


Frisläppt

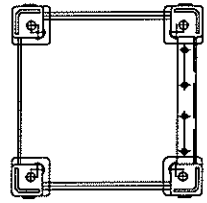
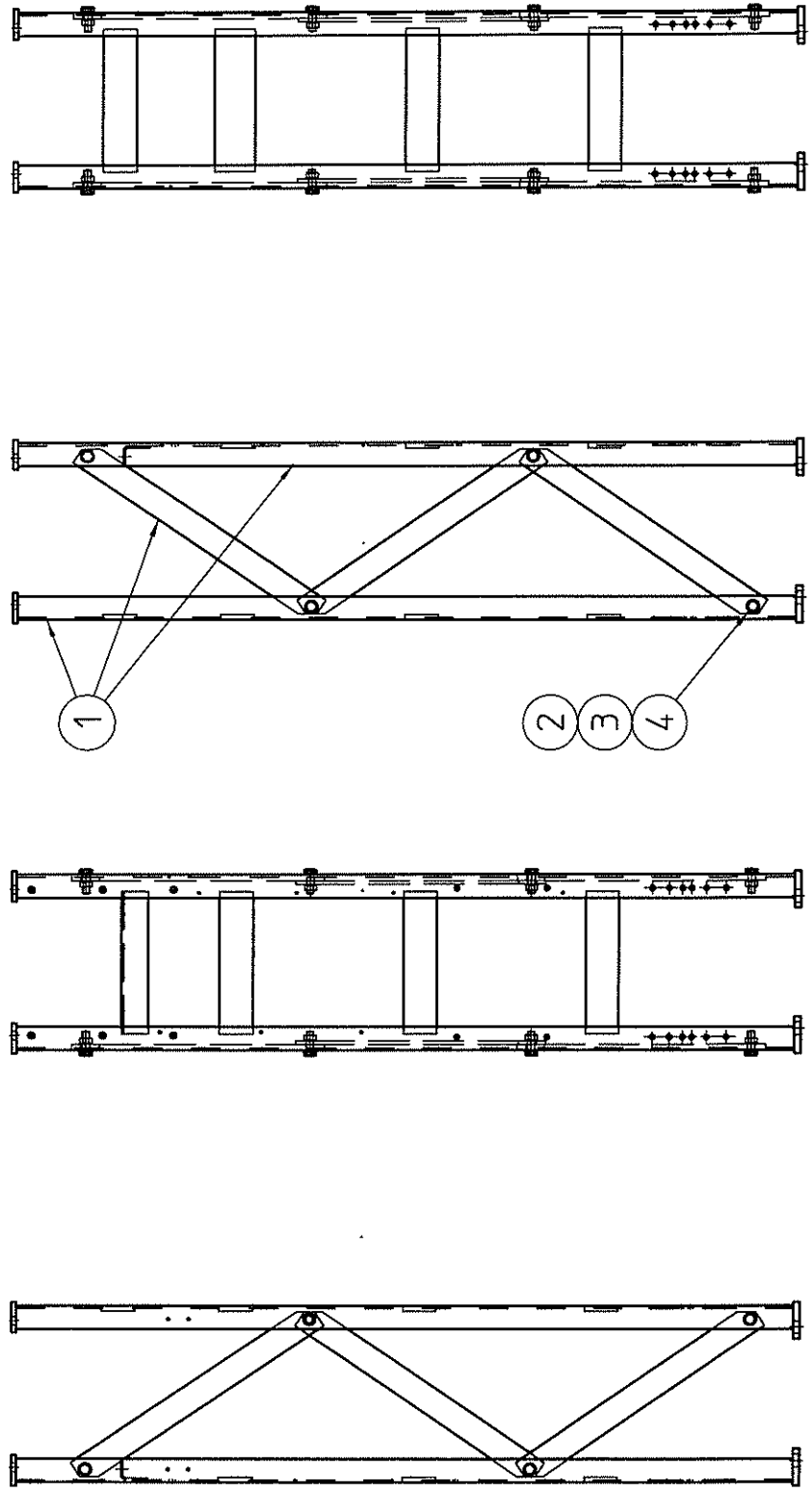
Qty	Unit	Item No.	Item des	Article No.	Name of item	Type Dimension
1	pcs	1		1HSB445284-M	SET OF FRAMEPARTS	STATIVSATS
24	pcs	2		9ADA121-76	M20X60 HEXAGON HEAD BOLT	M20X60 SEXKANTSSK. 8.8 FE/ZN45
24	pcs	3		9ADA268-6	M20 HEXAGON NUT FE/ZN	M20 SEXKANTMUTTER FE/ZN
48	pcs	4		9ADA316-8	21X37X3 PLAIN WASHER A4	21X37X3 RUNDBRICKA A4
1	pcs	5		2961234-13	PACKING, FOR SET OF BOLTS	EMBALLAGE, FÖR SKRUVSATS
Packing item 5 attached according to drawing 1HSB445284-M. Emballage pos 5 bandas fast enligt ritning 1HSB445284-M.						
Prepared 1998-08-20 Lindholm Jan				Responsible department	-902 Assembly drawing	Lang.
Approved 2006-03-31 Benny Wedin				BC	1HSB445284-Y	
Revision 002				Take over depart.	Title	Sheet
				BC	STATIVSATS, (3 st)	1
					SET OF FRAME (3 pcs)	
 ABB Power Technologies				Document no.		Cont
					1HSB445284-BA	-

REVISION PART				
Item 6 deleted and text revised.				
Prepared 1998-08-20 Lindholm Jan		Responsible department BC	-902 Assembly drawing 1HSB445284-Y	Lang.
Approved 2006-03-31 Benny Wedin				
Revision 002				
Take over depart. BC		Title	STATIVSATS, (3 st) SET OF FRAME (3 pcs)	Sheet R 1
ABB ABB Power Technologies		Document no.	1HSB445284-BA	Cont -

This document is issued by means of a computerized system.
The digitally stored original is electronically approved. The
approved document has a date entered in the 'Approved-Field'.
A manual signature is not required.

We reserve all rights in this document and in the
information contained herein. Reproduction, use or
disclosure to third parties without express authority
is strictly forbidden. ABB Power Technologies AB

Drawn by / Form No.	Design checked by	Rev. No.	Date	Year	Week	Cont.

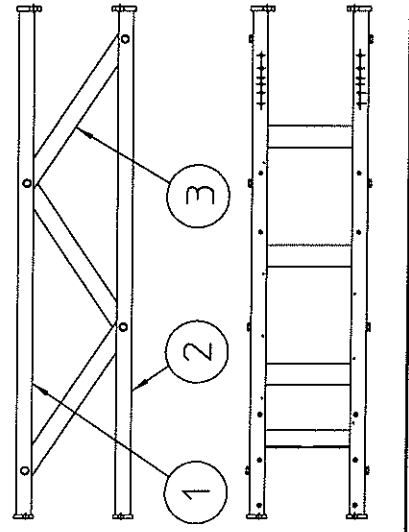


Prepared R. Magnusson	2004-01-19	Responsible department PTHVP/BDB	Title FRAME
Approved M. Stark	2004-01-20	Take over department	STATIV
Revision 1 Redrawn			
ABB ABB Power Technologies AB			Document no. 1HSB445284-Y
			Cont. -

The document is issued by means of a computerized system.
The digitally stored original is electronically approved. The
approved document has a date entered in the Approved field.
A manual signature is not required.

