

NOTES :

WEIGHT : ASSEMBLY : 339451 Kg
 WITHOUT TOP SECTION : 46840 Kg
 TOWER MID SECTION A: 50416 Kg
 INTERNALS) MID SECTION B: 51999 Kg
 MID SECTION C: 54032 Kg
 MID SECTION D: 57646 Kg
 DOOR SECTION : 59054 Kg
 TOWER BASE RING: 19464 Kg

- DIE AUSFUEHRUNG DER OBEREN SEKTION ENTSPRECHEND DER Z.-NR.:449W7139
 DESIGN OF TOP SECTION ACC. TO DWG.-NO. 449W7139
- DIE AUSFUEHRUNG DER MITTLEREN SEKTION A ENTSPRECHEND DER Z.-NR.:449W7140
 DESIGN OF MID SECTION A ACC. TO DWG.-NO. 449W7140
- DIE AUSFUEHRUNG DER MITTLEREN SEKTION B ENTSPRECHEND DER Z.-NR.:449W7141
 DESIGN OF MID SECTION B ACC. TO DWG.-NO. 449W7141
- DIE AUSFUEHRUNG DER MITTLEREN SEKTION C ENTSPRECHEND DER Z.-NR.:449W7142
 DESIGN OF MID SECTION C ACC. TO DWG.-NO. 449W7142
- DIE AUSFUEHRUNG DER MITTLEREN SEKTION D ENTSPRECHEND DER Z.-NR.:449W7143
 DESIGN OF MID SECTION D ACC. TO DWG.-NO. 449W7143
- DIE AUSFUEHRUNG DER TUERSEKTION ENTSPRECHEND DER Z.-NR.:449W7144
 DESIGN OF DOOR SECTION ACC. TO DWG.-NO. 449W7144
- DIE AUSFUEHRUNG DES TURMFUSSADAPTERS ENTSPRECHEND DER Z.-NR.448W6322
 DESIGN OF THE TOWER BASE RING ACC. TO DWG.-NO.448W6322
- DICHTUNGSMATERIAL
 SEALING COMPOUND
- VERSCHLUSSKAPPEN
 PLUGS
- TO 21. LABELS FLANSCHBOLZEN, POSITION CA. 400MM VOM UNTEREN ENDE DER SEKTION AUF 180° POSITION INNERHALB DES TURMES.
 LABELS FLANGE BOLTS, TO BE ATTACHED APPROX. 400MM FROM LOWER END OF THE TOWER SECTION AT 180° LOCATION INSIDE OF THE TOWER.
- BOHREN VON LOCHERN IN DEN GEKENNZEICHNETEN SCHALEN NICHT GESTATTET.
 DRILLING HOLES IS NOT ALLOWED IN THE MARKED CANS.
- ANSCHWEISSBUCHSEN IN DEN GEKENNZEICHNETEN NICHT GESTATTET.
 WELDED ATTACHMENTS ARE NOT ALLOWED IN THE MARKED CANS.

TIGHTENING METHOD: ANZIEHVERFAHREN: COMBINED METHOD KOMBINIERTES VERFAHREN	BREAK-IN-MAINTENANCE (BIM): INBETRIEBNAHMEWARTUNG: ALL BOLTS NUT ROTATION ANGLE +15° ALLE SCHRAUBEN WEITERDREHWINKEL +15°
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FLANGE BOLT SETS: - SIZES M36 ACC. TO EN14399-4 - HV - 10,9/10 - TZN - SIZES M39 ACC. DAST-R1 021 10,9 - TZN (DAST-RICHTLINIE 021, SEPT. 2013) - EACH BOLT SET CONSISTING OUT OF 1X BOLT, 1X NUT, 2X WASHER, LUBRICATED WITH MOS2
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FLANSCHBOLZENGARNITUREN: - GROESSEN M36 GEMAESS EN14399-4 - HV - 10,9/10 - TZN - GROESSEN M39 GEMAESS DAST-R1 021 10,9 - TZN (DAST-RICHTLINIE 021, SEPT. 2013) - JEDE GARNITUR BESTEHEND AUS 1X SCHRAUBE, 1X MUTTER, 2X SCHEIBE, GESCHMIERT MIT MOS2

POS.	FLANGE FLANSCH	QTY ANZ.	SIZE GROESSE	MOMENT + NUT ROTATION ANGLE ANZIEHMOMENT + WEITERDREHWINKEL	LIMIT TORQUE	SOCKET DIM. [mm]		TOOL GEOMETRY RADIUS R [mm]
						A/F / SW	DIA	
10	MF2	130	M36x205	1920Nm + 90°	5600Nm	60-HEX	≤100	≤50

