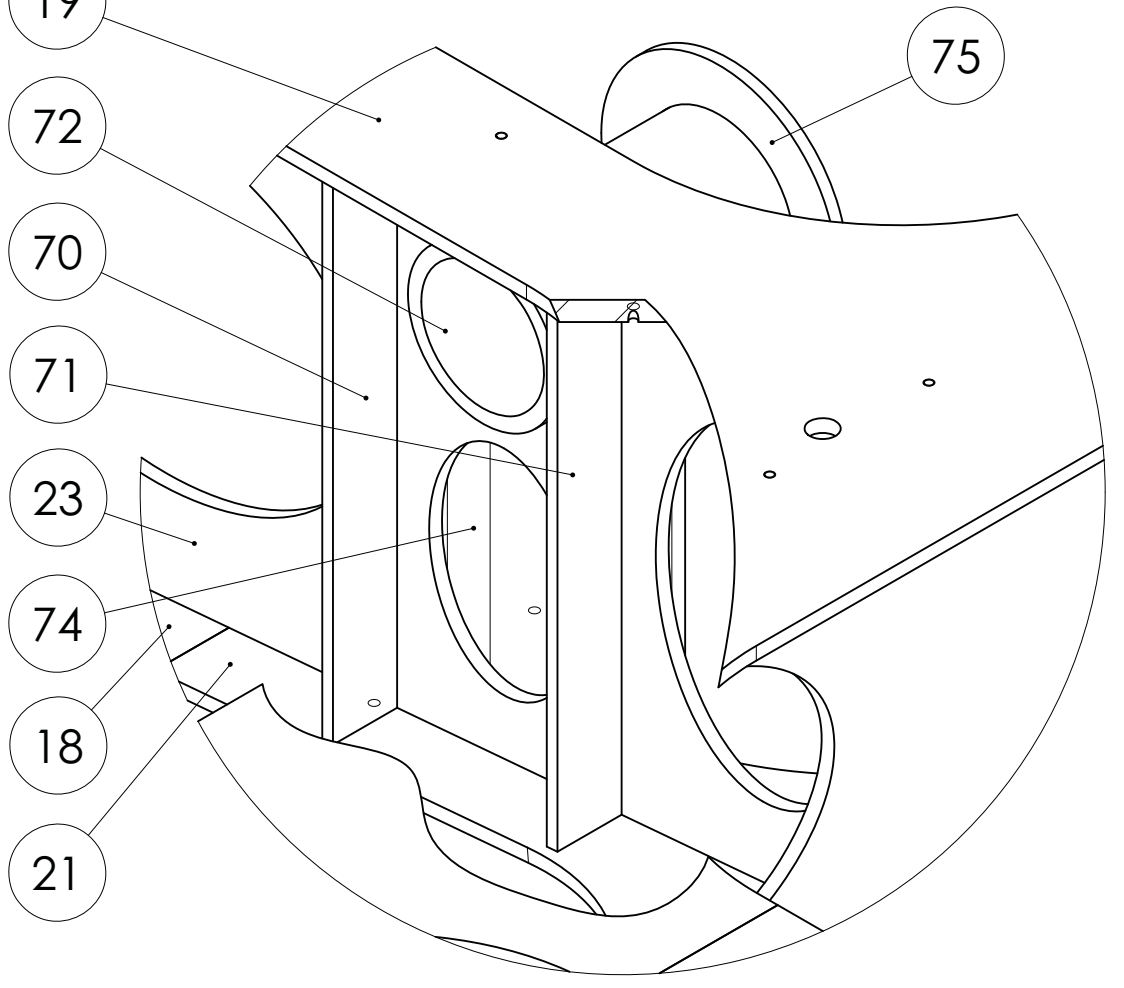
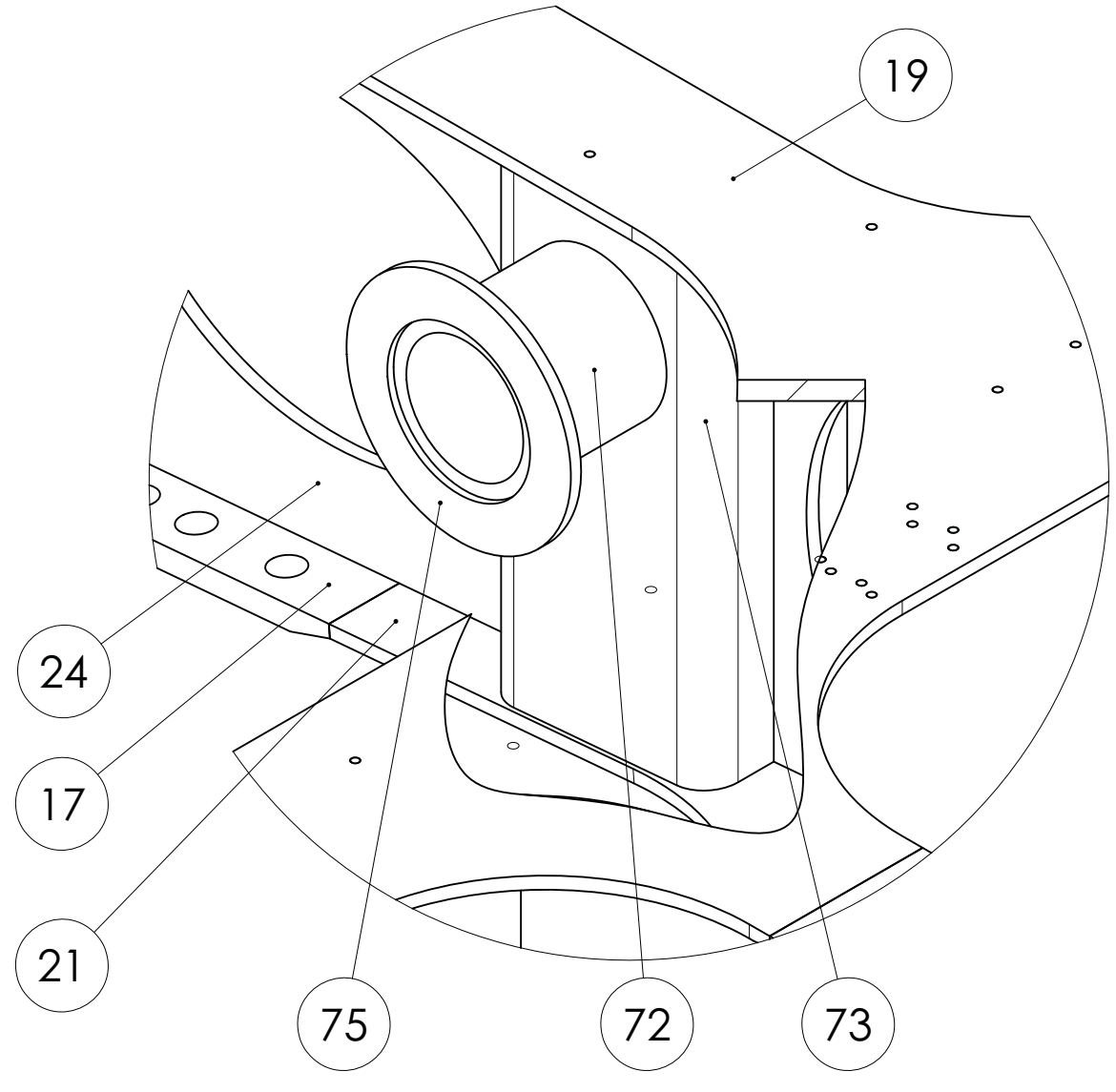
all missing dimensions and free form shapes in accordance with 3-D-model: DC-154.2-MF.GE.CT.01.00.00.01-A-A

Revision	Modification	Drawn	Designed	Checked	Project Manager	Management	Material	Date
							S355J2+N - 1.0577	2022-09-06
								Scale 1:20
								Weight 6986 kg
Title Description								Rev. No.
Generator Frame								A
Project								Sheet
Drawing Number								2/8
Specification Number								
SP-154.2-00.MA.00.00.00.01-A								
ECH Number								
Copyright reserved								
Refer to protection notice ISO 1616								
SolidWorks (R)								



DZ 1 : 5

DY 1 : 5



All machining and drilling has to be done after welding of the complete frame.
 All single part dimensions have to be double checked by the manufacturer.
 At single part views the welding preparation and the machining allowance has not been considered.