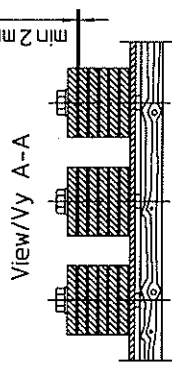
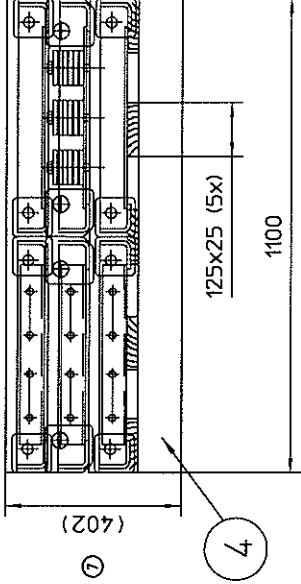
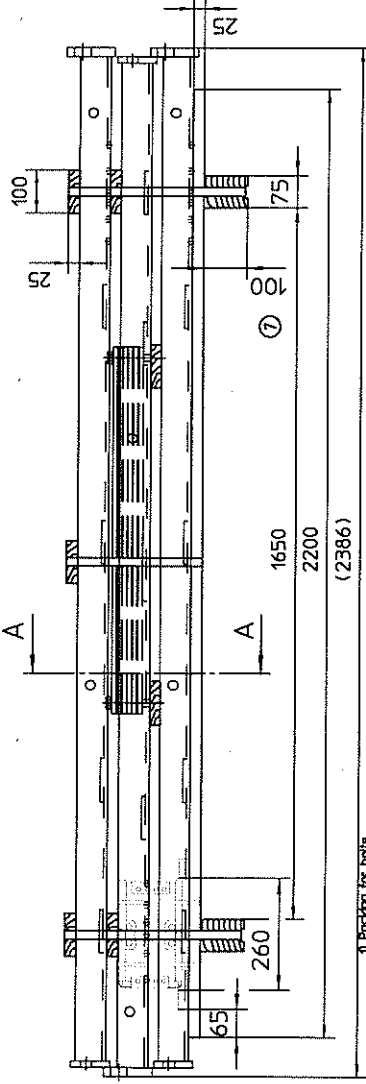
We reserve all rights in this document, and in the
information contained therein. Reproduction, use or
disclosure to third parties without express authority
is strictly forbidden. ABB Power Technologies AB

Drawn by	Form No.
Sheet	
Rev No.	Year
Rev No.	Week
Cont.	



Board 45x25 L=200 (2x)
rolled steel reinforcement
Brids 45x25 L=200 (2x)
Brids 45x25 L=200 (2x)
Brids 45x25 L=200 (2x)

1) Packing for bolts
25x1 234-01, strap.
2) Envelope for screw
25x1 234-01, bandage fast.



View/Vy A-A

The bars to be bolted with at least
2 mm air space. Use galvanized wire
or similar.

Stagen packas med minst 2 mm luft-
spalt tex med galvad tråd eller dylikt.

Each crate shall be marked with
drawing number 1HSB445284-M
in a weather protected cover,
visible from the side.

Varje kotti märkes med ritnings-
nummer 1HSB445284-M.
Synligt från sidan och placerat
i väderbeständig plastficka.

The crates shall be able to be
stacked upon each other.

Emballagen skall vara staplingsbar.

Marking of wooden packing shall be performed
according to TP 1HSB732961-1.
Märkning av träemballage skall utföras enligt
TB 1HSB732961-1.

1

2

3

4

5

6

7

8

9

10

11

12

13

14

15

16

17

18

19

20

21

22

23

24

25

26

27

28

29

30

31

32

33

34

35

36

37

38

39

40

41

42

43

44

45

46

47

48

49

50

51

52

53

54

55

56

57

58

59

60

61

62

63

64

65

66

67

68

69

70

71

72

73

74

75

76

77

78

79

80

81

82

83

84

85

86

87

88

89

90

91

92

93

94

95

96

97

98

99

100

101

102

103

104

105

106

107

108

109

110

111

112

113

114

115

116

117

118

119

120

121

122

123

124

125

126

127

128

129

130

131

132

133

134

135

136

137

138

139

140

141

142

143

144

145

146

147

148

149

150

151

152

153

154

155

156

157

158

159

160

161

162

163

164

165

166

167

168

169

170

171

172

173

174

175

176

177

178

179

180

181

182

183

184

185

186

187

188

189

190

191

192

193

194

195

196

197

198

199

200

201

202

203

204

205

206

207

208

209

210

211

212

213

214

215

216

217

218

219

220

221

222

223

224

225

226

227

228

229

230

231

232

233

234

235

236

237

238

239

240

241

242

243

244

245

246

247

248

249

250

251

252

253

254

255

256

257

258

259

260

261

262

263

264

265

266

267

268

269

270

271

272

273

274

275

276

277

278

279

280

281

282

283

284

285

286

287

288

289

290

291

292

293

294

295

296

297

298

299

300

301

302

303

304

305

306

307

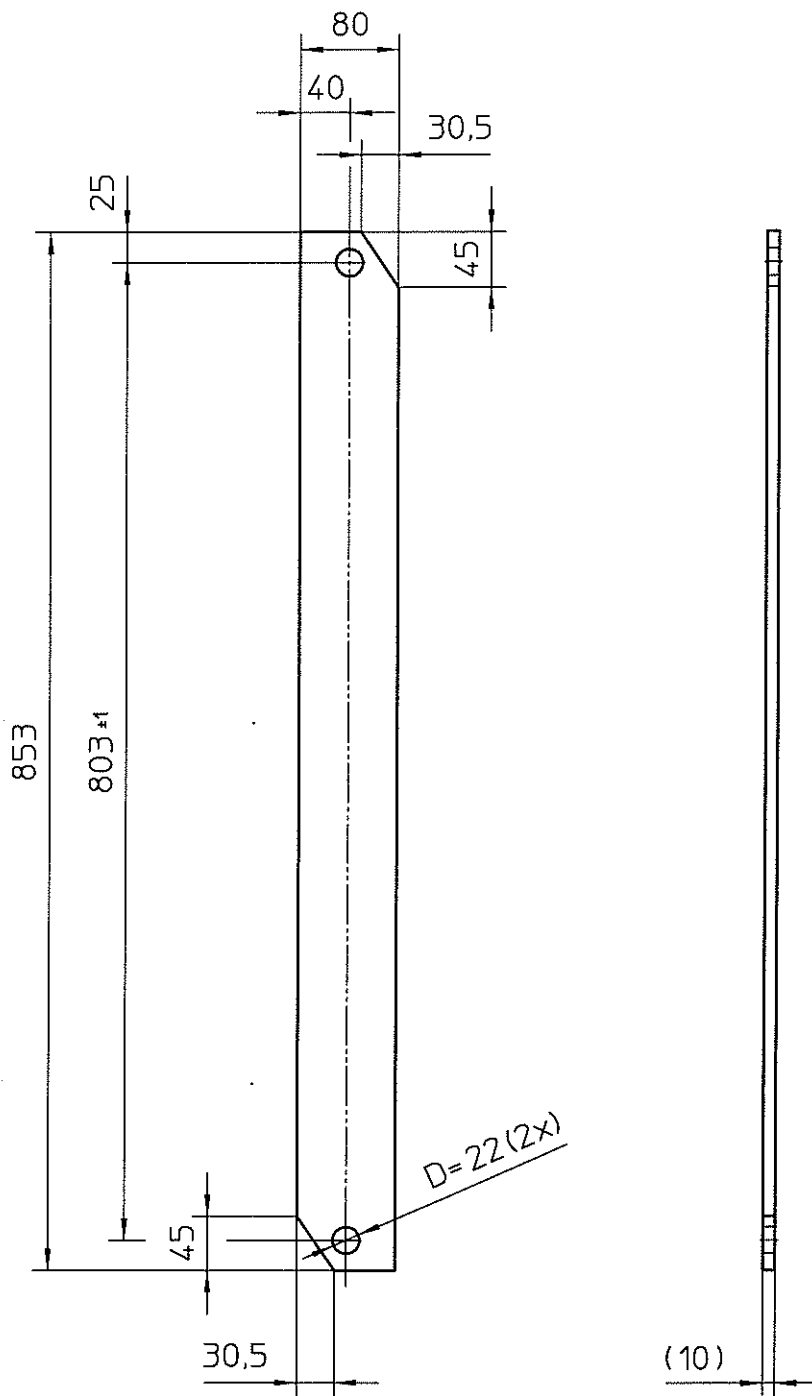
308

309

310

311

We reserve all rights in this document and in the information contained therein. Reproduction, use or disclosure to third parties without express authority ABB (Sweden) is strictly forbidden.



