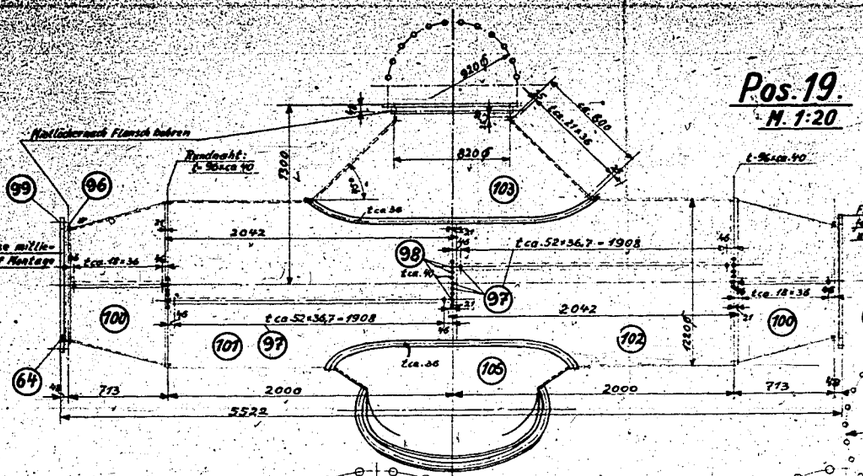
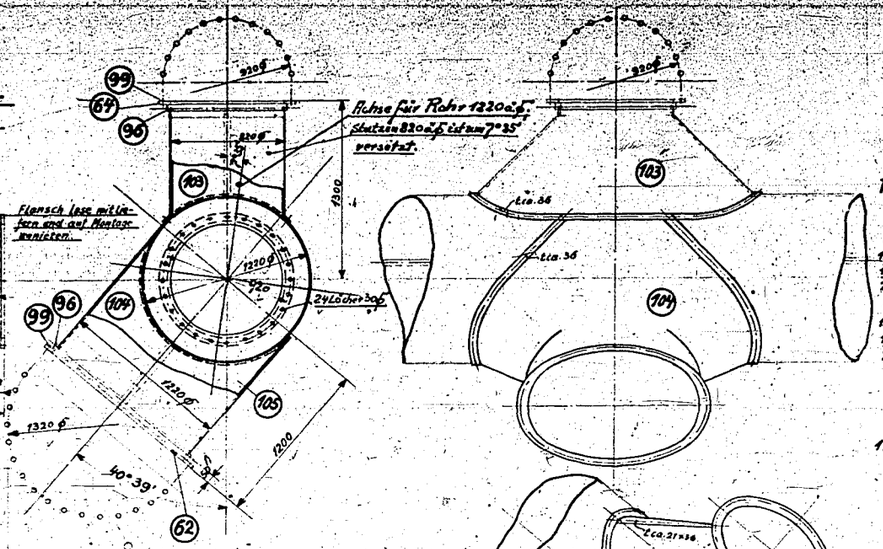
## Pos. 19.
M. 1:20

