

25 (✓)

Poz	Denumire	Nr.Desen	Buc	Material	Obs.	Masa
3	Traversa rama batiu		1	S235JR	U60x30x440	2.260
2	Latura 2 rama batiu		2	S235JR	U60x30x500	4.952
1	Latura 1 rama batiu		2	S235JR	U60x30x1450	14.714

**CONDITII TEHNICE:**

- Executie mijlocie cf. SREN 22768-2/95;
- Sudura de rezistenta, sudurile se vor executa ingrijit;

Proiectat	Lucian Ionescu
Desenat	Baicu Ionut
Verificat	Bogdan Duran
Contr. STAS	Bogdan Duran
Aprobat	Preda Dragos

DATA: oct. 2017

**SC. ROLIX IMPEX  
SERIES SRL**

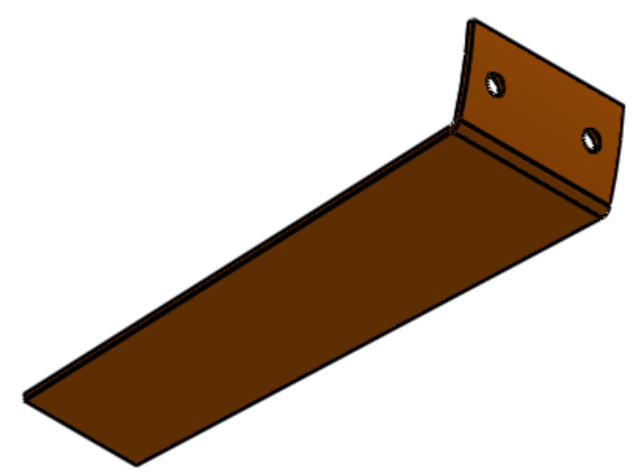
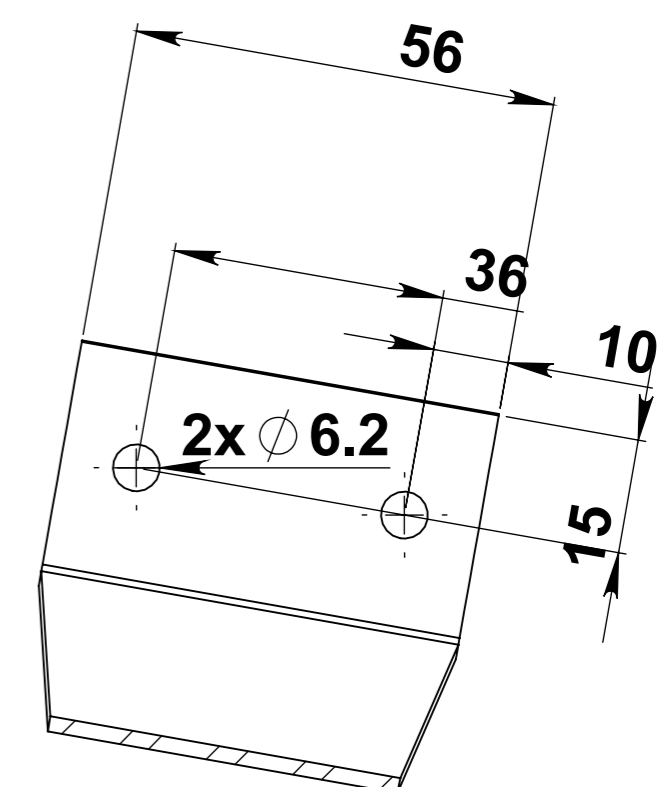
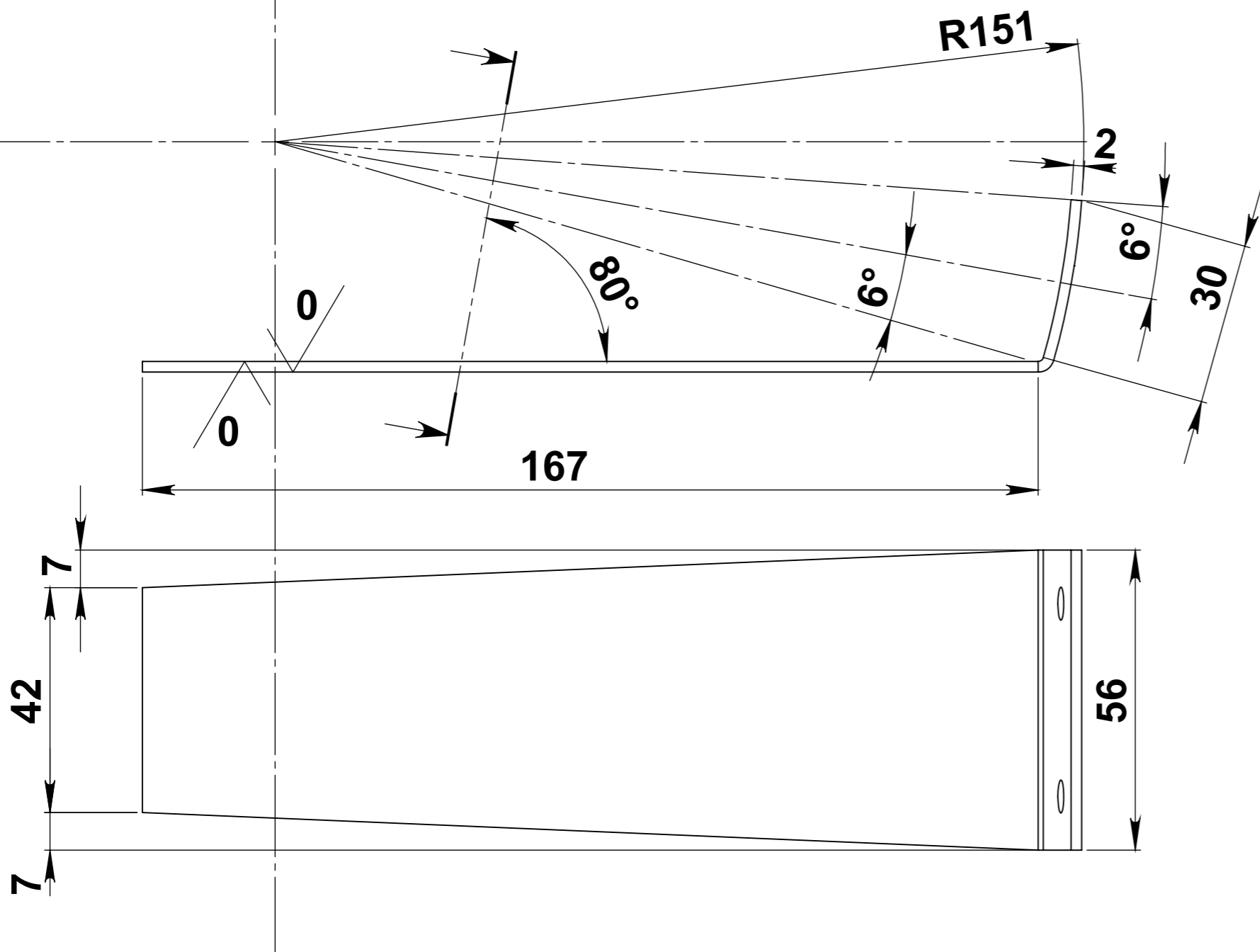
MATERIAL:

MASA:21.926Kg

**PRf - 20.1.0**

**Rama batiu**

A3



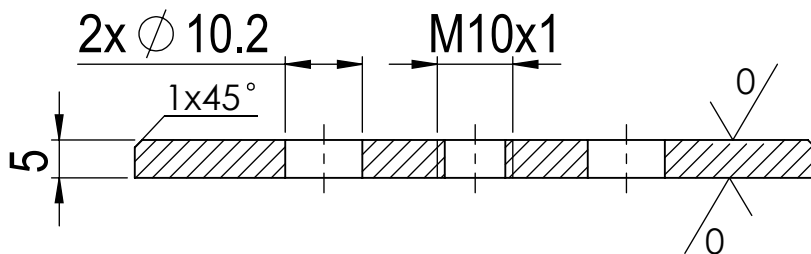
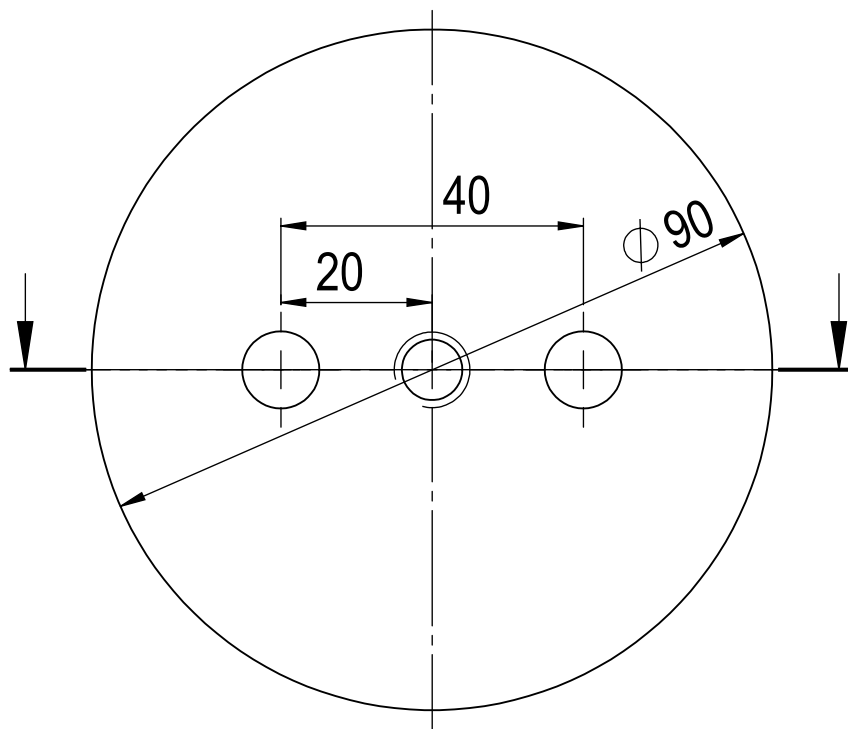
6.3 (✓)

**CONDITII TEHNICE:**

- Muchile necotate se tesesc 0,3x45°
- Executie mijlocie cf. SREN 22768-2/95

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>			MATERIAL: S235JR	<b>PRf - 4.2</b>	
			MASA: 0.155Kg	<b>Razuitor peleti v</b>	
					A3



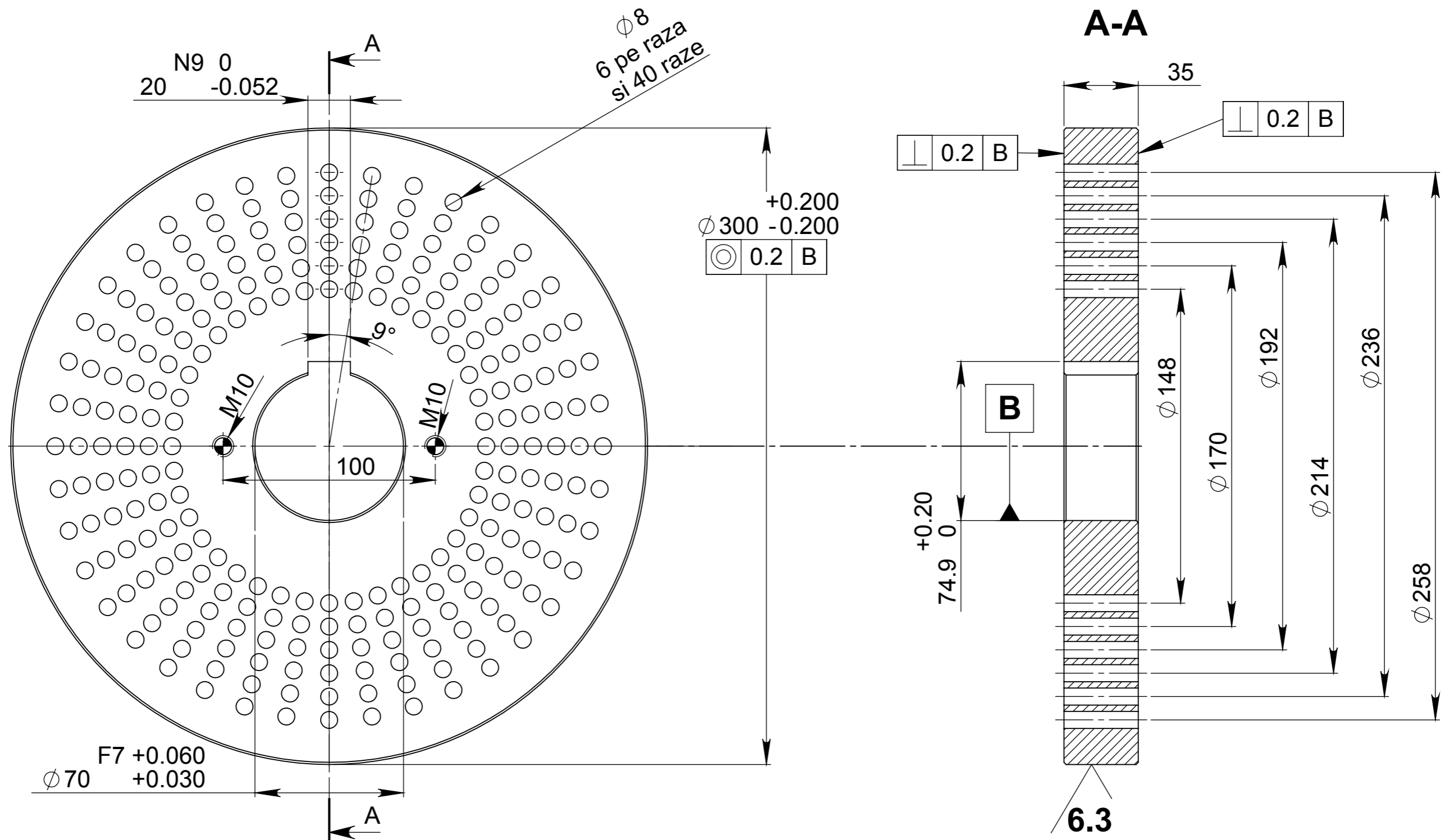


**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,2x45°;
- Executie mijlocie cf. SREN 22768-2/95;

6.3 / (✓)

Proiectat	Lucian Ionescu			<b>PRf - 5</b>	
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos				
<b>SC. ROLIX IMPEX SERIES SRL</b>		DATA: oct. 2017		<b>Saiba frontala ax motor</b>	
		MATERIAL: S235 JR			
		Masa: 0.239Kg			
				A4	



**NOTA:**  
Gaurile M10 sunt pentru extractia sitei

**CONDITII TEHNICE:**  
- Muchile necotate se tesesc  $0,5 \times 45^\circ$   
- Executie fina cf. SREN 22768-2/95

3.2 (✓)

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
SC. ROLIX IMPEX SERIES SRL			MATERIAL: C45		
			MASA: 14.914 Kg		
				<b>PRf - 12</b>	
				<b>Sita motoare</b>	A3



<b>SC. ROLIX IMPEX SERIES SRL Bucuresti ROMANIA</b>	<b>STANDARD DE FIRMA</b>	<b>SF.001/2019</b>
	<b>PRESA DE PELETI (15 kW)</b>	Rev.0

## 1. GENERALITATI

### 1.1. Obiect:

Prezentul standard de firma se refera la Presa de Peleti cu o putere instalata de 15 kW realizata in varianta cu sita motoare:

### 1.2. Norme de referinta:

- Legea nr. 319/2006 – Legea securitatii si sanatatii in munca;
- SR EN 692+A1:2009

### 1.3. Denumire, dimensiuni si domeniul de aplicare:

Presa de peleti (15kW);



Fig. 1 Presa de peleti (15 kW)

Elaborat: <b>SC. ROLIX IMPEX SERIES SRL</b>	Aprobat: <b>CT al SC. ROLIX IMPEX SERIES SRL</b>	Aprobat <b>Director General Preda Dragos</b>	Data reviziei: 09.07.2019
Sef Comp. Calitate: <b>Lucian Ionescu</b>	Ing.Sef <b>Bogdan Duran</b>		

<b>SC. ROLIX IMPEX SERIES SRL Bucuresti ROMANIA</b>	<b>STANDARD DE FIRMA</b>	<b>SF.001/2019</b>
	<b>PRESA DE PELETI (15 kW)</b>	Rev.0

**Dimensiuni:**

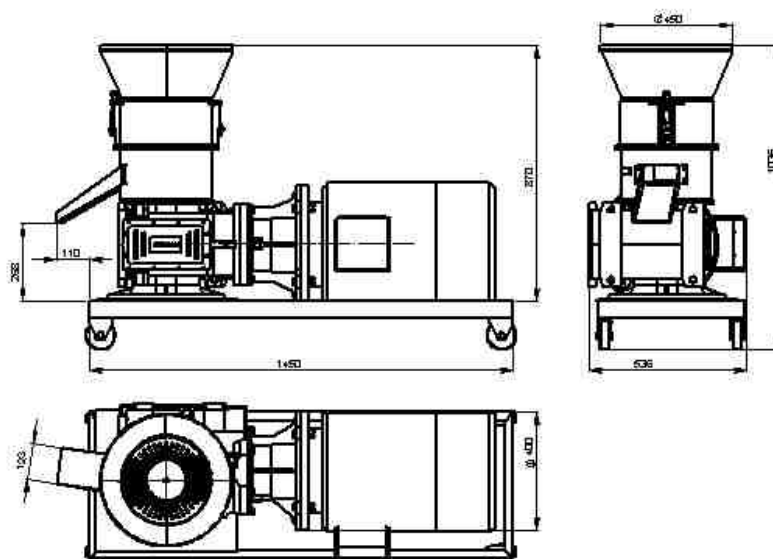


Fig.2 Dimensiuni de gabarit

**Domeniul de aplicare:**

Tehnologia de presare permite comprimarea biomasei si extrudarea acesteia prin orificiile sitei fara sa fie nevoie sa se utilizeze aditivi suplimentari.

Varianta aleasa permite obtinerea peletilor in regim continuu, rezultand o productivitate maxima.

Procesul de obtinere a peletilor consta din trecerea unei cantitati de biomasa prin matrita circular (sita) si obtinerea la iesire a unor snururi de material compactat si care vor fi portionate in functie de cerintele utilizatorilor. Solutia aleasa in cadrul acestui proiect este cu procesare continua prin miscarea relativa dintre sita (matrita) formatoare si cele doua role presoare. In fig.3 este prezentata solutia cu doua role presoare

Elaborat: <b>SC. ROLIX IMPEX SERIES SRL</b>	Aprobat: CT al <b>SC. ROLIX IMPEX SERIES SRL</b>	Aprobat Director General <b>Preda Dragos</b>	Data reviziei: 09.07.2019
Sef Comp. Calitate: <b>Lucian Ionescu</b>	Ing.Sef <b>Bogdan Duran</b>		



<b>SC. ROLIX IMPEX SERIES SRL Bucuresti ROMANIA</b>	<b>STANDARD DE FIRMA</b>	<b>SF.001/2019</b>
	<b>PRESA DE PELETI (15 kW)</b>	Rev.0

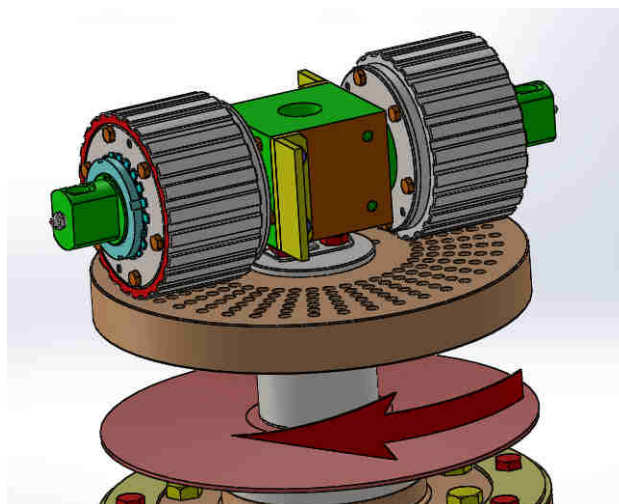


Fig.3 Solutia cu doua role presoare

## 2. Simbolizare: PRf-0-001/2019

### 3. Probe si verificari la punerea in functiune la beneficiar

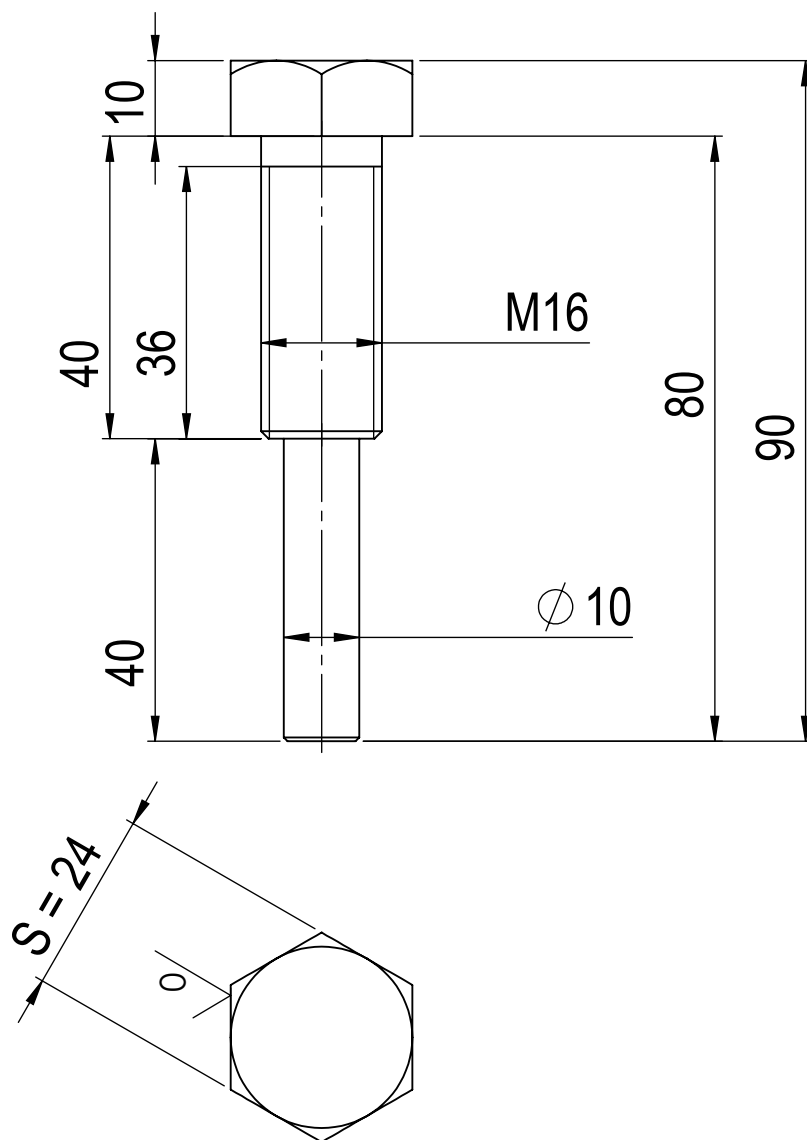
Inainte de punerea în functiune a produsului:

- se va verifica integritatea acestuia;
- se vor indeparta materialele existente in zona rotelor presoare;
- se va verifica corectitudinea conexiunilor dulapului electric de comanda si control.