TOLERANCES acc. to ISO TOLERANCES enl. ISO			
ISO 2768 -Coarse		For machining, För bearbetning	
SMS 723-B		For welding, För svetsning	
ISO 965	External threads: Utvändiga gängor: 6g	Internal threads: Invändiga gängor: 6H	For threads För gängor
Surface finish, Ytjämnhet		Ra 6,3	
Applicable where no tolerance is indicated. Gäller där tolerans ej direkt utsatts			

Drawn by Form No.	Sheet	Year	Week	Cont.
Design checked by	Per Ind Dept	Year	Week	Cont.
Inspection acc.to 1HSB 732008-1 Kontroll enligt 1HSB 732008-1				
Surface Fe/Zn acc. to 2062 0033-1 and SS 3583 class B Yta Fe/Zn enl. 2062 0033-1 och SS 3583 klass B				
Article No.		Material, type, etc		Dimensions
DOMEX 350 YP		L=853, T=10		Sheet of steel Plåt av stål
Prepared P STENGÅRD 96-12-03		Responsible department B5		Title STAY
Approved T STRÖM 96-12-09		Take over department BC		STAG
Revision				Language
ABB		ABB Switchgear		Sheet 1
Document no.		1HSB442176-1		Cont -

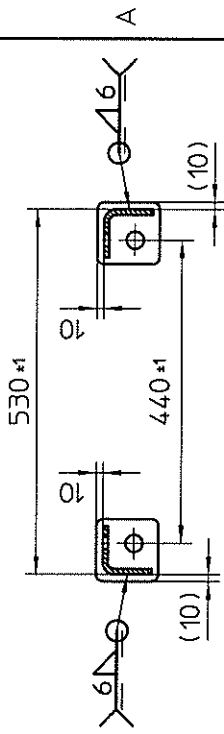
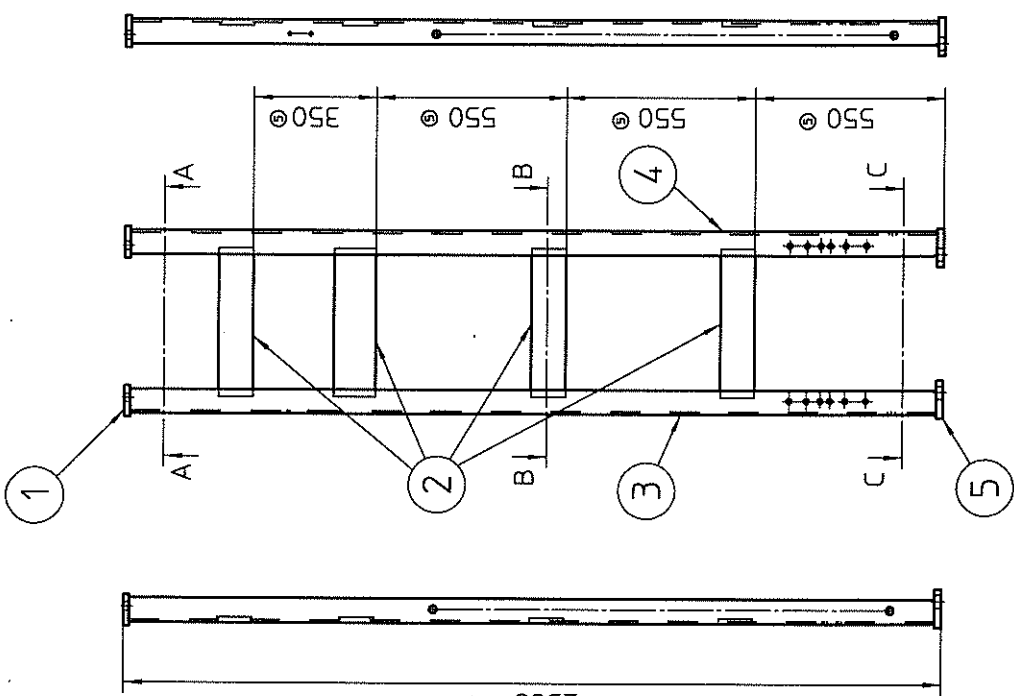
The document is issued by means of a computerized system.
The digitally signed original has a date entered in the Approved field.
A manual signature is not required.

We reserve all rights in this document and in the
disclosure to third parties without express authority
is strictly forbidden. ABB Power Technologies AB

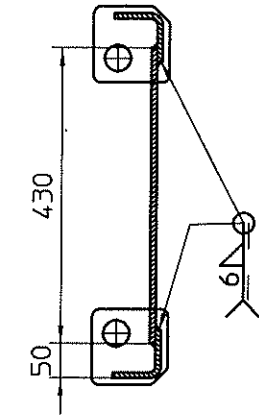
Form No.	Year	Week	Cont.
Design checked by	Rev. and	Dep.	

TOLERANCES acc. to ISO / TOLERANSER enl. ISO
Applicable where no tolerance is indicated. Gäller där tolerans ej direkt uttrycks
For machining / För bearbetning: ISO 2768-d
For welding / För svetsning: SS-EN ISO 13920-C8
For threads: ISO 965 External threads: 6g Internal threads: 6H
För gängor: ISO 965 Utvändiga gängor: 6g Invändiga gängor: 6H
Surface finish acc. to ISO 1302 Ra 6.3
Ytjämnhet enl. ISO 1302 Ra 6.3
Inspection acc. to IHSB 732008-1.
Kontroll enl. IHSB 732008-1.

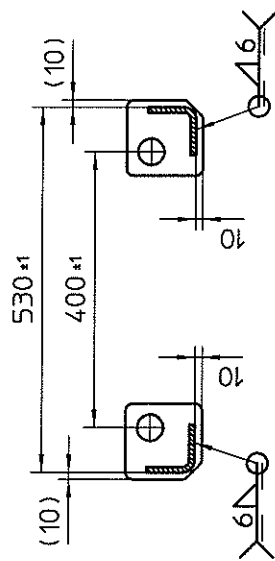
WELDING DATA/SVETSDATA for steel/för stål according to/enligt: SS-ISO 2553
Technical provisions/TB: 1VEM 202000-001
Quality level / kvalitetsnivå (acc. to/enligt SS-ISO 5817) C
Welding method/Svetsmetod (acc. to/enligt SS-ISO 4063) 131