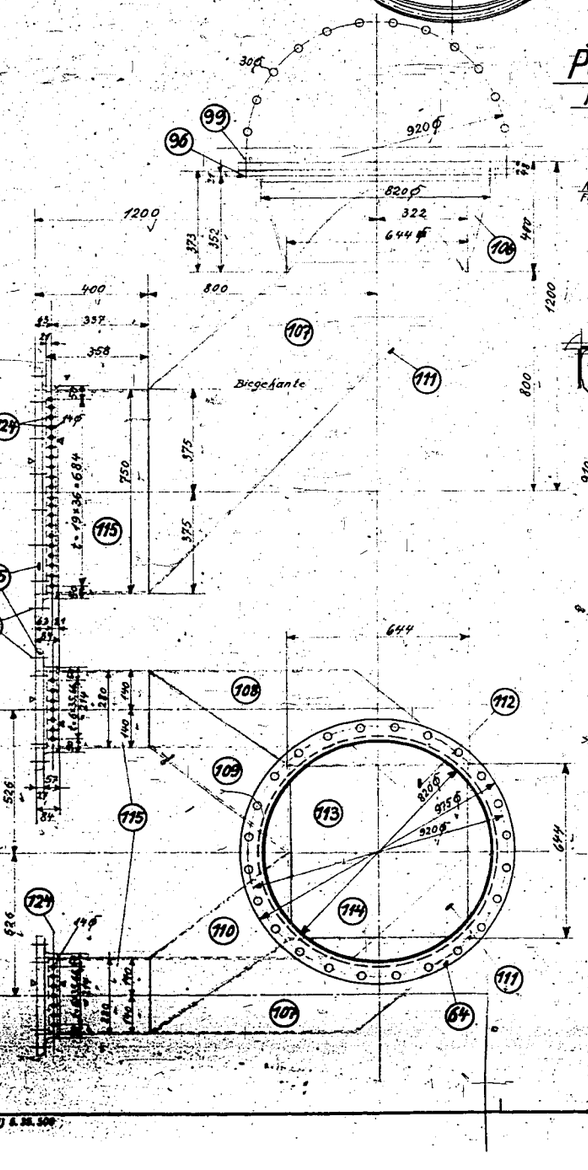


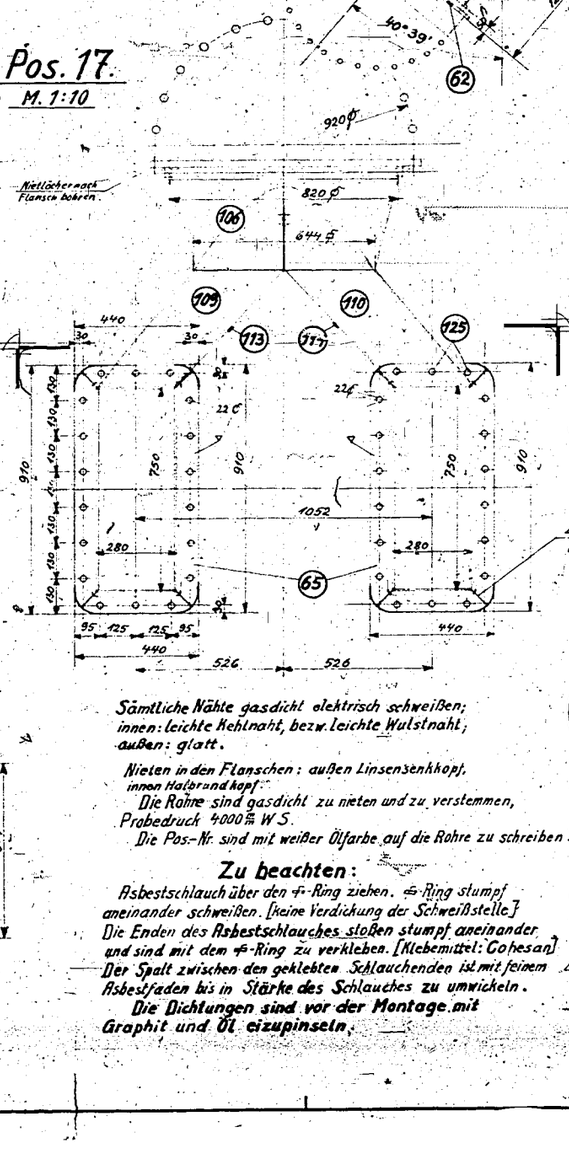







## Pos. 17.
M. 1:10




A: Rahmen auf Gärung schneiden und zusammen schweißen.

Sämtliche Nähte gasdicht elektrisch schweißen;
innen: leichte Kehlnaht, bezw. leichte Wulstnaht;
außen: glatt.

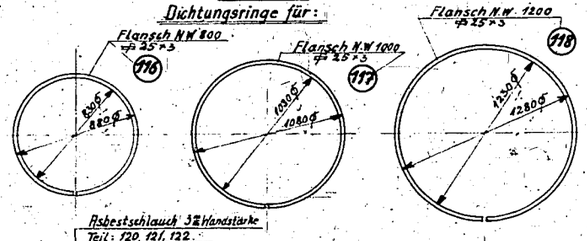
Nieten in den Flanschen: außen Linsensenkkopf, innen Halbrundkopf.
Die Rohre sind gasdicht zu nieten und zu verstemmen,
Probedruck 4000 mm WS.
Die Pos.-Nr. sind mit weißer Ölfarbe auf die Rohre zu schreiben.

