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|-----------------------|--------------------------|---------------------|----------------|----|
| FR-02.01/01/05.1/GSHT | <b>WYKAZ PRZYWIESZEK</b> |                     | <b>1 / / P</b> |    |
| Hasło na przywieszkę: |                          | Zlec.:              | Szt.:          | 10 |
|                       |                          | <b>90.24399.3.1</b> |                |    |

| <b>Lp.</b> | <b>Nr rys.</b>       | <b>Nr elementu</b> | <b>Ilość sztuk p.:</b> | <b>L.</b> |
|------------|----------------------|--------------------|------------------------|-----------|
| <b>1</b>   | <b>ME0107_ver. C</b> | <b>ME0107</b>      | <b>10</b>              |           |

2025-10-08  
 SPECJALISTA  
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 Tomasz Syczewski  
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**FR-02.01/02/06/GSPKT**

|             |  |
|-------------|--|
| Nr zlecenia |  |
|-------------|--|

**90.24399.3.1**

## Paleta Drum Gestell

[illegible]

## WYKAZ WYSYŁKOWY

Numer zlecenia: **90.24399.3.1**

Numer części: **1**

Hasło projektu: **Cradles**

Wykonuje: **Kooperacja**

Typ / Rewizja: **KONSTR. LEKKIE / 0**

Elementy ponadgabarytowe:

- dla cynkowania:

- dla transportu:

- dla kontenera:

Elementy luzem:

Rodzaje zabezpieczeń: | cynkowanie |  
- wg opisu przy każdym LP i/lub w uwagach poniżej.

Uwagi:

**ROZPATRYWAĆ ŁĄCZNIE Z WYKAZEM WYSYŁKOWYM MONTAŻOWYM**

1. Lp. 1 - wykonuje Kooperacja.

2. Lp. 2, Lp. 3, Lp. 4 - kupuje zaopatrzenie.

3. Konstrukcja cynkowana - wykonać otwory technologiczne.

4. Stępieć ostre krawędzie.

5. Wykonać z materiałów wg. WKE (+opcja 5 / 1.4 - materiały przydatne do cynkowania).

6. Przywieszki wykonać wg karty technologicznej 1/p

2025-10-08  
WYKONANIE  
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Masa części: **4075,00 [kg]**

Masa narastająco: **4075,00 [kg]**

Sprawdził(a):

Pracownik Sekcji  
Piotr Chleba  
tel. 25 643 93 50

Wydrukował(a): Tomasz Syczewski

| Lp.<br>Rewizja | Opis elementu:<br>L x B x H, Info dodatk.<br>Uwagi: | Nr rys.       | Ilość<br>sztuk: | Masa<br>jedn. [kg]<br>Gr. cenowa | Masa<br>całk. [kg] |
|----------------|---|---------------|-----------------|----------------------------------|--------------------|
| 1              | paleta ME0107<br>LxBxH: 1285 x 975 x 630            | ME0107_ver. C | 50              | 81,500                           | 4075,00            |
|                | patrz: wykaz wysyłkowy montażowy                    | C             |                 | Metal Cradle                     |                    |

2025-10-08

SPECIALISTA  
d/s TECHNOLOGII  
Tomasz Syczewski  
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Nr projektu: **90.24399.3.1**

Nr części wykazu: **1**

Wykonuje: **Kooperacja**

Wydrukował(a): Tomasz Syczewski

2025-10-08

Legenda:  
M – malowanie  
Y – metalizacja+malowanie  
C – cynkowanie ogniowe  
D – duplex  
N – bez zabezpieczenia (czarne)  
X – metalizacja  
G – cynkowanie galwaniczne  
R – wg rysunku  
P – zabezpieczenie producenta

Legenda:  
L – element luzem  
EZ – element złączny  
F – farba

# Wykaz wysyłkowy MONTAŻOWY

FR - 02.01/02/10/GSPKT

Nr zlecenia

**90.24399.3.1**

Obiekt

Paleta Drum Gestell

 Masa  
[kg]

4954,00

L.p.