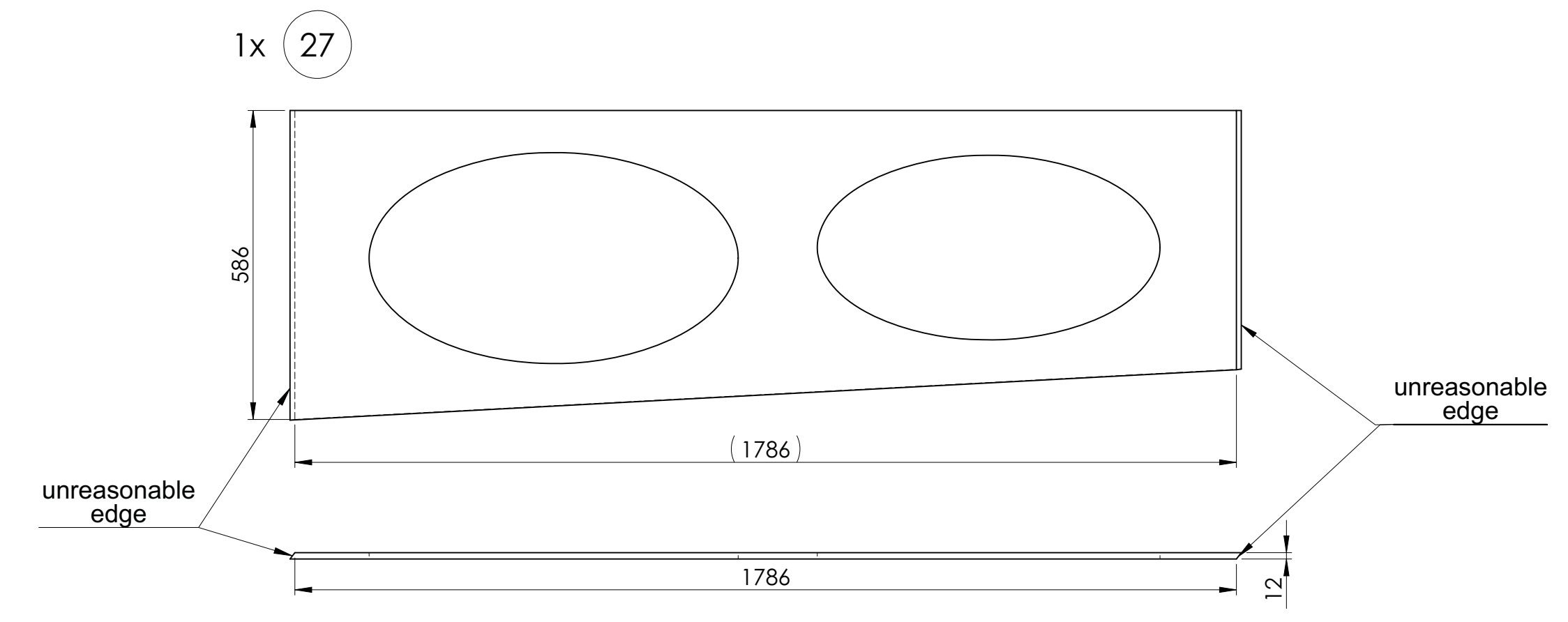
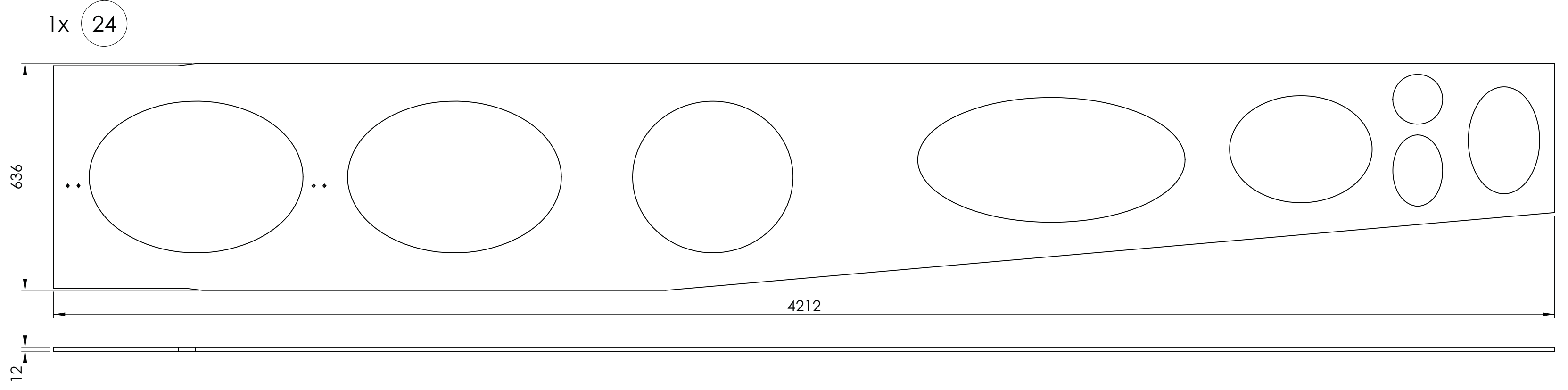
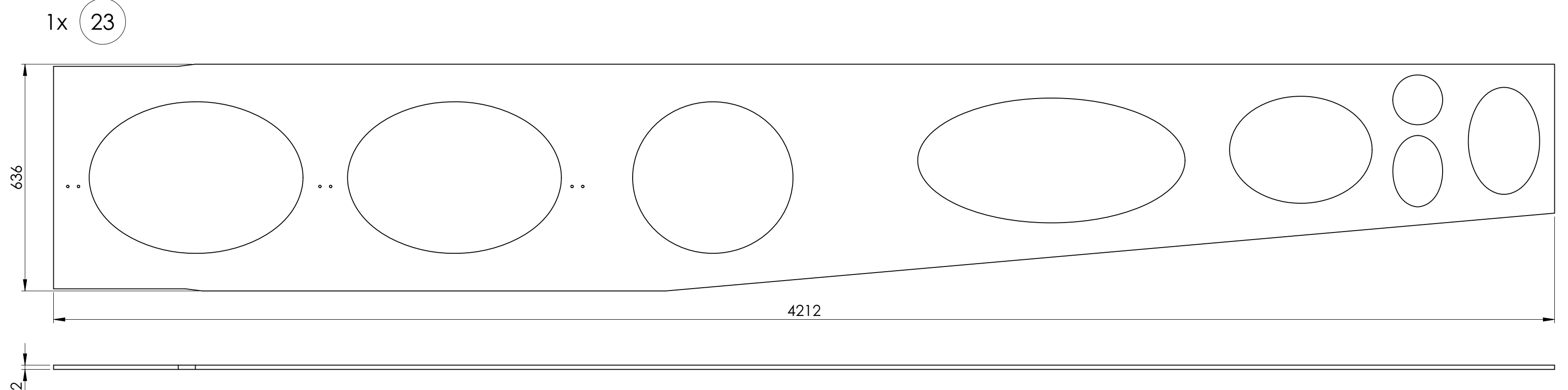
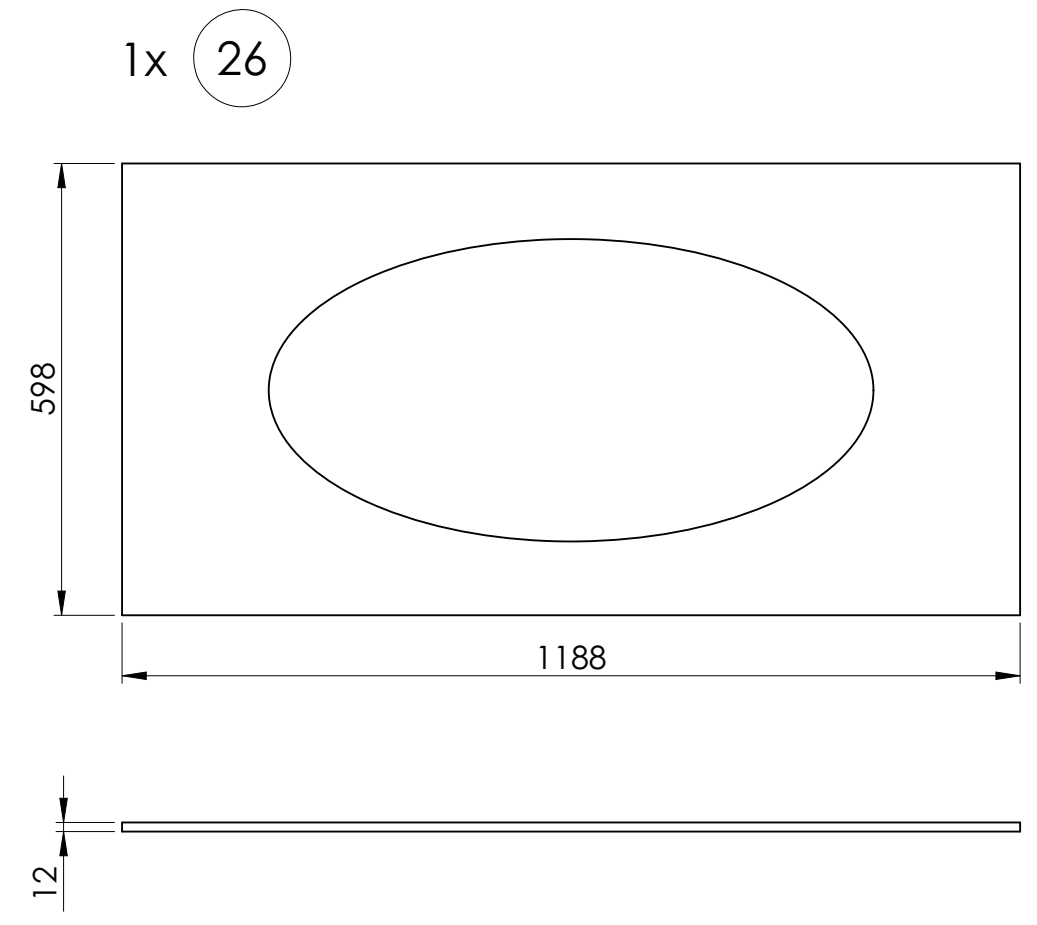
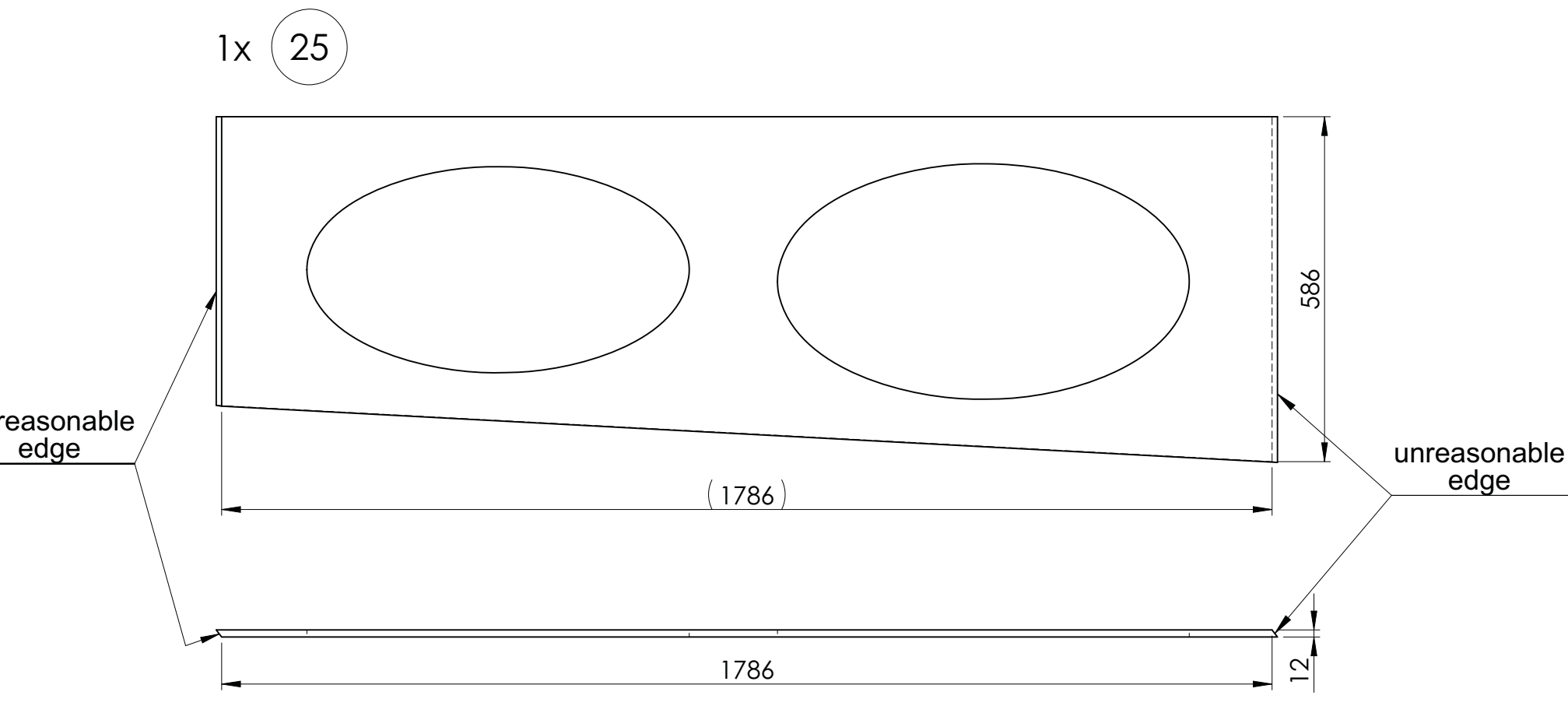
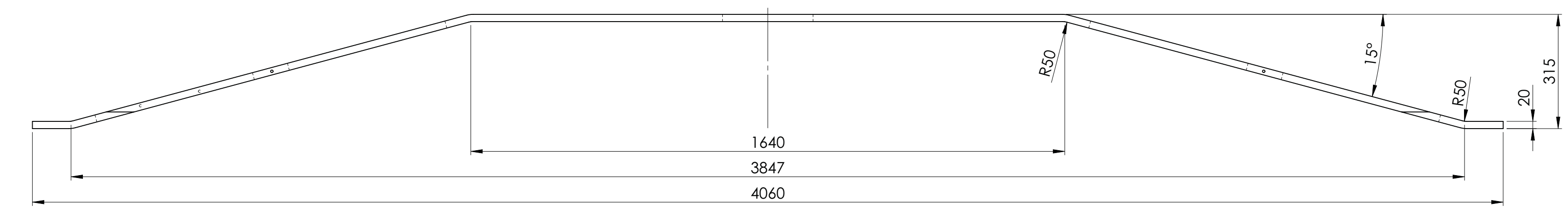
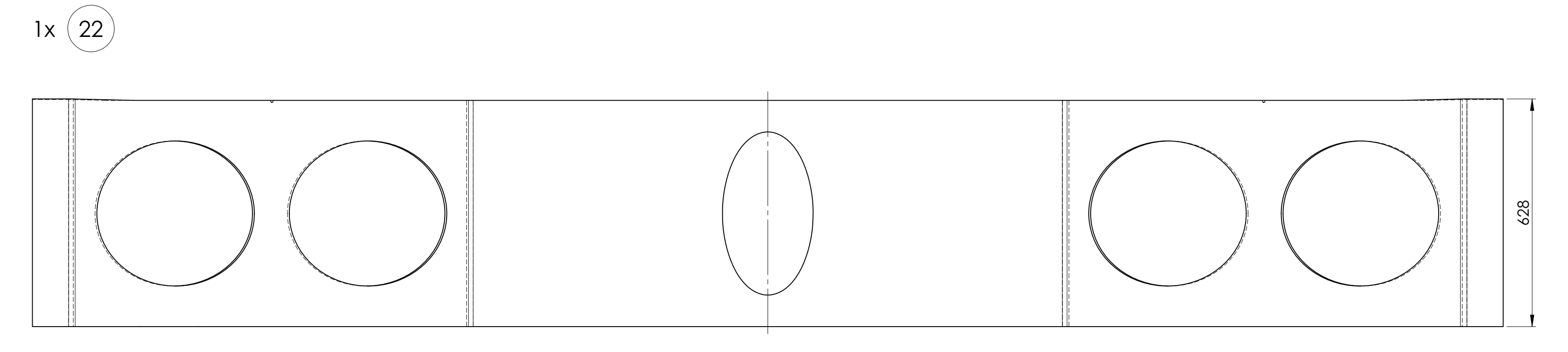
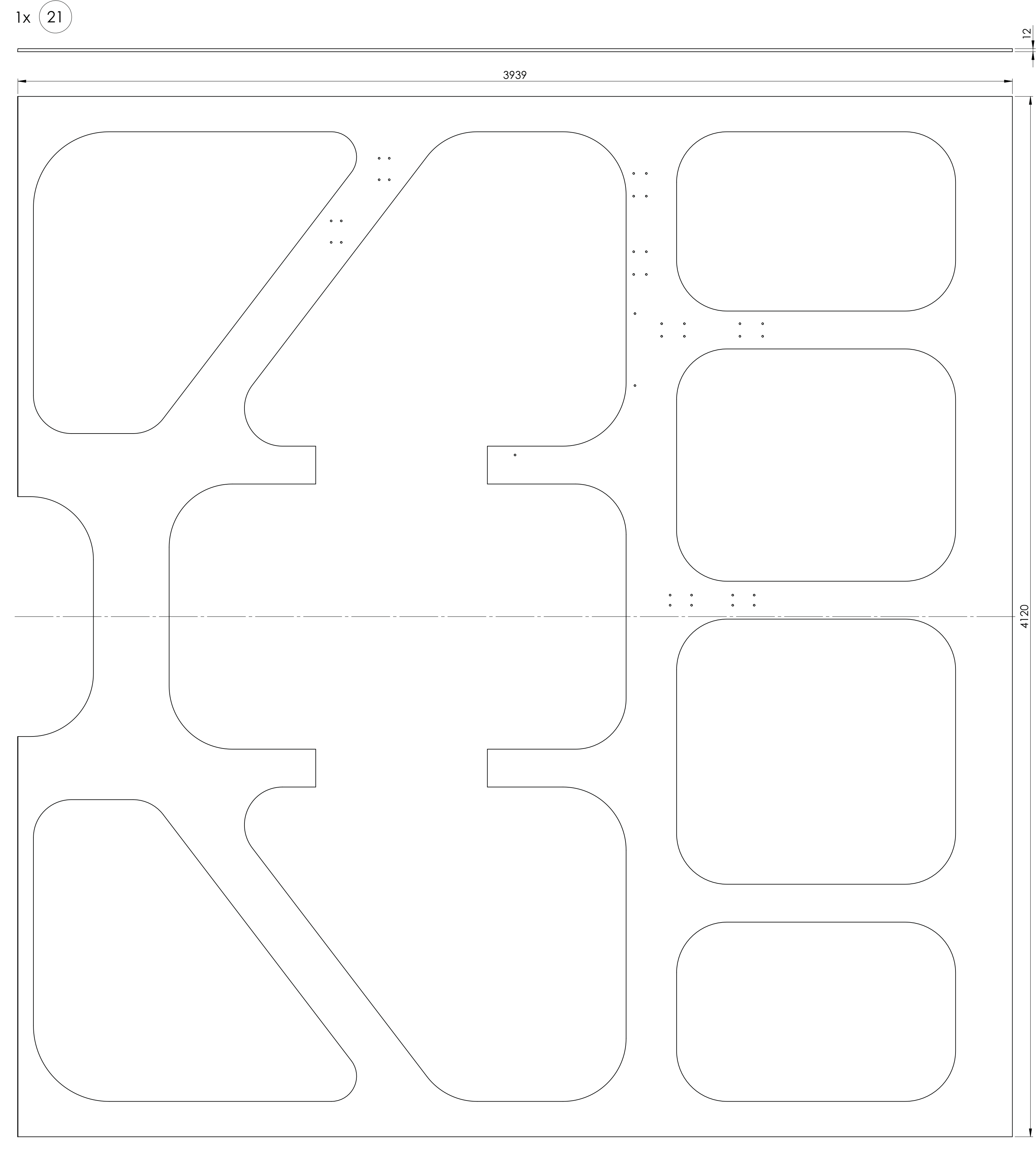
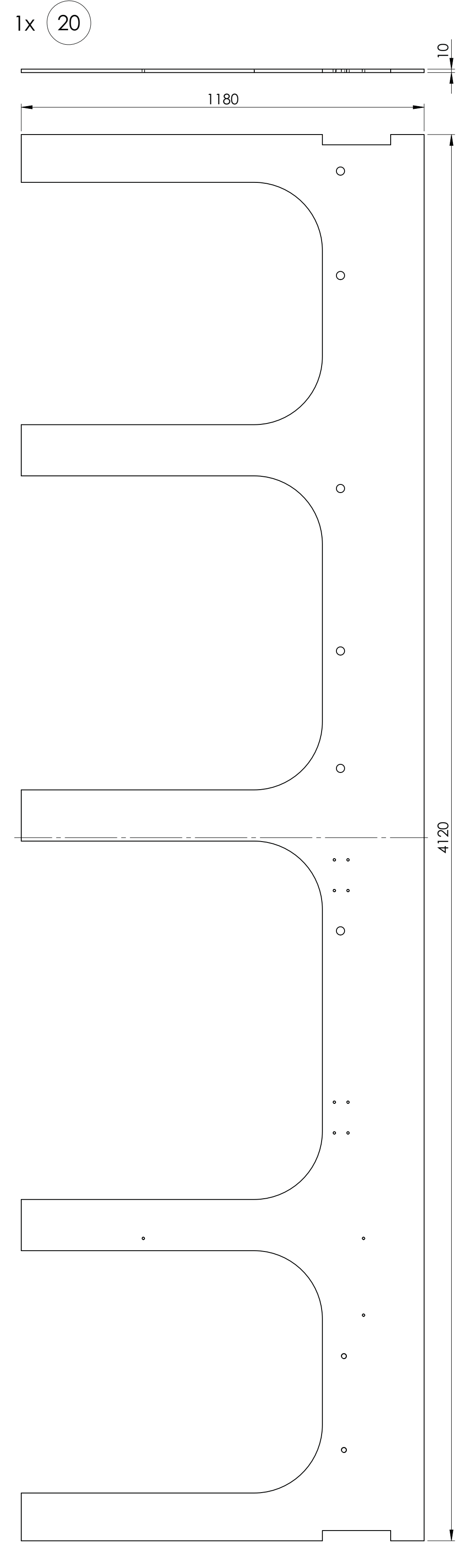
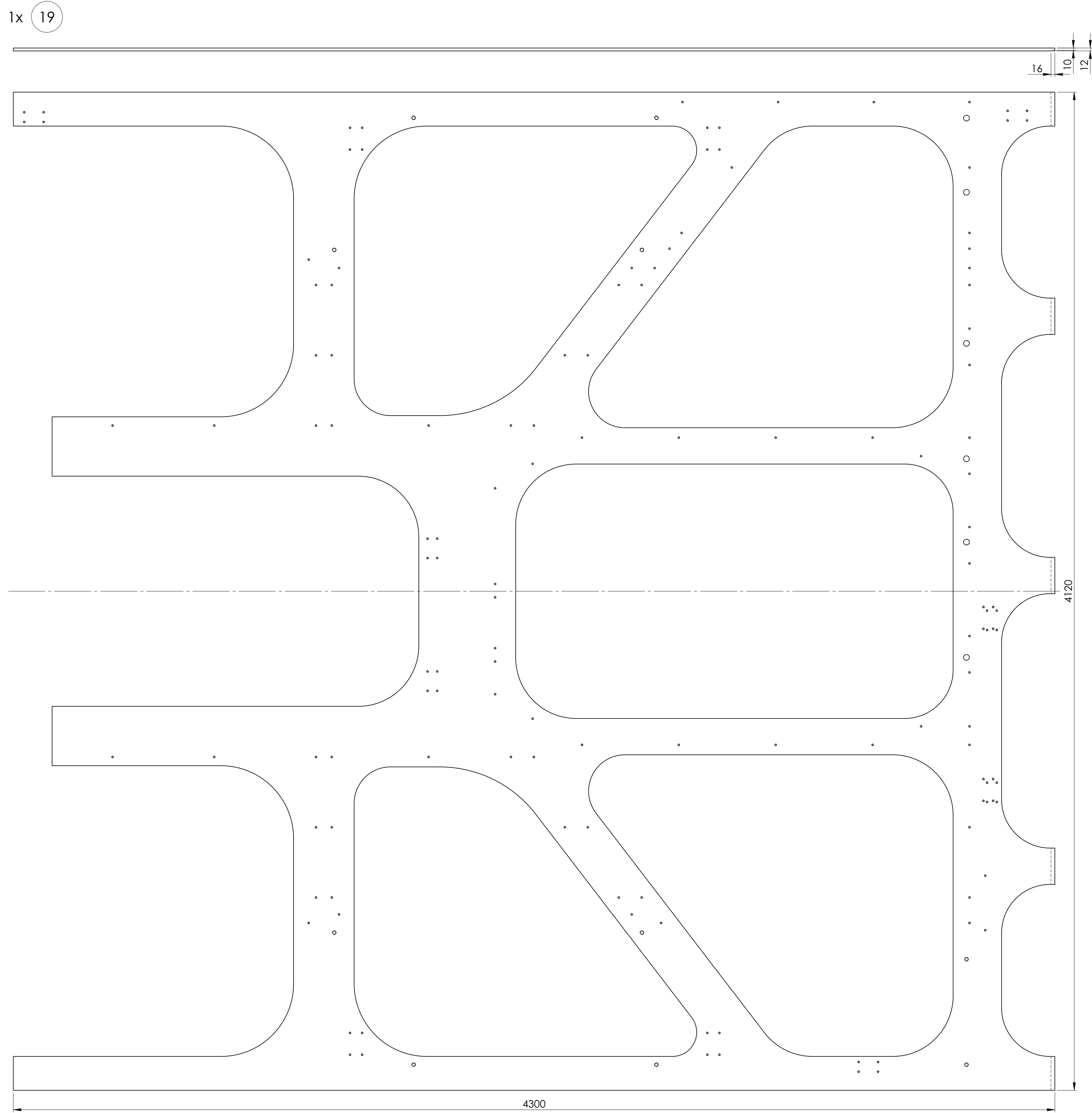
Heat treatment must be applied according to the "Manufacturing of Welded Parts" specification **SP-154.2-00.MA.00.00.00.01-A**, chapter 3.3 "Post Treatment of Welded Structure"