Section A-A
Snitt A-A



Section B-B
Snitt B-B



Section C-C
Snitt C-C

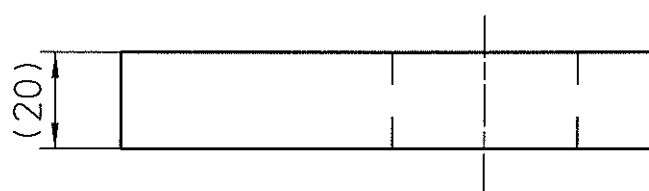
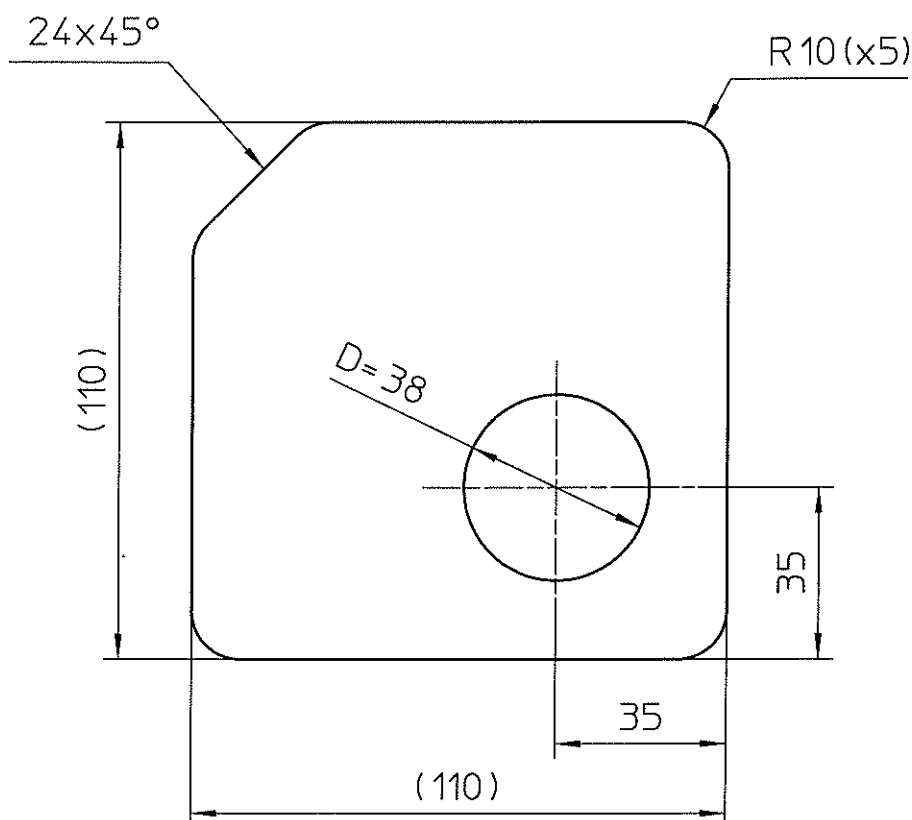
Holes D=7 shall not be filled with zinc.
Hål D=7 får ej vara igenfyllda med zink.

Hot dip galvanized class B acc. to SS 3583 and TP 2062 0033-1
Varmförzinkad klass B enligt SS 3583 och TB 2062 0033-1

2	5	1HSB 442154-3 (SS 2134-01)	Plate Platta
1	4	1HSB 442175-12 (Domex 350 YP)	Leg for frame Ben för stativ
1	3	1HSB 442175-13 (Domex 350 YP)	Leg for frame Ben för stativ
4	2	Domex 350 YP	Plate of steel Plåt av stål
2	1	1HSB 442154-2 (SS 2134-01)	Plate Platta

Qty.	Item No.	Article No.	Material, type, etc.	Dimensions	Name of item	Note
Prepared R Magnusson	2004-01-19	PTHVP/BDB	FRAME			
Approved M Stark	2004-01-20	Take over department	STATIV			
Revision	5	Item 2,3 and 4 and dim changed				
ABB	ABB Power Technologies AB	Document no.	1HSB445284-U			

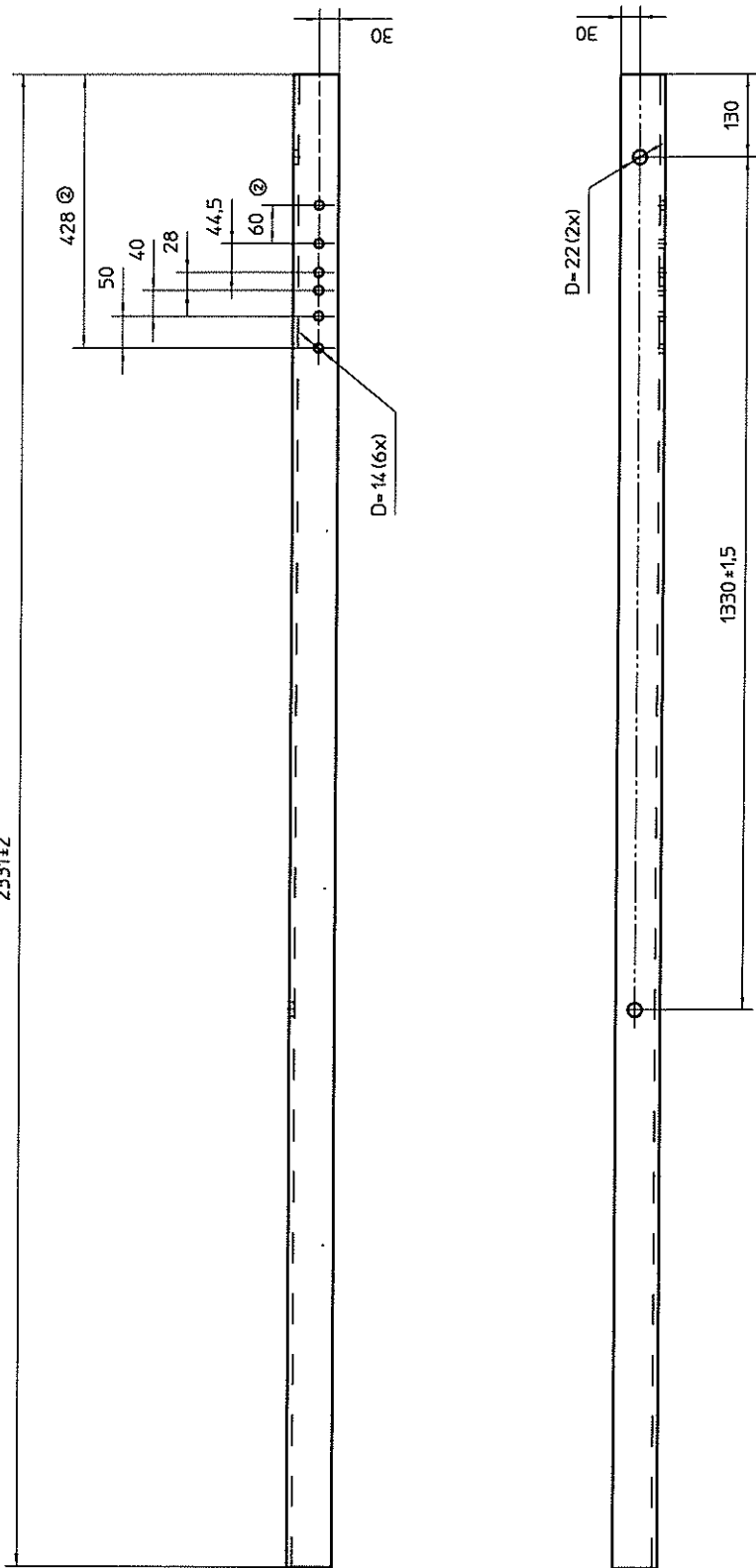
TOLERANCES acc. to ISO TOLERANSER enl. ISO		
ISO 2768-Coarse	For machining, För bearbetning	
SMS 723-B	For welding, För svetsning	
ISO 965	External threads: 6g Utvändiga gängor: 6g	Internal threads: 6H Invändiga gängor: 6H
Surface finish, Ytjämnhet		Ra 6,3
Applicable where no tolerance is indicated. Gäller där tolerans ej direkt utsatts		