#### ATENTIE:

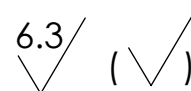
Biomasa de compactat sa nu contina desuri metalice

Elaborat: <b>SC. ROLIX IMPEX SERIES SRL</b>	Aprobat: CT al <b>SC. ROLIX IMPEX SERIES SRL</b>	Aprobat Director General <b>Preda Dragos</b>	Data reviziei: 09.07.2019
Sef Comp. Calitate: <b>Lucian Ionescu</b>	Ing.Sef <b>Bogdan Duran</b>		

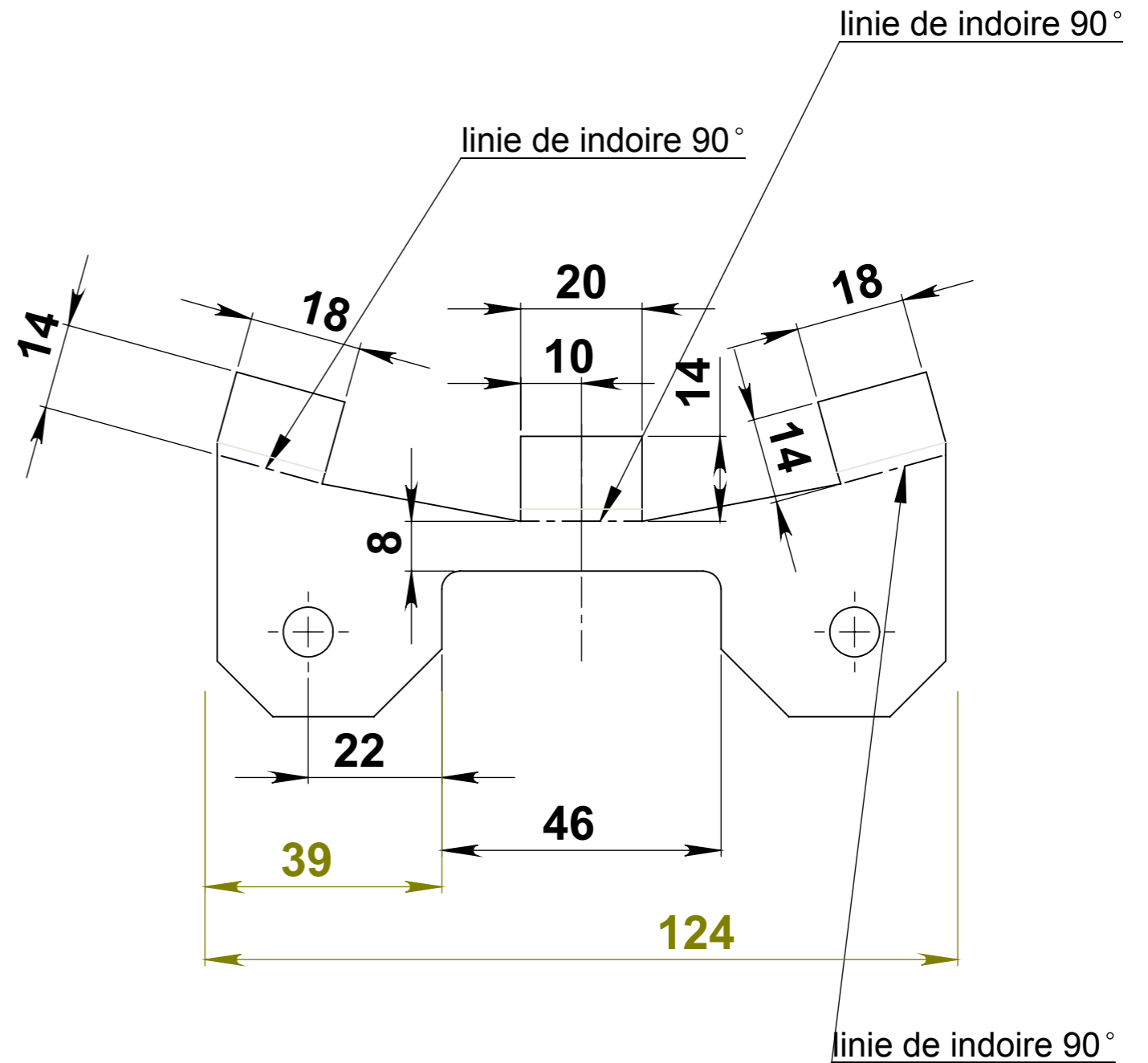
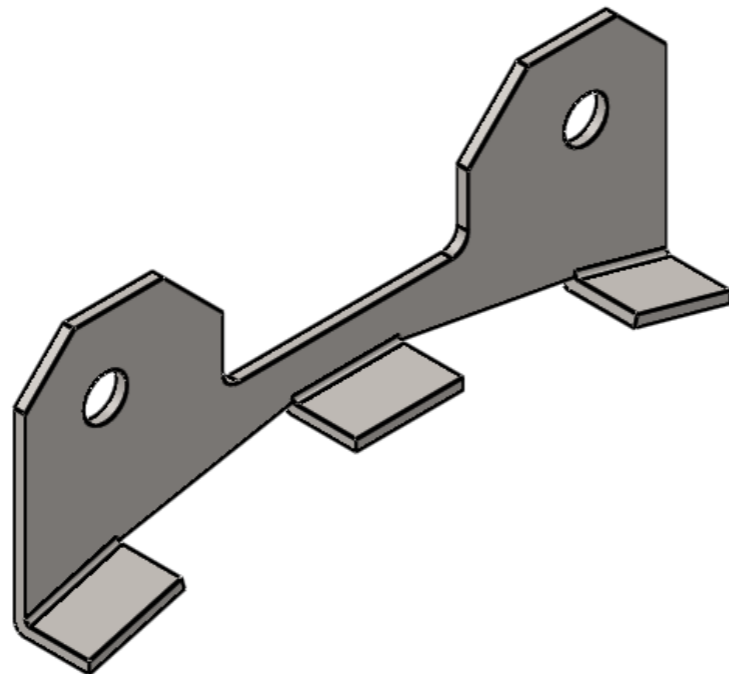
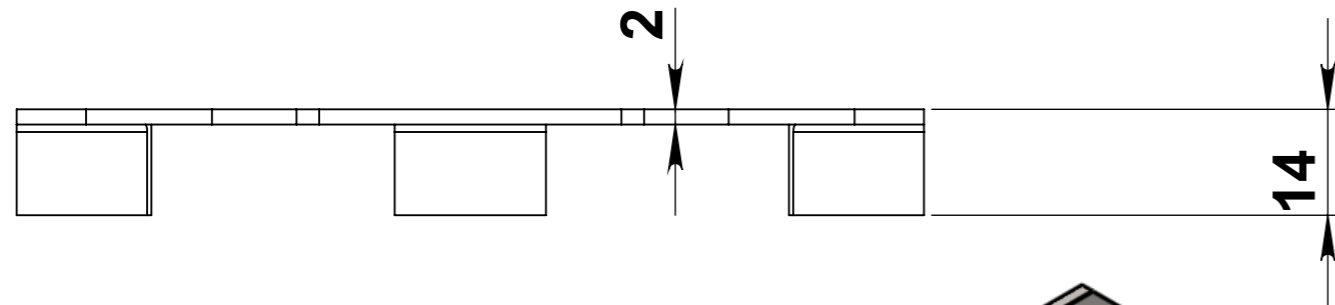
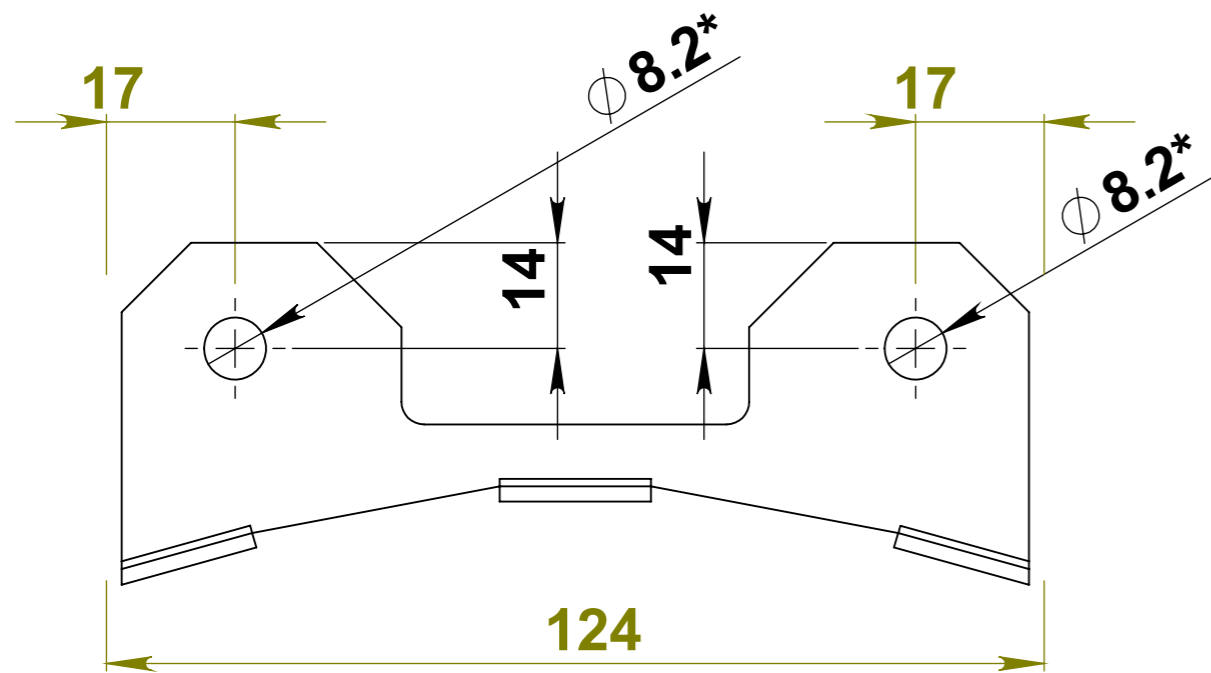


**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,5x45°;
- Executie mijlocie cf. SREN 22768-2/95



Proiectat		Lucian Ionescu					
Desenat		Baicu Ionut					
Verificat		Bogdan Duran					
Contr. STAS		Bogdan Duran					
Aprobat		Preda Dragos					
SC. ROLIX IMPEX SERIES SRL			DATA: oct. 2017		PRf - 19		
			MATERIAL: C45				
			Masa: 0.125Kg		Surub M16-presare role		
							A4

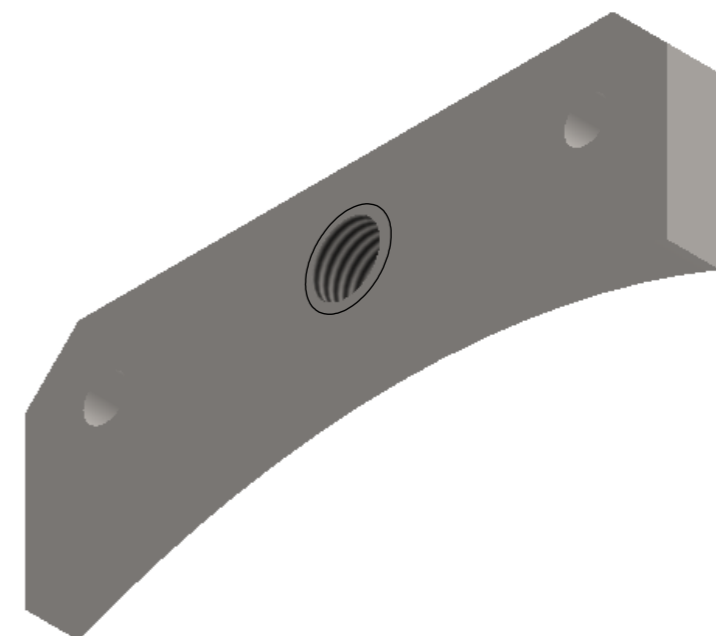
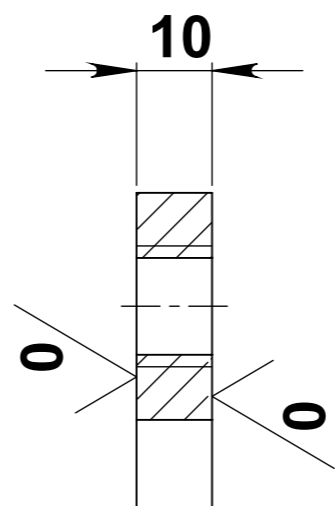
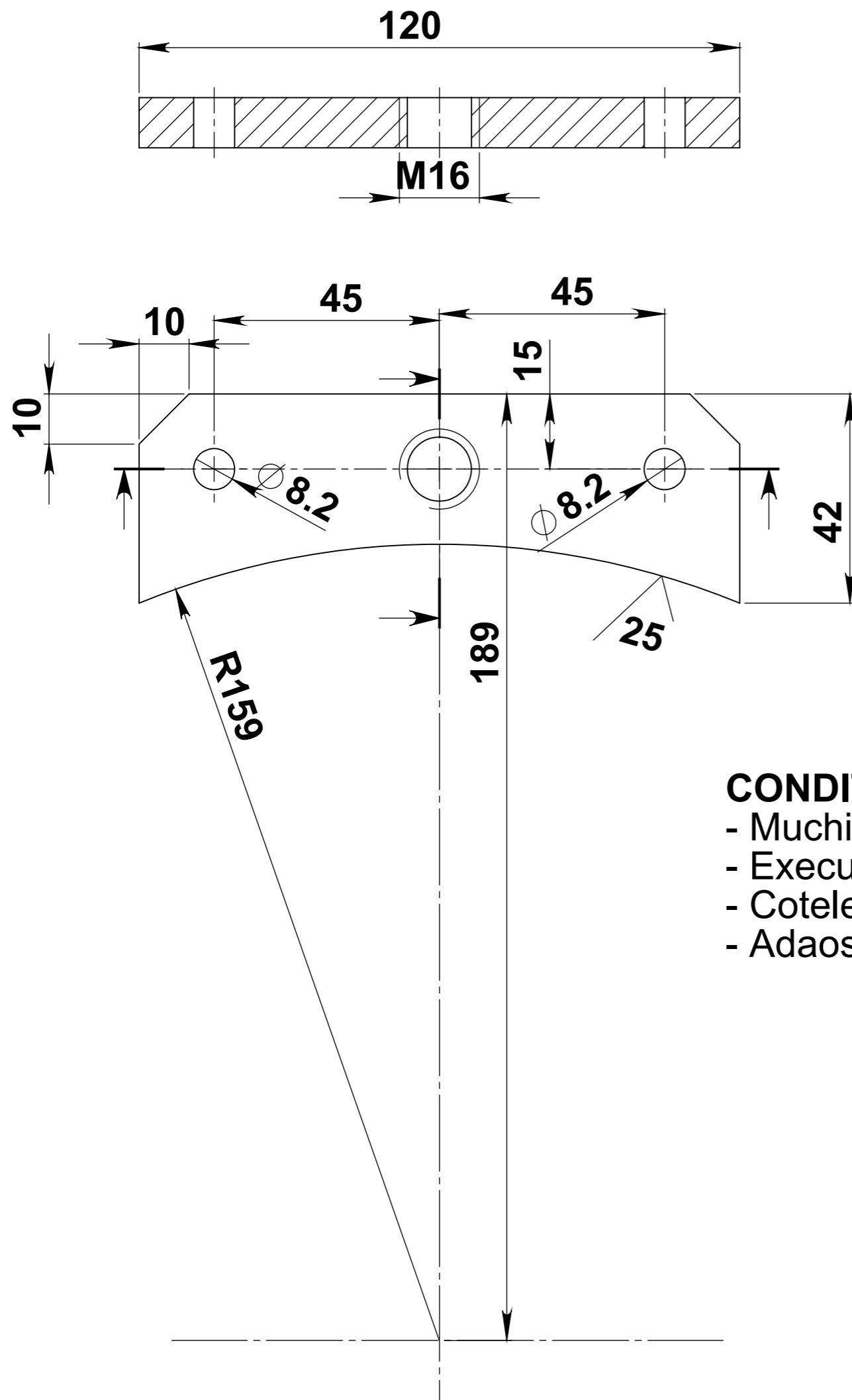


**NOTA:**  
 \* Gaurile  $\phi 8.2$  se vor da in ansamblu  
 Palnie rumegus sau Difuzor rumegus  
 in corespondenta cu contrapiesa

3.2 (✓)

**CONDITII TEHNICE:**  
 - Executie mijlocie cf. SREN 22768-2/95

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>		MATERIAL: S235JR		<b>PRf - 21.4</b>	
		MASA: 0.068 Kg			
					A3

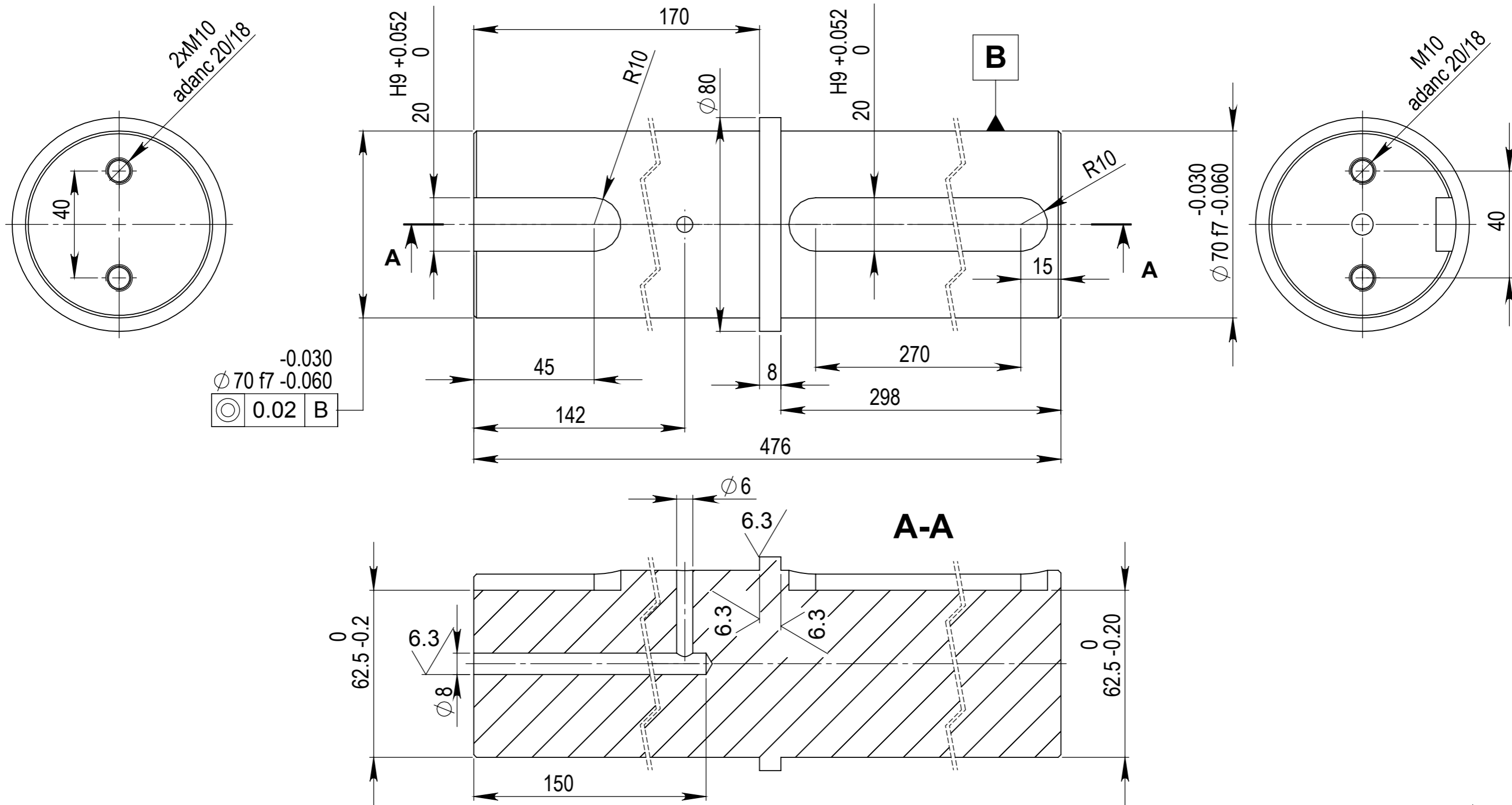


**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,5x45°
- Executie mijlocie cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

12.5 / ( ✓ )

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Dragos				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>			MATERIAL: S235JR	<b>PRf - 10.3</b>	
			MASA: 0.290Kg	<b>Ureche</b>	A3

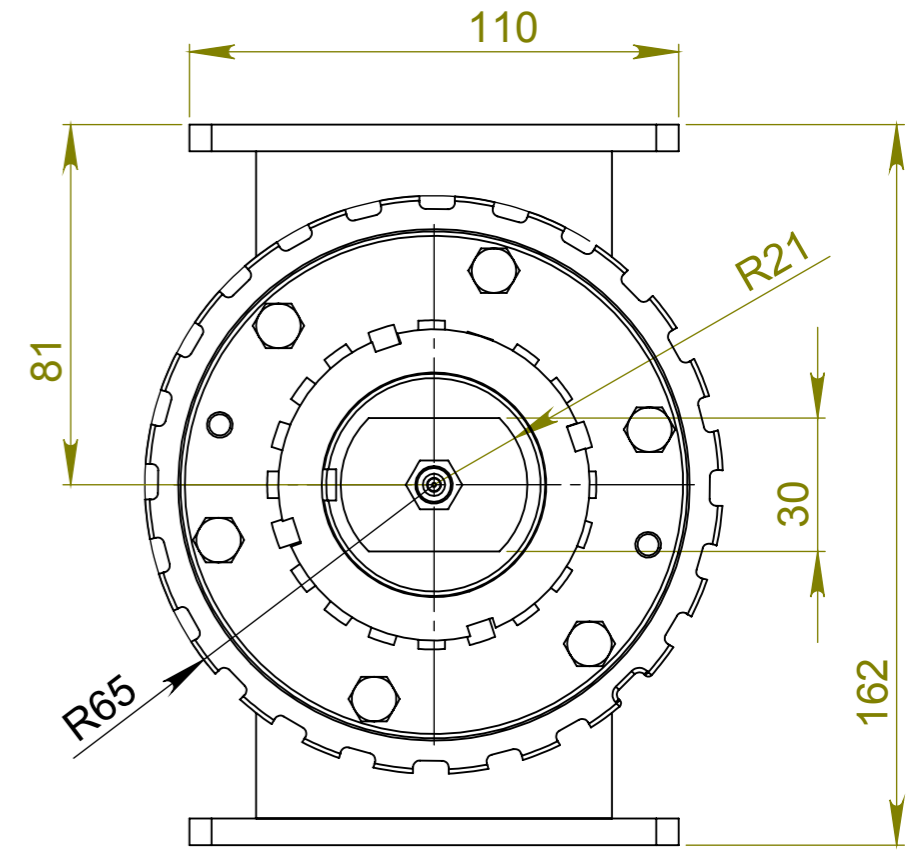
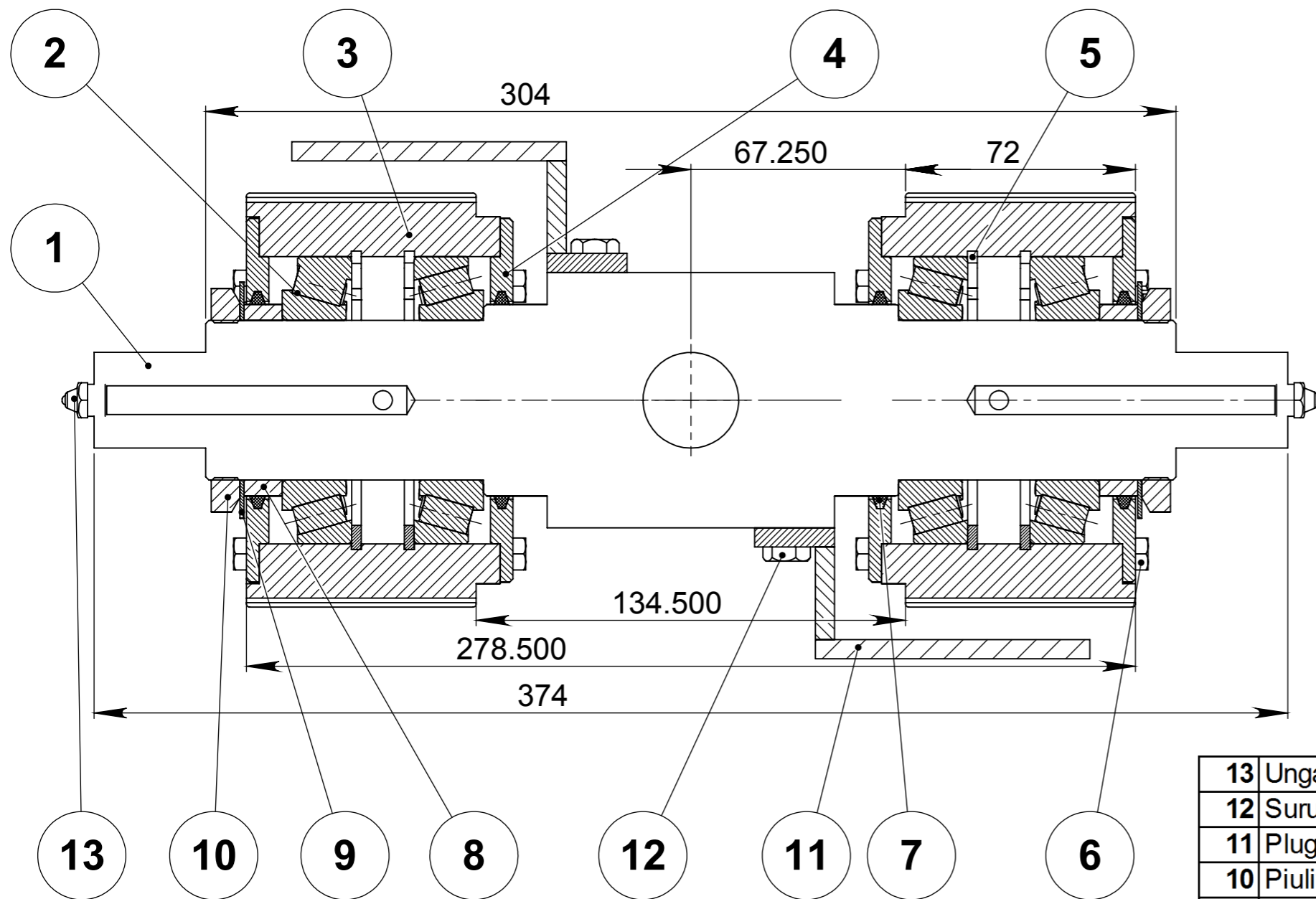


3.2 (✓)

**CONDITII TEHNICE:**

- Muchiile necotate se tesesc  $0,2 \times 45^\circ$
- Executie fina cf. SREN 22768-2/95
- Protejat prin brunare /fosfatare
- Tratament termic: IMBUNATATIRE la 260 - 280 HB

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
SC. ROLIX IMPEX SERIES SRL			MATERIAL:	41Cr4	
			MASA: 1.780Kg		
				<b>PRf-2</b>	
				<b>Arbore motor</b>	A3



**Nota:**  
La montaj spatiul dintre rulmenti  
se umple cu vaselina LiCa3

13	Ungator cu bila M10x1	SR 1116	2			0.014
12	Surub M8x18	ISO 4071	4	Gr.8.8		0.048
11	Plug rumegus b	PRf-11.11.0	2	S235 JR		1.270
10	Piulita KM10	DIN 1804	2	C45	M50x1.5	0.252
9	Saiba de siguranta MB10	DIN 1805	2	S235 JR		0.034
8	Bucsa uzura d50xD60	PRf-11.8	2	C45		0.160
7	Inel pasla $\phi 60 \times \phi 68 \times 4$		2	Pasla	$\phi 60 \times \phi 68 \times 4$	0.002
6	Surub M6x12	ISO 4071	24	Gr.8.8		0.144
5	Inel siguranta alezaj D90x3	DIN 472	4	60Si15A		0.144
4	Capac rola presoare	PRf-11.4	4	S235 JR		1.140
3	Rola presoare	PRf-11.3	2	C45		7.262
2	Rulment 30210	SKF	4		$\phi 50 \times \phi 90 \times 21.75$	2.160
1	Ax role presoare fixe PRf	PRf-11.1	1	41 Cr4		8.132
Poz	Denumire	Nr.Desen	Buc	Material	Obs.	Masa

Proiectat Lucian Ionescu  
Desenat Baicu Ionut  
Verificat Bogdan Duran  
Contr. STAS Bogdan Duran  
Aprobat Preda Dragos

DATA: oct. 2017

SC. ROLIX IMPEX  
SERIES SRL

MATERIAL:

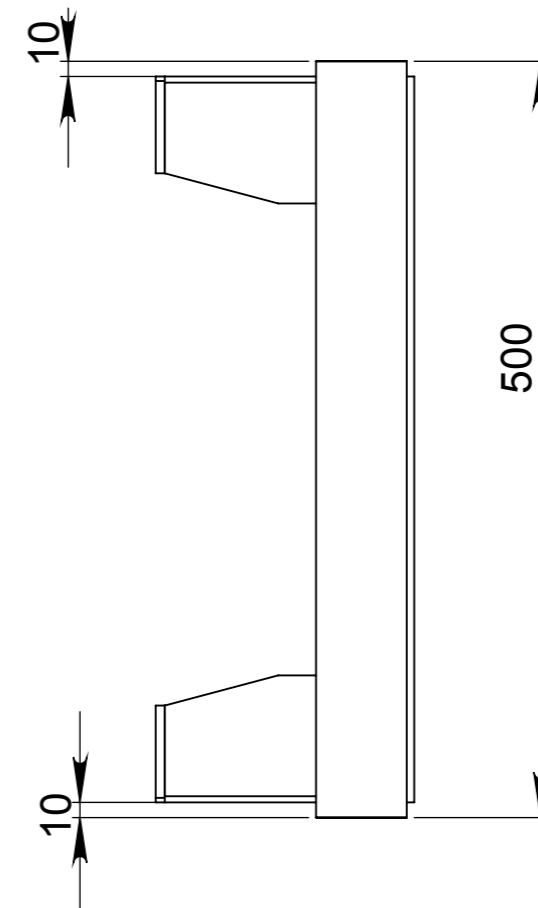
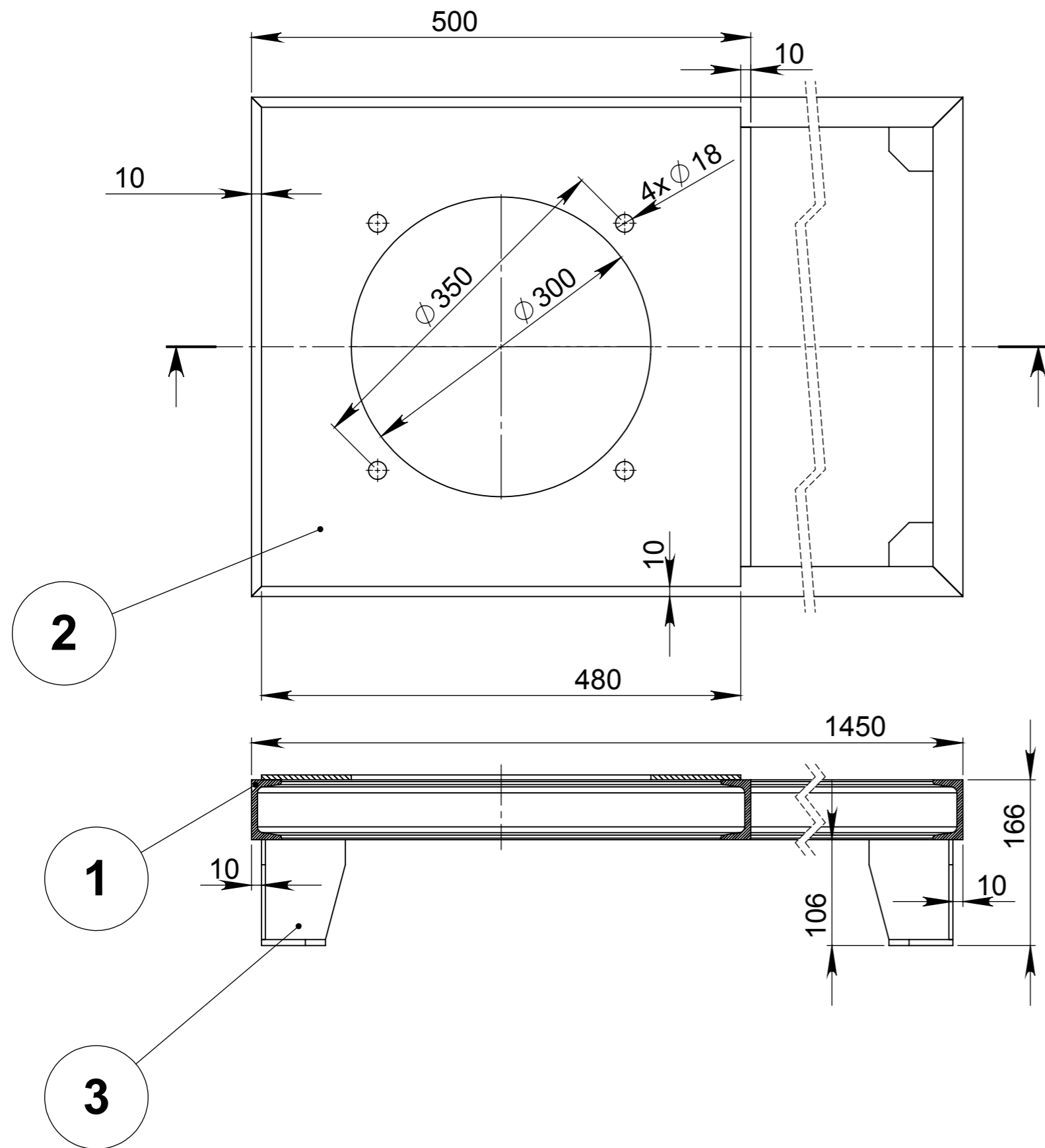
MASA: 20.640 Kg

**PRf - 11.0**

**Ax cu role presoare fixe PRf**

A3





**ATENȚIE:**  
Vor fi respectate  
COTELE si CONDITIILE TEHNICE  
indicate pe desenele componentelor

<b>3</b>	Picior batiu	PRf-20.3.0	4	S235JR		2.520
<b>2</b>	Placa baza batiu	PRf-20.2	1	S235JR		6.189
<b>1</b>	Rama batiu	PRf-20.1.0	1	S235JR		21.926
<b>Poz</b>	<b>Denumire</b>	<b>Nr.Desen</b>	<b>Buc</b>	<b>Material</b>	<b>Obs.</b>	<b>Masa</b>

**CONDITII TEHNICE:**

- Executie mijlocie cf. SREN 22768-2/95;
- Sudura de rezistenta, sudurile se vor executa ingrijit;

Proiectat Lucian Ionescu  
Desenat Baicu Ionut  
Verificat Bogdan Duran  
Contr. STAS Bogdan Duran  
Aprobat Preda Dragos

DATA: oct. 2017

**SC. ROLIX IMPEX  
SERIES SRL**

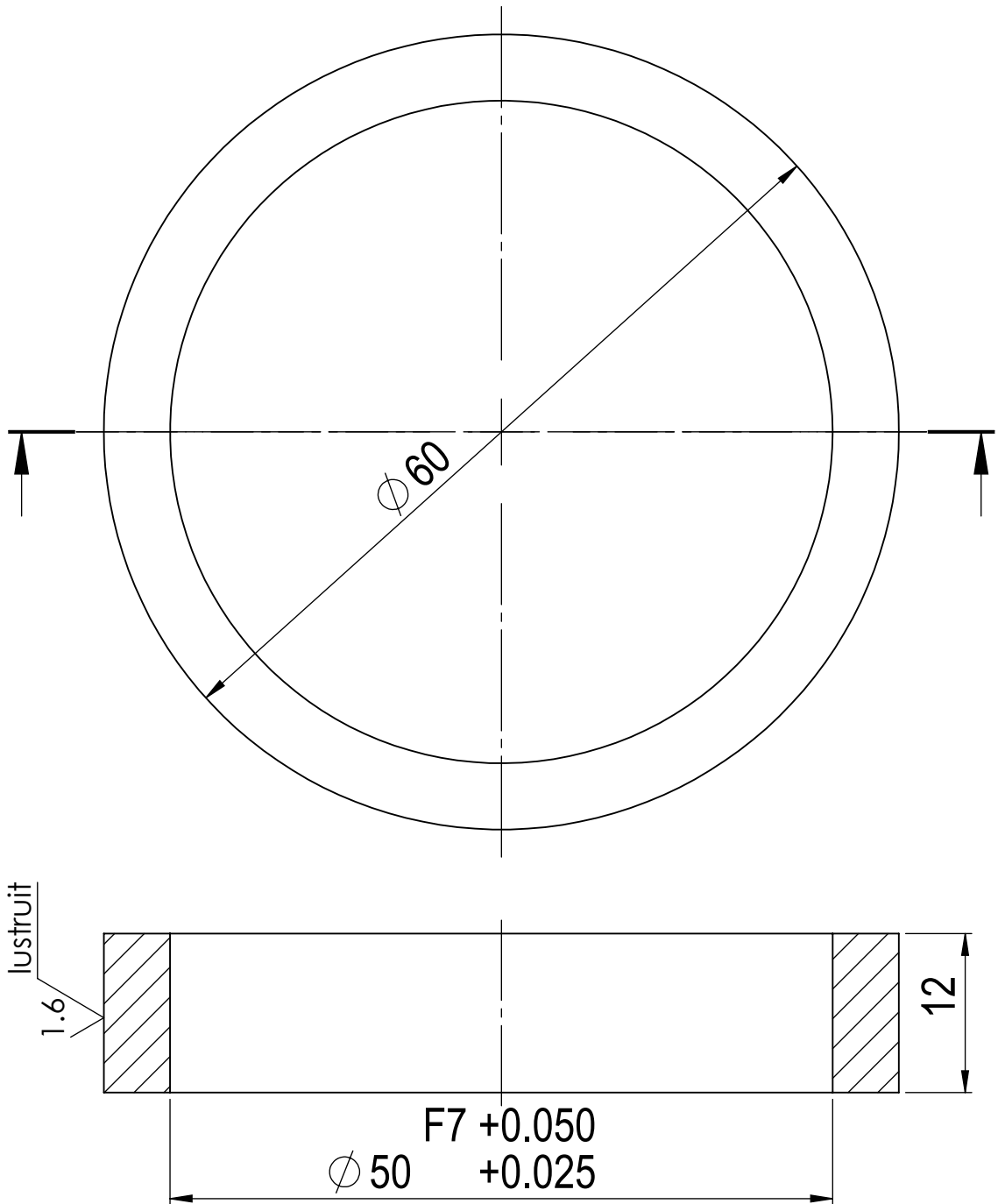
MATERIAL:  
MASA: 30.635Kg

**PRf - 20.0**

**Batiu presa peleti PF**

A3



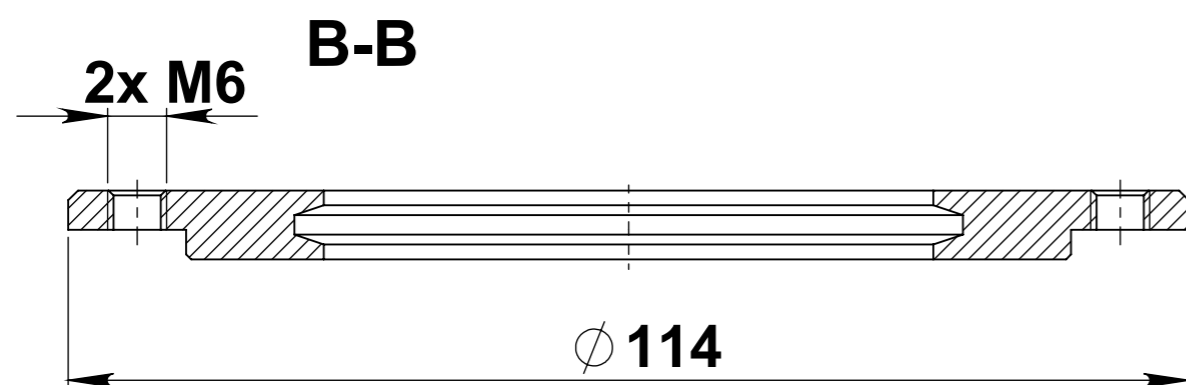
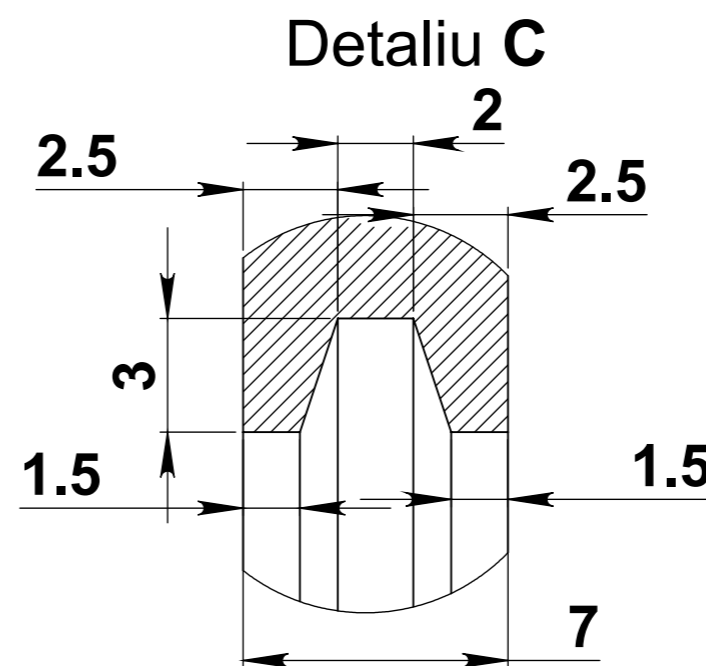
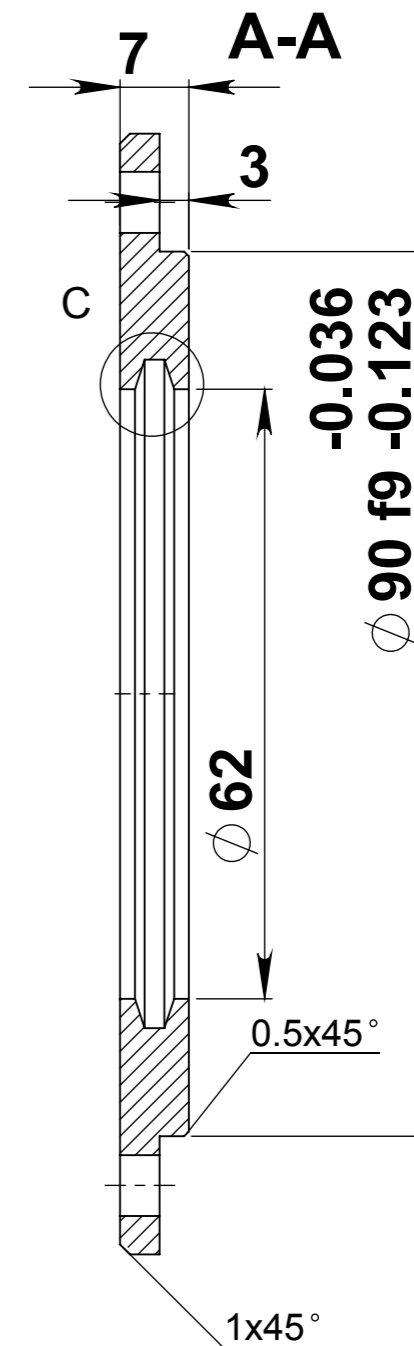
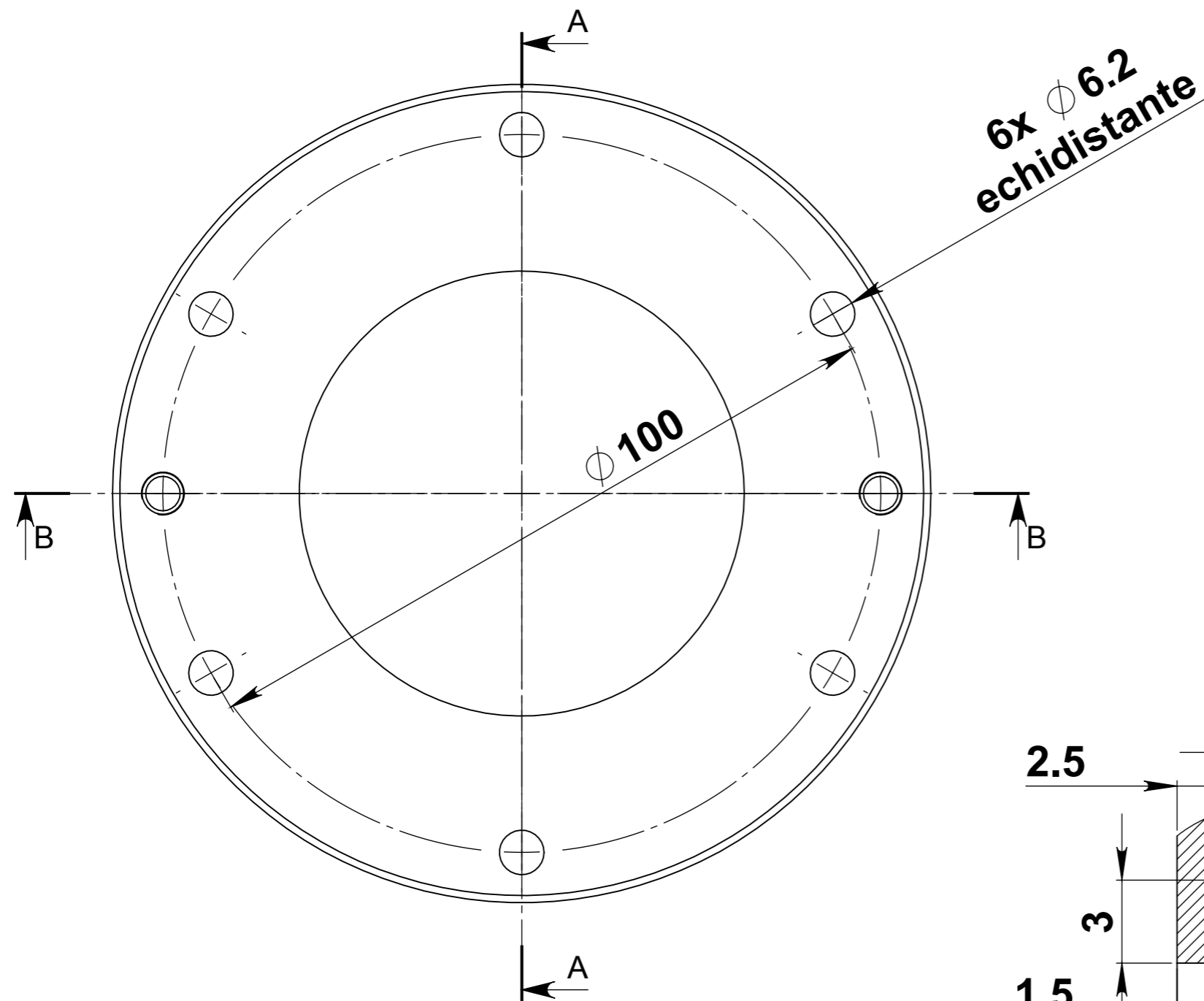


**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,2x45°
- Executie fina cf. SREN 22768-2/95
- Tratament termic: IMBUNATATIRE la 260 - 280 HB

6.3 / (✓)

Proiectat		Lucian Ionescu					
Desenat		Baicu Ionut					
Verificat		Bogdan Duran					
Contr. STAS		Bogdan Duran					
Aprobat		Preda Dragos		DATA: oct. 2017			
SC. ROLIX IMPEX SERIES SRL				MATERIAL: C45		PRf -11.8  Bucsa uzura d50xD60	
				Masa: 0.080Kg			

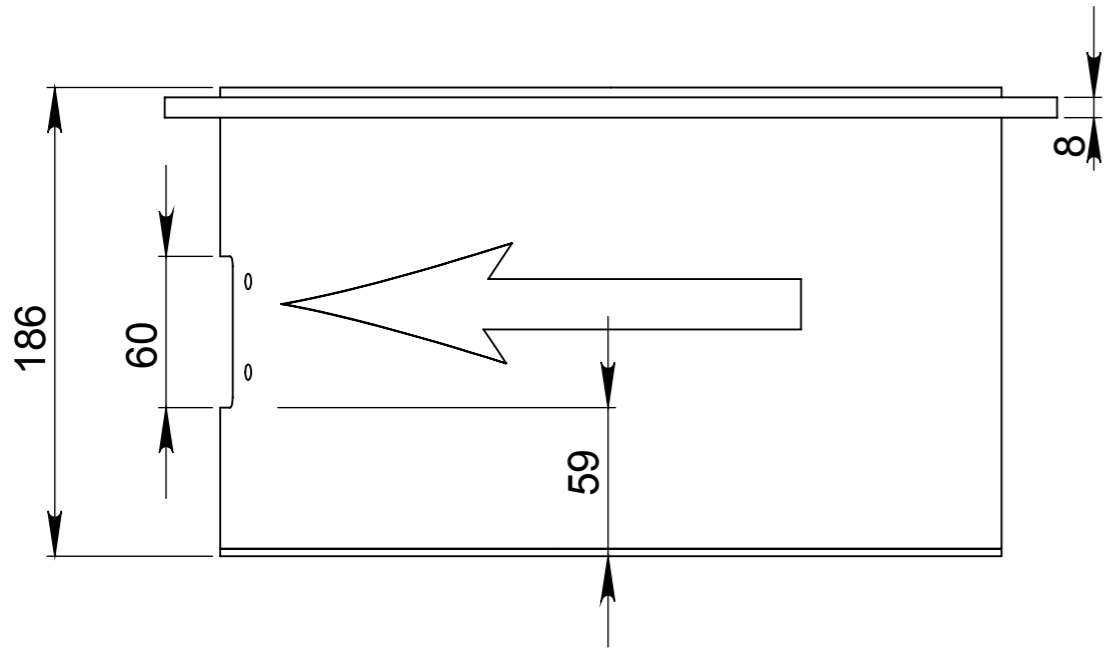
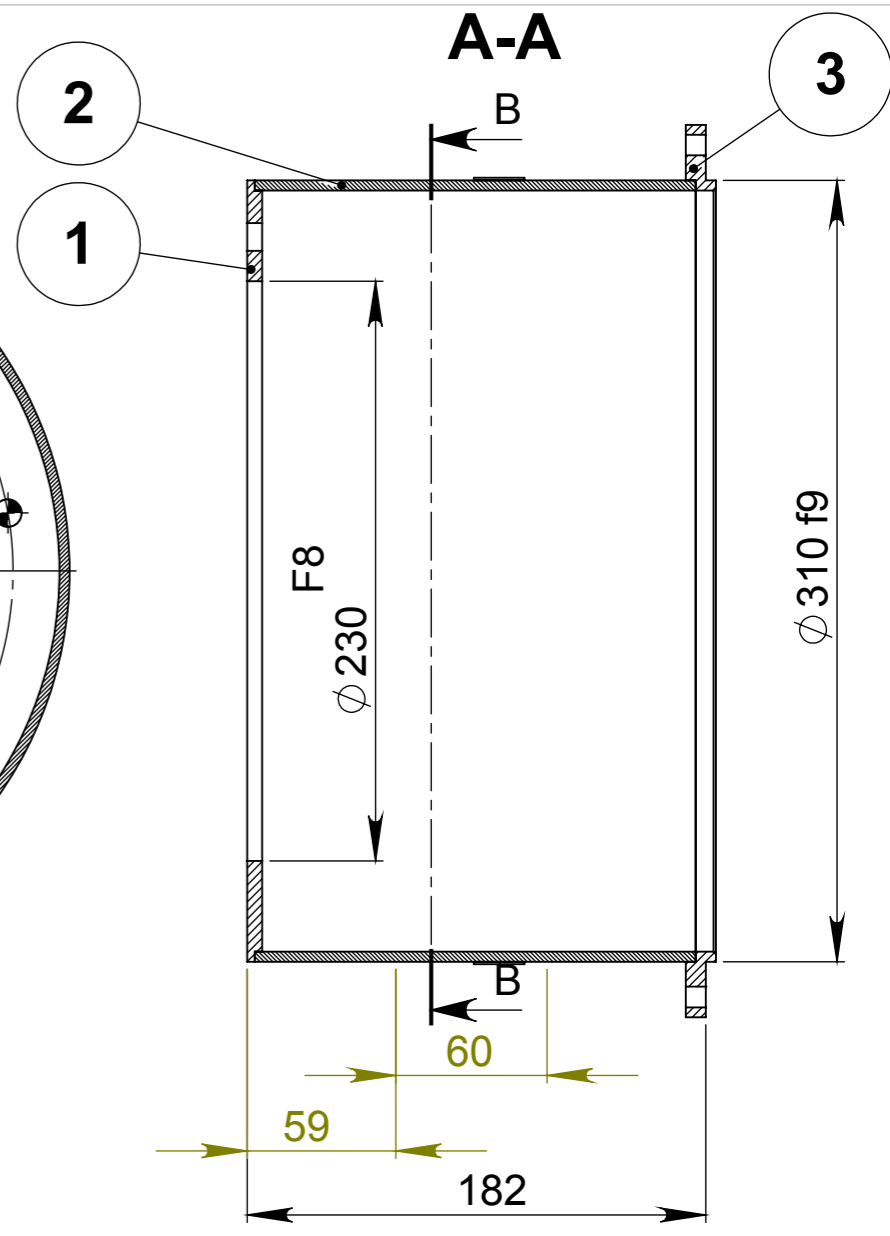
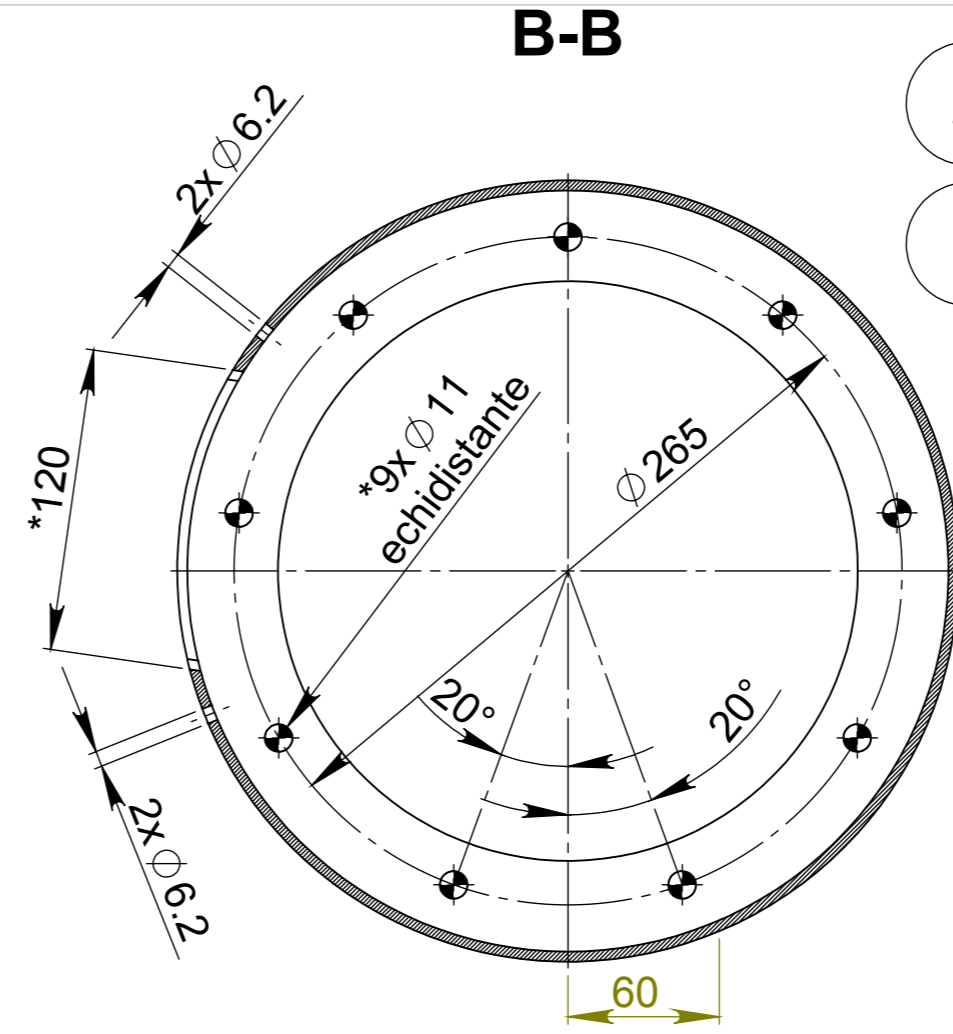
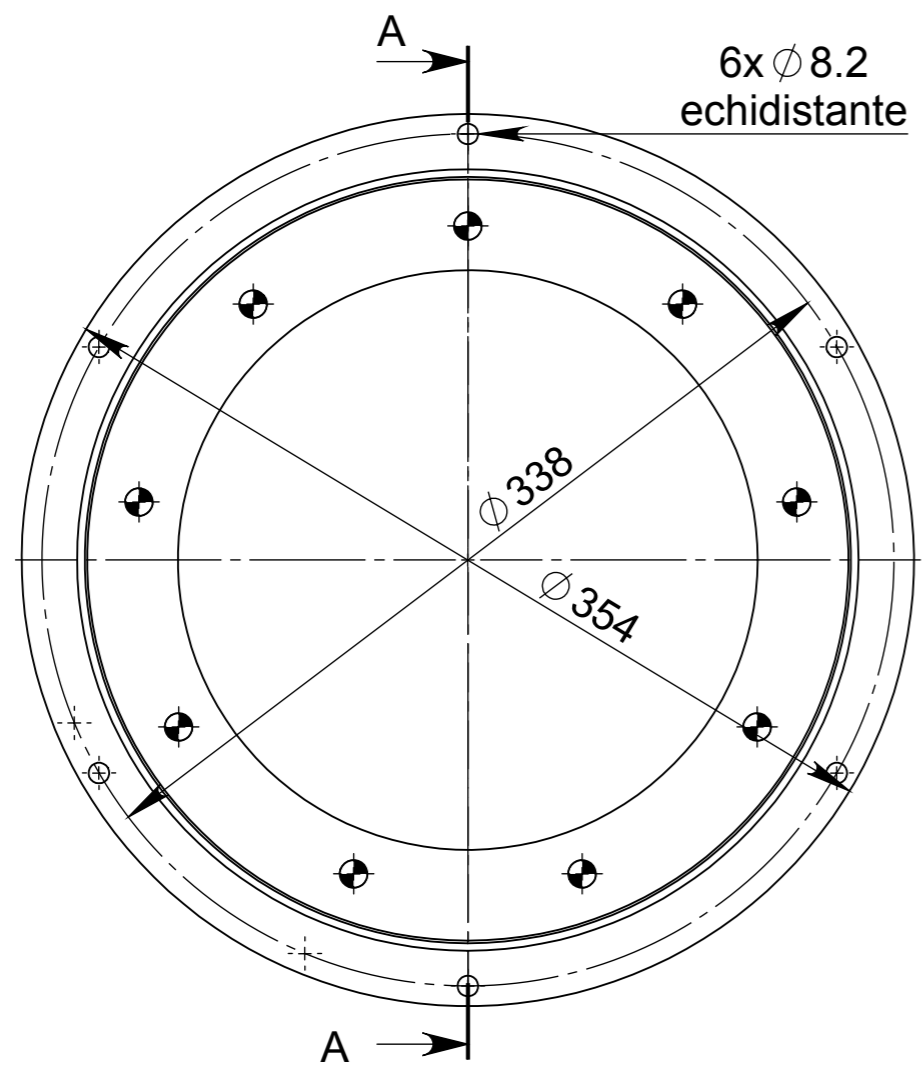