✓ (Rz 25)
 Surfaces EN ISO 1302

For coating system codes (S-01 to S-12) at surface texture flags see corrosion protection specification **SP-154.2-00.CO.00.00.00.01-A**, chapter 1.1 "Drawings".
 Use **S-03** or **S-05** for all surfaces without individual flags. Determining corrosibility category is **C2** in accordance with **EN ISO 12944**

all missing dimensions and free form shapes in accordance with 3-D-model.
 DC-154.2-MF.GE.CT.01.00.00.01-A-A

Revision	Designed	Checked	Project Manager	Management	Material	Date	2022-07-06
Drawn						Scale	1:10
						Weight	4986 kg
Tolerance ISO 8015							
DIN ISO 2768 - mH							
ISO 15715							
Title Declaration							
Project							
Drawing Number							
DP-154.2-MF.GE.CT.01.00.00.01-A							
Specification Number							
SP-154.2-00.MA.00.00.00.01-A							
ECN Number							
Copyright reserved							
Refer to protection notice (S2 1816)							
ScaleWorks®							



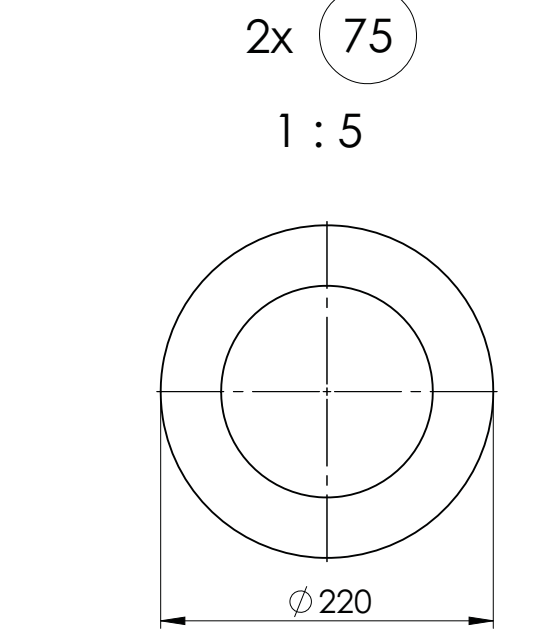
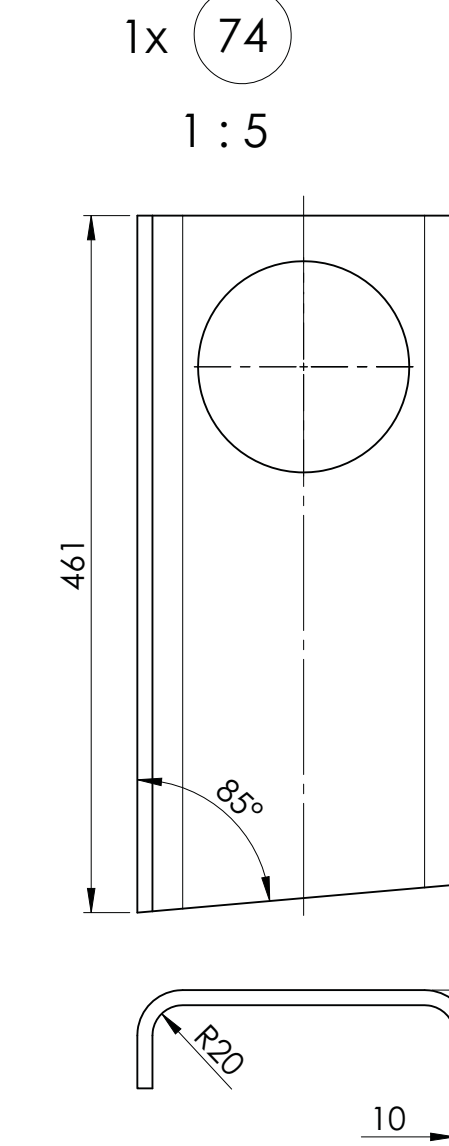
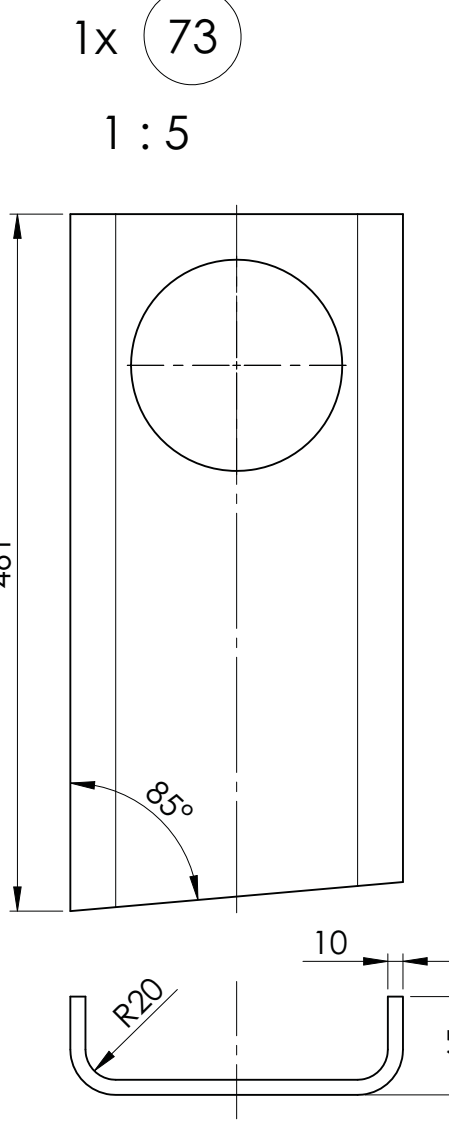
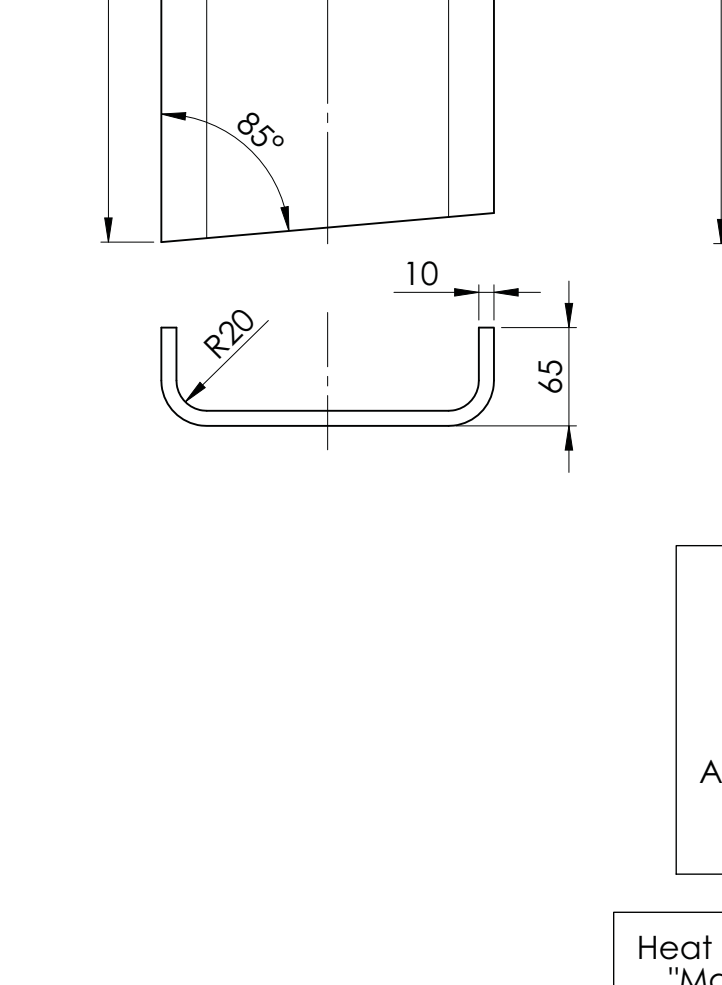
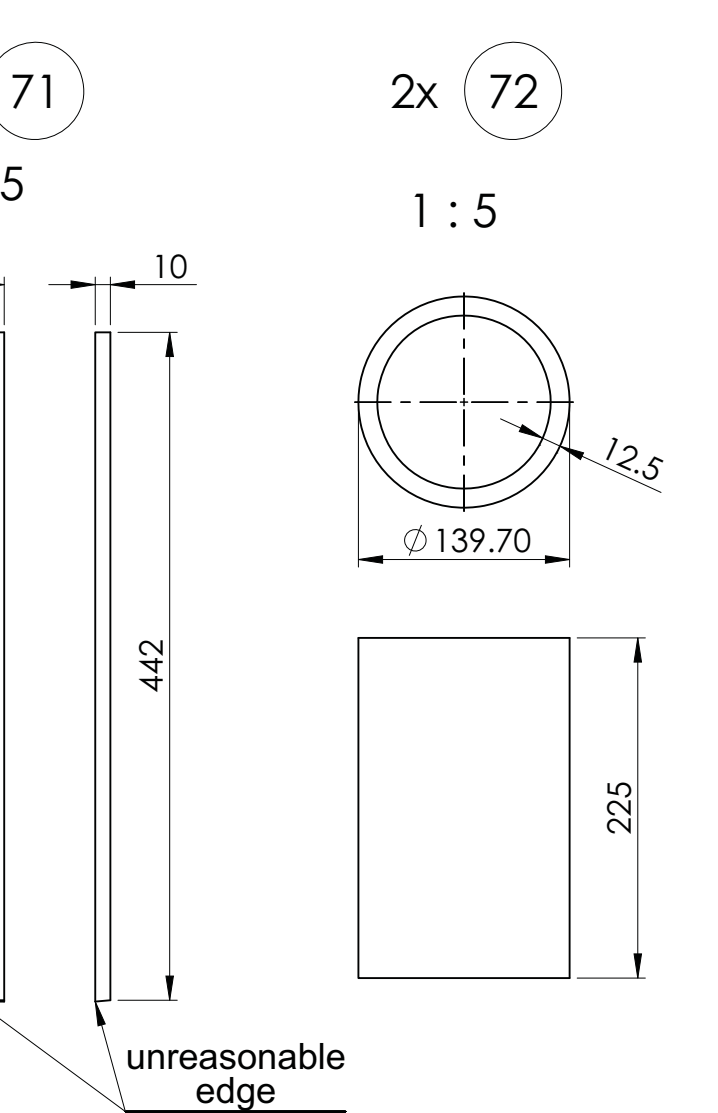
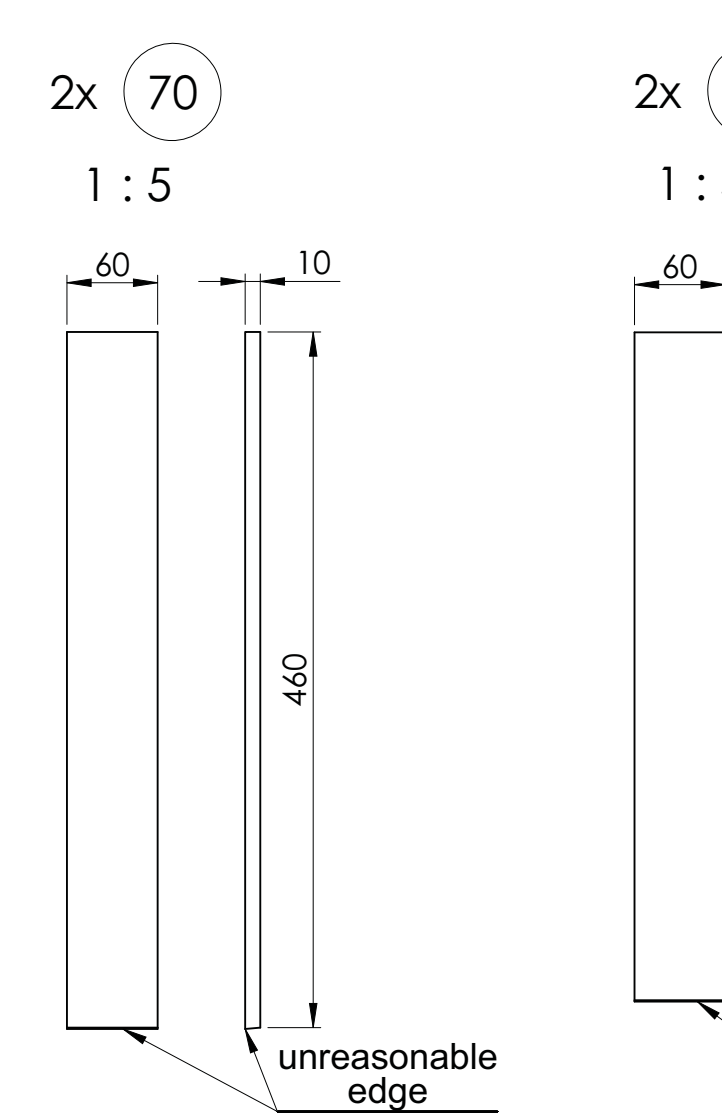
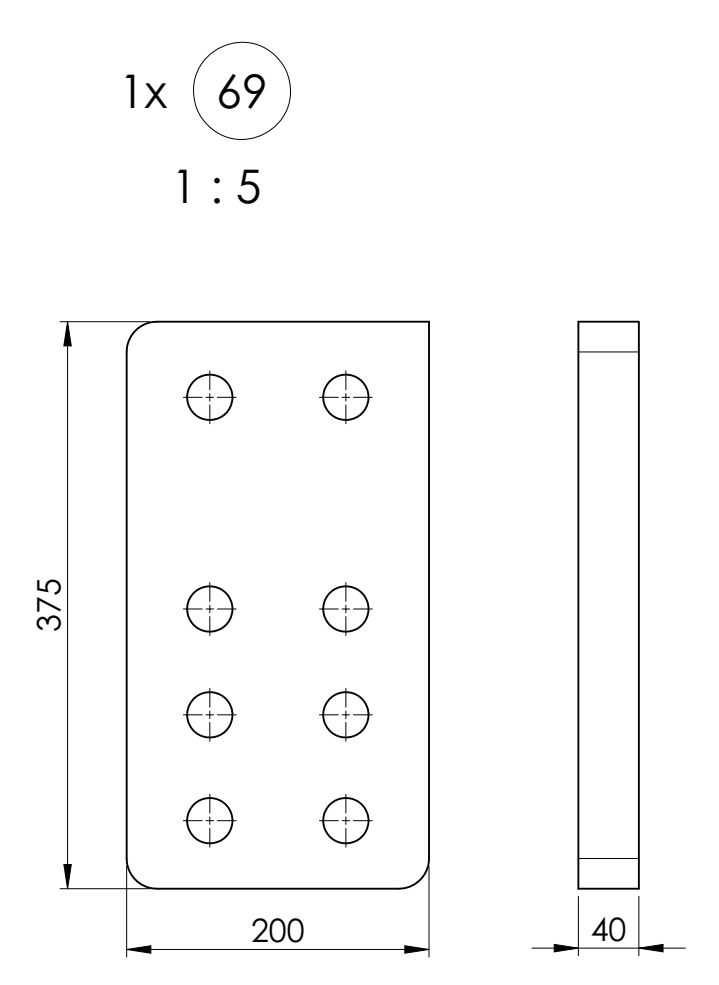
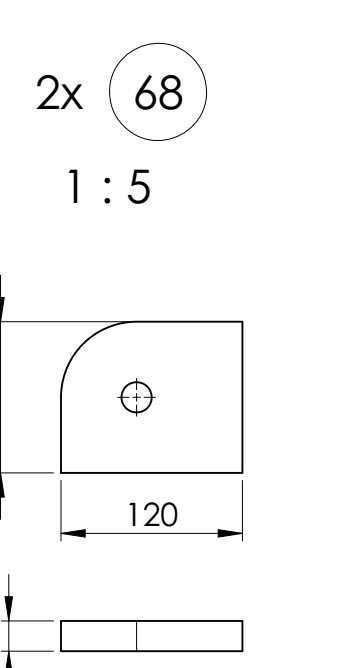