Drawn by	Sheet
	Year Week Cont.
	Dept
	Design checked by

SS 2134-01		T=20, 110x110	Sheet of steel Plåt av stål
Article No.	Material, type, etc	Dimensions	Name of item
Prepared R MAGNUSSON 98-04-21	Responsible department BC	Title PLATE PLATTA	Note
Approved J RUTHSTRÖM 98-04-23	Take over department BC		
Revision		Document no. 1HSB442154-3	Sheet 1 Cont -
ABB Switchgear			

2331±2



TOLERANCES acc. to ISO / TOLERANSER enl. ISO	
Applicable where no tolerance is indicated.	
Gäller där tolerans ej direkt utslås	
For machining / För bearbetning	ISO 2768-ck
For welding / För svetsning	ISO 5817
For threads: ISO 965	External threads: 6g Internal threads: 6H
For ganges: ISO 1302	External ganges: 6g Internal ganges: 6H
Surface finish acc. to: ISO 1302	Ra 6.3
Ytfinish enligt ISO 1302	Ra 6.3
Inspection acc. to: ISO 732008-1	
Kontroll enligt ISO 732008-1	

Article No.		DOMEX 350 YP	L=2331, T=8	Plat av stål	Sheet of steel
Material type		Material type	Dimensions	Name of firm	
Prepared		Responsible department	Title	Notes	
R Magnusson		PTHVP/BDB	LEG FOR FRAME	Language	
Approved		2004-01-19	Take over department	82	
M Stark		2004-01-20		Sheet	
Revision				1	
2		Hole added and 428 was 368		Cont	
ABB		ABB Power Technologies AB		Document no.	
				1HSB442175-12	
				6	

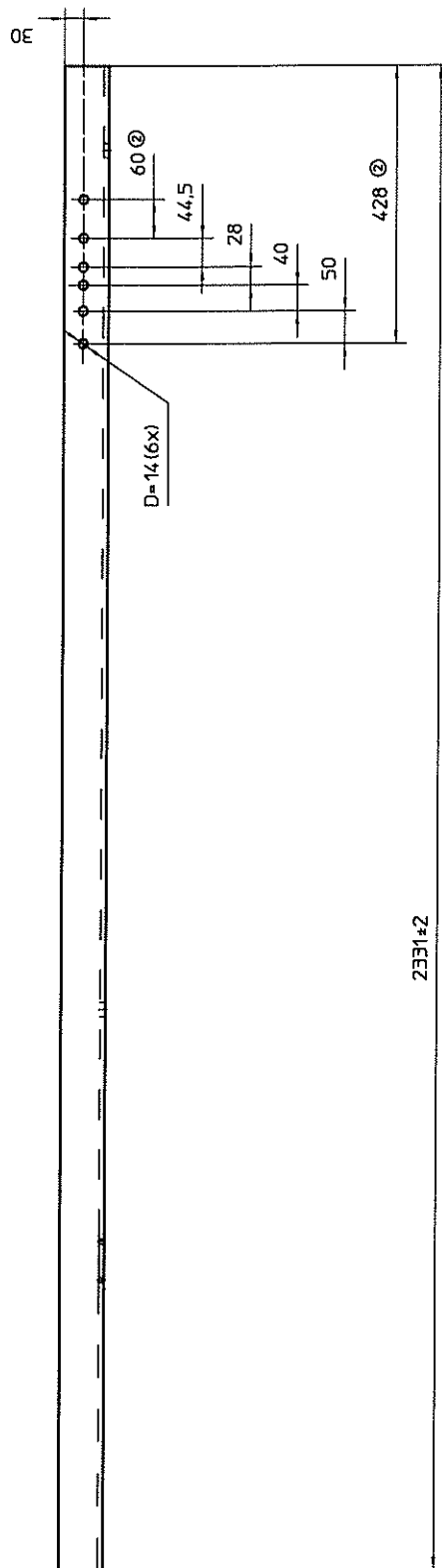
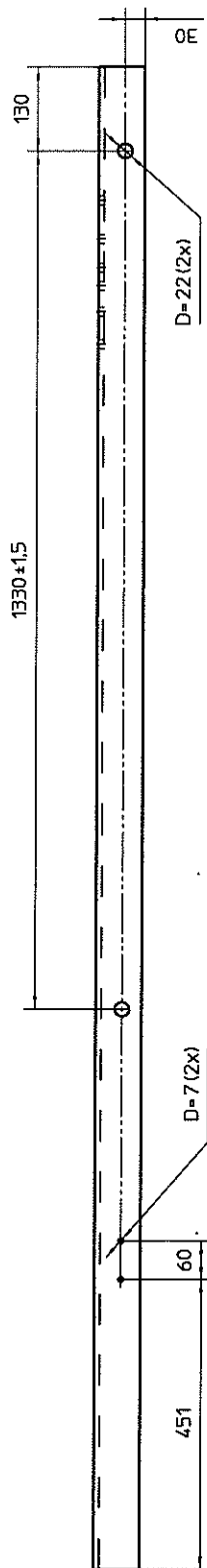
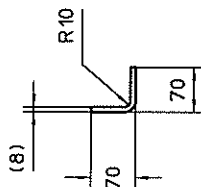
The document is issued by means of a computerized system.
The digitally stored original is electronically approved. The
approved document has a date entered in the "Approved" field.
A manual signature is not required.

We reserve all rights in this document and in the
information contained therein. Reproduction, use or
disclosure to third parties without express authority
is strictly forbidden. ABB Power Technologies AB



Design checked by	Form No.	Sheet
Year and Date	Year Week	Cont.

We reserve all rights in this document and in the information contained therein. Reproduction, use or disclosure to third parties without express authority is strictly forbidden. All Power Technologies AB

Design checked by	For Incl Disp	Year Incl Cont
Drawn by Form No.		Sheet

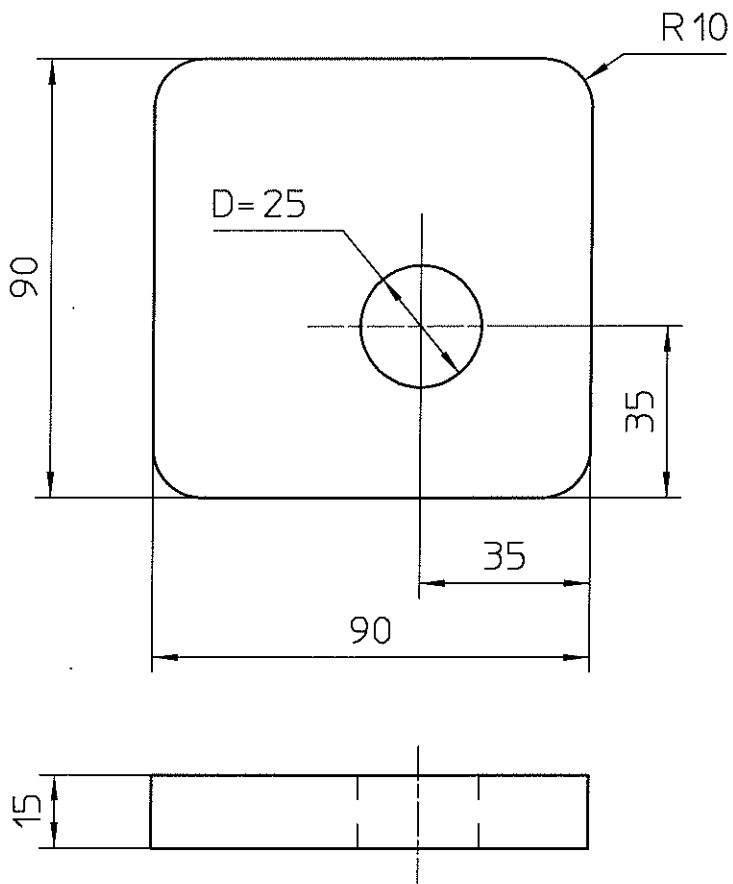


TOLERANCES acc. to ISO / TOLERANSEER enl. ISO
Applicable where no tolerance is indicated. Gäller där tolerans ej är direkt utsläppts
For machining / För bearbetning: ISO 2768 -cK
For welding / För svetsning: SS-EN ISO 49920-ZW
For threads: ISO 985 External threads: 6g För gängor: Inre gängor: 6H
Surface finish acc to ISO 1302 Ra 6,3 Ytjämnhet enligt ISO 1302
Inspection acc. to ISO 732008-1. Kontroll enligt ISO 732008-1.


