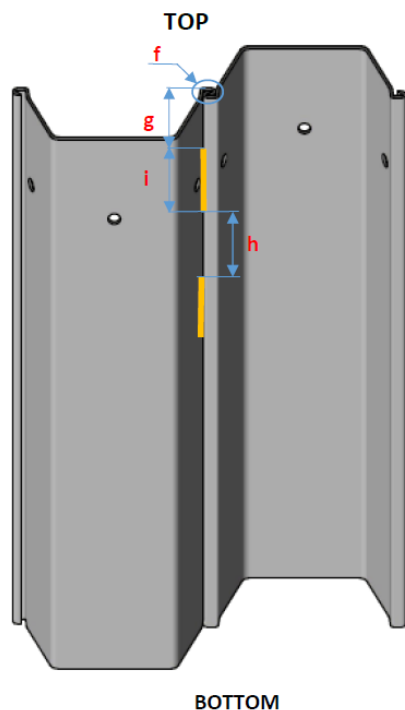
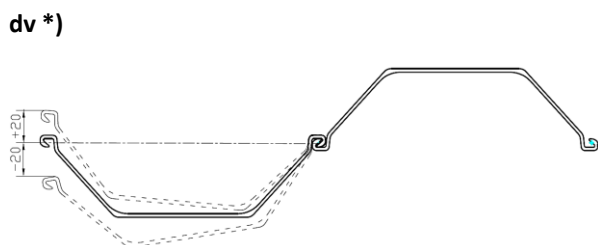
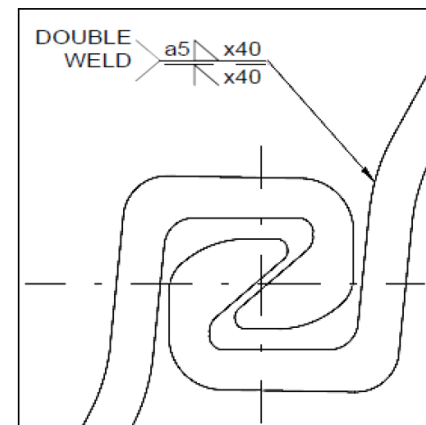
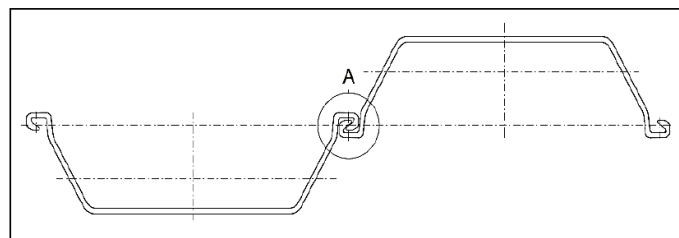


Info sheet No.	VL IS 04	Date of revision	7/04/2017
Type	III/n VL 504 - VL 507 (all modifications) VL 601 - VL 606 (all modifications)	Form (pairing)	DOUBLE/"S" or "Z" WELDED



Parametr Označení	Description Popis	Param. Value Hodnota (mm)	Tolerances (+/-) Tolerance (+/-)
g	Distance from the top edge of sheet pile and weld start Vzdálenost mezi horní hranou štětovnice a začátkem svaru	100	+50/-100 mm
h	Distance / spacing between welds Vzdálenost / rozteč mezi svary	1000	0/-100 mm
i	Dimension / weld length Rozměr / délka svaru	40	+15/ - 0 mm
f	Top edge alignment Zarovnání horní hrany	0	+20/-0 mm
dv	Max height deviation Maximální odchylka výšky	0	+20/-20 mm

*)Poznámka: Měřeno na rovném povrchu/Note: Measured on the flat surface



Welders qualified acc. to	EN ISO 5817; EN ISO 14732; EN ISO 9606-1
Welding procedure spec. acc. to	EN ISO 15609-1; EN ISO 15614-1
Requirements for welding supervisory staff	EN ISO 14731