Opis elementu, nr rysunku, pozycji

Szt.

Masa [kg]

Og.

1 szt

## CYNKOWANE

### 1 PALETA

l x b x h = 1285 x 975 x 630

Rys. ME0107\_ver. C

50

4954,00

99,08

### ELEMENTY ZŁĄCZNE (cynk. galwanicznie)

Rys. ME0107\_ver. C

### 2 Tabliczka 1x100 - 150

50

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### 3 Nit f4-12

200

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### 4 Guma 8x40 - 1105

100

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**Masa materiału użytego do wykonania całego zlecenia (bez spoin)**

=

**4866,50 kg**
**Masa jednej palety z modelu 3D**

=

**81,50 kg**
**Masa palet do cynkowania z modelu 3D**

=

**4075,00 kg**

### UWAGI:

1. Lp.1 - wykonuje kooperacja.
2. Lp. 2 ÷ Lp. 4 - kupuje zaopatrzenie. Przekazać do montażu na GSPAM.
3. Lp. 4 - okładziny gumowe zakupić takie same jak były zakupione w poprzednim zleceniu i dołączonej karty.
4. Numeracja palet: ..... ÷ ..... (po informacji z działu handlowego).

Wykonał

Sprawdził

Data

Strona / stron

08 paź 25

1/ 1

Paleta Drum Gestell

ME0107\_ver. C

Nr zlecenia

**Obiekt - charakterystyka**
**Nr rys zestawieniowego**
**90.24399.3.1**

| L.p. | Nazwa części - elementu wymiary podstawowe | Nr rys., normy, katalogowy |     | Gat. Mat. | Na wyrób    |       |                | Nr karty techn |
|------|--|----------------------------|-----|-----------|-------------|-------|----------------|----------------|
|      |  | Nr                         | Poz |           | Jedn. Miary | Ilość | Masa brutto kg |                |

**CYNKOWANE**

|   |                      |               |    |            |      |       |       |              |
|---|----------------------|---------------|----|------------|------|-------|-------|--------------|
| 1 | PALETA               | ME0107_ver. C |    | S235JR/2.2 | szt. | 1     | 97,33 |              |
|   | Rura kw. 40x4 - 580  | "             | 1  | "          | "    | 4     | 9,74  |              |
|   | Rura kw. 40x4 - 810  | "             | 2  | "          | "    | 3     | 10,21 |              |
|   | Rura kw. 40x4 - 1120 | "             | 3  | "          | "    | 2     | 9,41  |              |
|   | Rura kw. 40x4 - 566  | "             | 4  | "          | "    | 4     | 9,51  |              |
|   | Rura kw. 40x4 - 540  | "             | 5  | "          | "    | 2     | 4,54  |              |
|   | Rura kw. 40x4 - 105  | "             | 6  | "          | "    | 4     | 1,76  |              |
|   | Bl. 4x330 - 810      | "             | 7  | "          | "    | 4     | 33,56 |              |
|   | Bl. 4x40 - 1122      | "             | 8  | "          | "    | 2     | 2,82  |              |
|   | Bl. 10x40 - 906      | "             | 9  | "          | "    | 2     | 5,68  |              |
|   | Bl. 10x40 - 1216     | "             | 10 | "          | "    | 2     | 7,64  |              |
|   | Bl. 4x40 - 40        | "             | 11 | "          | "    | 4     | 0,20  |              |
|   | Pręt Ø12 - 168       | "             | 12 | S355J2/3.1 | "    | 2     | 0,30  |              |
|   | Bl. 4x125 - 125      | "             | 13 | S235JR/2.2 | "    | 4     | 1,96  |              |
|   |                      | 50            |    | szt.x      |      | 97,33 | =     | 4866,50 (kg) |

|   |  |               |    |           |      |   |      |  |
|---|--|---------------|----|-----------|------|---|------|--|
|   | <b>ELEMENTY ZŁĄCZNE (cynk. galwanicznie)</b> | ME0107_ver. C |    |           | szt. | 1 | ---- |  |
| 2 | Tabliczka 1x100 - 150                        |               | 14 | alumimium | "    | 1 | ---- |  |
| 3 | Nit φ4-12                                    |               | 15 | St*St     | "    | 4 | ---- |  |
| 4 | Guma 8x40 - 1105                             |               | 16 | guma      | "    | 2 | ---- |  |
|   |  | 50            |    | kpl. x    | ---- | = | ---- |  |