3.2 (✓)

**CONDITII TEHNICE:**

- Muchile necotate se tesesc 0,3x45°
- Executie fina cf. SREN 22768-2/95

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
SC. ROLIX IMPEX SERIES SRL			MATERIAL: S235JR		
			MASA:0.285Kg		
<b>PRf - 11.4</b>					
<b>Capac rola presoare</b>					A3



**ATENTIE:**  
\*La pozitia decuparii de 120mm fata de gaurile  $\phi 11$

**NOTA:**  
Vor fi respectate COTELE si CONDITIILE TEHNICE indicate pe desenele componentelor

3.2 (✓)

3	Flansa superioara carcasa baza	PRf-4.1.3	1	S235 JR		1.645
2	Cilindru carcasa baza	PRf-4.1.2	1	S235 JR		5.014
1	Flansa inferioara carcasa baza	PRf-4.1.1	1	S235 JR		1.459
Poz	Denumire	Nr.Desen	Buc	Materia	Obs.	Masa

Proiectat	Lucian Ionescu
Desenat	Baicu Ionut
Verificat	Bogdan Duran
Contr. STAS	Bogdan Duran
Aprobat	Preda Dragos

DATA: oct. 2017

SC. ROLIX IMPEX SERIES SRL

MATERIAL:  
MASA: 8.118 Kg

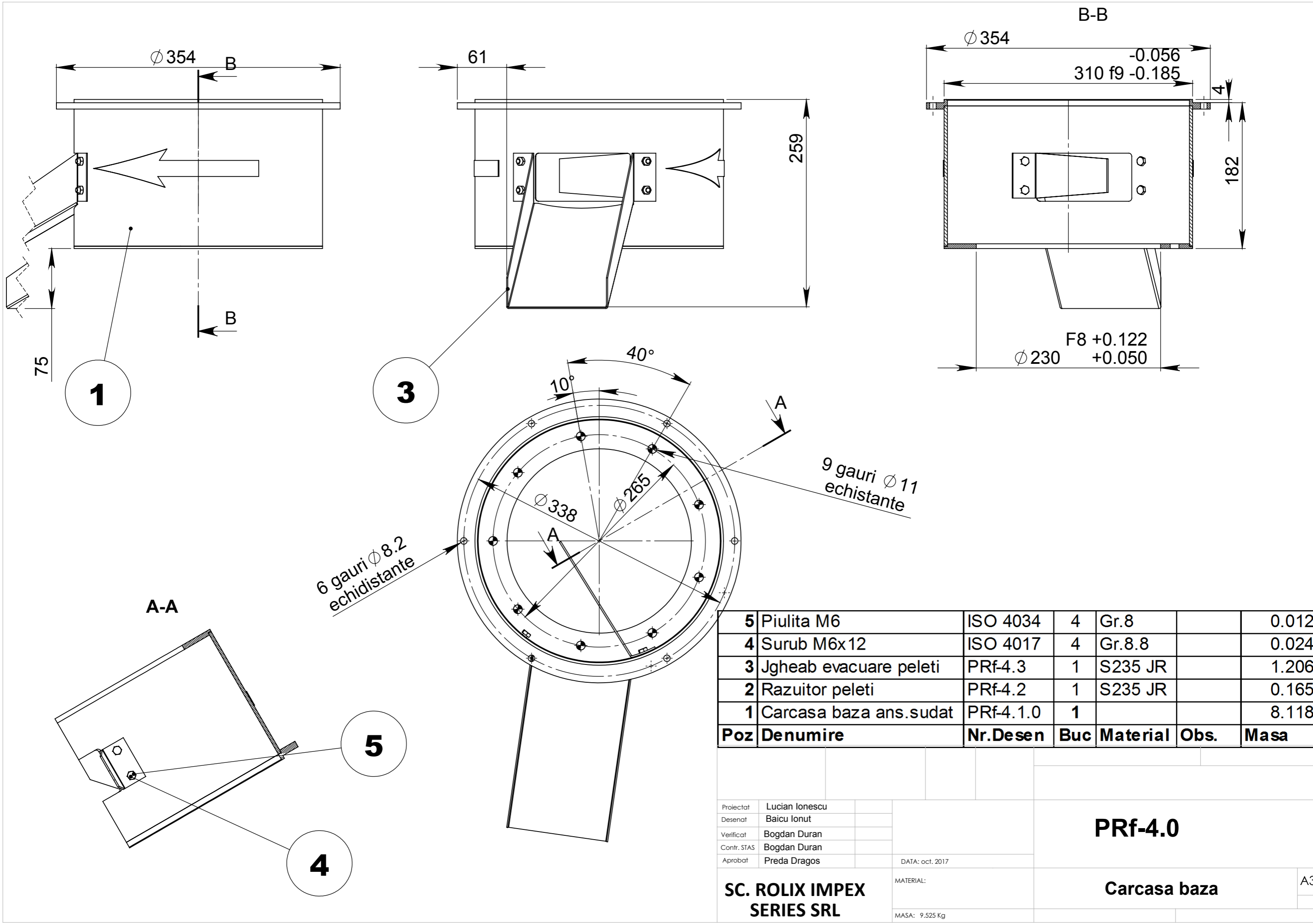
**PRf - 4.1.0**

**Carcasa baza ans.sudat**

A3

**CONDITII TEHNICE:**

- Muchiile necotate se tesesc  $0,5 \times 45^\circ$ ;
- Executie mijlocie cf. SREN 22768-2/95;
- Sudura de rezistenta, sudurile se vor executa ingrijit;
- Dupa sudura piesa se va detensiona.
- Suprafetele inactive se vor proteja prin grunduire



<b>5</b>	Piulita M6	ISO 4034	4	Gr.8		0.012
<b>4</b>	Surub M6x12	ISO 4017	4	Gr.8.8		0.024
<b>3</b>	Jgheab evacuare peleti	PRf-4.3	1	S235 JR		1.206
<b>2</b>	Razuator peleti	PRf-4.2	1	S235 JR		0.165
<b>1</b>	Carcasa baza ans.sudat	PRf-4.1.0	1			8.118
<b>Poz</b>	<b>Denumire</b>	<b>Nr.Desen</b>	<b>Buc</b>	<b>Material</b>	<b>Obs.</b>	<b>Masa</b>

Proiectat Lucian Ionescu  
 Desenat Baicu Ionut  
 Verificat Bogdan Duran  
 Contr. STAS Bogdan Duran  
 Aprobat Preda Dragos

DATA: oct. 2017

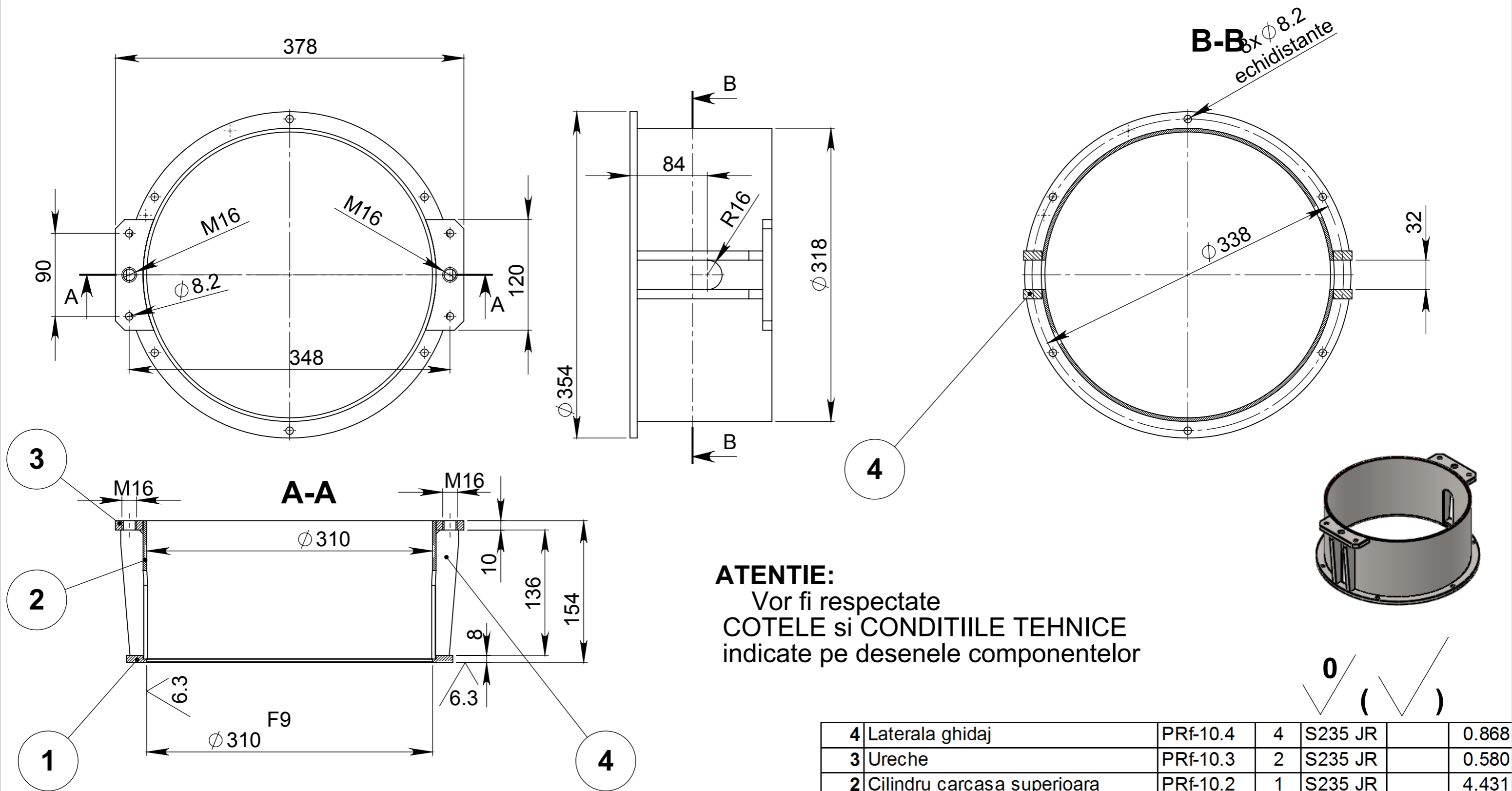
**SC. ROLIX IMPEX**  
**SERIES SRL**

MATERIAL:  
 MASA: 9.525 Kg

**PRf-4.0**

**Carcasa baza**

A3



**ATENȚIE:**  
 Vor fi respectate  
**COTELE si CONDITIILE TEHNICE**  
 indicate pe desenele componentelor

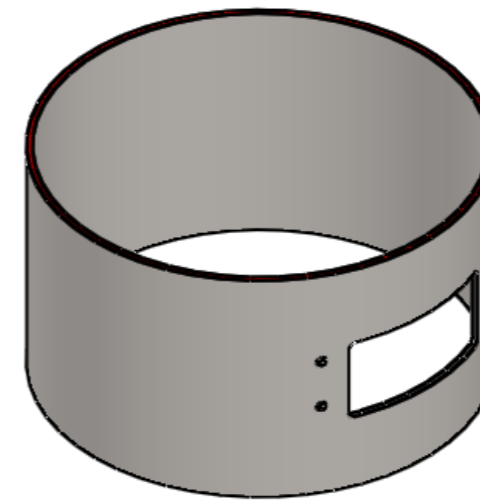
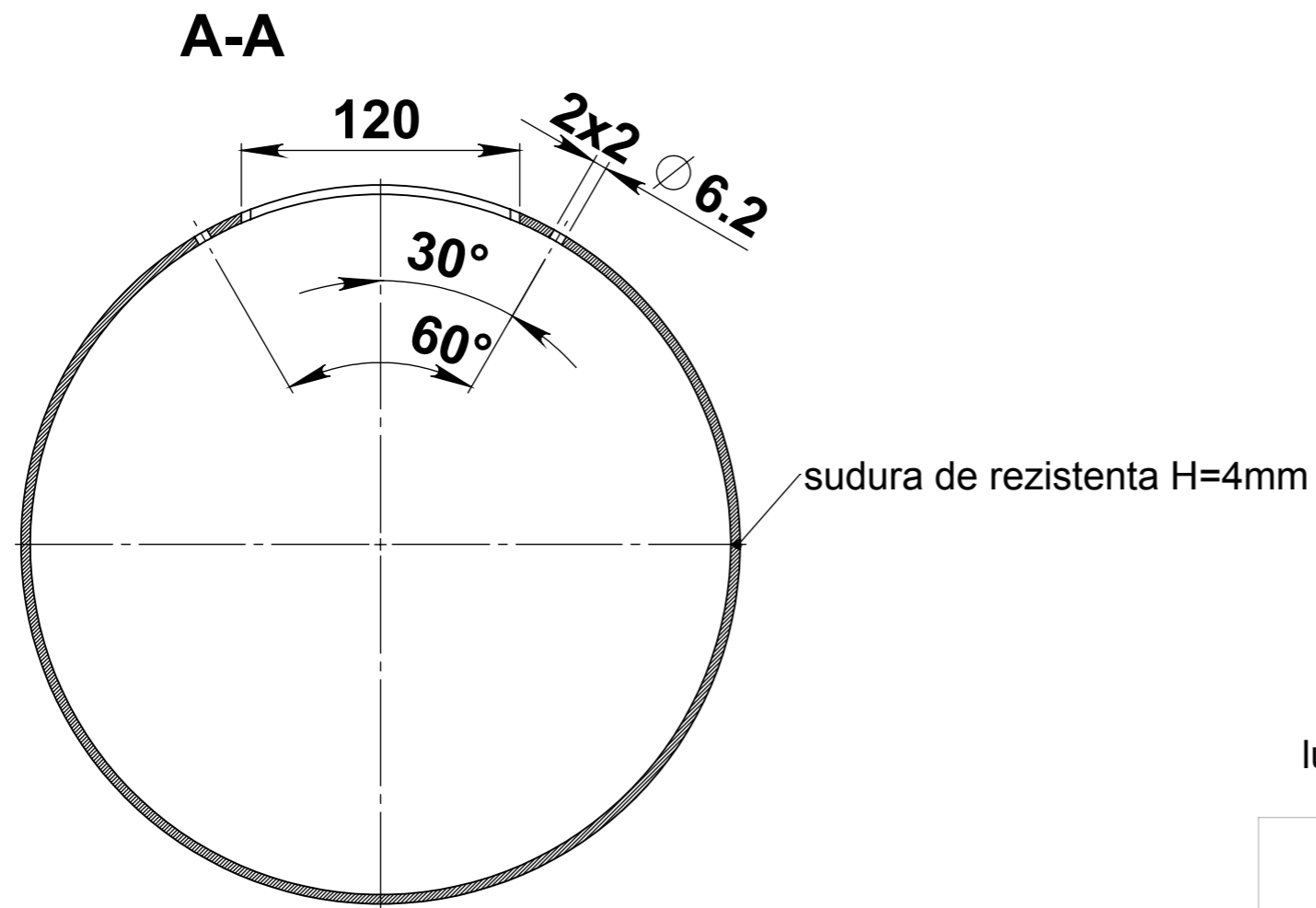
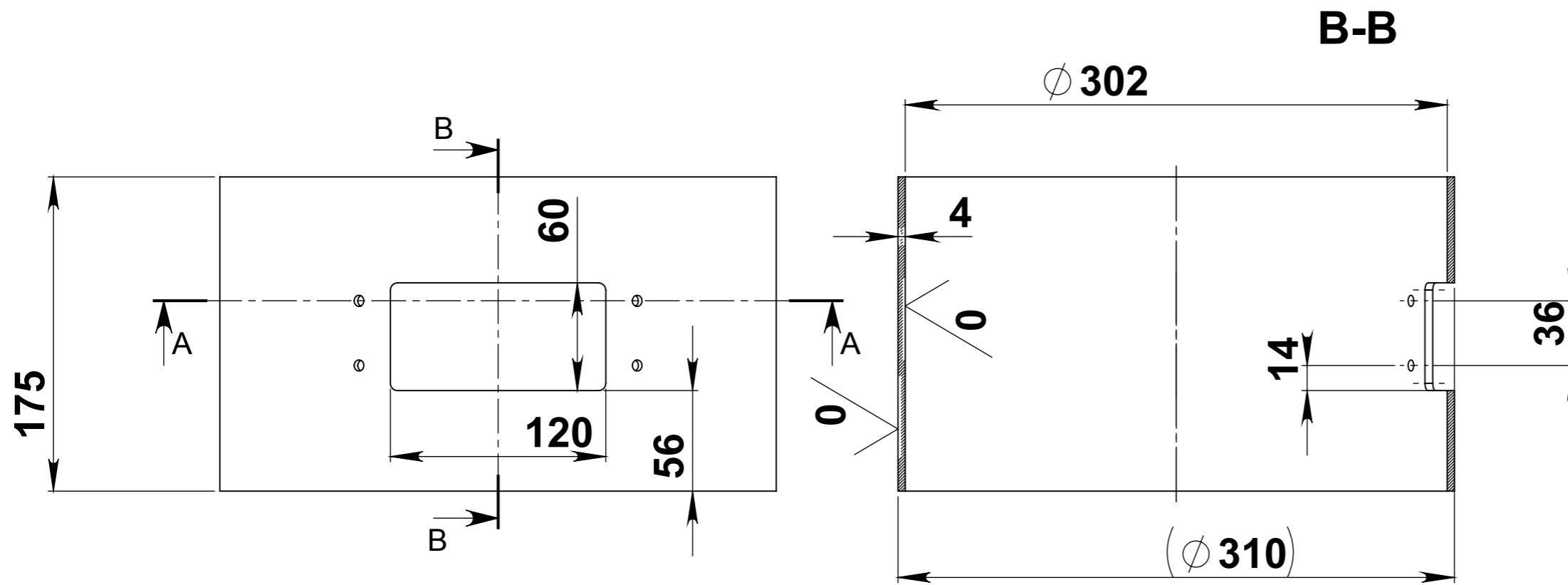
0  
 ( ✓ )

**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,5x45°;
- Executie mijlocie cf. SREN 22768-2/95;
- Sudura de rezistenta, sudurile se vor executa ingrijit;
- Dupa sudura piesa se va detensiona.
- Suprafetele inactive se vor proteja prin grunduire

4	Laterala ghidaj	PRf-10.4	4	S235 JR		0.868
3	Ureche	PRf-10.3	2	S235 JR		0.580
2	Cilindru carcasa superioara	PRf-10.2	1	S235 JR		4.431
1	Flansa inf.carcasa role presoare	PRf-10.1	1	S235 JR		1.278
Poz	Denumire	Nr.Desen	Buc	Material	Obs.	Masa

Proiectat	Lucian Ionescu					
Desenat	Baicu Ionut					
Verificat	Bogdan Duran					
Contr. STAS	Bogdan Duran					
Aprobat	Preda Dragos			DATA: oct. 2017		
<b>SC. ROLIX IMPEX SERIES SRL</b>		MATERIAL:		<b>PRf - 10.0</b>		
		MASA: 7.157 Kg				
				<b>Carcasa role presoare fixe</b>		A3



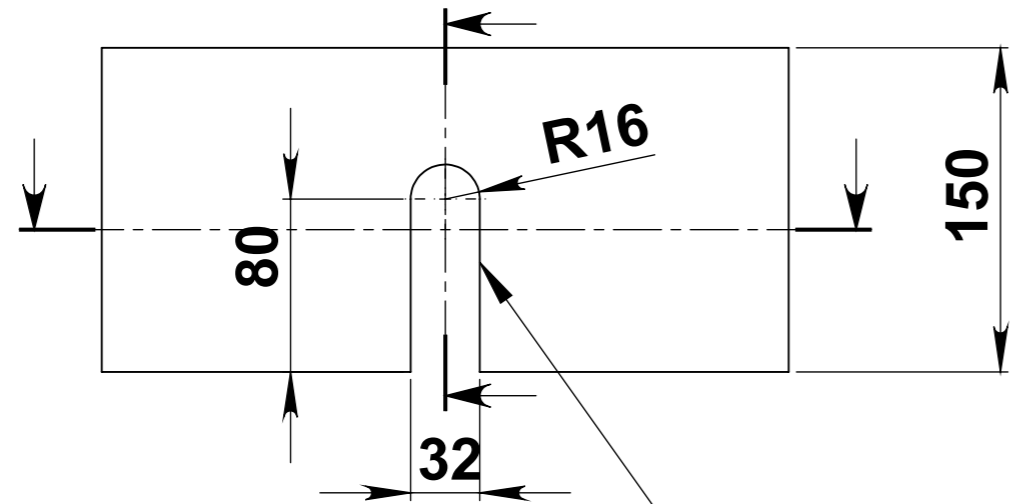
lungime desfasurata =961mm

6.3 (✓)

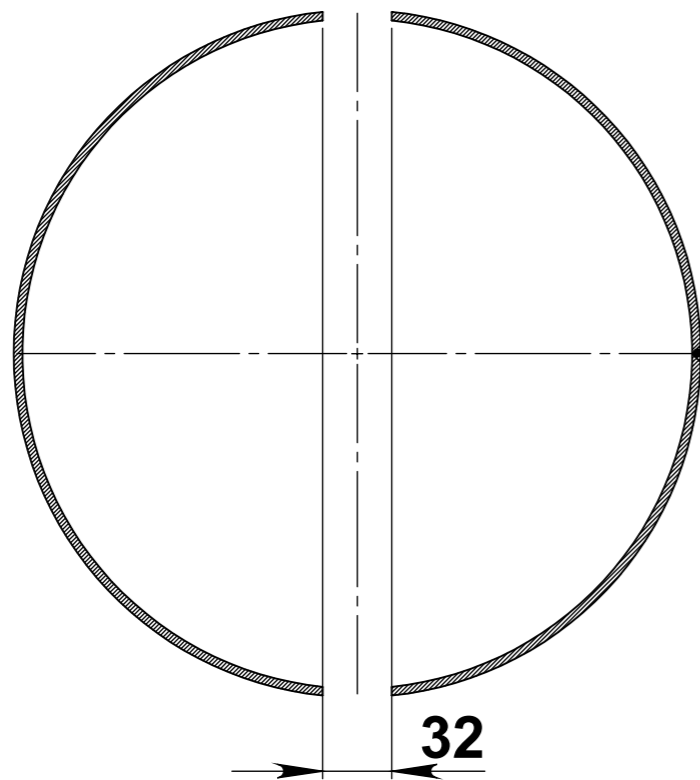
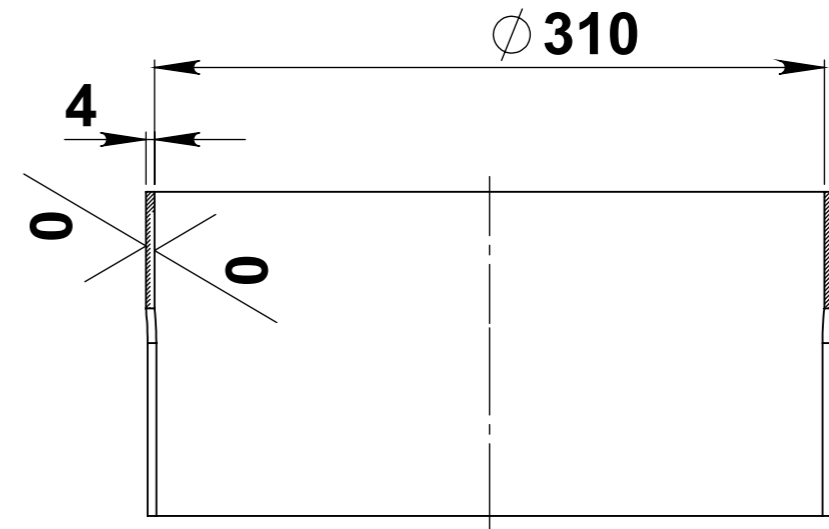
**CONDITII TEHNICE:**

- Muchile necotate se tesesc 0,3x45°
- Executie fina cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bgdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>			MATERIAL: S235JR	<b>PRf - 4.1.2</b>	
			MASA:5.014Kg	<b>Cilindru carcasa baza</b>	A3