_____	DOMEX 350 YP	L=2331, T=8	Plot on A3 Sheet of steel
Article No.	Material/Type/size	Dimensions	Name of Item
Prepared	Responsible department	Title	 Language 82 Sheet 1
Approved	2004-01-19	PTHVP/BDB	
Revision	2004-01-20	Take over department	
2		Hole added and 428 was 368	
 ABB Power Technologies AB		Document no.	1HSR442175-13
		Cont.	-

We reserve all rights in this document and in the information contained therein. Reproduction, use or disclosure to third parties without express authority is strictly forbidden.
ABB (Sweden)

TOLERANCES acc. to ISO TOLERANSER enl. ISO			
ISO 2768-Coarse		For machining, För bearbetning	
SMS 723-B		For welding, För svetsning	
ISO 965	External threads: Utvändiga gängor: 6g	Internal threads: Invändiga gängor: 6H	For threads För gängor
Surface finish, Ytjämnhet		Ra 6,3	
Applicable where no tolerance is indicated. Gäller där tolerans ej direkt utsatts			



Drawn by / Form No.	Design checked by	Rev. no.	Year	Week	Cont.

	SS 2134-01	T=15, 90x90	Sheet of steel Plåt av stål
Article No.	Material, type, etc	Dimensions	Name of Item
Prepared P STENGÅRD 96-11-29	Responsible department B5	Title PLATE PLATTA	
Approved T STRÖM 96-12-09	Take over department BC		
Revision			Sheet 1
ABB Switchgear		Document no. 1HSB442154-2	Cont -

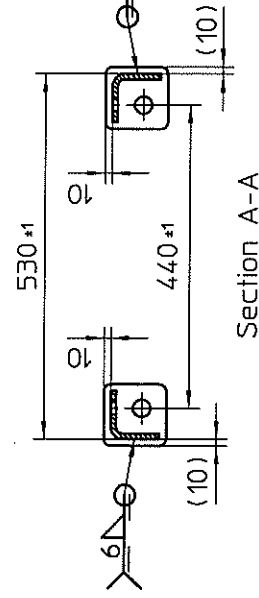
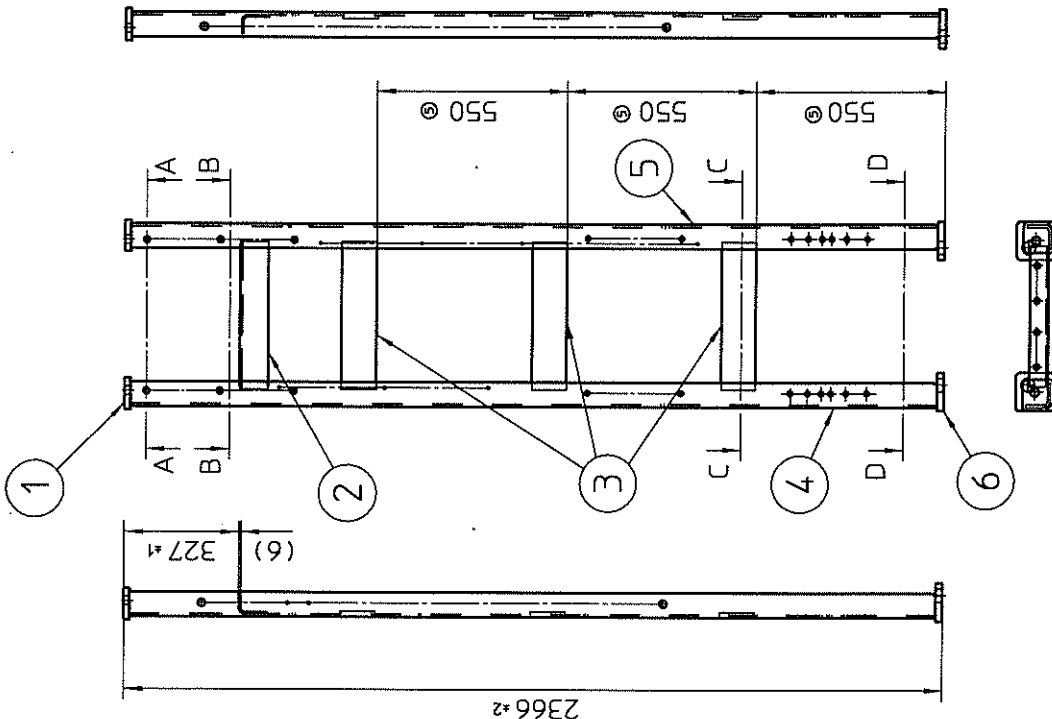
The document is issued by means of a computerized system.
The digitally signed original is electronically approved. The
approved document has a date entered in the Approved field.
A manual signature is not required.

We reserve all rights in this document and in the
information contained therein. Reproduction, use or
disclosure to third parties without express authority
is strictly forbidden. ABB Power Technologies AB

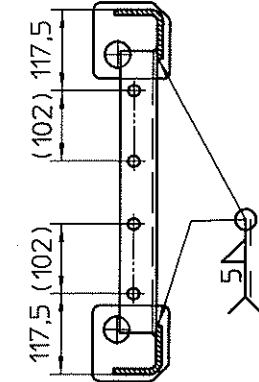
Drawn by	Form No.	Sheet
Design checked by	Per and Date	Year Week Cont.

TOLERANCES acc. to ISO / TOLERANSER enl. ISO
Applicable where no tolerance is indicated. Gäller där tolerans ej direkt utställs
For machining / För bearbetning ISO 2768-MK
For welding / För svetsning SS-EN ISO 13920-ZW
For threads: ISO 965 External threads 6g Inre trådar: 6H
Surface finish acc. to ISO 1302 Ra 6,3 For beaktade ytor
Ytjämnhet enligt ISO 1302.
Inspection acc. to IHSB 732008-1.
Kontroll enligt IHSB 732008-1.

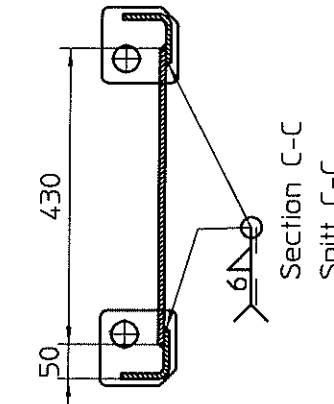
WELDING DATA/SVETSDATA for steel/för stål according to/enligt: SS-ISO 2553
Technical provisions/TB: 1VEM 202000-001
Quality level / kvalitetsnivå (acc. to/enligt SS-ISO 5817) C
Welding method/Svetsmetod (acc. to/enligt SS-ISO 4063) 131



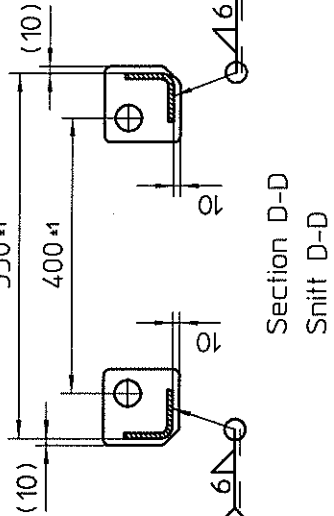
Section A-A
Snitt A-A



Section B-B
Snitt B-B



Section C-C
Snitt C-C



Section D-D
Snitt D-D

Holes D=7 and D=6 shall not be filled with zinc.
Hål D=7 och D=6 får ej vara igenfyllda med zink.