Klej Terokal 2444

3,01 kg / zlecenie

**UWAGI:**

1. Lp.1 - wykonuje kooperacja.
2. Lp. 2 ÷ Lp. 4 - kupuje zaopatrzenie. Przekazać do montażu na GSPAM.
3. Lp. 4 - okładziny gumowe zakupić takie same jak były zakupione w poprzednim zleceniu i dołączonej karty.
4. Numeracja palet: ..... ÷ ..... (po informacji z działu handlowego).

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08 paź 25

Kierownik Sekcji

 Piotr Chłopa  
 tel. 25 643 94 61

08 paź 25

|  |  |                             |                     |  |                        |                           |          |         |                                    |       |      |                |  |
|--|--|-----------------------------|---------------------|--|------------------------|---------------------------|----------|---------|------------------------------------|-------|------|----------------|--|
| FR-02.01/02/03/GSPKT<br><b>MOSTOSTAL</b><br>SIEDLCE  |  | <b>Karta technologiczna</b> |                     |  |                        | Gatunek materiału / Atest |          |         | Nr zlecenia<br><b>90.24399.3.1</b> |       |      | Nr k. techn.   |  |
| Nr rysunku   |  | Poz. rys                    | Postać materiału    |  | Cecha detalu /elementu | Sztuk                     | Masa1szt | Wykonał | Nr oper                            | Stan. | Szt. | Uwagi / przyrz |  |
| ME0107_ver. C  |  |                             | Paleta Drum Gestell |  |                        |                           |          |         |                                    |       | 50   |                |  |
| <p><b>UWAGA:</b></p> <p>Palety wykończyć po cynkowaniu.</p> <p>Dobre odtłuścić i przygotować powierzchnię pod przyklejanie gum.</p> <p>Gumy kleić za pomocą kleju TEROKAL 2444 (zgodnie ze specyfikacją podaną przez wytwórcę kleju).</p> <p>Przynitować tabliczkę znamionową (Lp. 2).</p> <p>Pakować w paczki po 4 (cztery) sztuki.</p> |  |                             |                     |  |                        |                           |          |         |                                    |       |      |                |  |
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|  |   | Siedlce, ul. Terespolska 12<br>tel. (0-25) 644 31 20 |                                   | Badane Elementy:             |                              | FR-02.01/01/08/GSPKT |        |
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| Klient :   |   |  |                                   | Paleta Drum Gestell          |                              |                      |        |
| Lokalizacja obiektu:   |   |  |                                   | Nr Zlecenia: 90.24399.3.1    |                              |                      |        |
| Plan Kontroli w produkcji  |   |  |                                   |                              |                              |                      |        |
| L.p.   | Kontrola i testy                                      | Wymagania  | Normy i inne dokumenty            | Wykonujący czynność kontroli |                              |                      | Podpis |
|  |   |  |                                   | Kod komórki prowadz.kontrolę | Zakres kontroli (wg legendy) | Data                 |        |
| 1  | Określenie jakości spoin, klasa spoin                 | kl. C  | PN-EN ISO 5817                    | GSJ / GSP                    | PO / PU                      |                      |        |
| 2  | Badanie spoin: - kontrola wizualna                    | TAK (100%)   | PN - EN 17637                     | GSJ / GSP                    | PO                           |                      |        |
|  | - kontrola rentgenem                                  | NIE  | PN - EN 17636                     | GSJ                          | Sp. czółowe PU               |                      |        |
|  | - kontrola penetrantem (magnet. proszk.)              | NIE  | PN - EN 17638                     | GSJ                          | PU                           |                      |        |
|  | - kontrola ultradźwiękowa                             | NIE  | PN - EN 17640                     | GSJ                          | KL                           |                      |        |
| 3  | Badanie blach na rozwarstwienie                       | NIE  | S-E-L 072                         | GSJ                          | PU                           |                      |        |
| 4  | Kontrola wykonania i wykończenia<br>Kontrola wymiarów | TAK  | EN - ISO 13920-BF                 | GSJ / GSP                    | PO / PU                      |                      |        |
| 5  | Oczyszczenie powierzchni                              | S.A.2,5  | EN ISO 8501-1                     | GSJ / GSP                    | PO                           |                      |        |
| 6  | Cynkowanie  | TAK  | EN ISO 1461                       | GSJ / GSP                    | PU                           |                      |        |
| 7  | Malowanie   | NIE  | wg instr. Działu tech. Chemicznej | GSJ                          | PU                           |                      |        |
| 8  | Znakowanie  | TAK  | wg. karty technologicznej         | GSJ                          | PO                           |                      |        |
| 9  | Montaż próbny   | NIE  | -----                             | GSJ / GSP                    | PU                           |                      |        |