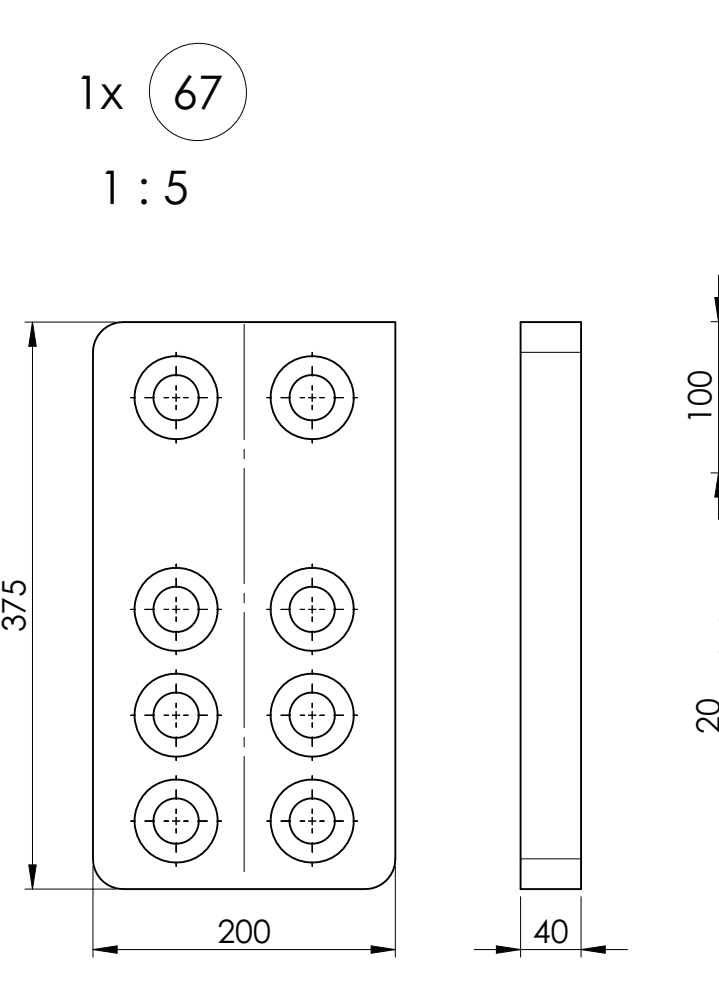
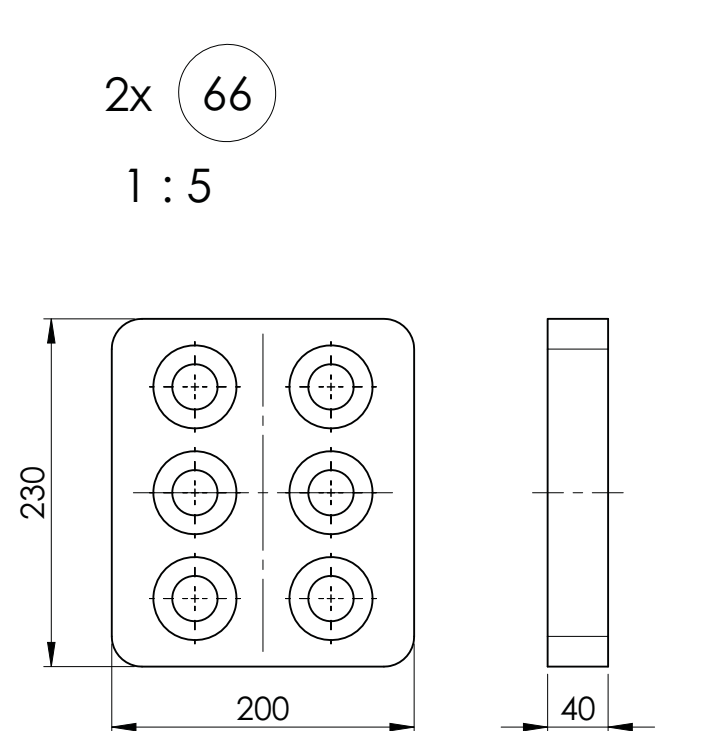
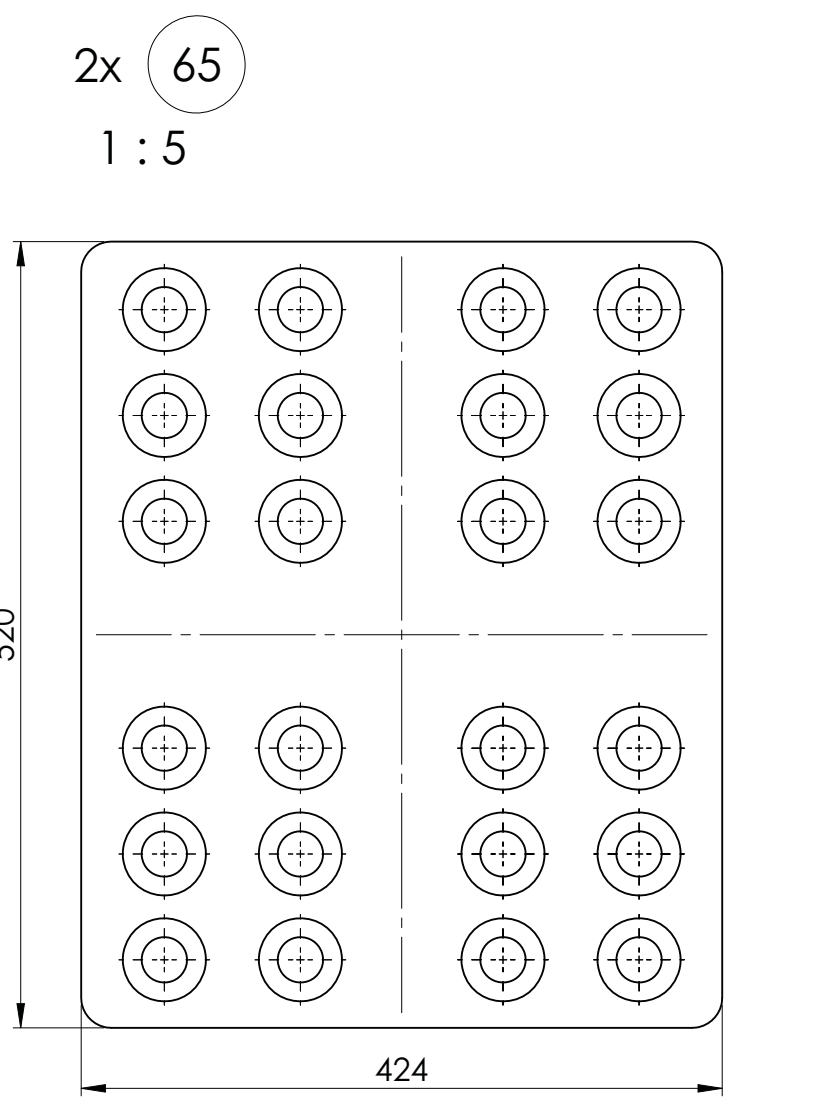
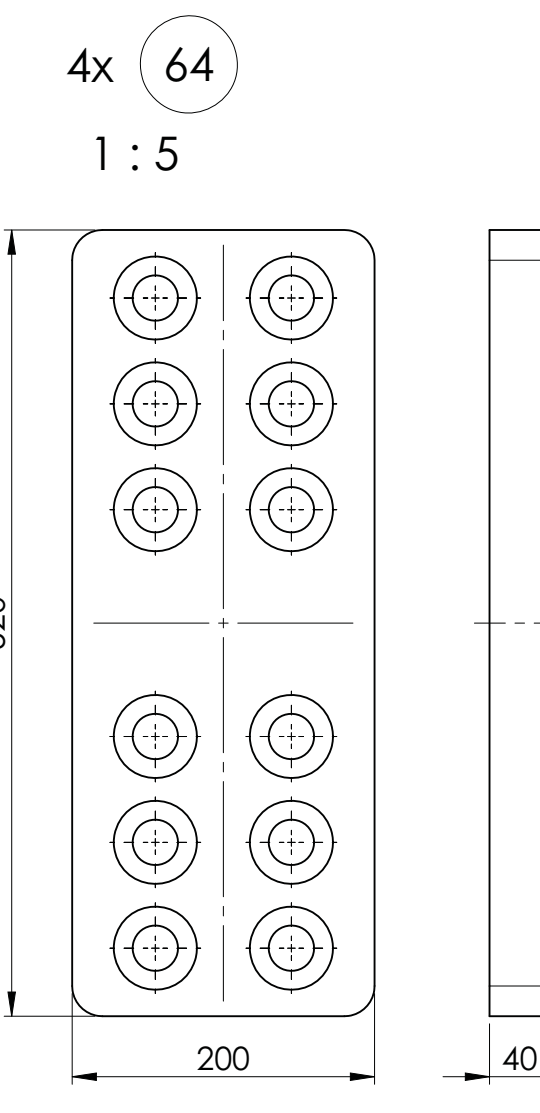
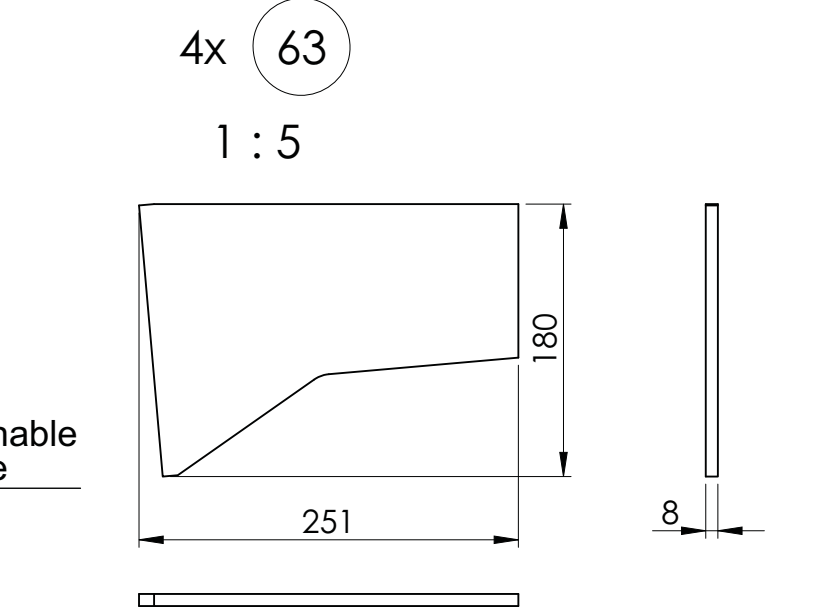
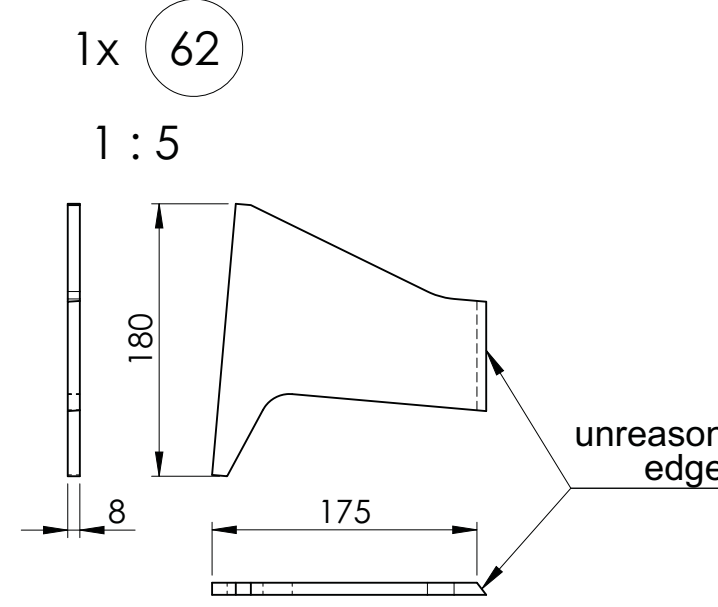
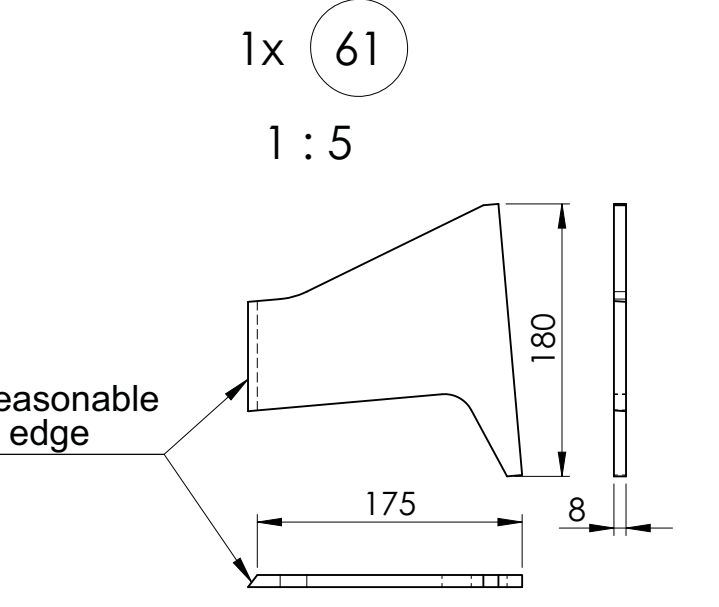
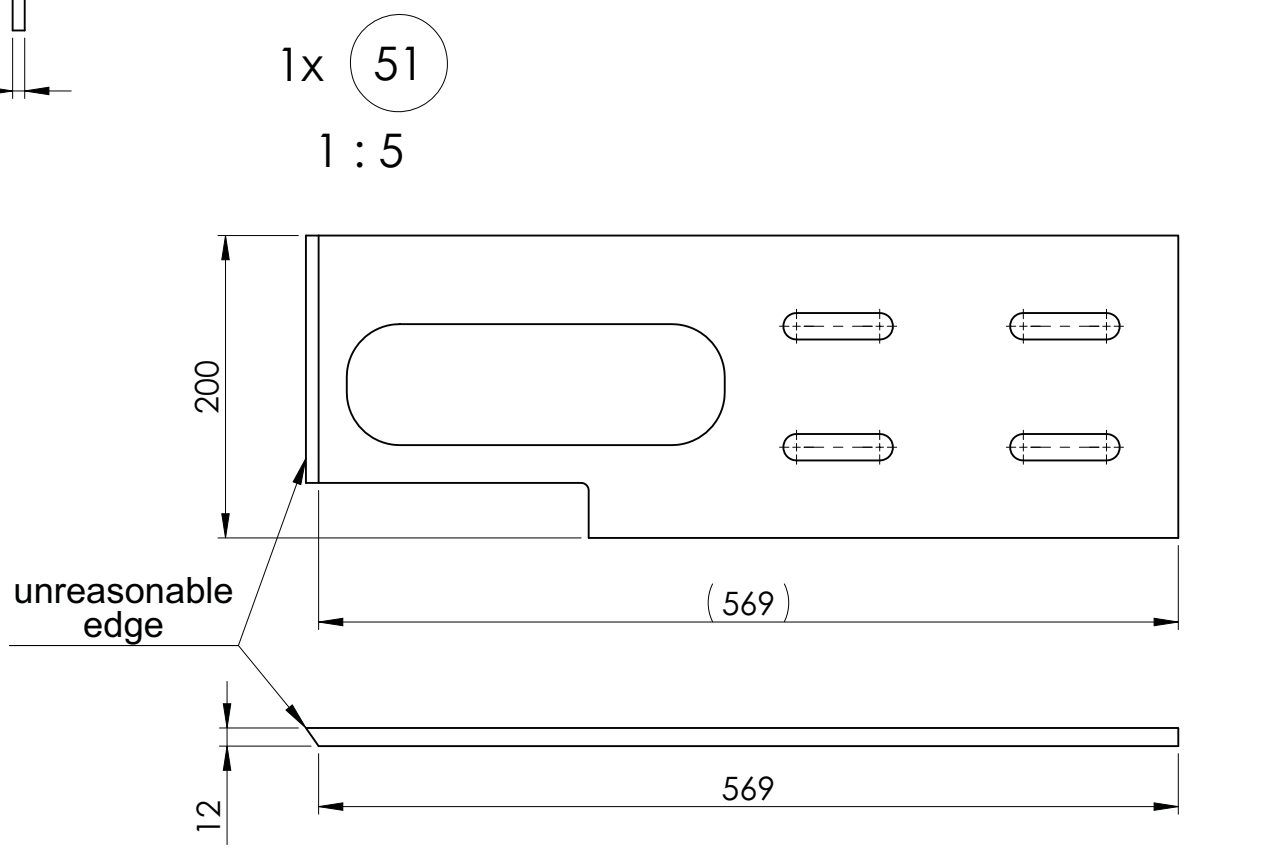
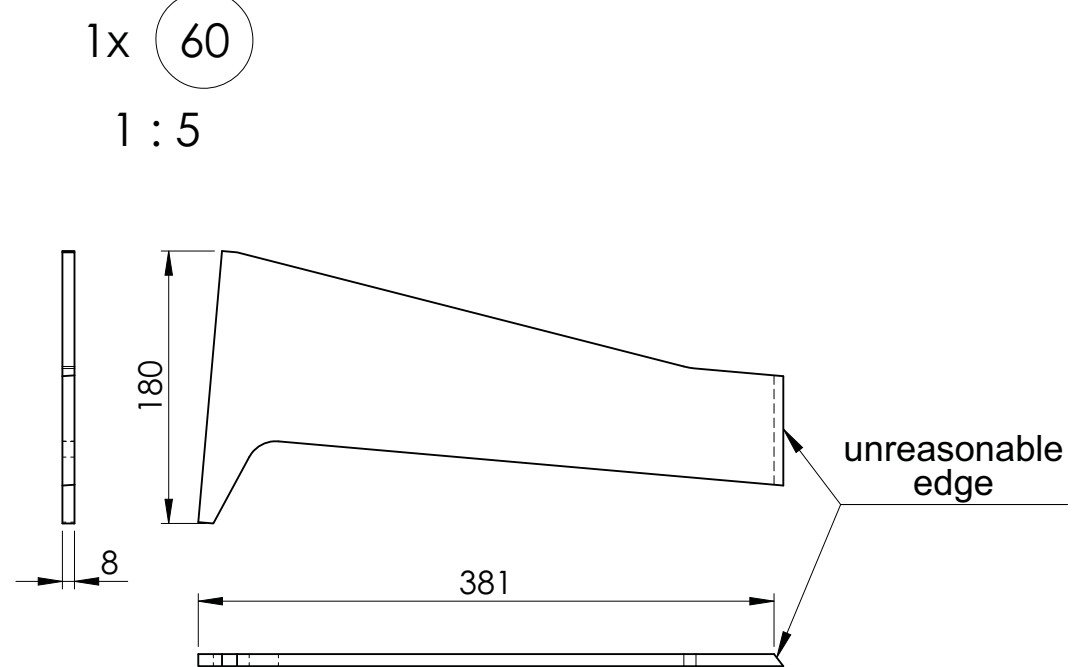
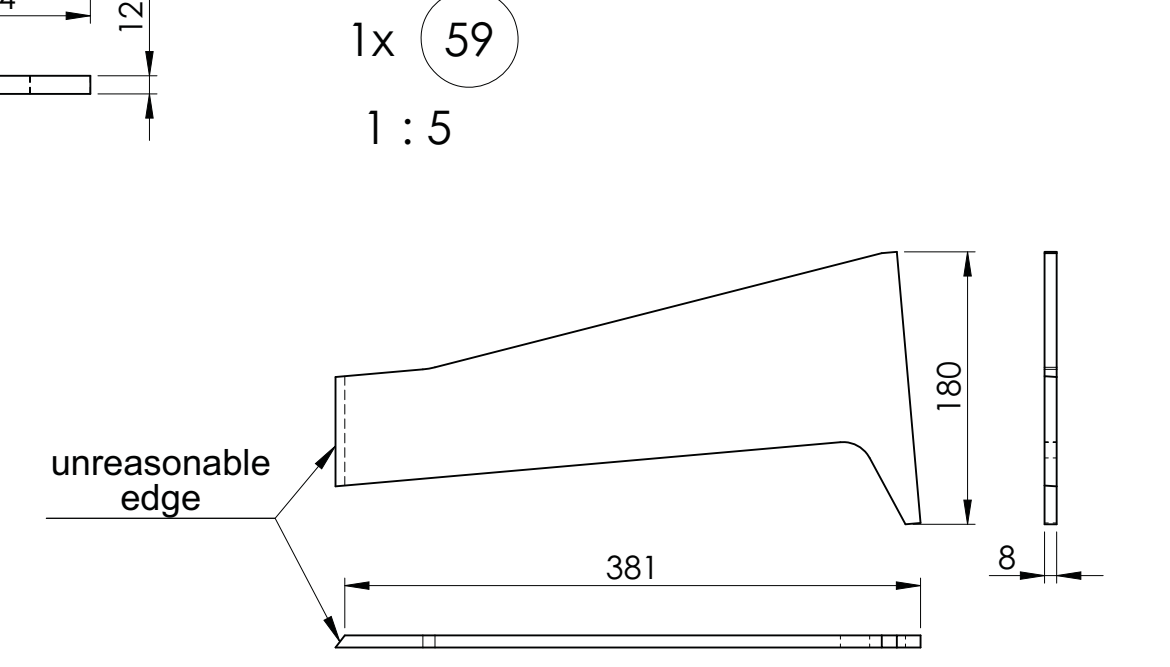
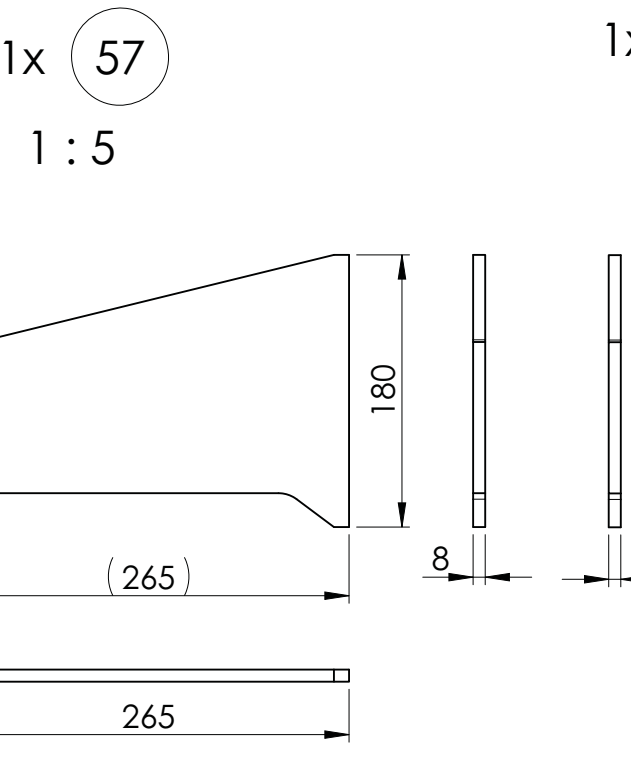
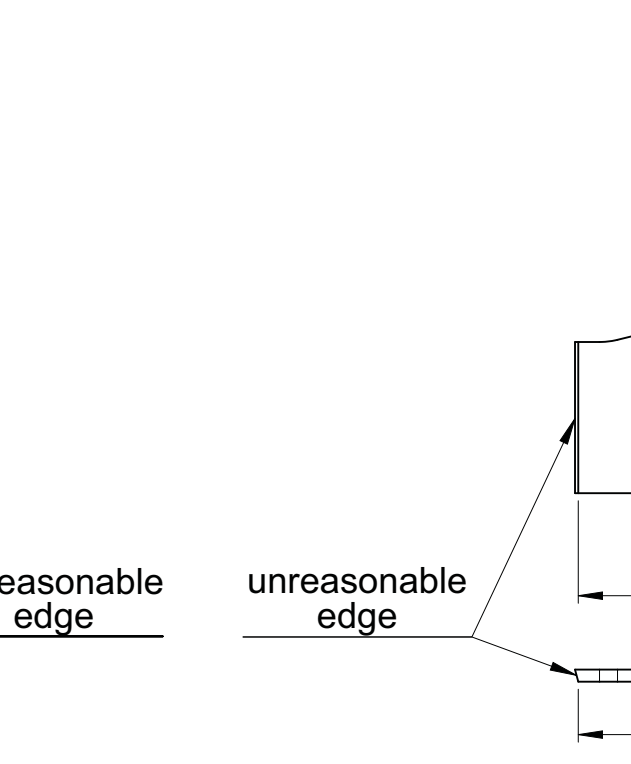
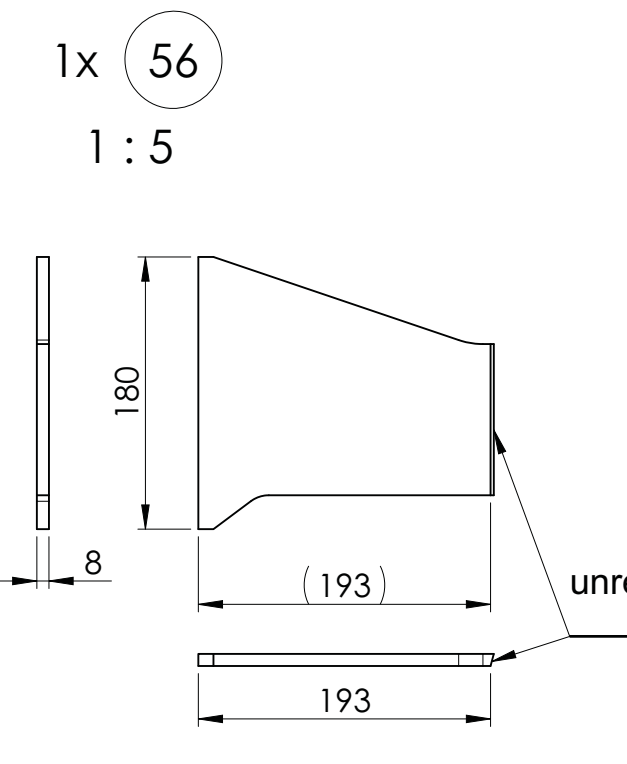
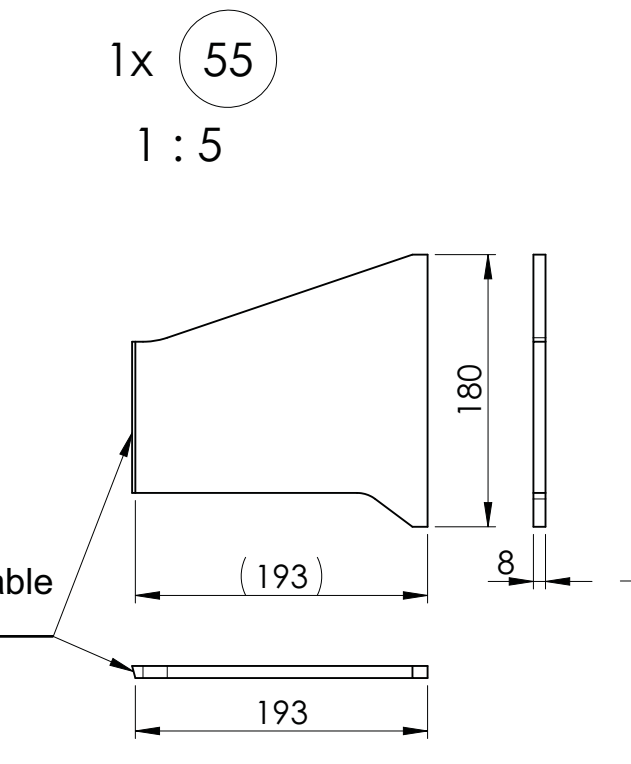
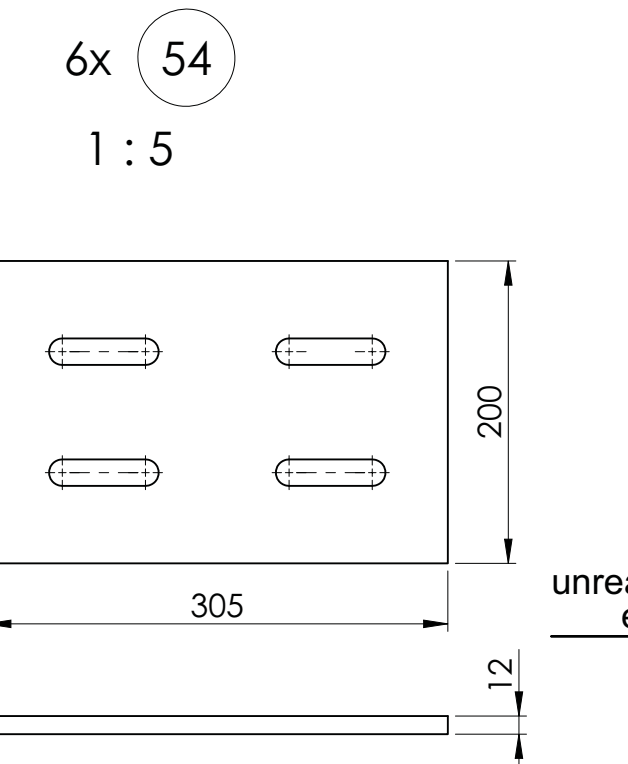
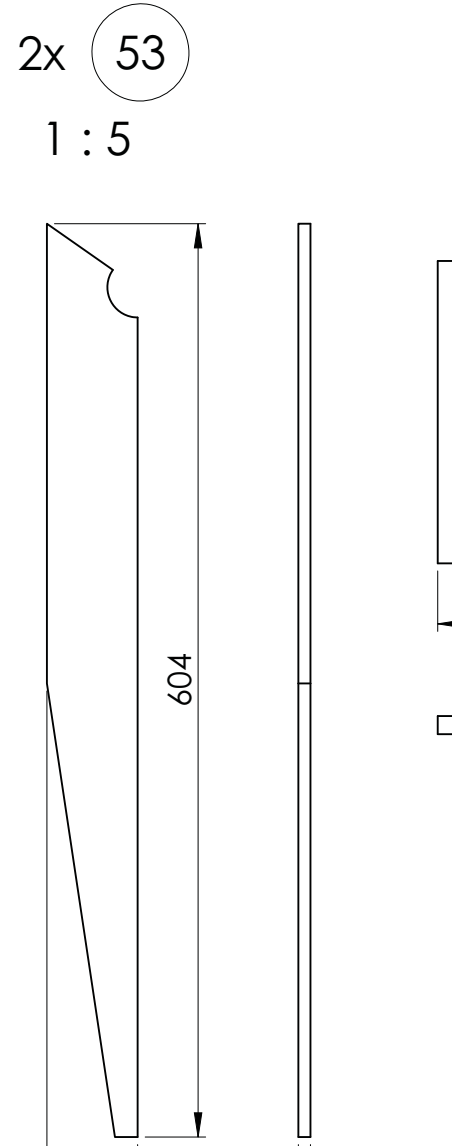