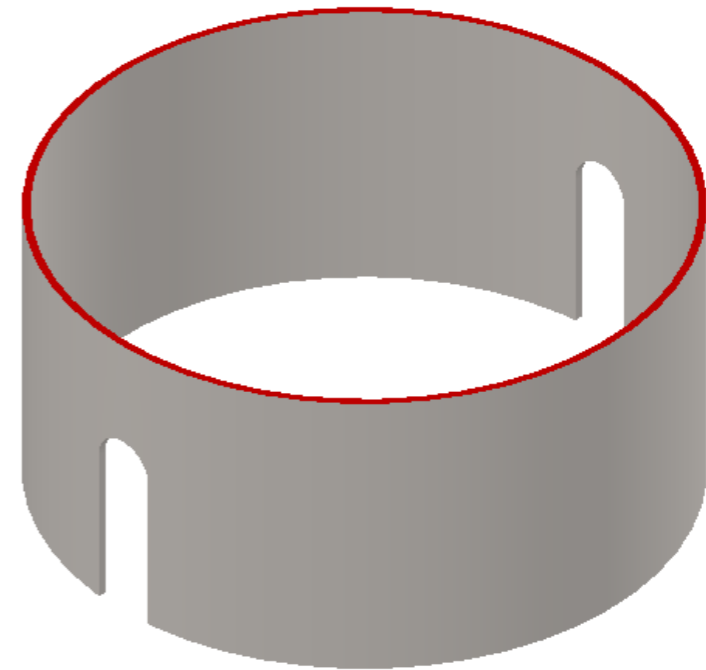


doua decupari diametral opuse



sudura de rezistenta h=4mm

lungime desfasurata =986mm

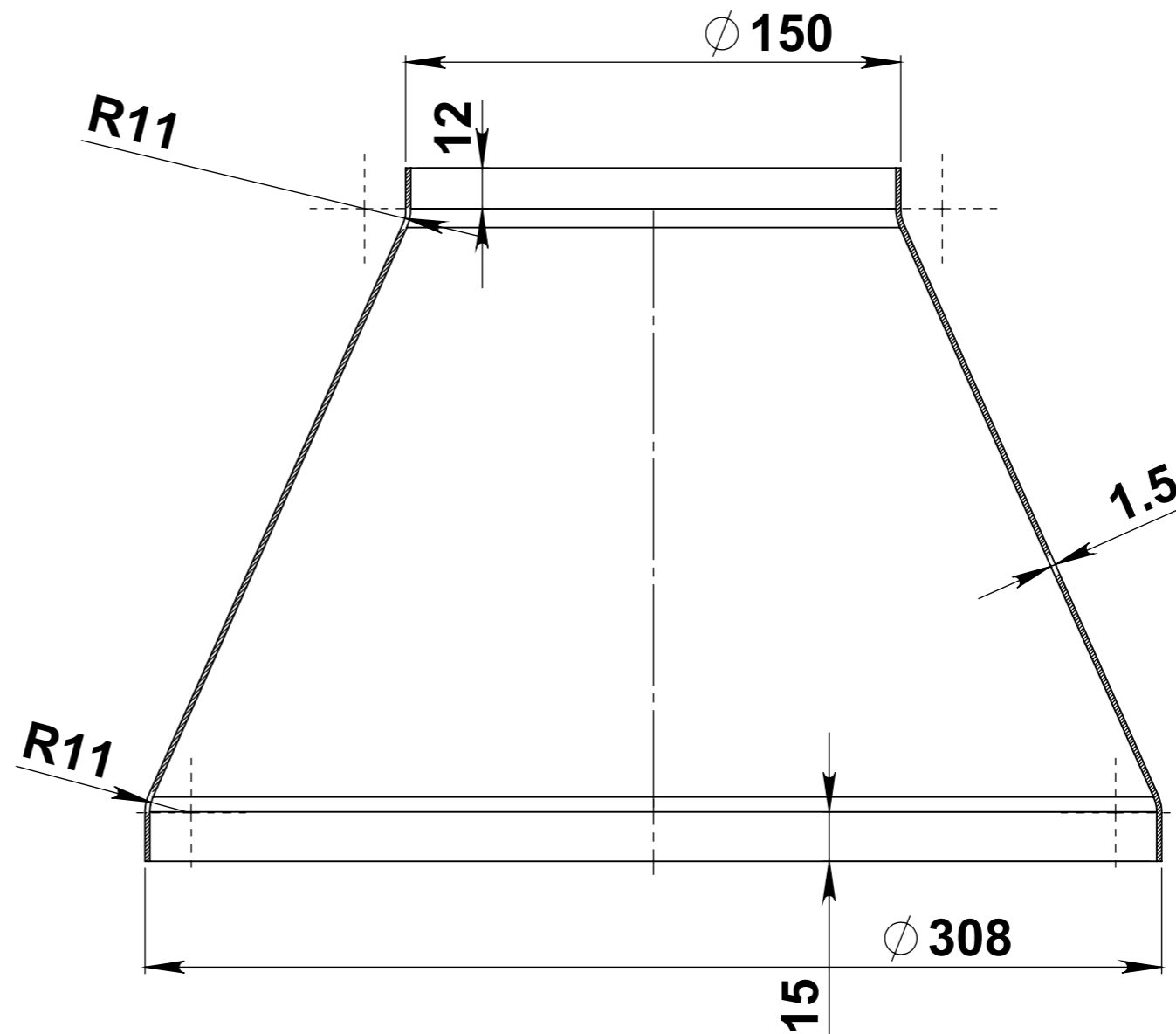
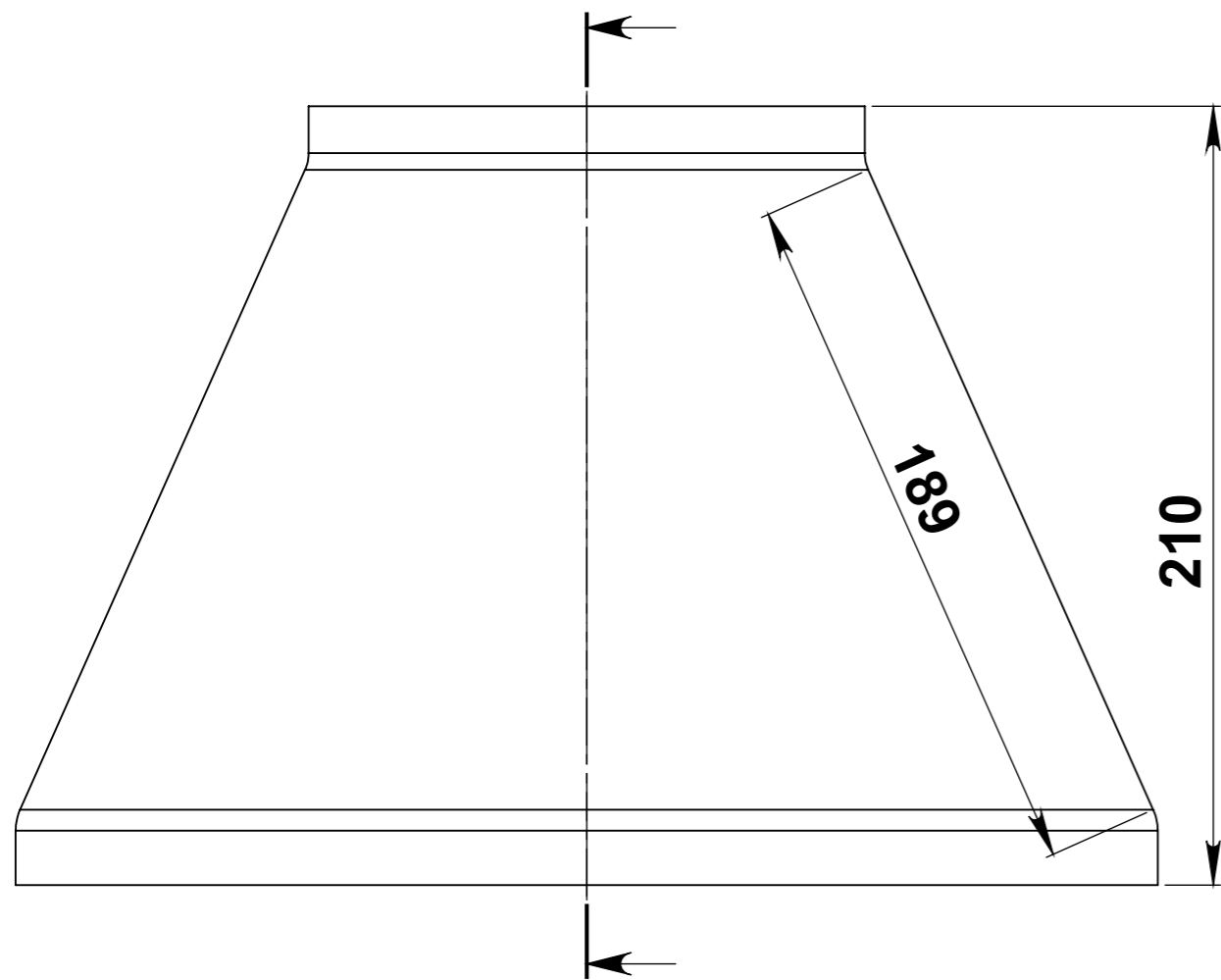


6.3 (✓)

### CONDITII TEHNICE:

- Muchiile necotate se tesesc 0,5x45°
- Executie mijlocie cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

Proiectat	Lucian Ionescu					
Desenat	Baicu Ionut					
Verificat	Bogdan Duran					
Contr. STAS	Bogdan Duran					
Aprobat	Preda Dragos				DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>			MATERIAL: S235JR		<b>PRf - 10.2</b>	
			MASA: 4.431Kg		<b>Cilindru carcasa superioara</b>	
						A3

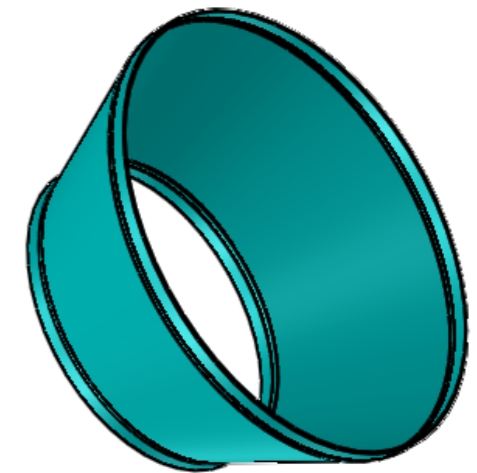
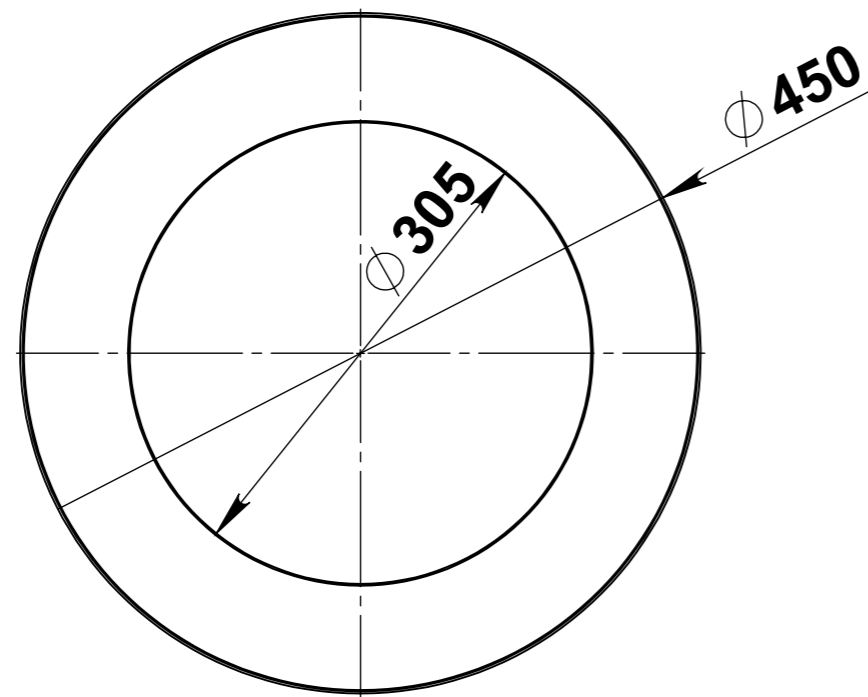
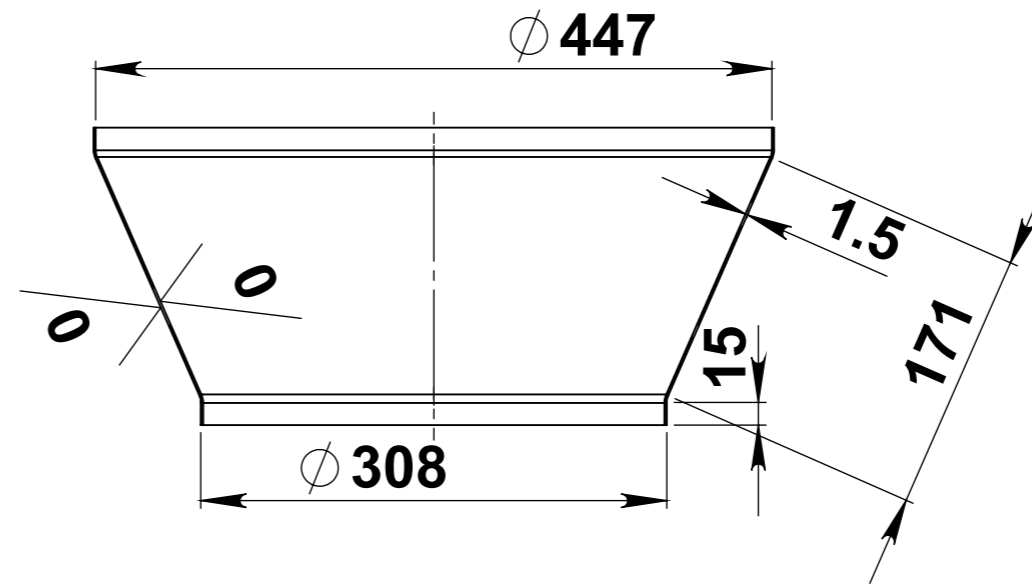
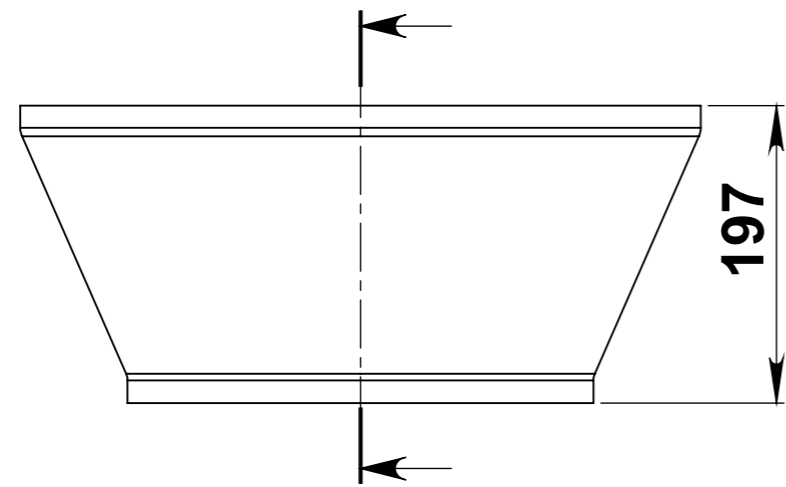


3.2 (✓)

**CONDITII TEHNICE:**  
- Executie mijlocie cf. SREN 22768-2/95

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>			MATERIAL: S235JR	<b>PRf - 21.1</b>	
			MASA: 1.900Kg	<b>Con exterior difuzor rumegus</b>	
					A3



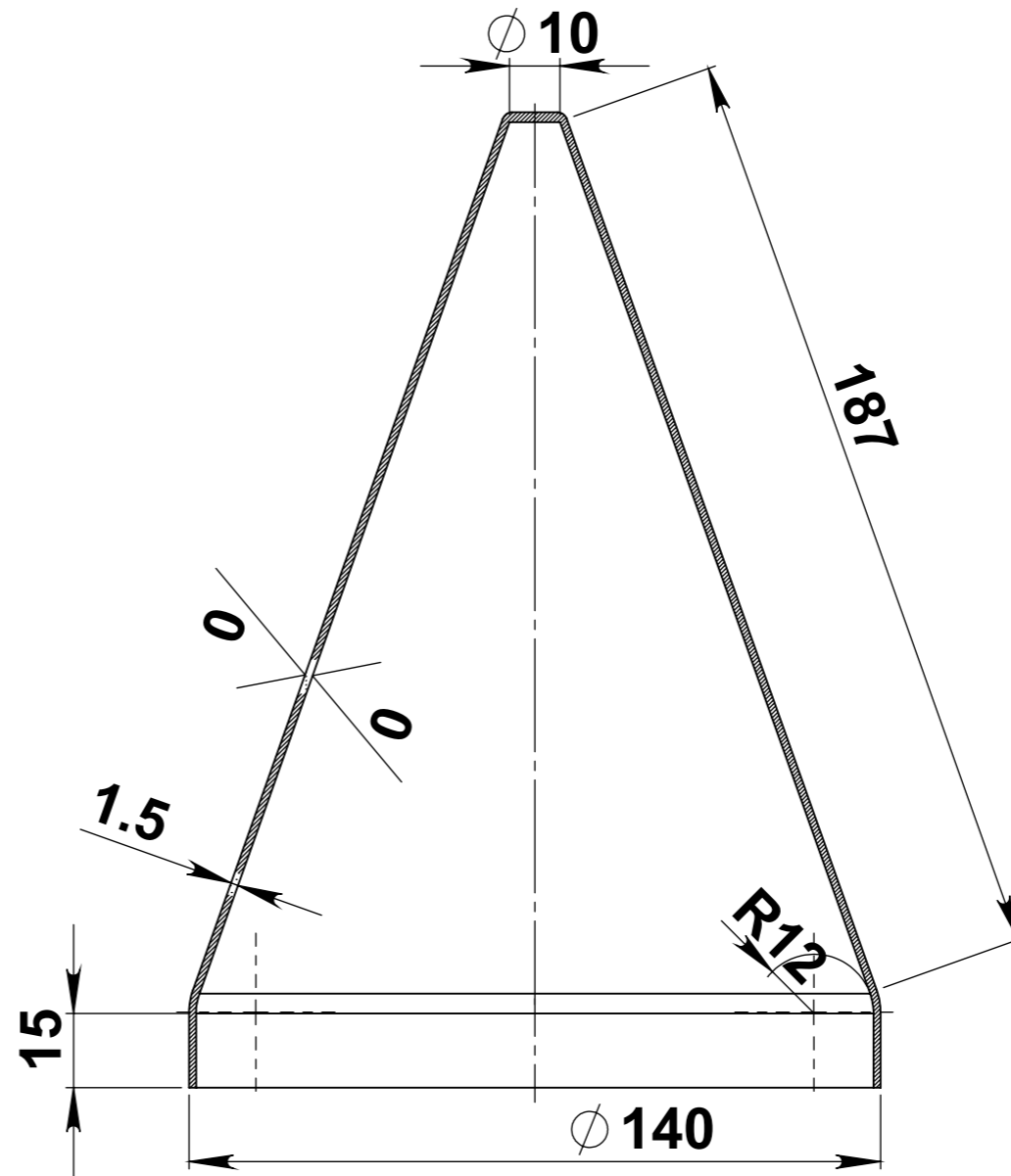
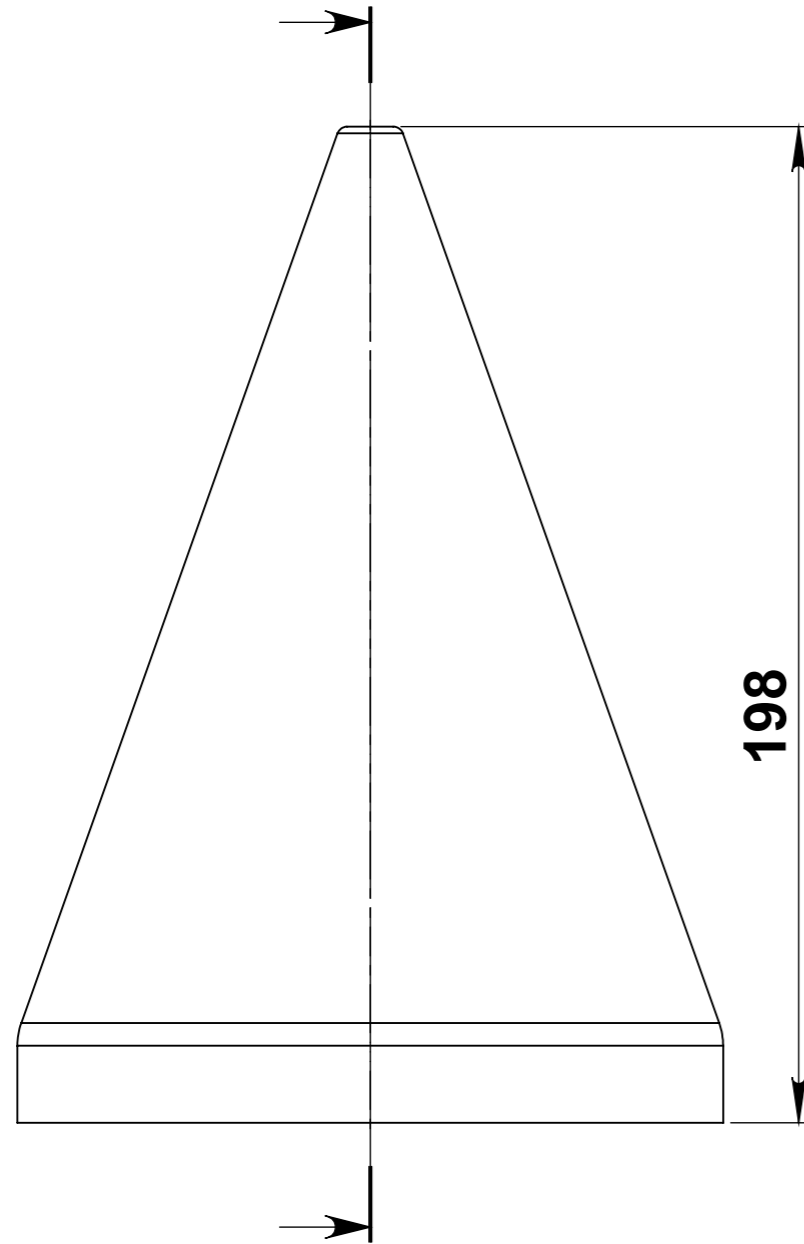


12.5 / ( ✓ )

**CONDITII TEHNICE:**

- Executie mijlocie cf. SREN 22768-2/95;
- Sudura prin puncte.

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>			MATERIAL: S235JR	<b>PRf - 22.1</b>	
			MASA: 2.995Kg		
					A3