Legenda: KL - Kontrola losowa

PU - Pomiary udokumentowane

PO - Pełne oględziny

GSJ - Dz. Kontroli Jakości

GSP - Samokontrola wykonawcy

Sporządził

Zatwierdził



Siedlce dn. 2025-10-08



## **Warunki wykonania i odbioru konstrukcji**

**Wyrób: Paleta Drum Gestell**

**Zl: 90.24399.3.1**

### **1. Materiały.**

Konstrukcję wykonać ze stali (jak w WKE) **S235JR, S235JRH, at. 2.2, S355J2 at. 3.1** wg EN 10025:2004 (+opcja 5 do cynkowania). Na materiały muszą być przedstawione świadectwa (atesty) wg EN 10204:2004 w jęz. niemieckim lub jęz. angielskim.

### **2. Dokładność wykonania.**

Wszystkie ostre krawędzie powinny być stępione  $1/45^\circ$ . Wszystkie otwory ogratowane a odpryski spawalnicze usunięte. Krawędzie po cięciu na gilotynie czy palnikach należy wyrównać i zabielić przez szlifowanie (maksymalna nierówność krawędzi  $< 0,3$  mm). Krawędzie w otworach i wycięciach należy gratować obustronnie –faza  $1/45^\circ$ .

### **3. Tolerancja wykonania.**

Oprócz norm naniesionych w dokumentacji stosować normę:

- a) w przypadku wykonywania detali składowych palety (poprzez cięcie na pilach, cięcie laserem, wiercenie otworów, itp.) stosować normę DIN ISO 2768-mK,
- b) przy montażu (spawania palety w całość) stosować normę PN-EN ISO 13920: tolerowanie wymiarów liniowych w kl. B oraz kl. F dla tolerancji prostoliniowości, płaskości i równoległości. Dopuszczalne tolerancje dla wszystkich otworów  $\pm 0.5$ .

### **4. Spawanie konstrukcji.**

Stan powierzchni materiału przed spawaniem i po spawaniu nie mniejszy od stopnia P2 wg EN ISO 8501-3. Brzegi tworzące rowek spawalniczy w spoinach czołowych cięte palnikiem acetylenowo-tlenowym zabielić przez szlifowanie. Spawanie wykonać zgodnie z dokumentacją konstrukcyjną i technologiczną. Spoiny czołowe i spoiny pachwinowe wykonać w klasie C wg PN-EN ISO 5817.

### **5. Kontrola jakości.**

Dokonać kontroli jakości użytych materiałów co do gatunku i wymiarów oraz sprawdzić atesty materiałów. Skontrolować wymiary geometryczne. Sprawdzić jakość spoin wg PN-EN ISO 5817 klasa C. Spoiny kontrolować wizualnie wg PN EN – 17637. Inne badania spoin wg dokumentacji, jeżeli dokumentacja je przewiduje.