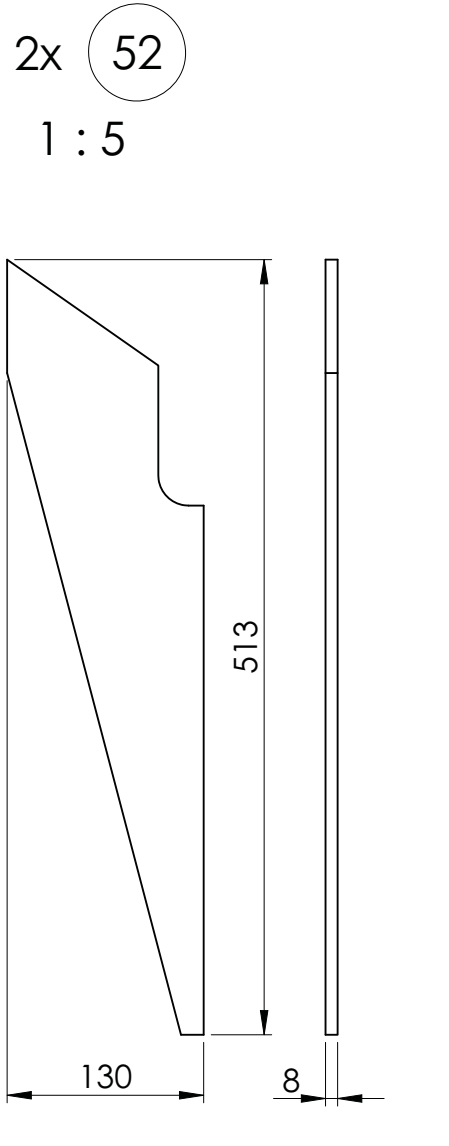
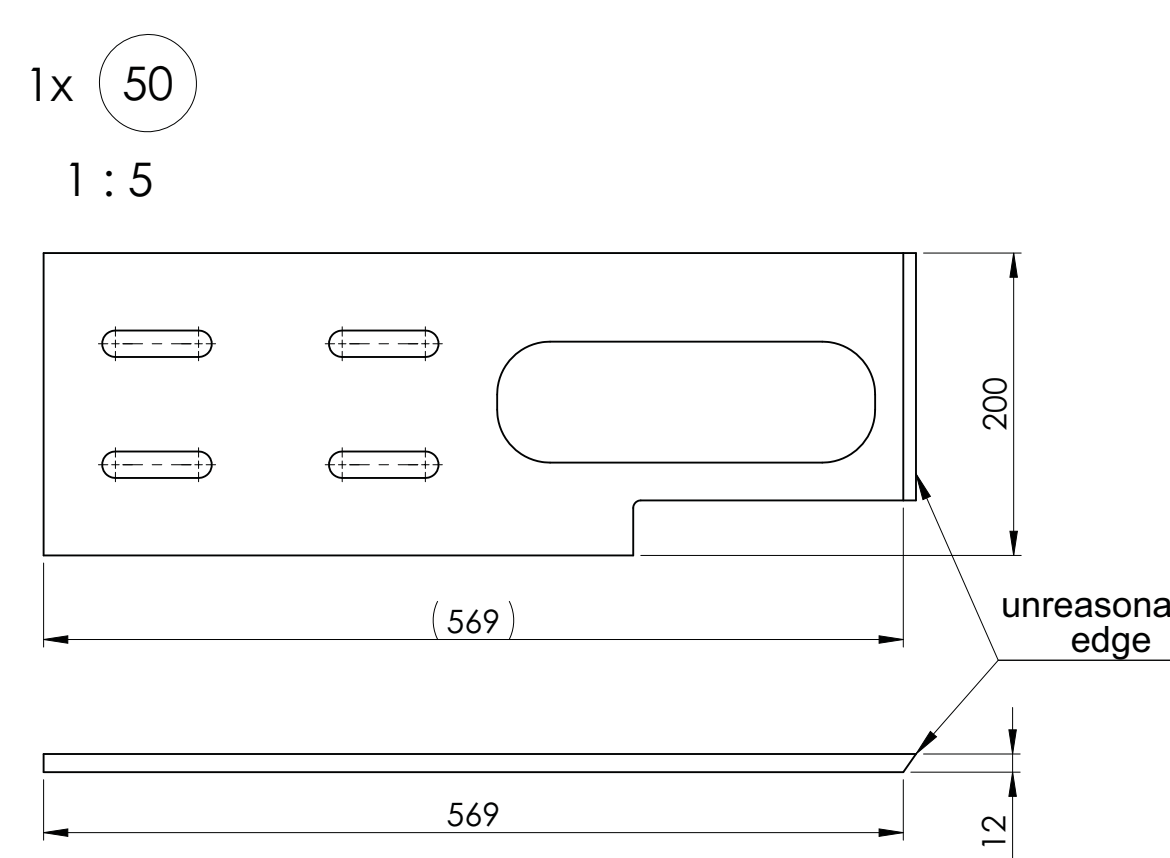
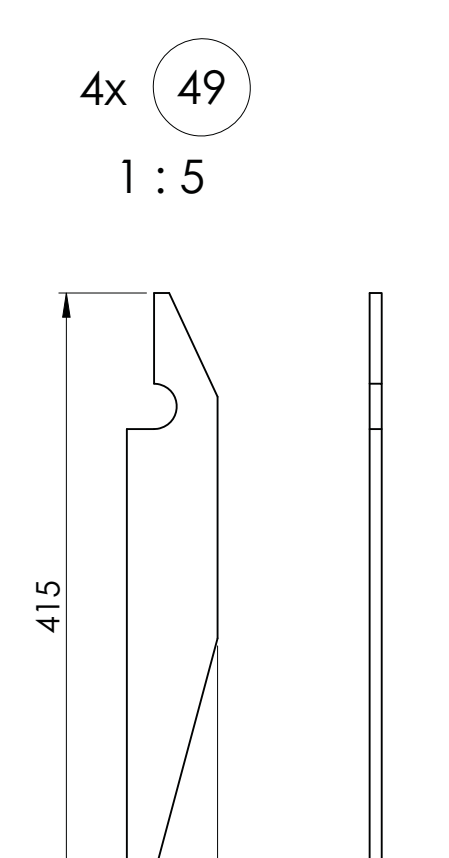
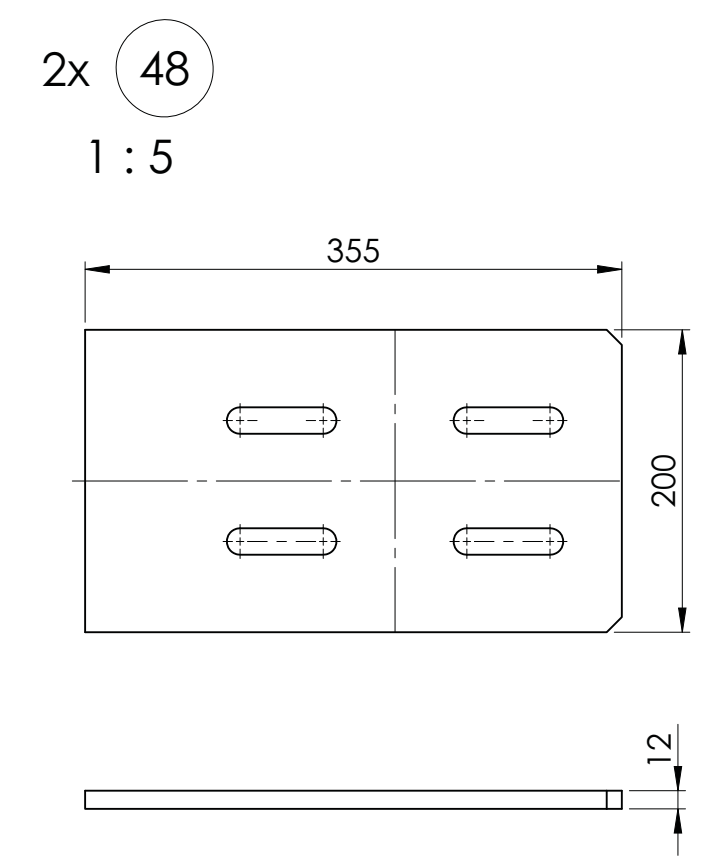
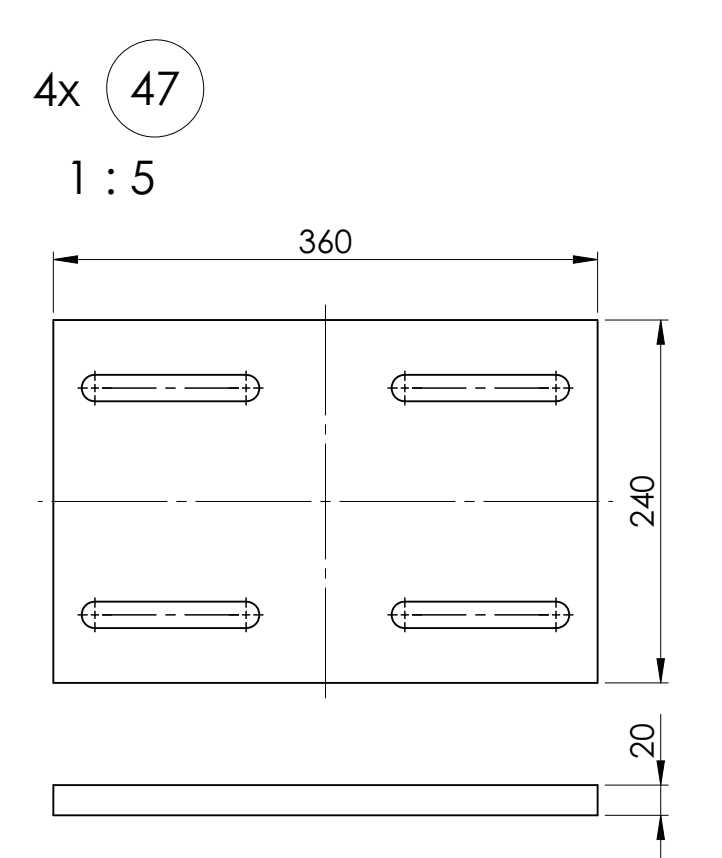
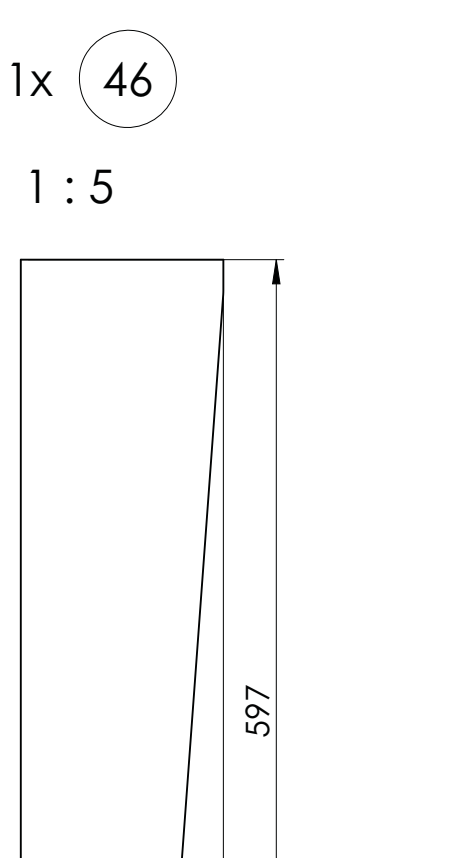
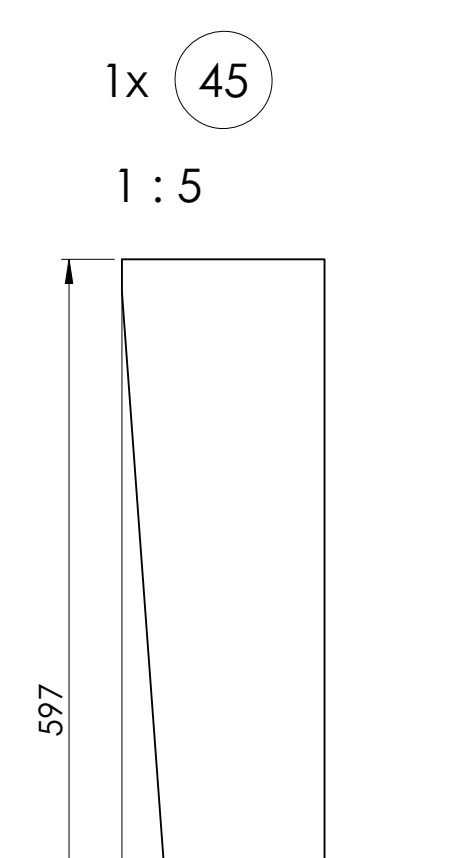
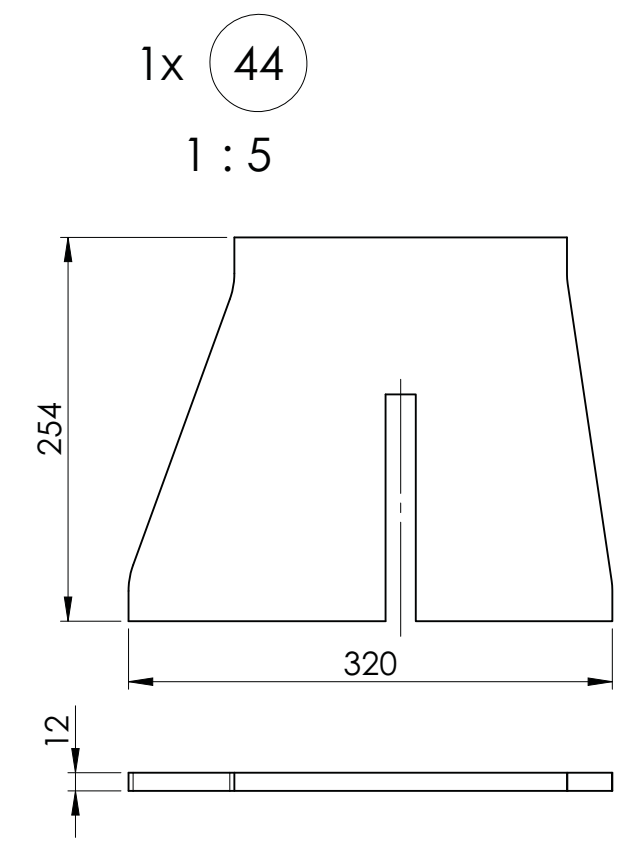
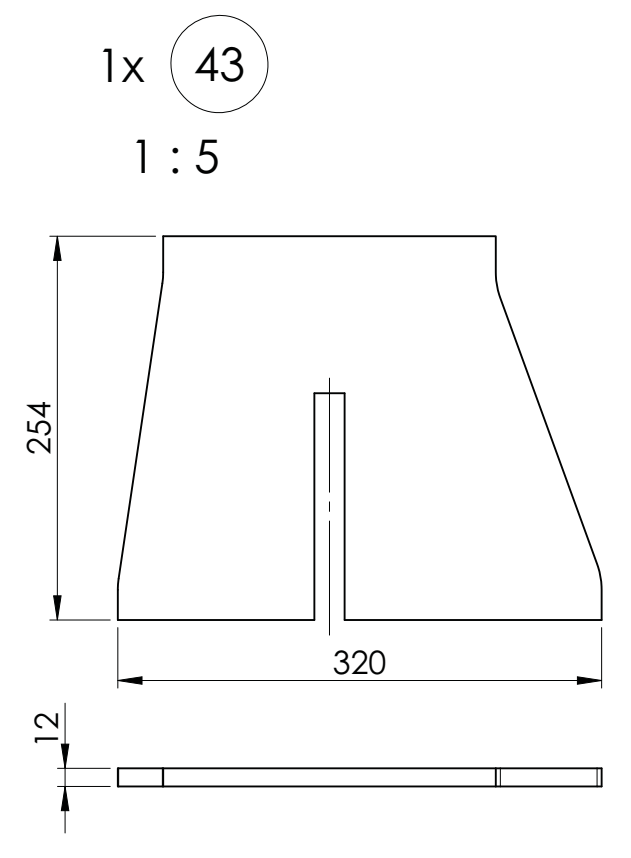
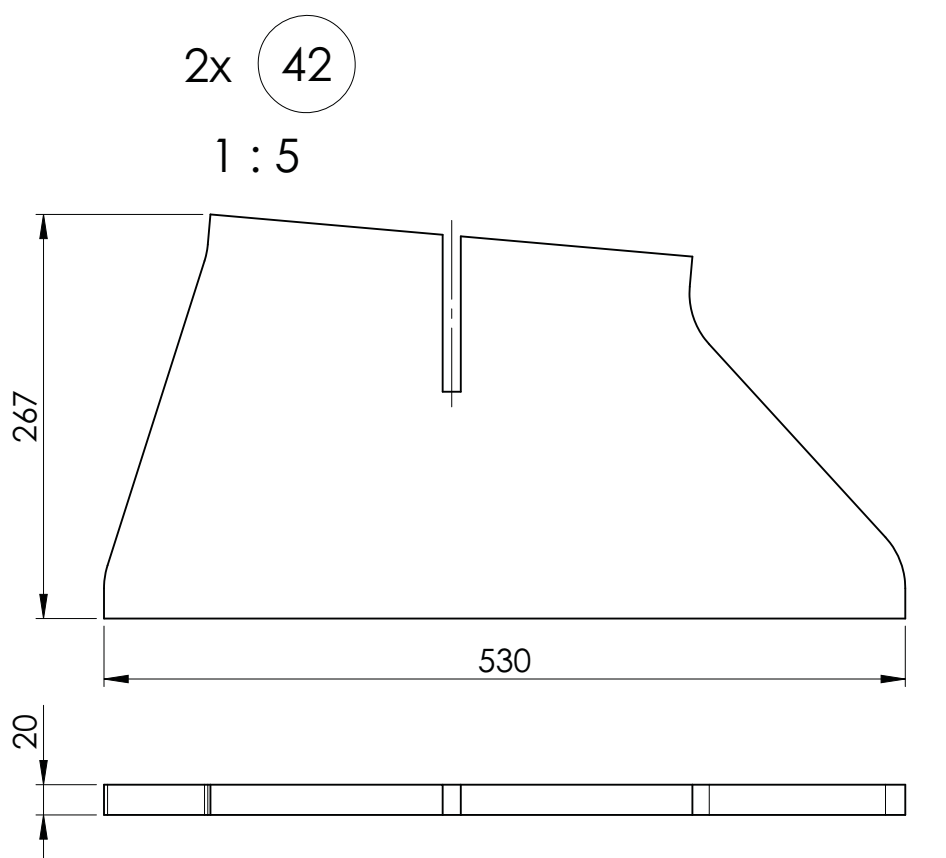
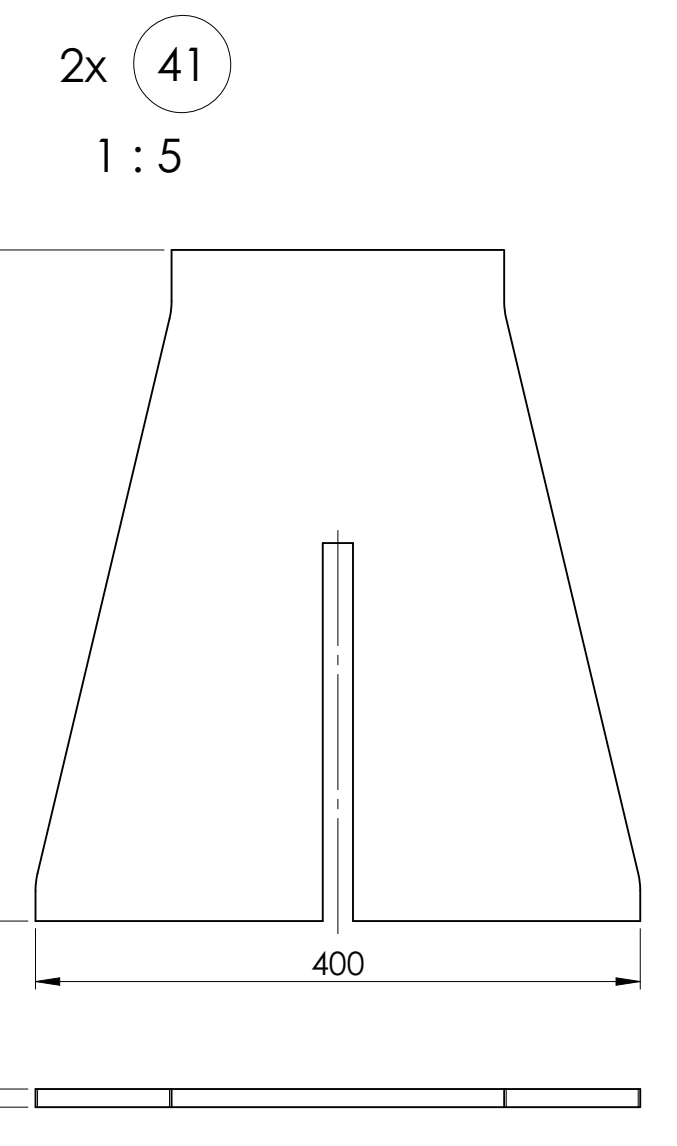
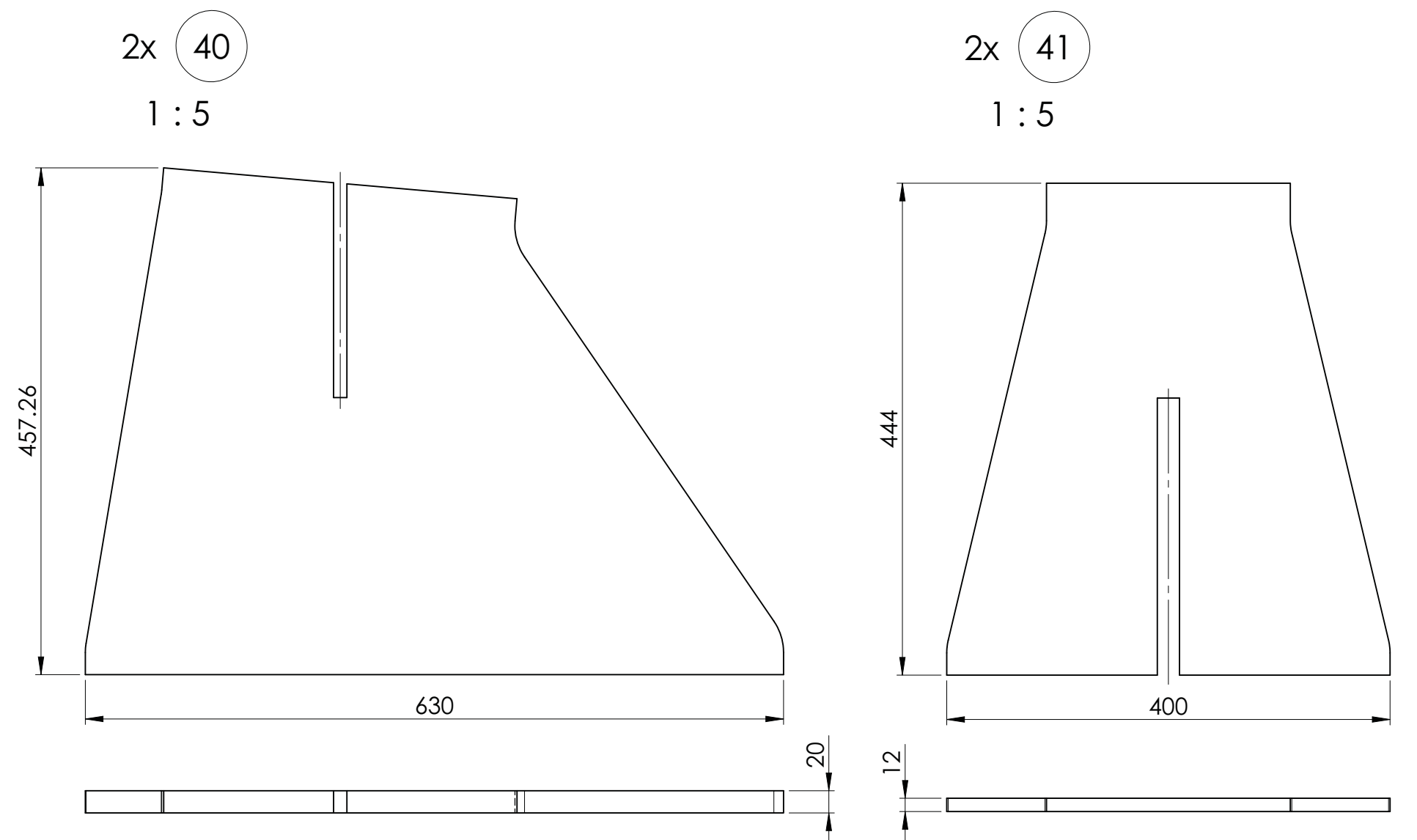
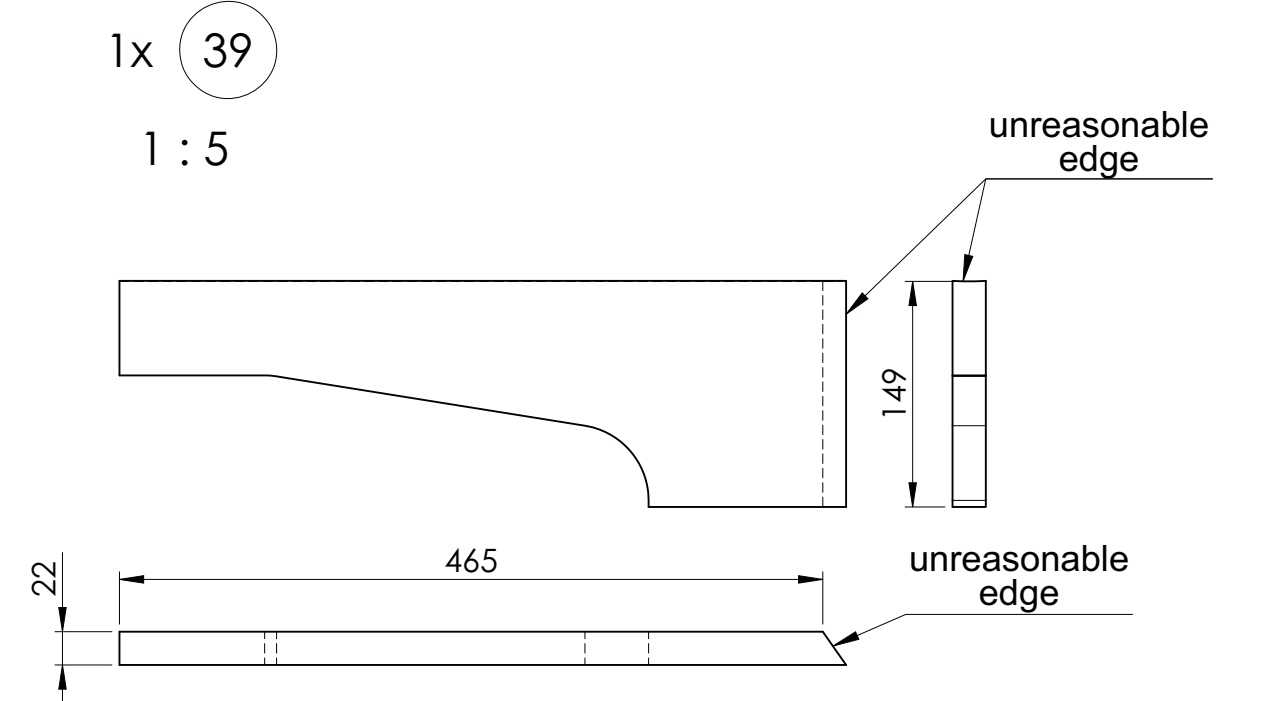
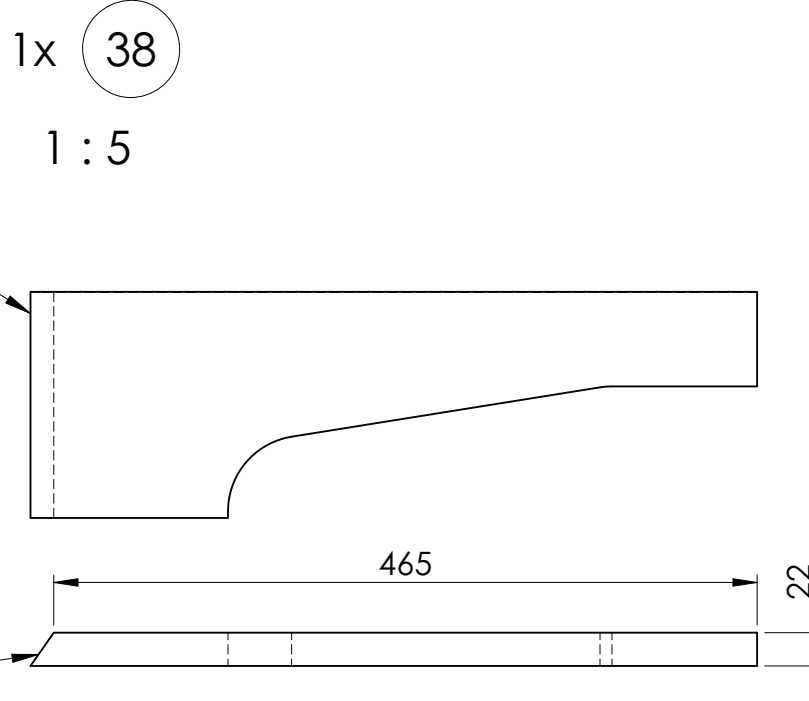
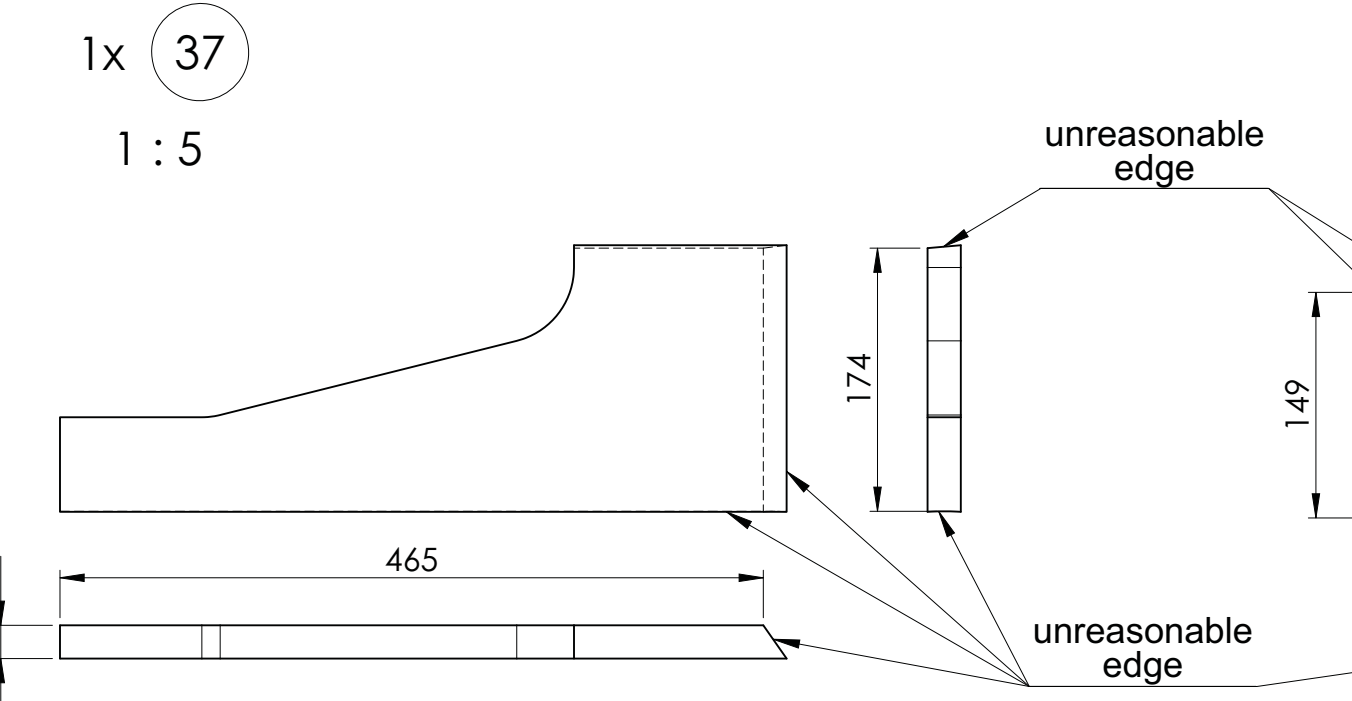