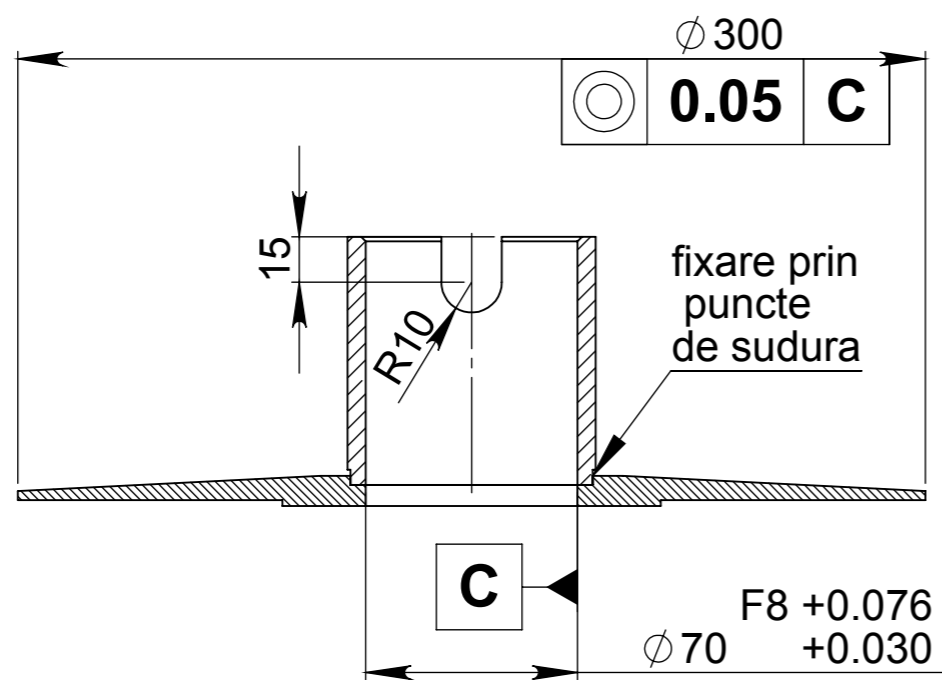
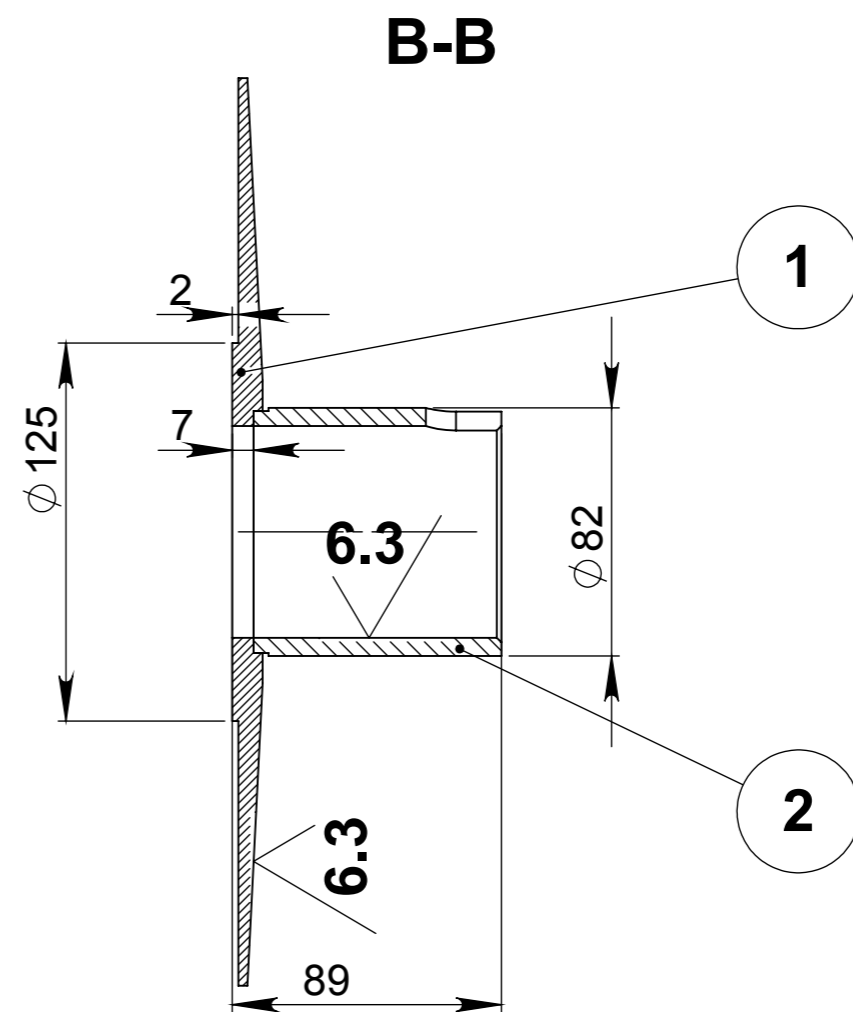
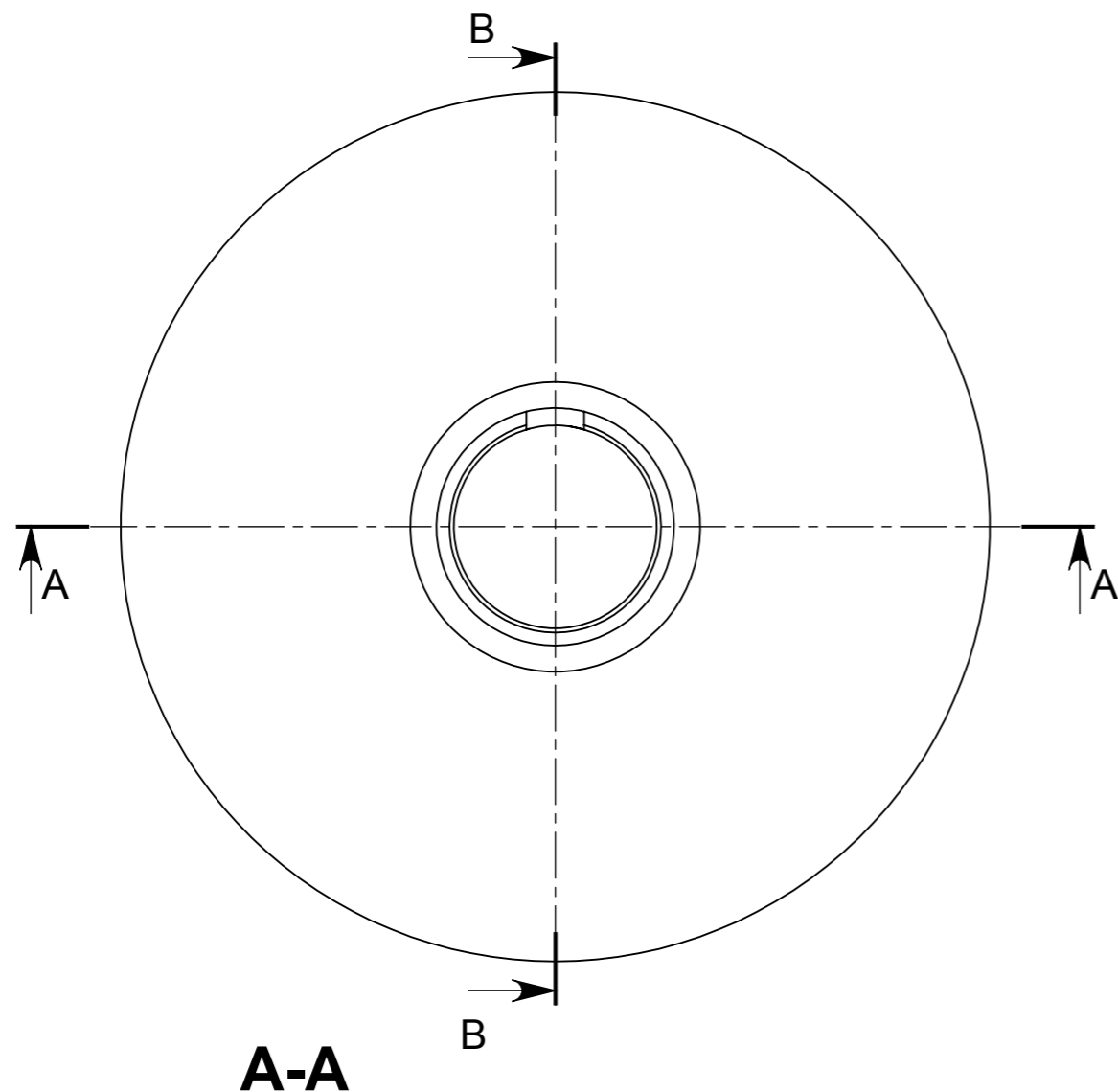


12.5 (✓)

**CONDITII TEHNICE:**

- Executie mijlocie cf. SREN 22768-2/95;
- Sudura prin puncte.

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>			MATERIAL: S235JR	<b>PRf - 21.2</b>	
			MASA: 0.607 Kg	<b>Con interior difuzor rumegus</b>	
					A3



**CONDITII TEHNICE:**

- Muchile necotate se tesesc 0,3x45°
- Executie fina cf. SREN 22768-2/95

**ATENTIE:**

Vor fi respectate  
COTELE si CONDITIILE TEHNICE  
indicate pe desenele componentelor

12.5 (✓)

Poz	Denumire	Nr.Desen	Buc	Material	Obs.	Masa
2	Inel fixare deflector	PRf-9.2	1	S235 JR		0.882
1	Disc deflector	PRf-9.1	1	S235 JR		2.845

Proiectat	Lucian Ionescu
Desenat	Baicu Ionut
Verificat	Bogdan Duran
Contr. STAS	Bogdan Duran
Aprobat	Preda Dragos
<b>SC. ROLIX IMPEX SERIES SRL</b>	

DATA: oct. 2017

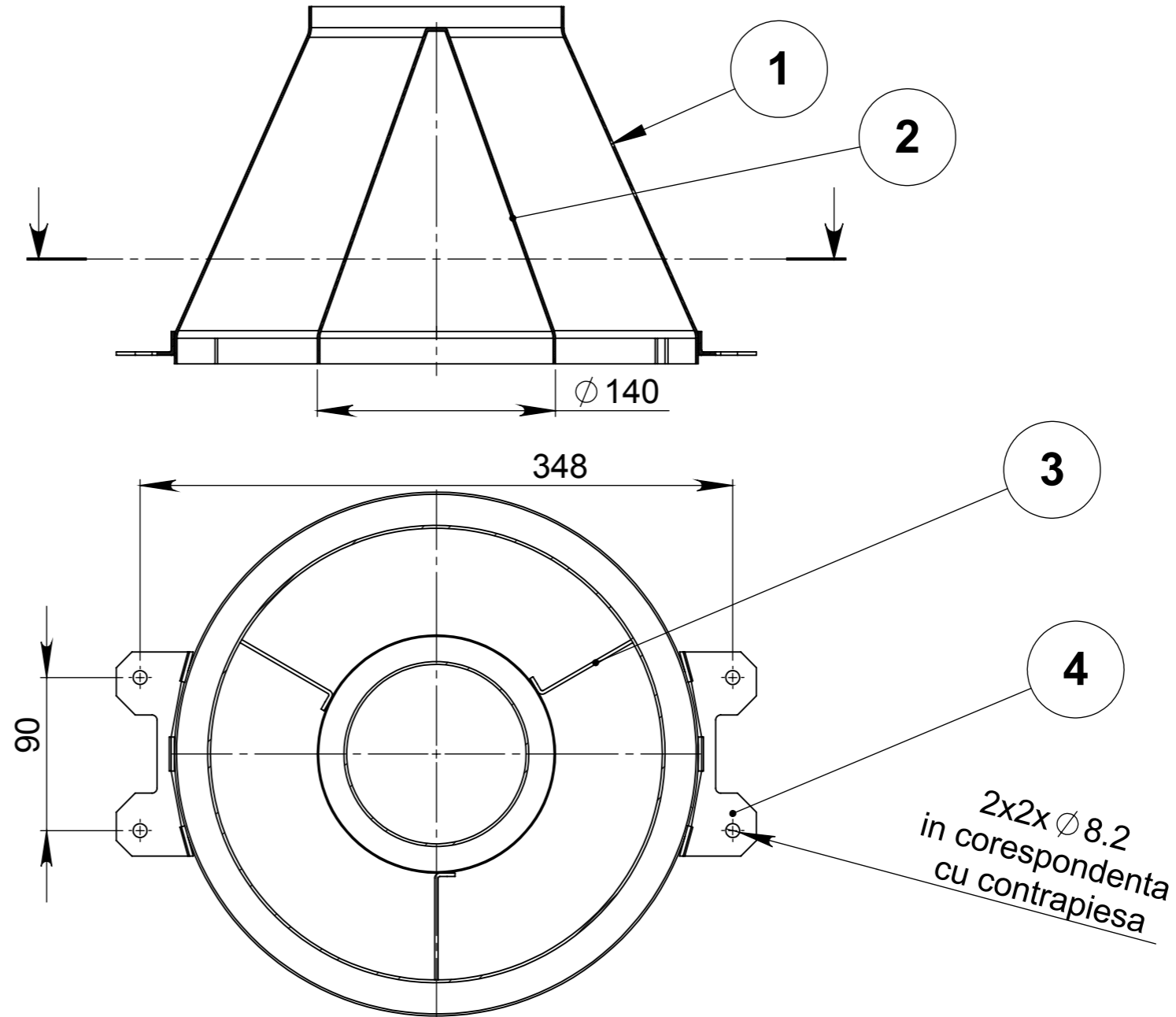
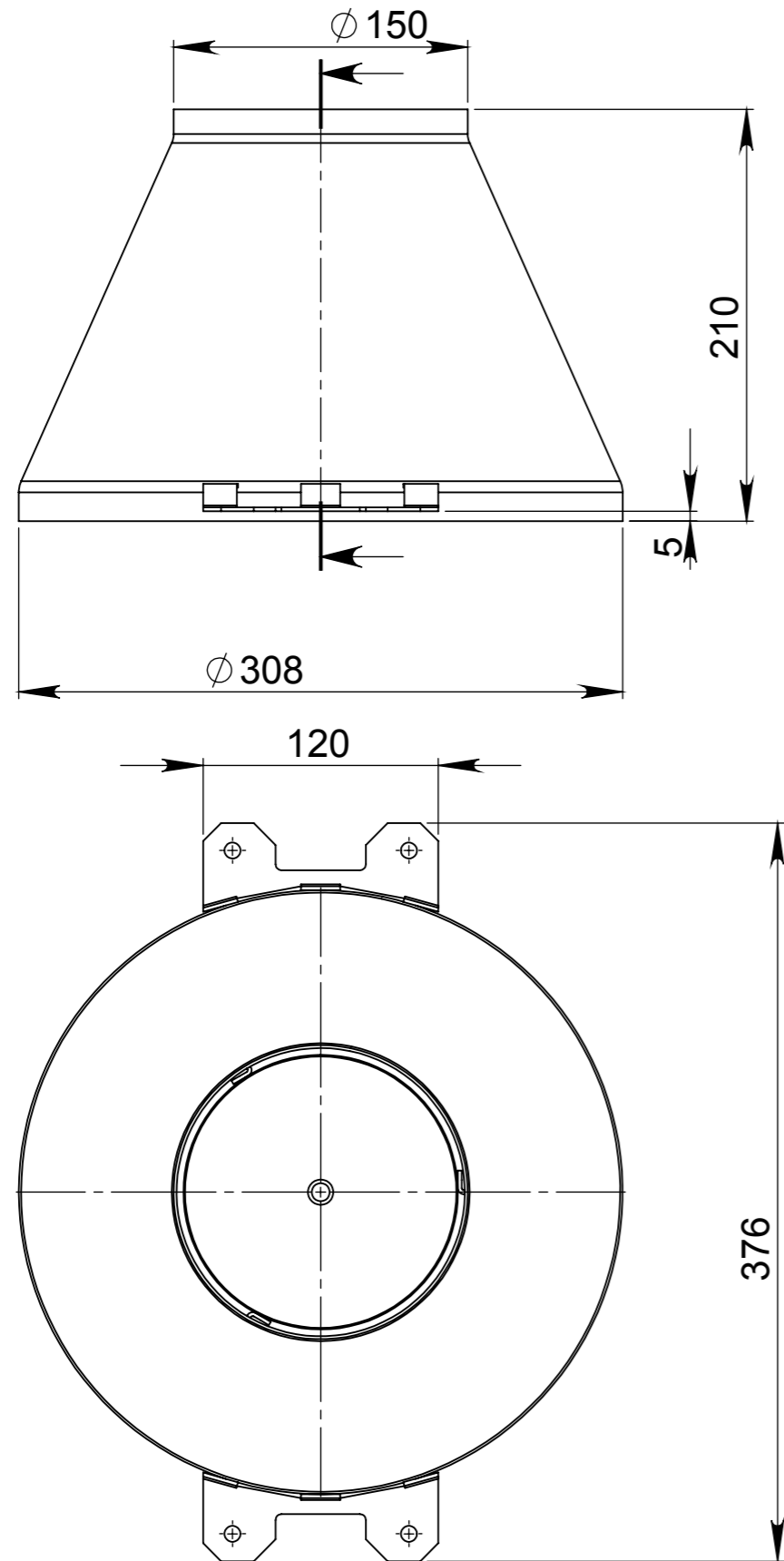
MATERIAL:

MASA: 3.728Kg

**PRf - 9.0**

**Deflector peleti**

A3



**CONDITII TEHNICE:**

- Executie mijlocie cf. SREN 22768-2/95;
- Sudura de rezistenta prin puncte;

Poz	Denumire	Nr.Desen	Buc	Material	Obs.	Masa
4	Ureche difuzor	PRf-21.4	2	S235JR		0.136
3	Spita difuzor	PRf-21.3	3	S235JR		0.069
2	Con interior difuzor rumegus	PRf-21.2	1	S235JR		0.607
1	Con exterior difuzor rumegus	PRf-21.1	1	S235JR		1.900

Proiectat	Lucian Ionescu
Desenat	Baicu Ionut
Verificat	Bogdan Duran
Contr. STAS	Bogdan Duran
Aprobat	Preda Dragos

DATA: oct. 2017

**SC. ROLIX IMPEX  
SERIES SRL**

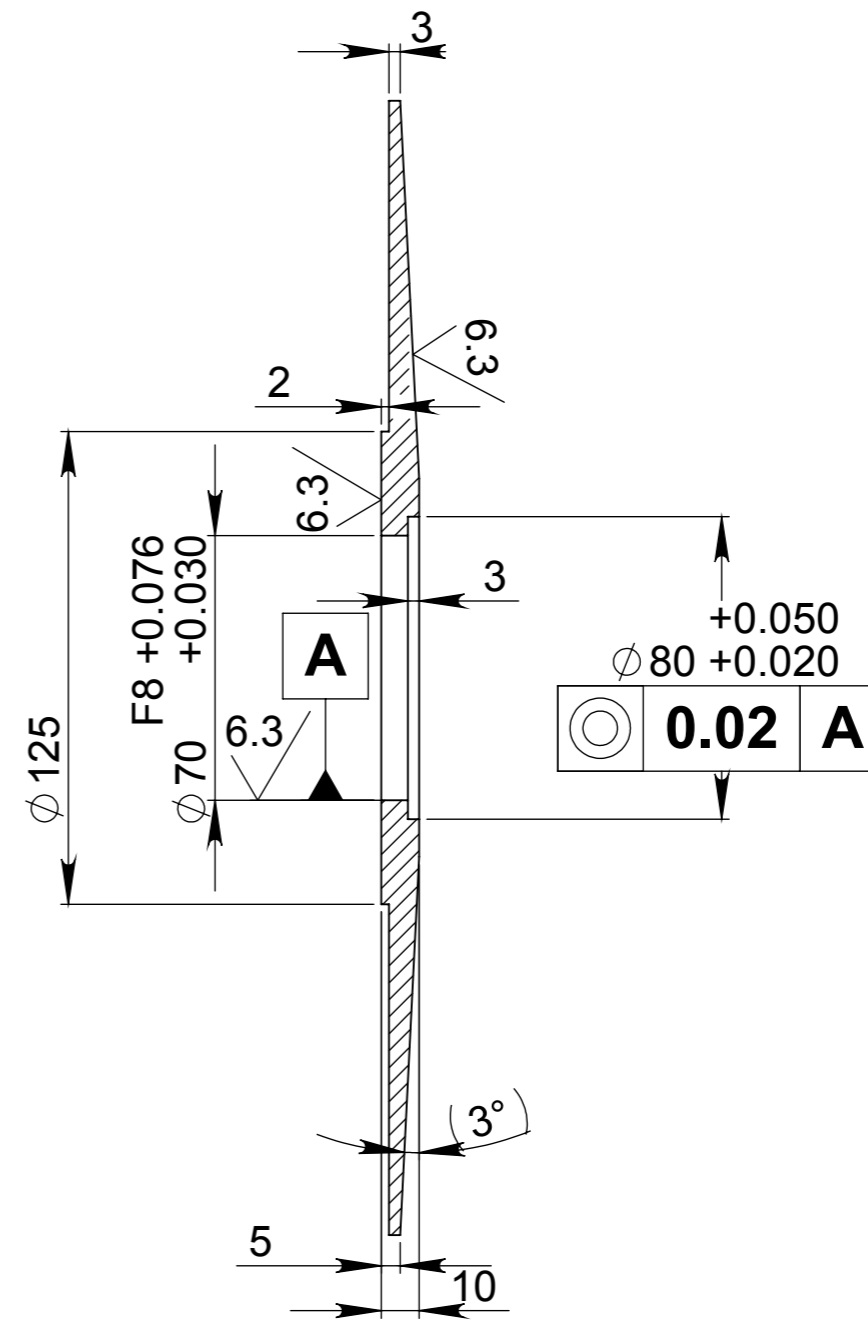
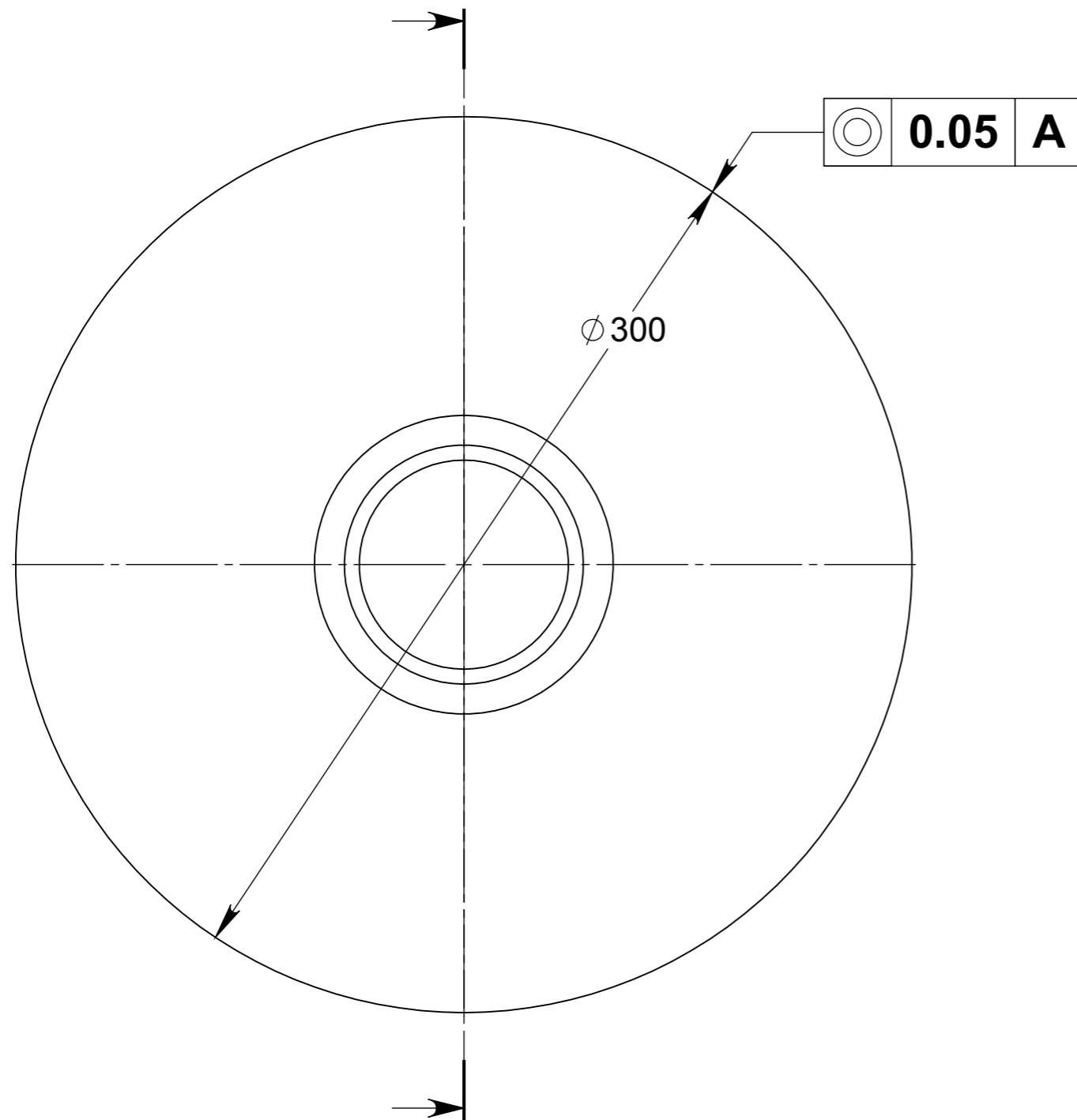
MATERIAL:

MASA: 2.712Kg

**PRf - 21.0**

**Difuzor rumegus**

A3



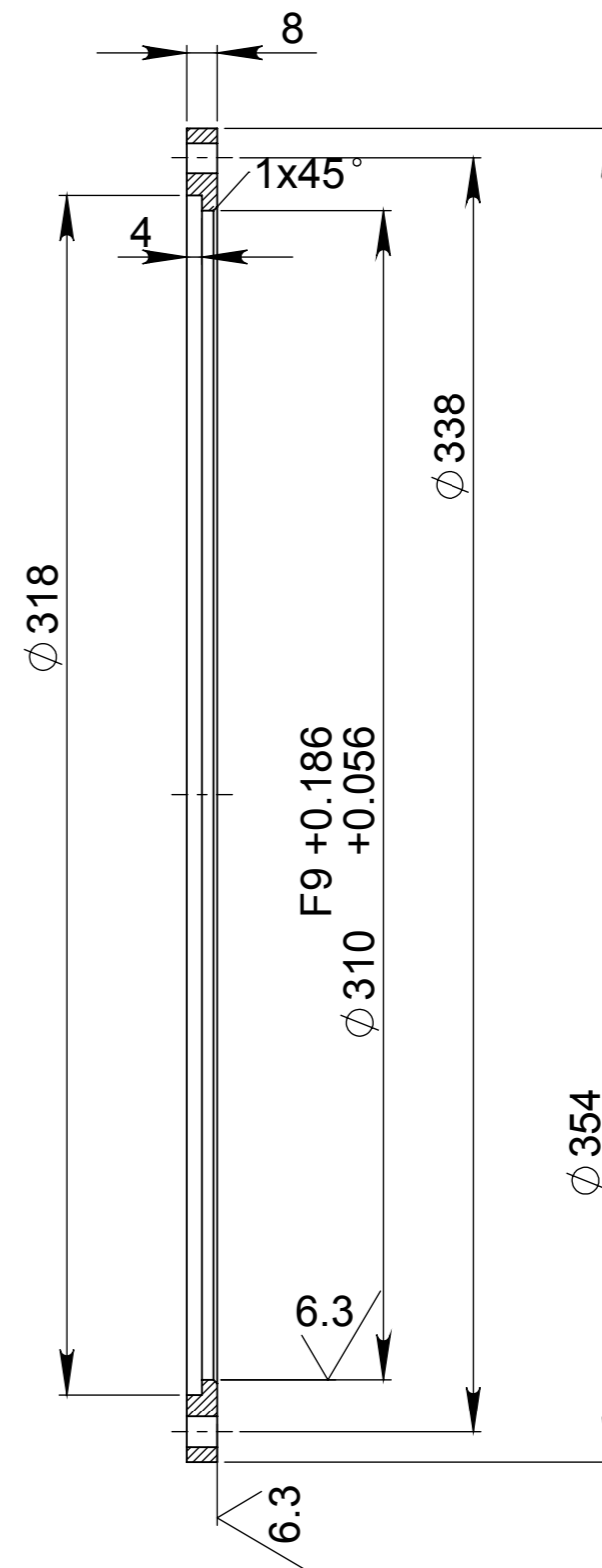
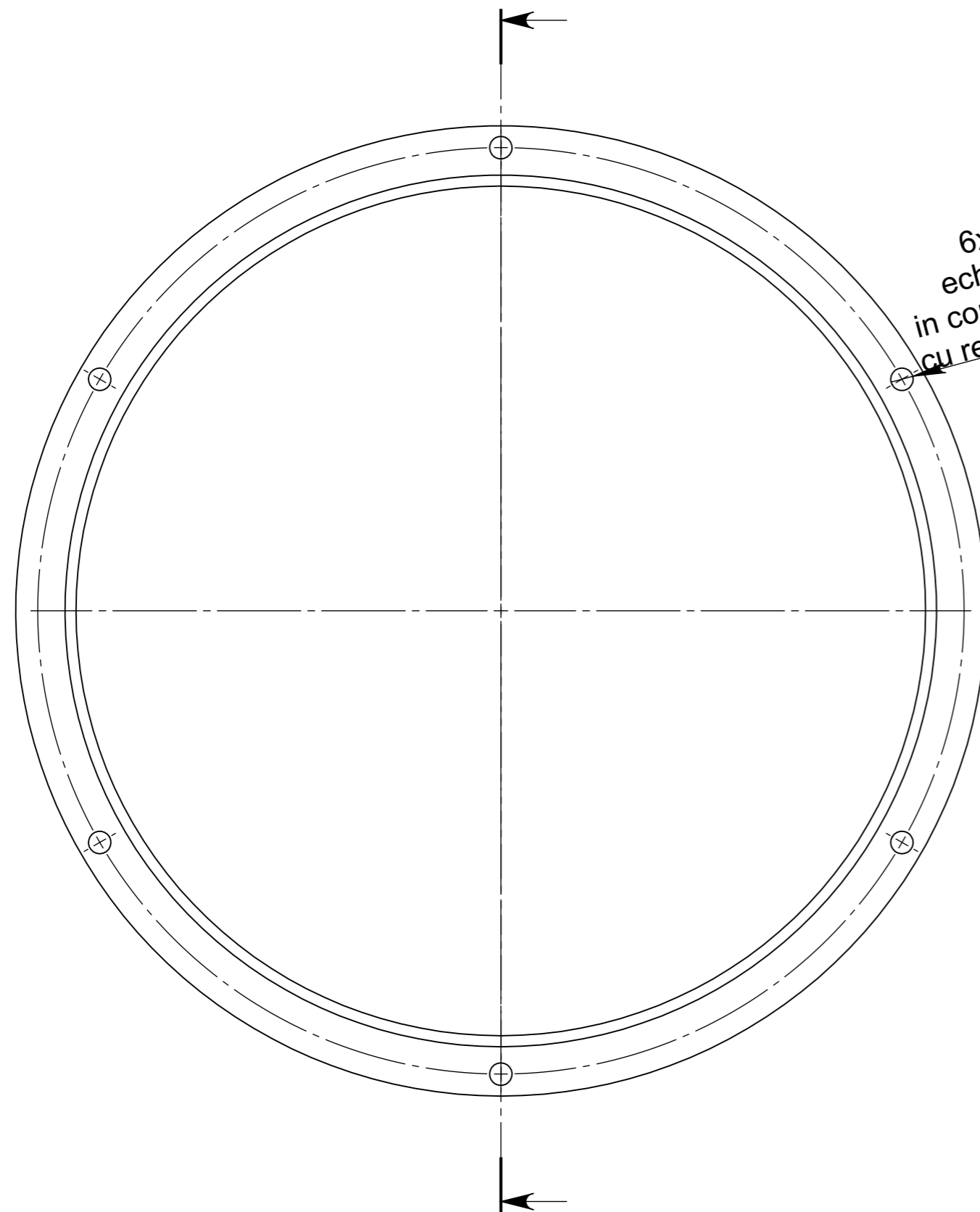
12.5 / ( ✓ )