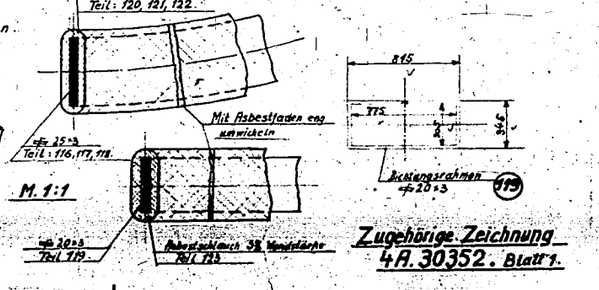
### Zu beachten:

Asbestschlauch über den ⏀-Ring ziehen. ⏀-Ring stumpf aneinander schweißen. [keine Verdickung der Schweißstelle.]
Die Enden des Asbestschlauches stoßen stumpf aneinander und sind mit dem ⏀-Ring zu verkleben. [Klebemittel: Cohesan]
Der Spalt zwischen den geklebten Schlauchenden ist mit feinem Asbestfaden bis in Stärke des Schlauches zu umwickeln.
Die Dichtungen sind vor der Montage mit Graphit und Öl einzupinseln.

M. 1:20

Dichtungsringe für:




Zugehörige Zeichnung
4A. 30352. Blatt 1.