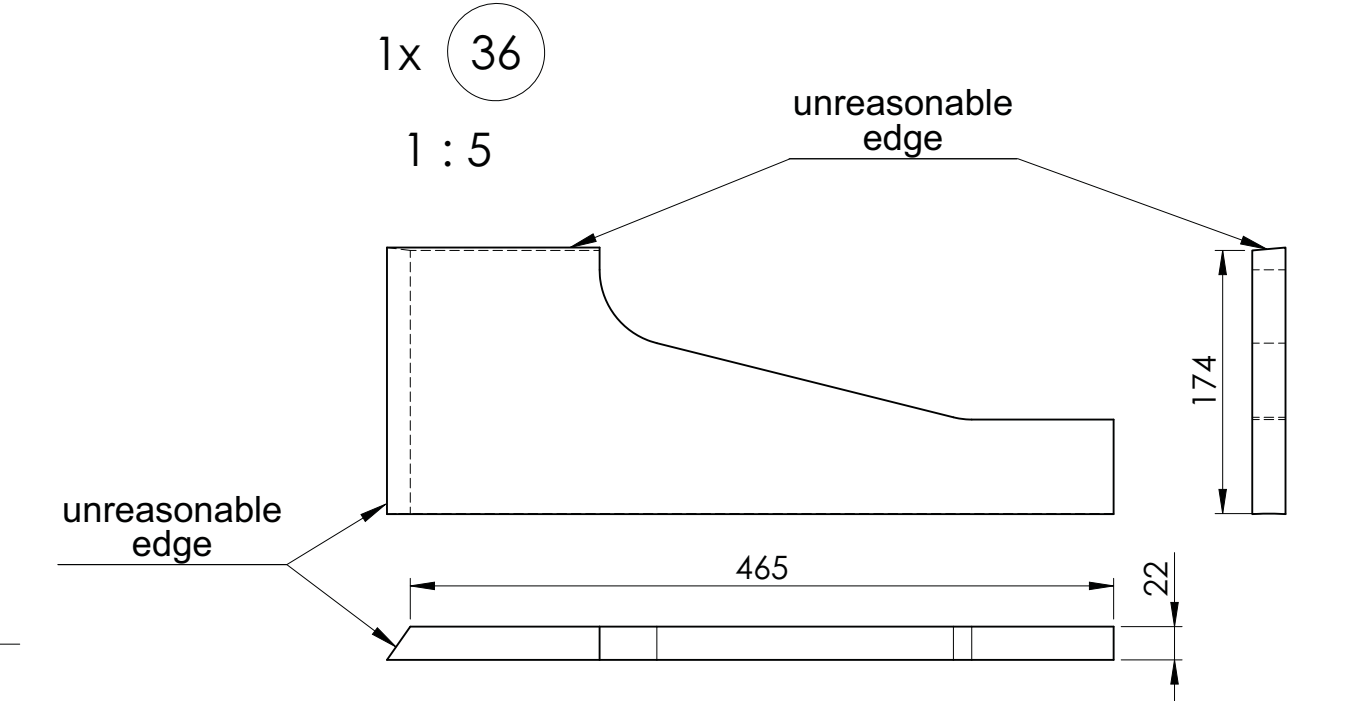
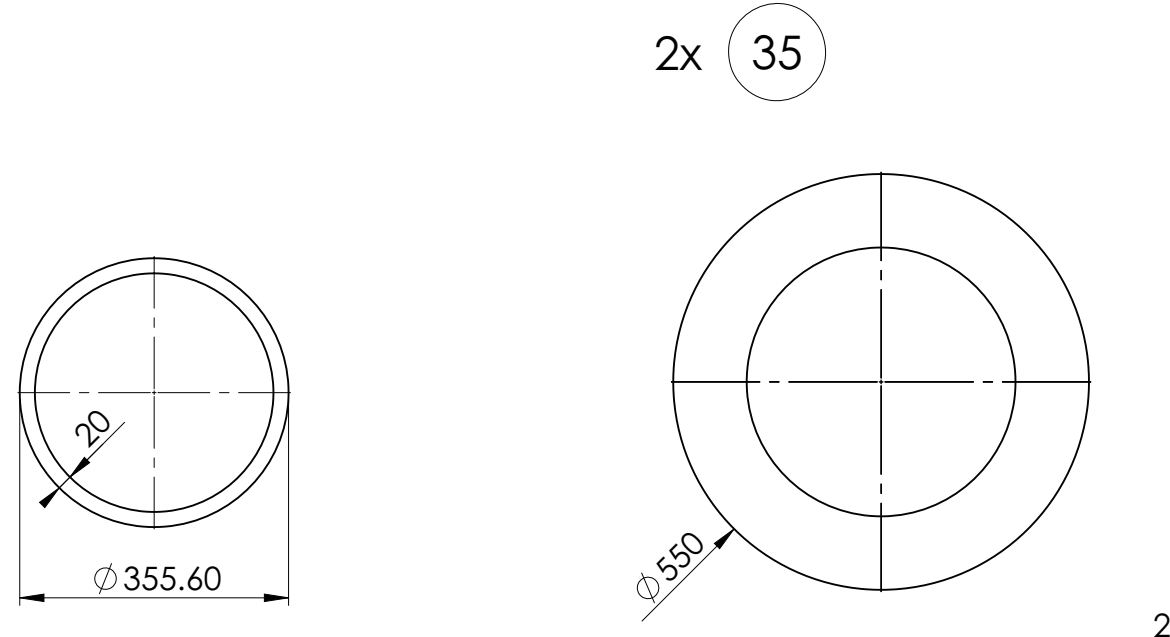
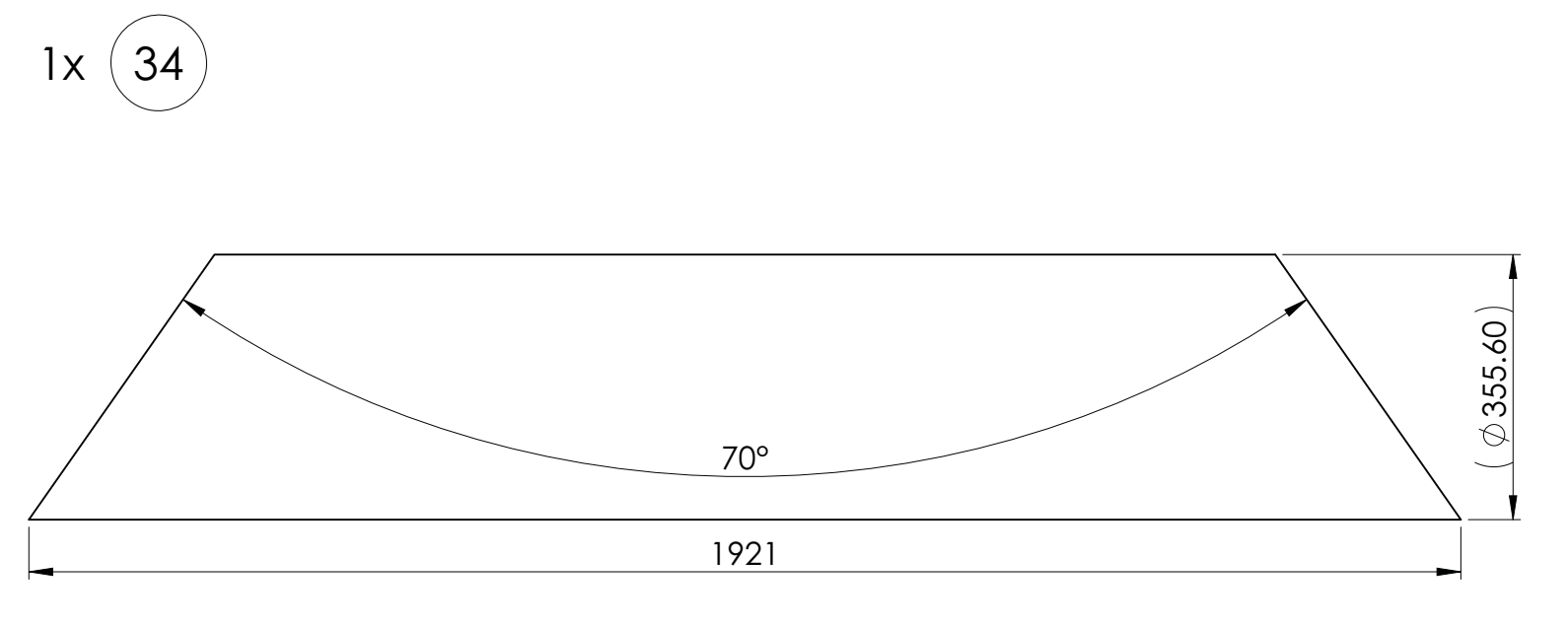
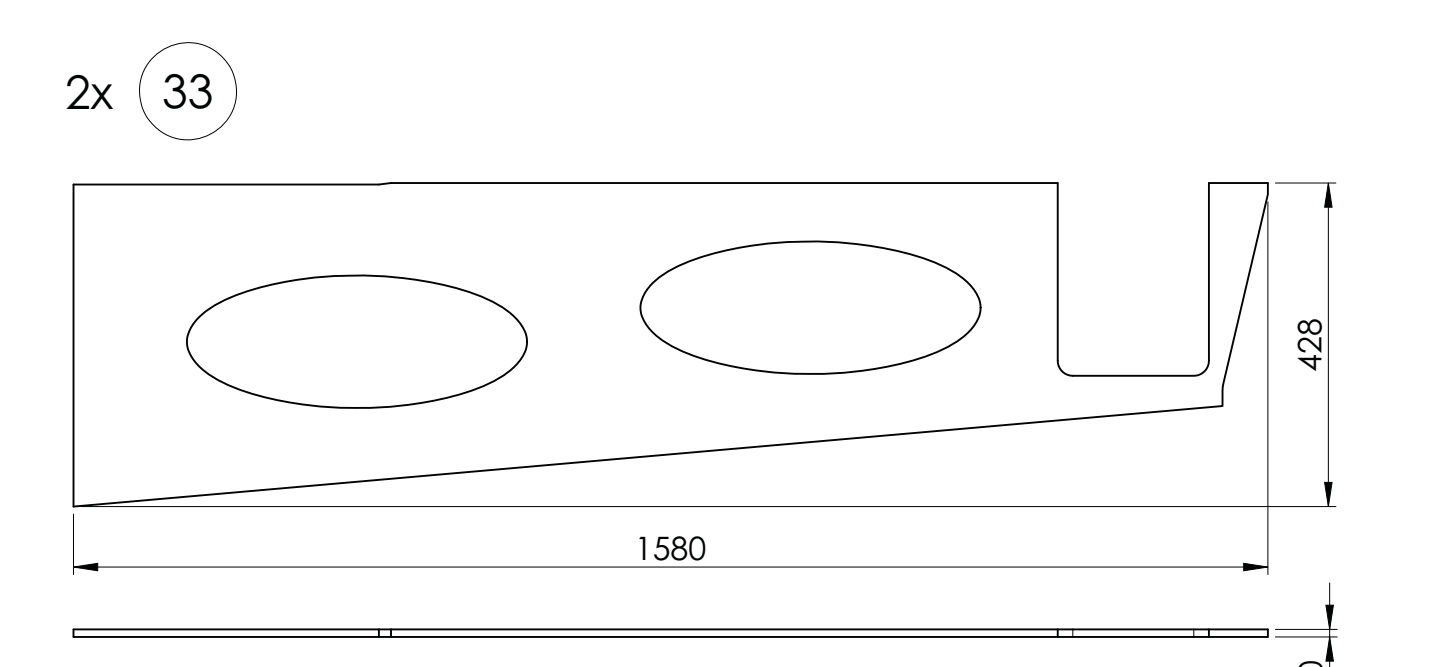
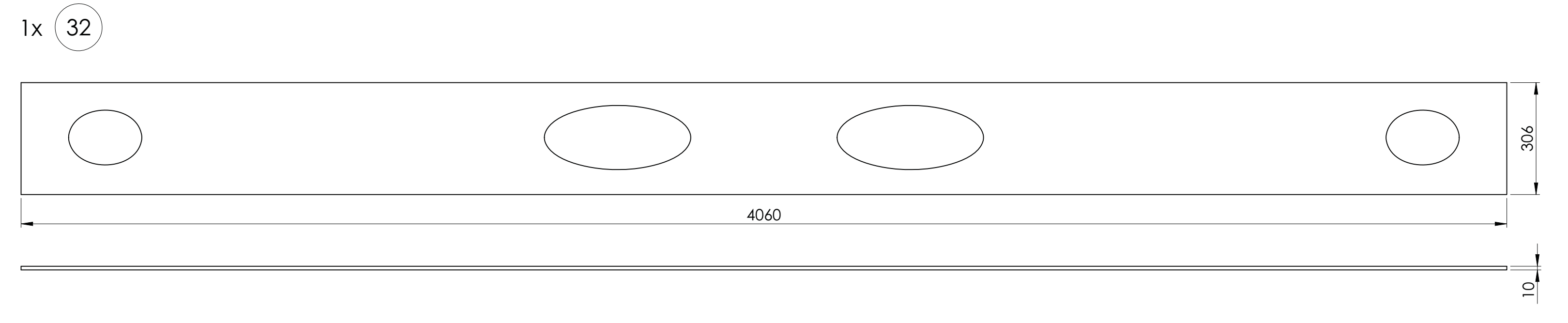
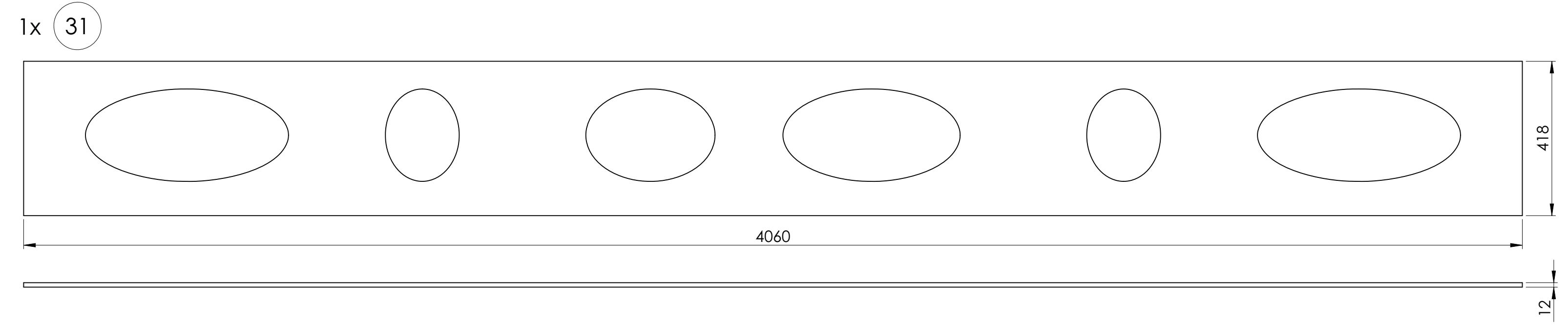
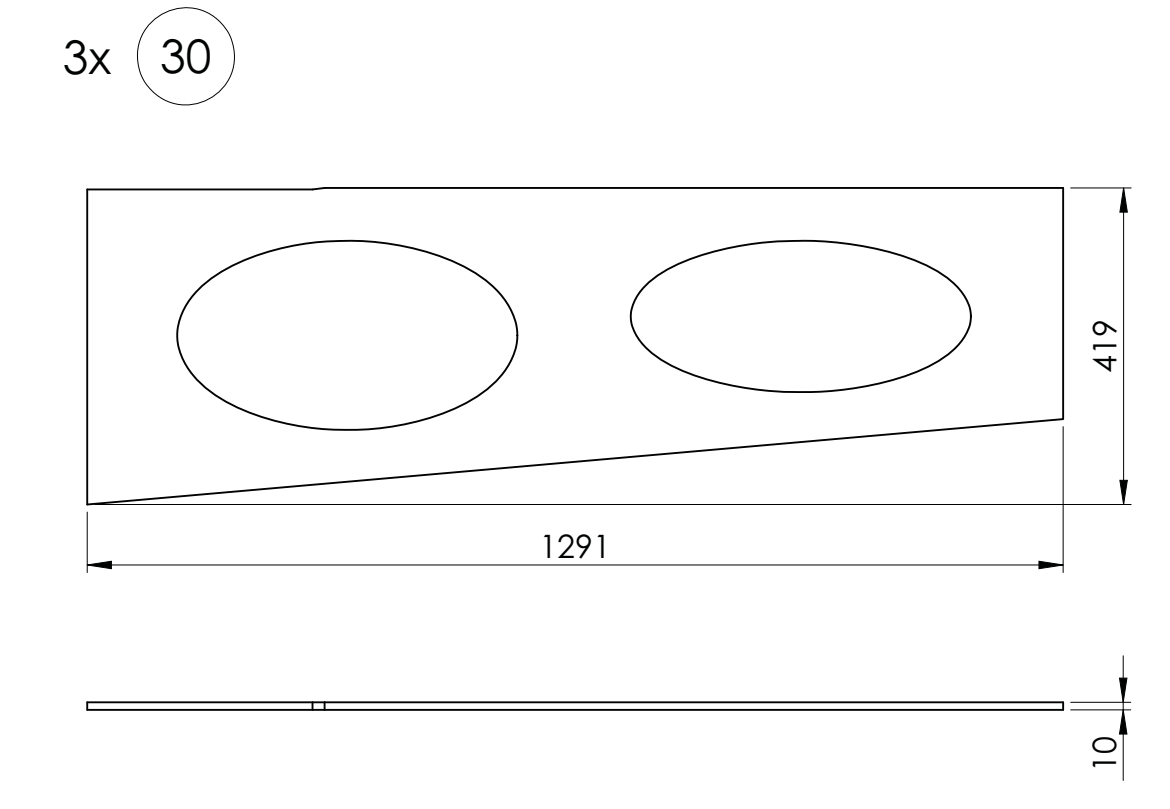
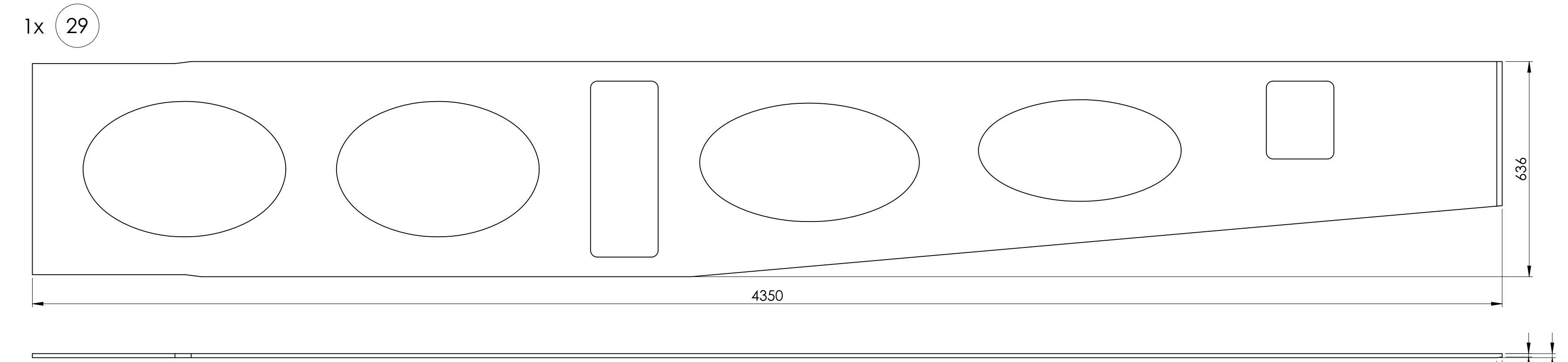
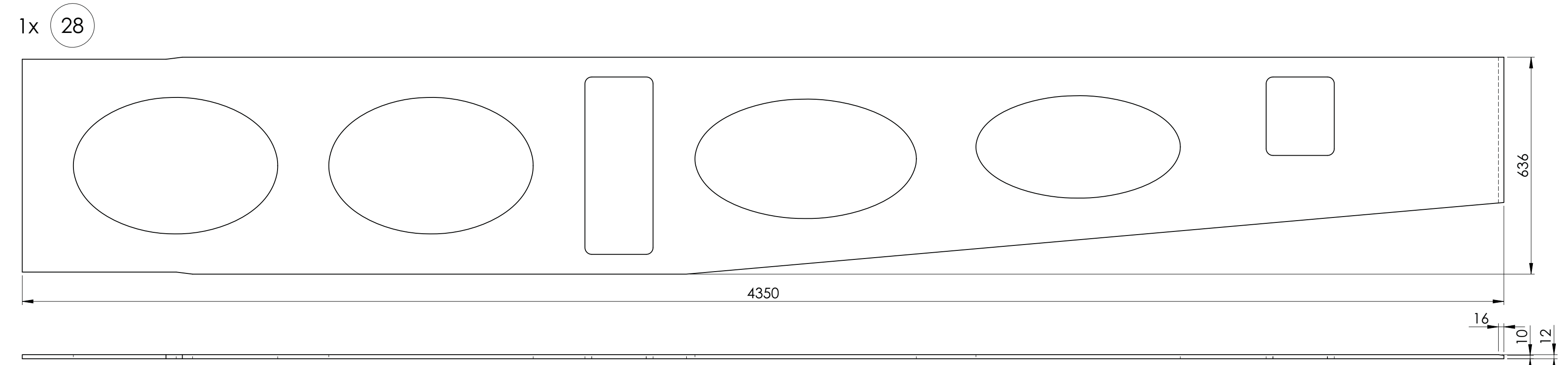
All machining and drilling has to be done after welding of the complete frame.
All single part dimensions have to be double checked by the manufacturer.
At single part views the welding preparation and the machining allowance has not been considered.