**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,5x45°
- Executie fina cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

Proiectat	Lucian Ionescu					
Desenat	Baicu Ionut					
Verificat	Bogdan Duran					
Contr. STAS	Bogdan Duran					
Aprobat	Preda Dragos				DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>		MATERIAL: S235JR		<b>PRf - 9.1</b>		
		MASA: 2.845Kg		<b>Disc deflector</b>		A3





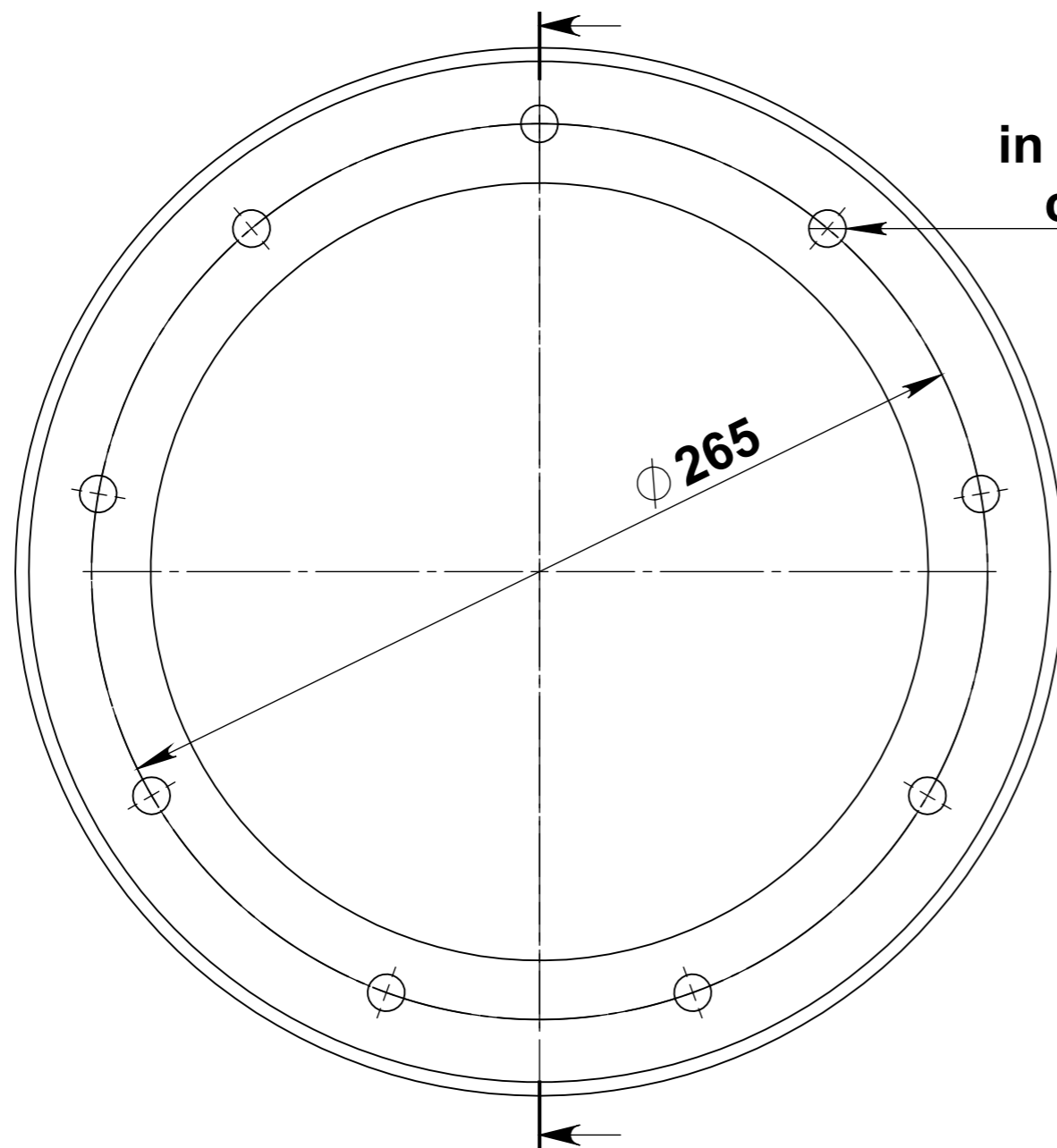
12.5



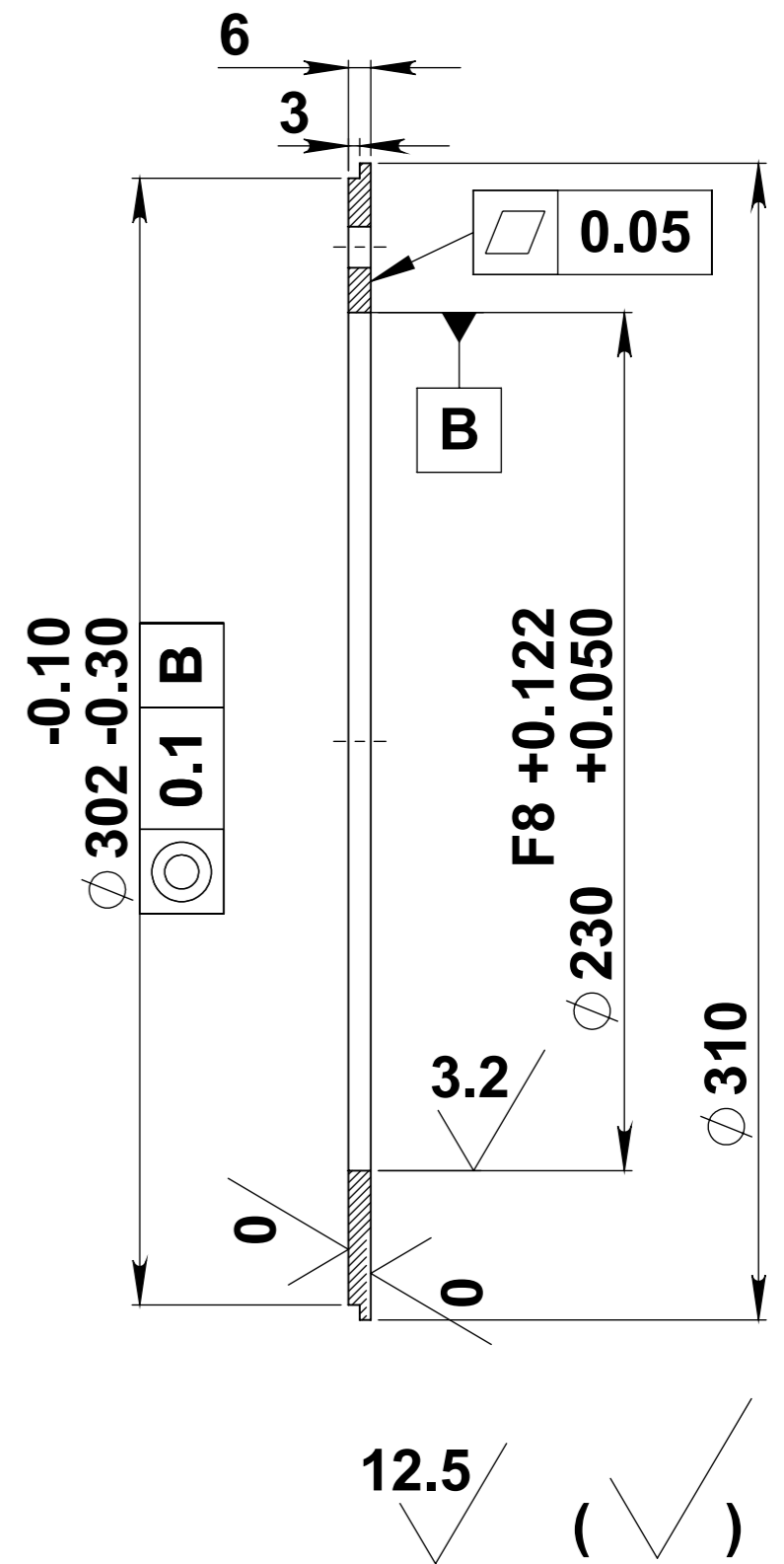
**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,5x45°
- Executie mijlocie cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>		MATERIAL: S235JR		<b>PRf-10.1</b>	
		MASA: 1.278 Kg		<b>Flansa inf. carcasa role presoare</b>	
					A3



9x  $\phi 11$   
 echidistante  
 in corespondenta  
 cu reper PRf-3



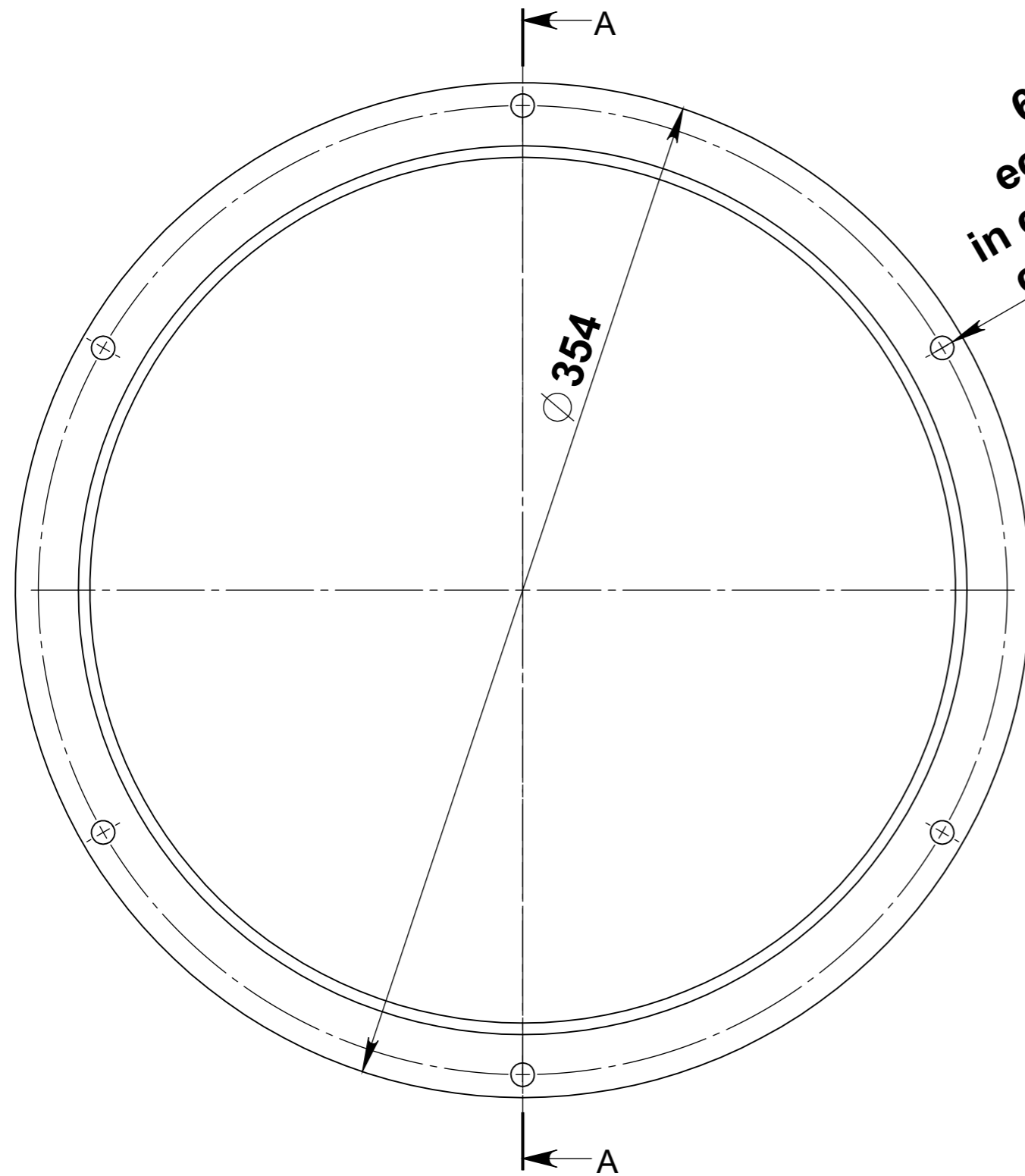
**CONDITII TEHNICE:**

- Muchiile necotate se tesesc  $0,5 \times 45^\circ$
- Executie mijlocie cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

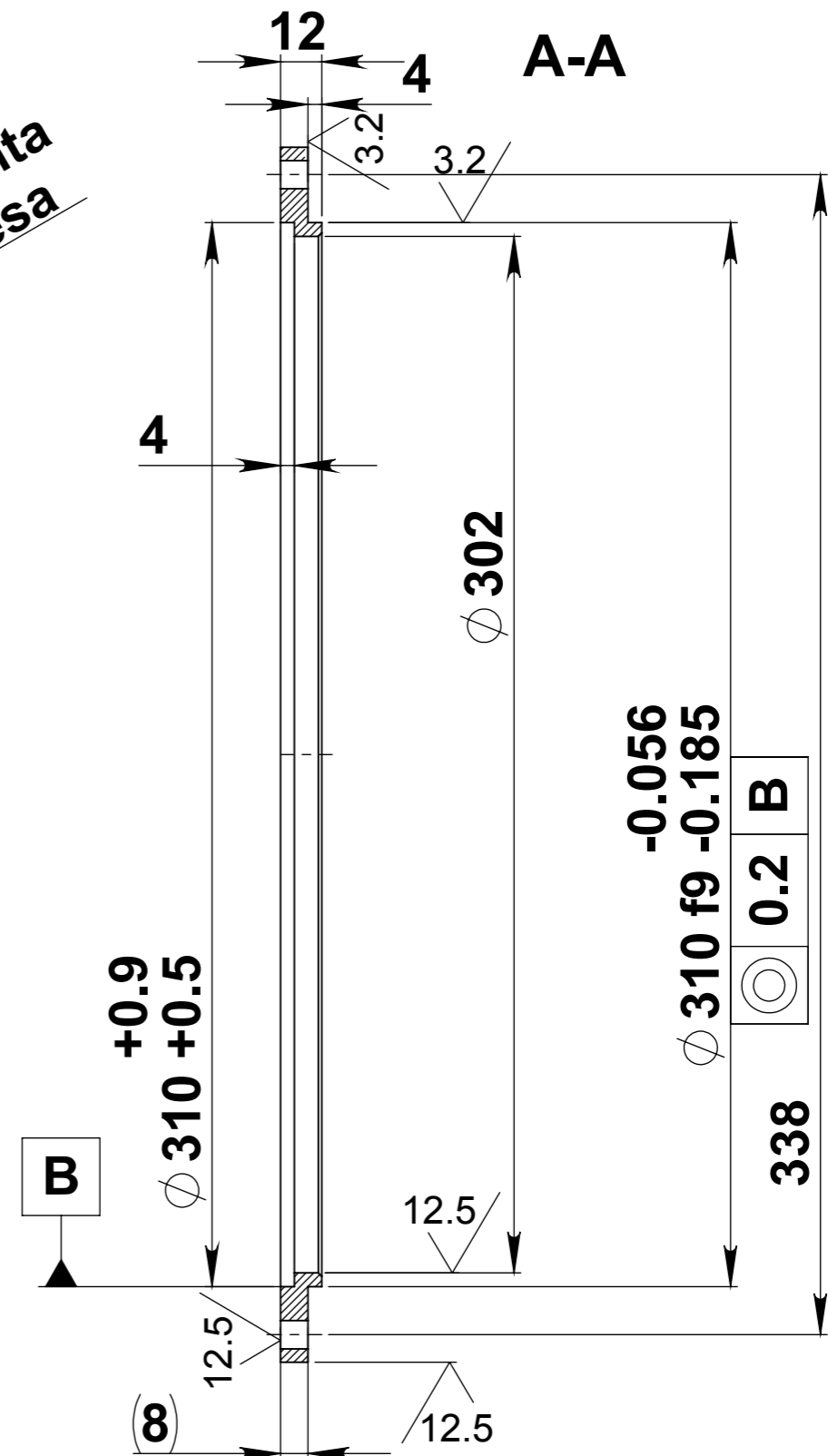
Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
SC. ROLIX IMPEX SERIES SRL			MATERIAL: S235JR		Flansa inferioara carcasa baza
			MASA: 1.459Kg		
					A3

**PRf-4.1.1**





6x  $\phi$  8.2  
 echidistante  
 in corespondenta  
 cu contra piesa

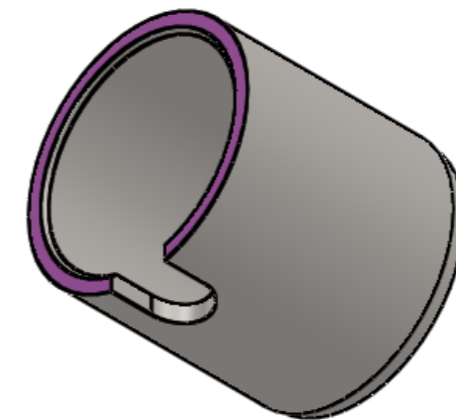
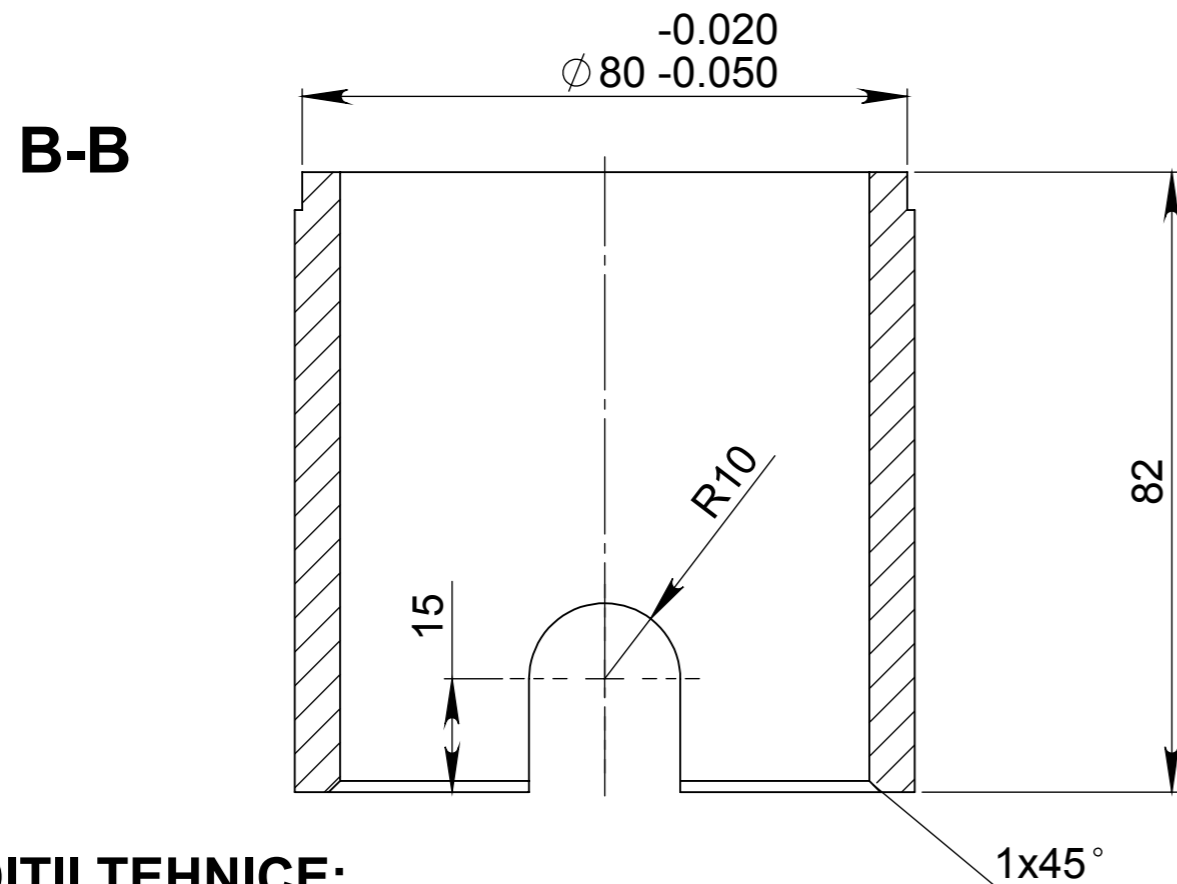
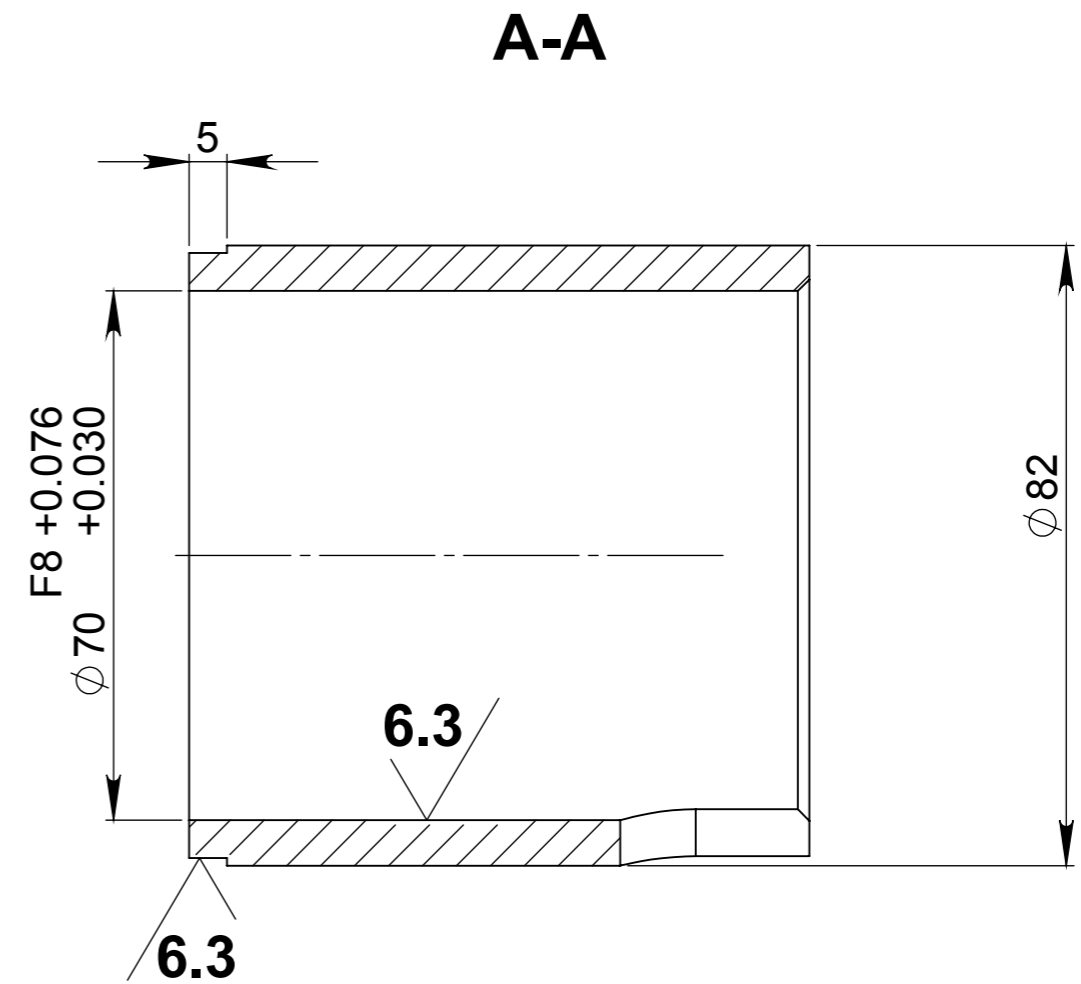
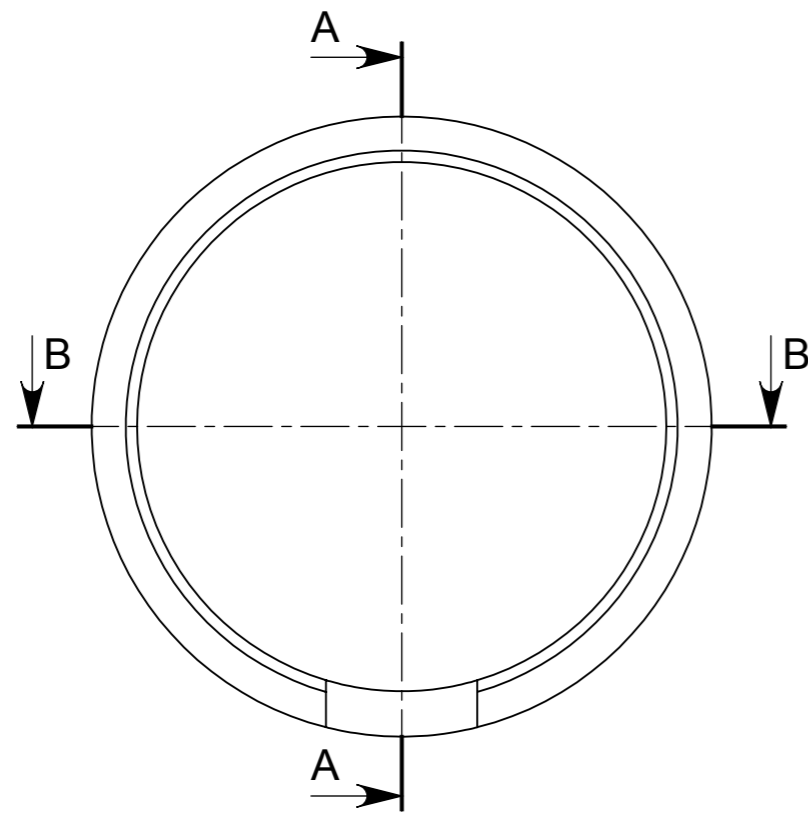