| Pos. | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| 12 | 80 | R. Sechskant-Schrb. 3/4" × 100 | DIN 418 | 125 | | St. 38.13 | | 30 |
| 17 | 280 | Halbrundniet 13 × 36 | " 123 | 124 | | " 34.13 | | 13 |
| 17 | 95 | m Asbestschlauch 3½ W.St. für [illegible] | | 123 | | Pabest | | |
| 18/19 | 4 | m " " " " 118 | | 122 | | " | | |
| 12 | 28 | m " " " " 117 | | 121 | | " | | |
| 20 | 70 | m " " " " 116 | | 120 | | " | | |
| 17 | 4 | Dichtungsrahmen ⏀20×3 [illegible] | | 119 | | St. 37 | | 5 |
| 18/19 | 1 | Dichtungsring ⏀25×3 ca. 4000 | | 118 | | " " | | 2 |
| 12 | 8 | " " " " [illegible] | | 117 | | " " | | 1 |
| 20 | 25 | " " " " [illegible] | | 116 | | " " | | 4 |
| | 4 | Bleche 6 × ca. 360 × ca. 2060 | | 115 | | " " | | 9 |
| | 2 | " 6 ⏀ | | 114 | | " " | | 5 |
| | 2 | " 6 " | | 113 | | " " | | 5 |
| | 2 | " 6 " | | 112 | | " " | | 4 |
| | 2 | " 6 " | | 111 | | " " | | 4 |
| 17 | 2 | " 6 " | | 110 | | " " | | 1 |
| | 2 | " 6 " | | 109 | | " " | | 1 |
| | 2 | " 6 " | | 108 | | " " | | 5 |
| | 2 | " 6 " | | 107 | | " " | | 5 |
| | 2 | " 6 " | | 106 | | " " | | 18 |
| | 1 | " 6 " für Stutzen | | 105 | | " " | | 1 |
| | 1 | " 6 " | | 104 | | " " | | 1 |
| 19 | 1 | Stutzen Blech 6 ⏀ | | 103 | | " " | | 1 |
| | 1 | Blech 6 × 2042 × ca 3860 | | 102 | | " " | | 3 |
| | 1 | " 6 × 2042 × ca 3860 | | 101 | | " " | | 3 |
| | 2 | kon. Stutzen Blech 6 ⏀ | | 100 | | " " | | 2 |
| | 570 | R. Sechskant-Schrb. 1" × 90 | DIN 418 | 99 | | " 38.13 | | 39 |
| 12 | 250 | Halbrundniete 13 × 40 | " 123 | 98 | | " 34.13 | | 1 |
| 20 | 4500 | " 13 × 34 | " " | 97 | | " " | | 25 |
| | 2000 | " 13 × 30 | " " | 96 | | " " | | 10 |
| | 2 | Bleche 6 × 7733 × ca. 3245 | | 95 | | " 37 | | 53 |
| | 2 | " 6 × ca. 700 × ca 3285 | | 94 | | " " | | 16 |
| | 2 | " 6 × " 950 × " 3245 | | 93 | | " " | | 21 |
| | 2 | " 6 × " 970 × " 3285 | | 92 | | " " | | 21 |
| | 2 | " 6 × " 500 × " 3245 | | 91 | | " " | | 9 |
| | 2 | kon. Stutzen Blech 6 ⏀ | | 90 | | " " | | 16 |
| | 1 | Blech 6 × 1393 × ca 3850 | | 89 | | " " | | 25 |
| | 1 | " 6 × 2742 × " 3900 | | 88 | | " " | | 39 |
| | 1 | kon. Stutzen Blech 6 ⏀ | | 87 | | " " | | 12 |
| | 2 | " " " " | | 86 | | " " | | 15 |
| | 2 | Bleche 6 × ca 1150 × ca. 3285 | | 85 | | " " | | 20 |
| | 2 | " 6 × " 920 × " 3245 | | 84 | | " " | | 21 |
| | 1 | kon. Stutzen Blech 6 ⏀ | | 83 | | " " | | 8 |
| | 1 | Blech 6 × 1881 × ca. 3245 | | 82 | | " " | | 29 |
| 12 | 1 | " 6 × 1881 × " 3245 | | 81 | | " " | | 29 |
| 16 | 1 | Zwickel Blech 6 ⏀ | | 80 | | " " | | 6 |
| 18 | 1 | Stutzen Blech 6 ⏀ | | 79 | | " " | | 11 |
| 20 | 1 | Blech 6 × 2021 × ca. 3245 | | 78 | | " " | | 31 |
| | 1 | " 6 × 2742 × " 3285 | | 77 | | " " | | 33 |
| | 1 | " 6 × 2742 × " 3245 | | 76 | | " " | | 26 |
| | 1 | kon. Stutzen Blech 6 ⏀ | | 75 | | " " | | 9 |
| | 1 | Blech 6 × ca 550 × ca 3245 | | 74 | | " " | | 7 |
| | 2 | " 6 × " 630 × " 3285 | | 73 | | " " | | 7 |
| | 2 | " 6 × " 630 × " 3245 | | 72 | | " " | | 7 |
| | 1 | " 6 × " 710 × " 3285 | | 71 | | " " | | 9 |
| | 1 | " 6 × 2041 × " 3246 | | 70 | | " " | | 31 |
| | 1 | " 6 × 1240 × " 3245 | | 69 | | " " | | 19 |
| | 1 | " 6 × 2242 × " 3245 | | 68 | | " " | | 34 |
| | 1 | " " " " [illegible] | | 67 | | " " | | 31 |
| | 1 | " " " " [illegible] | | 66 | | " " | | 31 |
| | 1 | kon. Stutzen Blech 6 ⏀ | | 65 | | " " | | 9 |
| | 4 | Nietflansche, Tomflanschen | | 64 | | " 37.12 | | 50 |
| 12 | 12 | " N.W. 800 | DIN 2616 | 63 | | " 34.11 | | 59 |
| 20 | 12 | " " " 1000 | " " | 63 | | " " | | 78 |
| | 2 | " " " 1200 | " " | 62 | | " " | | 15 |
| | | | | | | | | 11492 |

Braunkohle-Benzin A.G.
Bau:
4A 357-1

# Wassergasleitungen 1000 u. 1200 N.W.

15. Juli 1937

Zeichnungs-Registratur TA Böhlen. Blatt 2.

Ges.: B. Dat. 19.9.37
Gepr.:
Ges.:
Norm gepr.:
Maßst. 1:20, 1:10, 1:1

BAMAG-MEGUIN AKTIENGESELLSCHAFT BERLIN

4A. 30353

Ersatz für:
Ersetzt durch:

Nach dieser Zeichnung werden nur die mit einer Fabriknummer versehenen Stücke ausgeführt.