W przypadku zgody na dodatkowe łączenia, spoiny wykonać na pełen przetop i kontrolować metodą MT lub UT w zależności od wielkości i rodzaju przekroju.

### **6. Znakowanie elementów.**

Znakowanie wykonać na przywieszkach wg technologii i przywiązać do elementów.

### **7. Pokrycie antykorozyjne.**

Konstrukcja do cynkowania powinna być wolna od zanieczyszczeń technologicznych (farby, smary, chłodziwa, odpryski spawalnicze, itp.)

Cynkowanie wg EN ISO 1461.

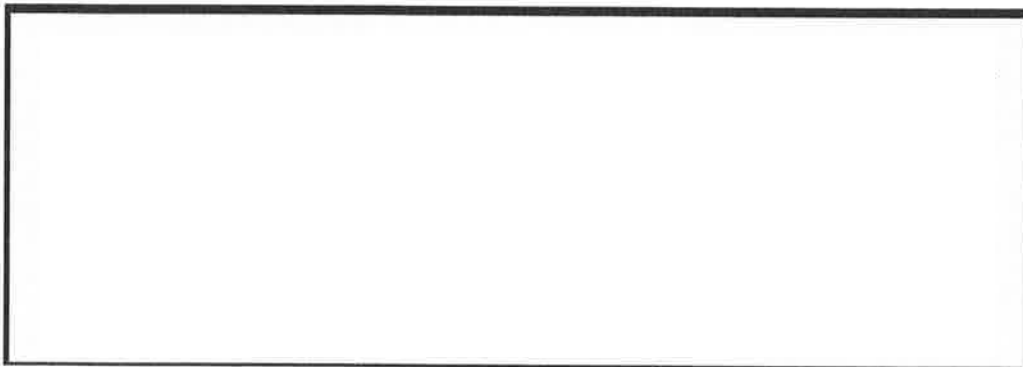
Elementy cynkowane na wirówkach: grubość powłoki max.  $100\mu\text{m}$  bez zgrubień.

### **8. Pakowanie.**

Pakować po cztery palety w paczkę.

2025-10-08  
 SPECJALISTA  
 d/s TECHNOLOGII  
 Tomasz Syczewski  
 tel. 25 643 94 61  
**Opracował:**

Warunki konstrukcji  
 Data: 08.10.2025  
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**Zatwierdził:**



## **Płyty zwykłe SBR - guma ogólnego przeznaczenia**

### **Konstrukcja**

Płyty gumowe wulkanizowane z mieszanek gumowych, mogą być produkowane bez przekładek tkaninowych oraz z 1 lub 2 przekładkami.

### **Powierzchnia**

Barwa płyt czarna. Powierzchnie płyt mogą być gładkie lub z odciskiem tkaniny. Płyty o gładkiej powierzchni pokryte są cienką warstwą talku, zabezpieczającego płyty przed sklejeniem.

### **Przeznaczenie**

Mogą być stosowane w różnych gałęziach przemysłu, głównie do wyrobu podkładek i uszczelek pracujących statycznie w stanie nie rozciągniętym.

### **Charakterystyka techniczna**

Płyty ogólnego przeznaczenia zwykłe, mogą być stosowane w zakresie temperatur od  $-30$  do  $+70^{\circ}\text{C}$  w obojętnych roztworach wodnych. Posiadają atest higieniczny Nr HK/B/0883/01/99 do stosowania w pomieszczeniach przeznaczonych na czasowy pobyt ludzi, w magazynie itp.

### **Wymagania techniczne - dot. gumy stosowanej do produkcji płyt standardowych.**

Twardość oShA  $65 \pm 5$

Wytrzymałość na rozciąganie Mpa 4

Wydłużenie względne, % min. 150

**Zl. 90.24399.3.1**

UWAGA:

*zamówić identyczne gumy jak były*

*kupowane w poprzednim zl. 90.24291.3.1*

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