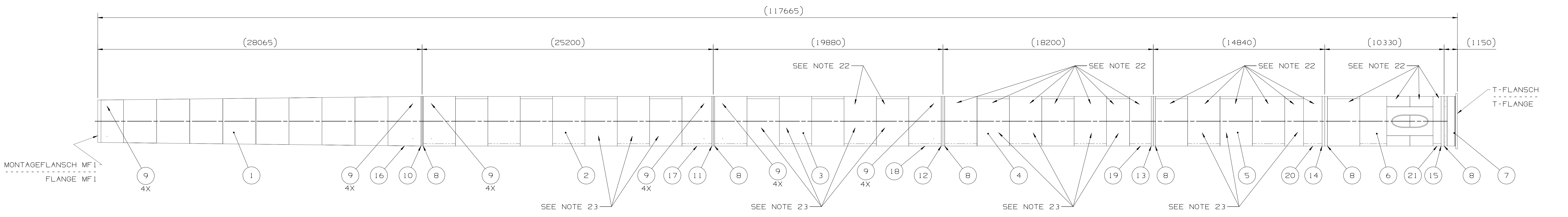
FLANGE BOLT SETS: - ACC. TO GE SPECIFICATION 445W7294. NUT WITH 12-POINT/B1-HEX GEOMETRY - EACH BOLT SET CONSISTING OUT OF 1X BOLT, 1X NUT, 2X WASHER, LUBRICATED WITH MOS2

FLANSCHBOLZENGARNITUREN: - GEMAESS GE SPEZIFIKATION 445W7294. MUTTER MIT 12-PUNKT/DOPPELSECHSKANT-GEOMETRIE - JEDE GARNITUR BESTEHEND AUS 1X SCHRAUBE, 1X MUTTER, 2X SCHEIBE, GESCHMIERT MIT MOS2

POS.	FLANGE FLANSCH	QTY ANZ.	SIZE GROESSE	MOMENT + NUT ROTATION ANGLE ANZIEHMOMENT + WEITERDREHWINKEL	LIMIT TORQUE	SOCKET DIM. [mm]		TOOL GEOMETRY RADIUS R [mm]
						A/F / SW	DIA	
11	MF3	121	M48x260	4450Nm + 90°	13000Nm	60 - 12-Pt.	≤119	≤59
12	MF4	136	M48x320	4450Nm + 90°	13000Nm	60 - 12-Pt.	≤120	≤61
13	MF5	121	M56x370	6850Nm + 90°	20000Nm	70 - 12-Pt.	≤131	≤65
14	MF6	109	M64x480	10300Nm + 90°	30000Nm	80 - 12-Pt.	≤140	≤78
15	MF7	109	M64x510	10300Nm + 90°	30000Nm	80 - 12-Pt.	≤139	≤80

REVISION HISTORY			
REV	ZONE	DESCRIPTION	DATE (YYYY-MM-DD)
-		SEE PLM FOR DETAILS	

REVISE ON CAD ONLY
 NX PART: 449W6623



5.X 120.9mHH TOWERS

Anlage zum Prüfbericht zur Typenprüfung
 Nr.: T-7008/18-4 Rev. 0
 vom 13. Nov. 2019



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SEE SEPARATE PARTS LIST	GE CLASS II (INTERNAL NON-CRITICAL)	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS	DWG TYPE ASSEMBLY	GE RENEWABLE ENERGY
TOLERANCE CLASS: 150 2768-cl 150 13920-BE	DRAWN SEE PLM DRAWN DATE (YYYY-MM-DD) 2019-08-29 CHECK SEE PLM	
FIRST ANGLE PROJECTION	CHECK DATE (YYYY-MM-DD) ENGR 212742457 ENGR DATE (YYYY-MM-DD)	ZUSAMMENBAUZEICHNUNG TURMSCHALE TOWER STRUCTURE ASSY SHELL
MATERIAL: SEE NOTES	ADDITIONAL APPROVALS SEE PLM FOR APPROVAL INFORMATION MLI/PBM CODE/UNIT TYPE #06C DWG SOURCE NX12 SIMILAR TO 449W6477 DOL CODE US-SC, GREENVILLE	SIZE CAGE CODE DWG NO AO NONE 449W6623
		SCALE NONE APPROXIMATE # SEE NOTES SHEET 1 OF 1