Heat treatment must be applied according to the "Manufacturing of Welded Parts" specification SP-154.2-00.MA.00.00.00.01-A chapter 3.3 "Post Treatment of Welded Structure"

all missing dimensions and free form shapes in accordance with 3-D-model: DC-154.2-MF.GE.CT.01.00.00.01-A-A

Flag "unreasonable edge": For technical reasons, the CAD model cannot be set up with realistic welding joints. Therefore the drawn edge does not correspond to the required geometry of the semi-finished product. The supplier is requested to derive the actually required geometry from the welding assembly.

Revision	Drawn	Checked	Project Manager	Management	Material	Date	2022-07-06
01						Scale	1:10
						Weight	4986 kg
Tolerance ISO 8015							
DIN ISO 2768 - mH							
ISO 15715							
Title Description							
Generator Frame							
Project							
DP-154.2-MF.GE.CT.01.00.00.01-A							
Specification Number							
SP-154.2-00.MA.00.00.00.01-A							
ECN Number							
Copyright reserved							
Refer to protection notice (S) 14616							
Part No. DP-154.2-MF.GE.CT.01.00.00.01-A-A.pdf							
SolidWorks®							



All machining and drilling has to be done after welding of the complete frame.
All single part dimensions have to be double checked by the manufacturer.
At single part views the welding preparation and the machining allowance has not been considered.

Heat treatment must be applied according to the "Manufacturing of Welded Parts" specification SP-154.2-00.MA.00.00.00.01-A chapter 3.3 "Post treatment of Welded Structure"

all missing dimensions and free form shapes in accordance with 3-D-model DC-154.2-MF.GE.CT.01.00.00.01-A-A

Flag "unreasonable edge": For technical reasons, the CAD model cannot be set up with realistic welding joints. Therefore the drawn edge does not correspond to the required geometry of the semi-finished product. The supplier is requested to derive the actually required geometry from the welding assembly.

Revision	Drawn	Checked	Project Manager	Management	Material	Date
01						2022-07-06
02						1:10
03						4984 kg

Title Description		Scale
Generator Frame		1:10
Project		aeroMaster 4
Drawing Number		DP-154.2-MF.GE.CT.01.00.00.01-A
Specification Number		SP-154.2-00.MA.00.00.00.01-A
Revision		8/8