Hot dip galvanized class B acc. to SS 3583 and TP 2062 0033-1
Varmförzinkad klass B enligt SS 3583 och TP 2062 0033-1

Qty.	Item No.	Article No.	Material, type, etc	Dimensions	Name of item	Note
2	6	1HSB 442154-3	(SS 2134-01)		Platta	
1	5	1HSB 442175-11	(Domex 350 YP)		Leg for frame	
1	4	1HSB 442175-10	(Domex 350 YP)		Ben för stativ	
3	3	—	Domex 350 YP	430x100,T=8	Platt av stål	
1	2	1HSB 442176-8	(Domex 350 YP)		Stag	
2	1	1HSB 442154-2	(SS 2134-01)		Platta	

Prepared R Magnusson	2004-01-19	Responsible department PTHVP/BDB	Title FRAME
Approved M Stark	2004-01-20	Taken over department	STATIV
Revision 5	Item 3,4 and 5 and dim changed		
ABB	ABB Power Technologies AB	Document no. 1HSB445284-T	

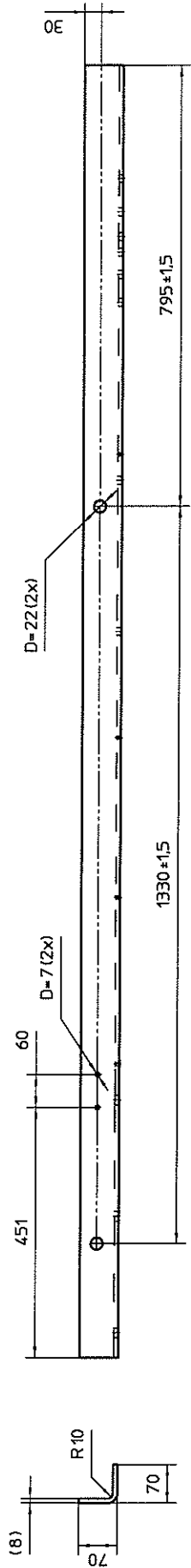
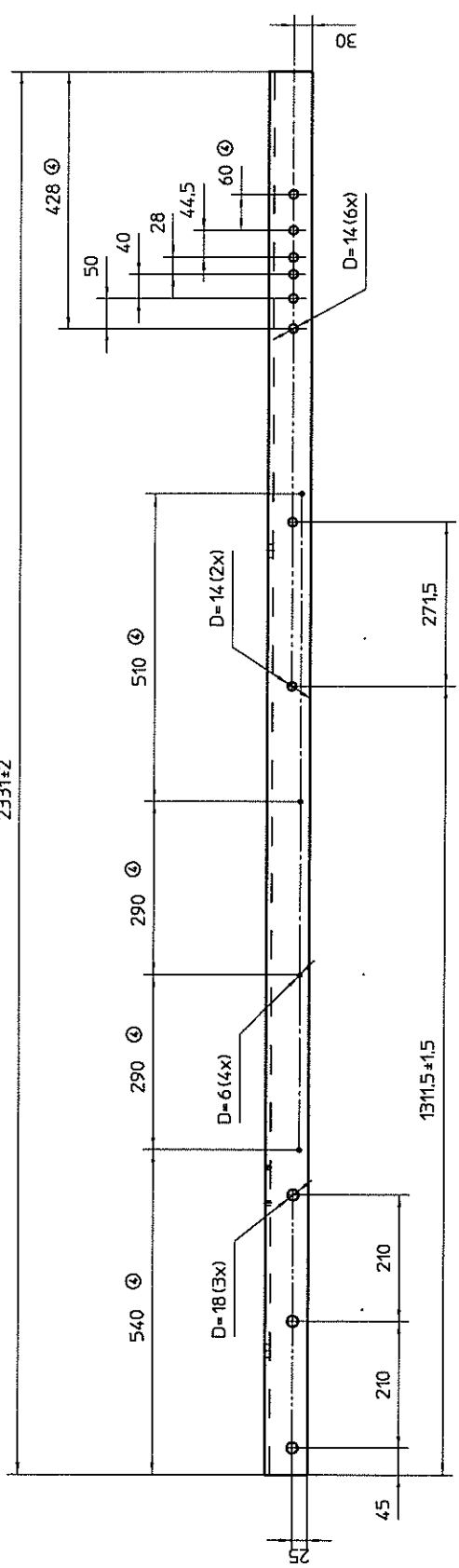
A

B

C

D

2331±2



TOLERANCES acc. to ISO / TOLERANSER enl. ISO	
Applicable where no tolerance is indicated.	
Gäller där tolerans ej direkt utsläts	
For machining / För bearbetning	ISO 2768-cK
For welding / För svetsning	ISO 5817
For threads: ISO 965	External threads: 6g Internal threads: 6H
For ganges: ISO 965	Utvändiga gänger: 6g Invändiga gänger: 6H
Surface finish acc. to: ISO 1302	Ra 6.3
Ytfinish enligt: ISO 1302	Ra 6.3
Inspection acc. to: IHSB 732008-1.	
Kontroll enligt: IHSB 732008-1.	

DOMEX 350 YP		L=2331, T=8	Pikt av stål Sheet of steel	Note
Article No.	Material type	Dimensions	Name of item	
Prepared R Magnusson	Responsible department PTHVP/BDB	Title LEG FOR FRAME		Language 82
Approved M Stark	Take over department	BEN FÖR STATIV		Sheet 1
Revision 4	D=14 added, D=6 moved and 428 was 368	Document no 1HSB442175-11		Cont. -



