

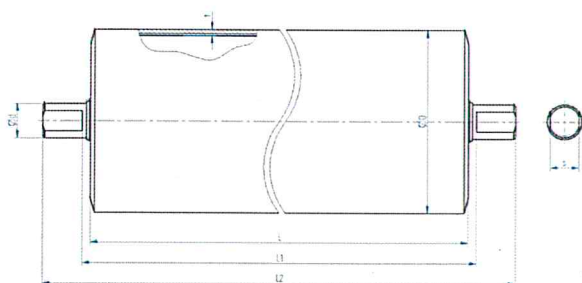
	Protocol nr. 0361	DIN 22112-3
		ISO1940
		1

Stress tests of Transroll rollers

Rollers from each order go through the random choice following process:

1. Visual control
2. Dimension control
3. Excentricity testing
4. Imbalance measuring
5. Dynamic resistance measuring
6. Static run up measuring
7. Tightness control


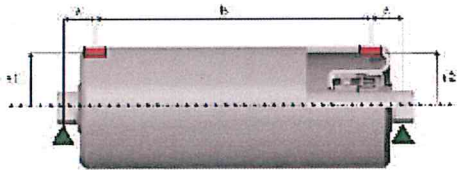
Roller dimension control is based on the parameters and particular tolerance stated on the technical drawing, see scheme.



ROLLER	UNIT	TOLERANCE	VALUE	RESULT
Ø159X465/6306				
ROTATING RESISTANCE	N	Max.	3,9	3,4
STATIC RUN-UP	N	Max.	5,85	5,4
RADIAL RUN OUT	%	Max.	0,5	0,16
IMBALANCE	g.mm	G16	20,019	14,86
SURFACE ROUGHNESS (Ra)			<0,8	approved
AX. SHAFT SHIFT	mm	Max.	1	0,6
TEMPERATURE RESISTANCE				approved
WATER RESISTANCE	g	Max.	10	4
DUST RESISTANCE				approved



Att. no. 2
 Dynamic excentricity certificate

TRANSROLL – CZ, a.s. Komenského 814 691 44 Lednice Czech republic		www.transroll.cz info@transroll.cz Tel: +420 519364511												
<h2 style="margin: 0;">CERTIFIKÁT</h2> <h3 style="margin: 0;">DYNAMICKÉHO VYVÁŽENÍ</h3> <p style="margin: 0;">(dynamic balance, dynamisches Gleichgewicht, динамическое равновесие)</p>														
Datum (Date, Datum, Date) : 28/04/2015														
Typ válce: <small>Type of roller, Rollentyp, Тип ролика</small>	Vál.hl. 89x214/6204 2RS													
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2" style="text-align: center;">Rotordata (#33#)</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">a</td> <td style="text-align: center;">25</td> </tr> <tr> <td style="text-align: center;">b</td> <td style="text-align: center;">190</td> </tr> <tr> <td style="text-align: center;">c</td> <td style="text-align: center;">25</td> </tr> <tr> <td style="text-align: center;">r1</td> <td style="text-align: center;">44,5</td> </tr> <tr> <td style="text-align: center;">r2</td> <td style="text-align: center;">44,5</td> </tr> </tbody> </table>	Rotordata (#33#)		a	25	b	190	c	25	r1	44,5	r2	44,5		
Rotordata (#33#)														
a	25													
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Tolerance použité normy <small>Tolerance used standards Toleranz verwendet Standards Точность используемых стандартов</small>	ISO G	ISO weight (kg)	ISO rpm											
ISO 1940	16	2	600											
Tolerance <small>(Tolerance, Toleranz, Точность)</small>														
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 50%;">P1 (g)</th> <th style="width: 50%;">P2 (g)</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">5,722</td> <td style="text-align: center;">5,722</td> </tr> </tbody> </table>		P1 (g)	P2 (g)	5,722	5,722									
P1 (g)	P2 (g)													
5,722	5,722													
Počáteční nevyváženost <small>(Initial imbalance, Anfangliches Ungleichgewicht, Начальная дисбаланс)</small>														
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P1 (g)	P2 (g)													
2,61	1,82													
170,3°	197,9°													
Měřicí otáčky - 600 rpm <small>(Measuring speed, Messgeschwindigkeit, Измерение скорости)</small>														
Podpis : _____ <small>(Signature, Unterschrift, Подпись)</small>														