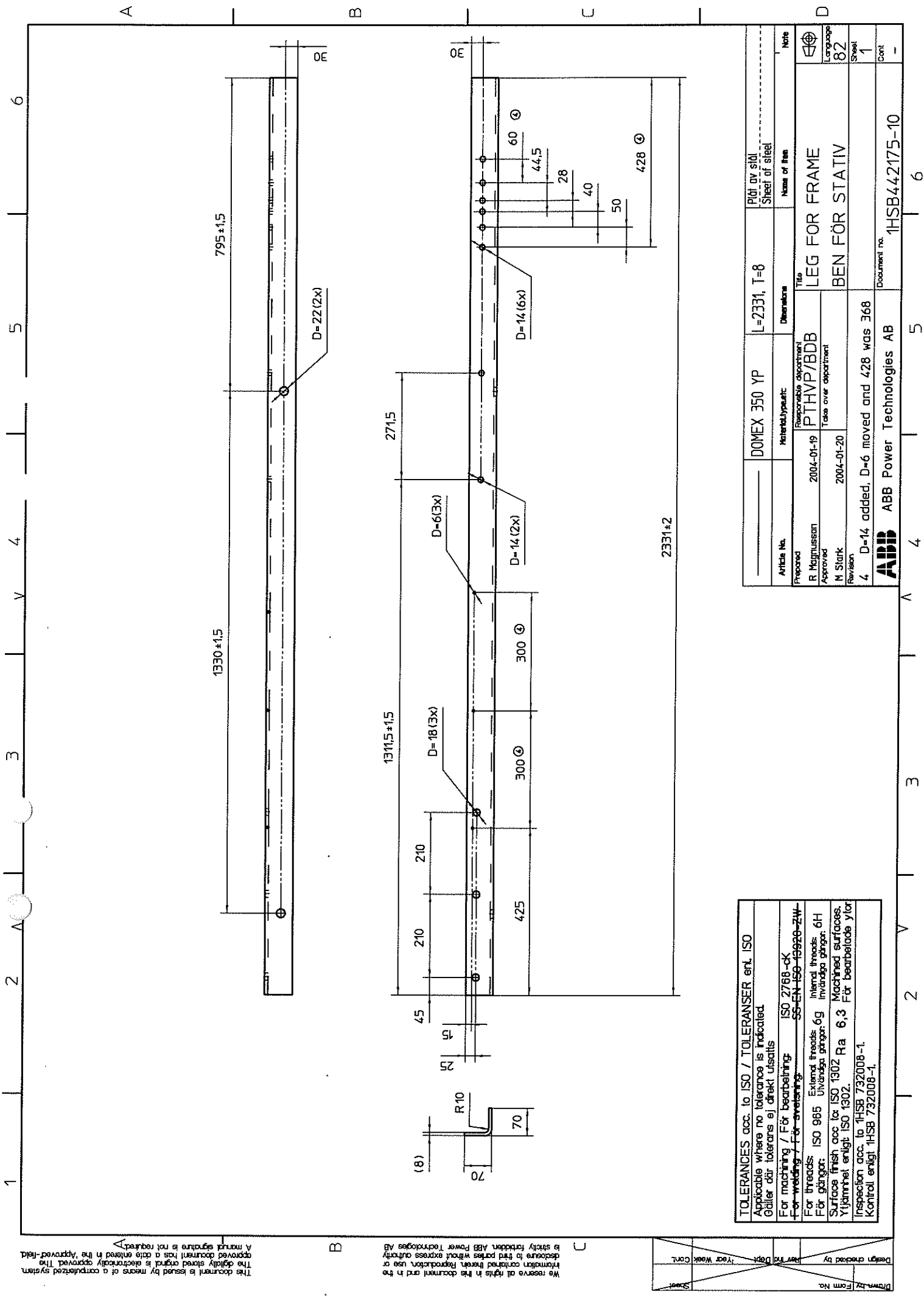
ABB Power Technologies AB

1HSB442175-11

The document is issued by means of a computerized system.
The digitally stored original is electronically approved. The
approved document has a date entered in the Approved field.
A manual signature is not required.

We reserve all rights in the document and in the
information contained therein. Reproduction, use or
distribution is strictly forbidden. ABB Power Technologies AB

Drawn by	Form No.	Design checked by	Rev. No.	Year	Week	Cont.



Article No.	Material type	Dimensions	Plat av stål
DOMEX 350 YP		L=2331, T=8	Sheet of steel
Prepared	Responsible department	Title	Note
R Magnusson	PTHVP/BDB	LEG FOR FRAME	
Approved	Take over department	BEN FÖR STATIV	
M Stark			
Revision			
4	D=14 added, D=6 moved and 428 was 368		
ABB	ABB Power Technologies AB	Document no	1HSB442175-10

TOLERANCES acc. to ISO / TOLERANSER enl. ISO
Applicable where no tolerance is indicated.
Gäller där tolerans ej direkt utställs
For machining / För bearbetning
ISO 2768-mK
SS-EN ISO 1302-214
For threads
ISO 985
Internal threads: 6H
External threads: 6g
Invändiga gängor: 6H
Utvändiga gängor: 6g
Surface finish acc. to ISO 1302
Ra 6.3
Machined surfaces.
Ytfinish enligt ISO 1302.
För bearbetade ytor
Inspection acc. to 1HSB 732008-1.
Kontroll enligt 1HSB 732008-1.

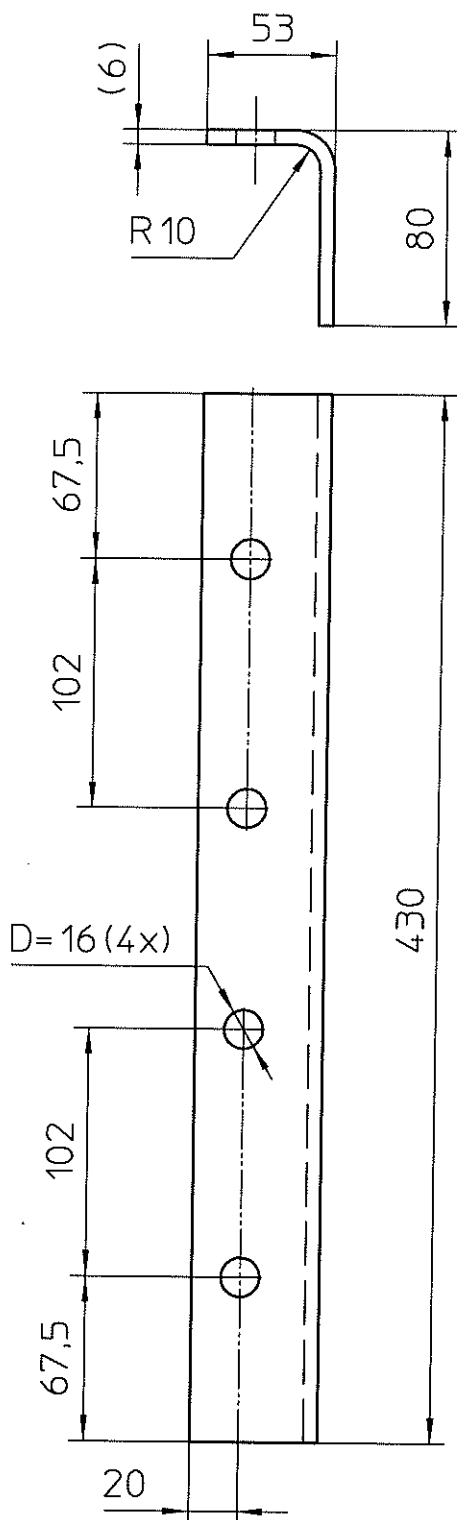
The document is issued by means of a computerized system.
The digitally stored original is electronically approved. The
A manual signature is not required.

We reserve all rights in the document and in the
information contained therein. Reproduction, use or
disclosure to third parties without express authority
is strictly forbidden. ABB Power Technologies AB

Drawn by	Form No.	Design checked by	Rev No.	Year	Week	Cont.

We reserve all rights in this document and in the information contained therein. Reproduction, use or disclosure to third parties without express authority is strictly forbidden. ABB Power Technology Products AB

We reserve all rights in this document and in the information contained therein. Reproduction, use or disclosure to third parties without express authority is strictly forbidden. ABB Power Technology Products



TOLERANCES acc. to ISO / TOLERANCES enl. ISO

Applicable where no tolerance is indicated.
Gäller där tolerans ej direkt utsatts



For machining / För bearbetning: ISO 2768-cG

For welding / För svetsning: SS-EN ISO 19920-ZW

For threads:	ISO 965	External threads:	6g	Internal threads:	6H
För gängor:		Utvändiga gängor:		Invändiga gängor:	

Surface finish acc to: ISO 1302
YTjämnhet enligt: ISO 1302. **Ra 6,3**
Machined surfaces.
För bearbetade ytor.

Inspection acc. to 1HSB 732008-1.
Kontroll enligt 1HSB 732008-1.

		DOMEX 350 YP	L=430, T=6	Sheet of steel Plåt av stål
Article No.		Material, type, etc	Dimensions	Name of Item
Prepared P Stengård 97-12-04		Responsible department PTHVP/BDB	Title STAY	 Language 82
Approved J Ruthström 2003-10-15		Take over department	STAG	
Revision 1 Two holes added				
 ABB Power Technology Products			Document no. 1HSB442176-8	Sheet 1 Cont -