6.3 (✓)

**CONDITII TEHNICE:**

- Muchile necotate se tesesc 0,3x45°
- Executie mijlocie cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>		MATERIAL: S235JR		<b>PRf-4.1.3</b>	
		MASA: 1.645Kg		<b>Flansa superioara carcasa baza</b>	
					A3

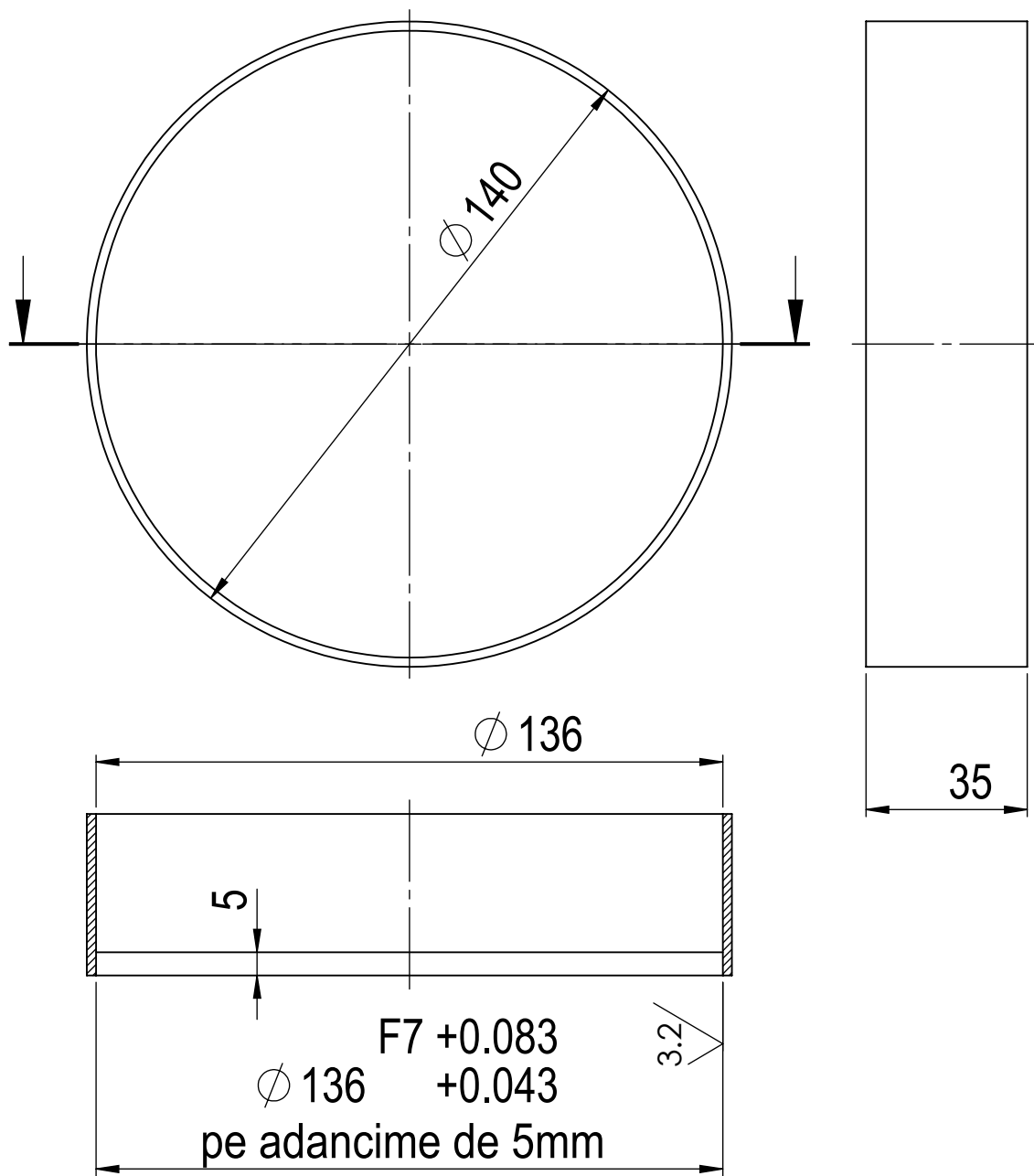


3.2 (✓)

**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,5x45°
- Executie fina cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>		MATERIAL: S235JR		<b>PRf - 9.2</b>	
		MASA: 0.882Kg		<b>Inel fixare deflector</b>	
					A3

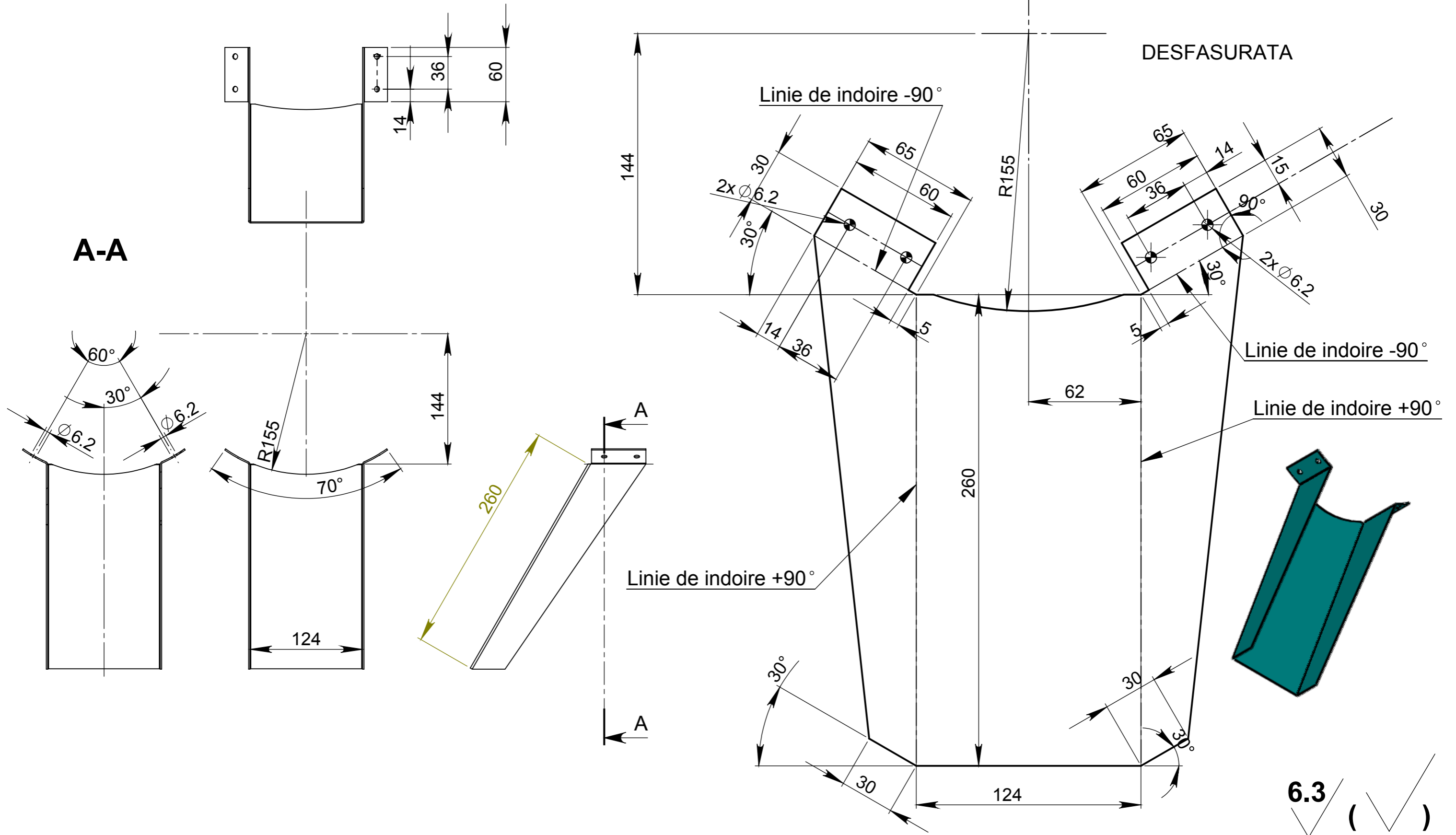


**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,2x45°;
- Executie mijlocie cf. SREN 22768-2/95;

12.5/ (✓)

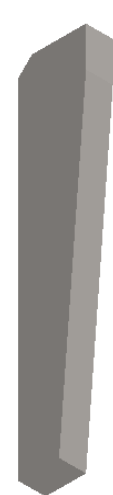
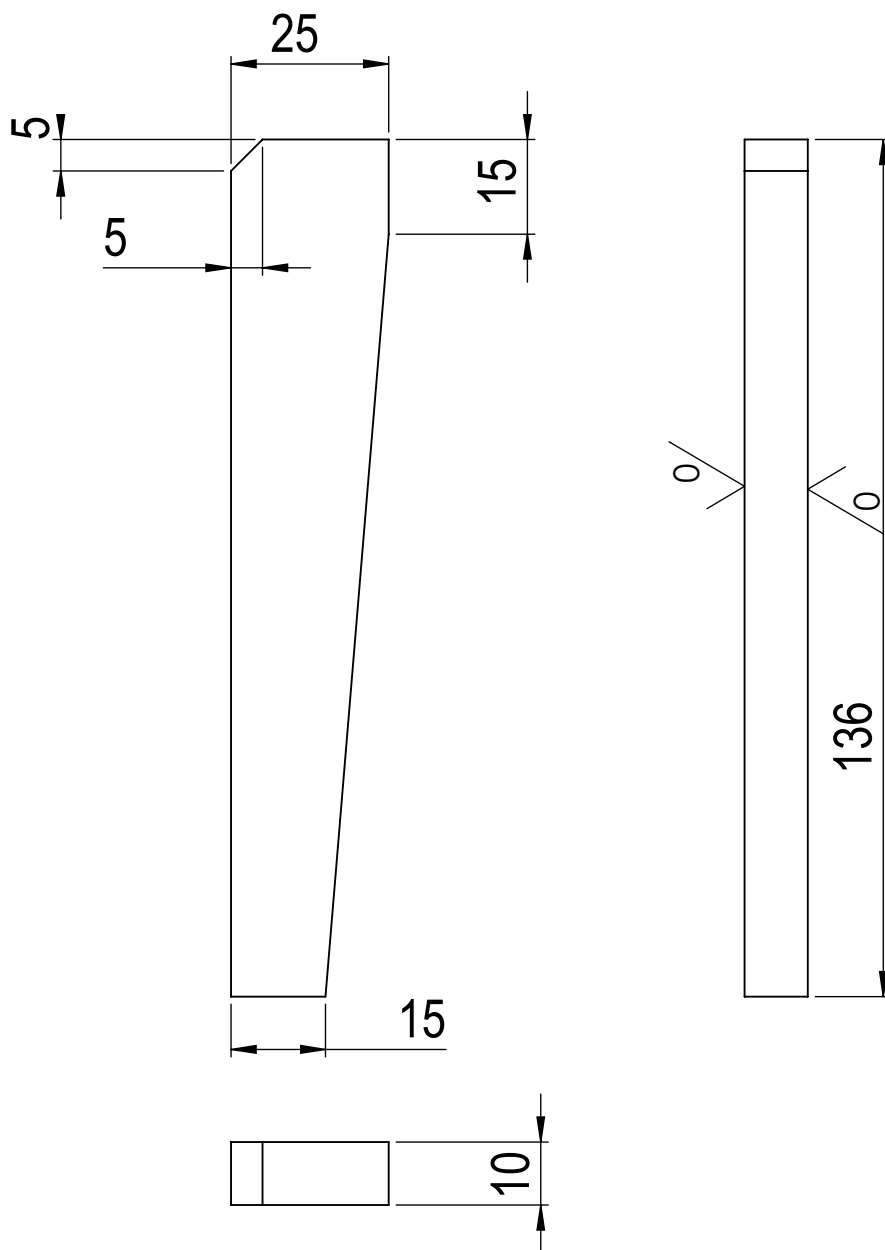
Proiectat		Lucian Ionescu					
Desenat		Baicu Ionut					
Verificat		Bogdan Duran					
Contr. STAS		Bogdan Duran					
Aprobat		Preda Dragos		DATA: oct. 2017			
SC. ROLIX IMPEX SERIES SRL				MATERIAL:		Inel protectie rulment axial	
				S235JR			
				Masa: 0.236			
						PRf - 8	
						A4	



**CONDITII TEHNICE:**

- Muchile necotate se tesesc 0,3x45°
- Executie fina cf. SREN 22768-2/95

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>		MATERIAL: S235JR		<b>PRf - 4.3</b>	
		MASA: 0.674Kg			
					A3

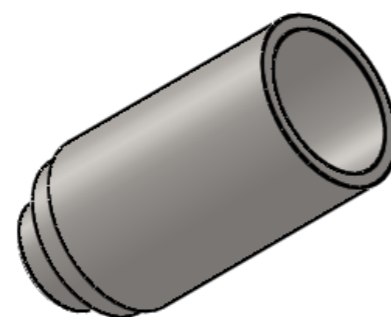
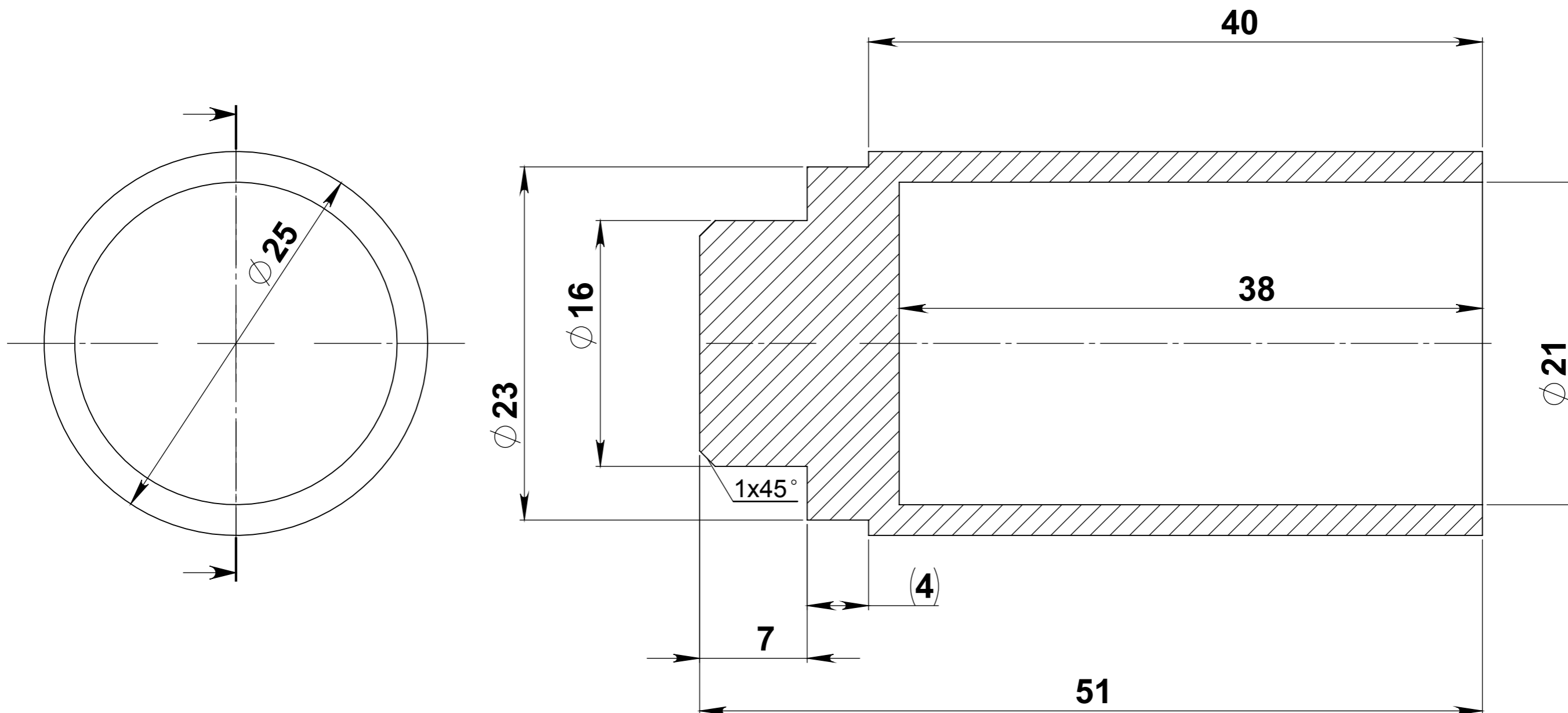


**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,5x45°
- Executie mijlocie cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

12.5/ (✓)

Proiectat		Lucian Ionescu				
Desenat		Baicu Ionut				
Verificat		Bogdan Duran				
Contr. STAS		Bogdan Duran				
Aprobat		Preda Dragos	DATA: oct. 2017			
<b>SC. ROLIX IMPEX SERIES SRL</b>			MATERIAL: S235JR		<b>PRf - 10.4</b>	
			Masa: 0217Kg			
					<b>Laterala ghidaj h136</b>	
					A4	

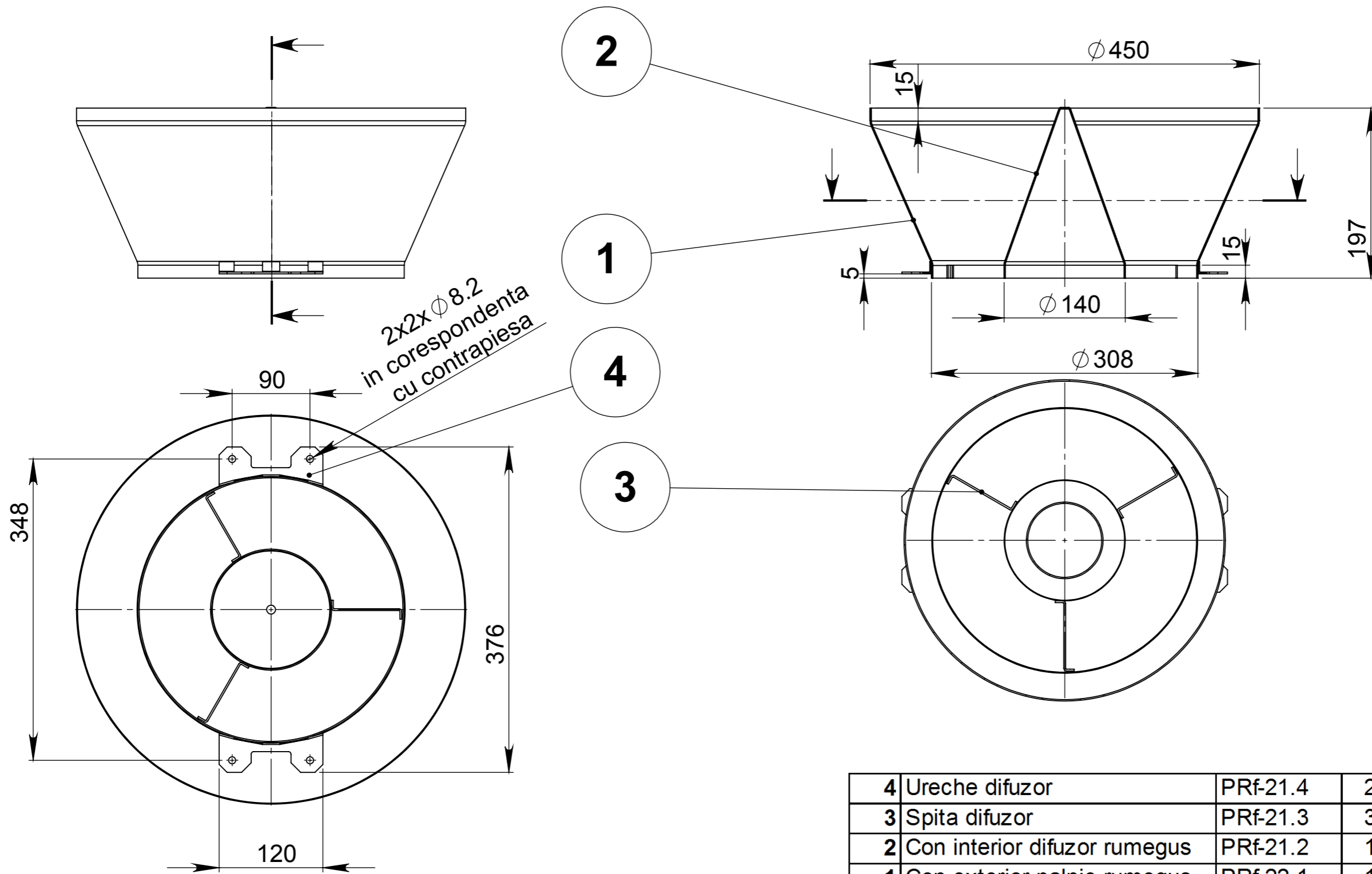


**CONDITII TEHNICE:**

- Muchile necotate se tesesc  $0,3 \times 45^\circ$
- Executie fina cf. SREN 22768-2/95

6.3

Proiectat	Lucian Ionescu					
Desenat	Baicu Ionut					
Verificat	Bogdan Duran					
Contr. STAS	Bogdan Duran					
Aprobat	Preda Dragos			DATA: oct. 2017		
<b>SC. ROLIX IMPEX SERIES SRL</b>			MATERIAL: S235JR		<b>PRf - 16</b>	
			MASA: 0.077Kg		<b>Pahar arc disc</b>	
						A3



**CONDITII TEHNICE:**

- Executie mijlocie cf. SREN 22768-2/95;
- Sudura prin puncte.

4	Ureche difuzor	PRf-21.4	2	S235JR		0.136
3	Spita difuzor	PRf-21.3	3	S235JR		0.069
2	Con interior difuzor rumegus	PRf-21.2	1	S235JR		0.607
1	Con exterior palnie rumegus	PRf-22.1	1	S235JR		2.995
<b>Poz</b>	<b>Denumire</b>	<b>Nr.Desen</b>	<b>Buc</b>	<b>Material</b>	<b>Obs.</b>	<b>Masa</b>

Proiectat Lucian Ionescu  
 Desenat Baicu Ionescu  
 Verificat Bogdan Duran  
 Contr. STAS Bogdan Duran  
 Aprobata Preda Dragos

DATA: oct. 2017

**SC. ROLIX IMPEX  
 SERIES SRL**

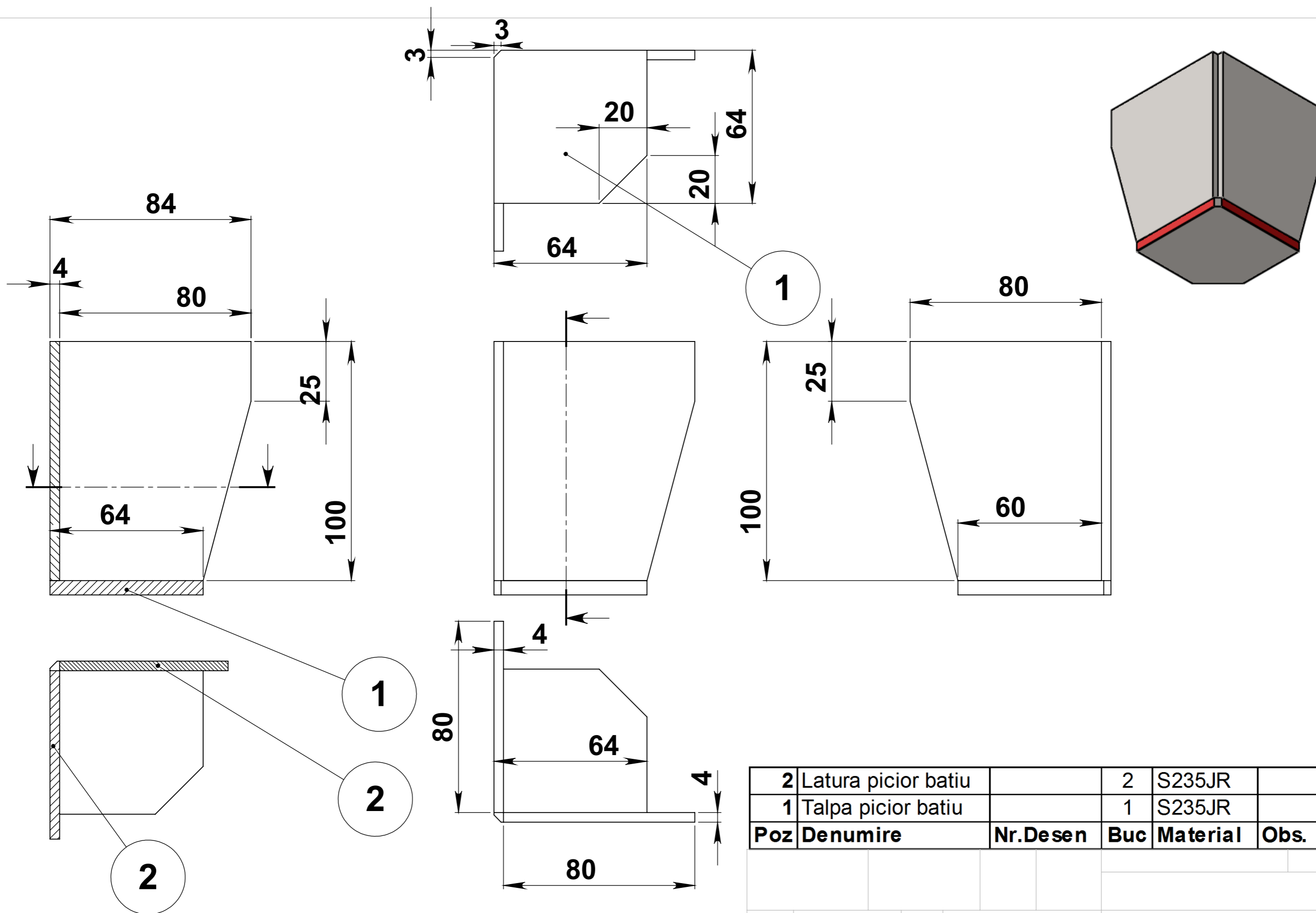
MATERIAL:

MASA: 3.671Kg

**PRf - 22.0**

**Palnie rumegus**

A3



**CONDITII TEHNICE:**

- Executie mijlocie cf. SREN 22768-2/95;
- Sudura de rezistenta, sudurile se vor executa ingrijit;

Poz	Denumire	Nr.Desen	Buc	Material	Obs.	Masa
2	Latura picior batiu		2	S235JR		0.448
1	Talpa picior batiu		1	S235JR		0.182

Proiectat	Lucian Ionescu
Desenat	Baicu Ionut
Verificat	Bogdan Duran
Contr. STAS	Bogdan Duran
Aprobat	Preda Dragos
<b>SC. ROLIX IMPEX SERIES SRL</b>	

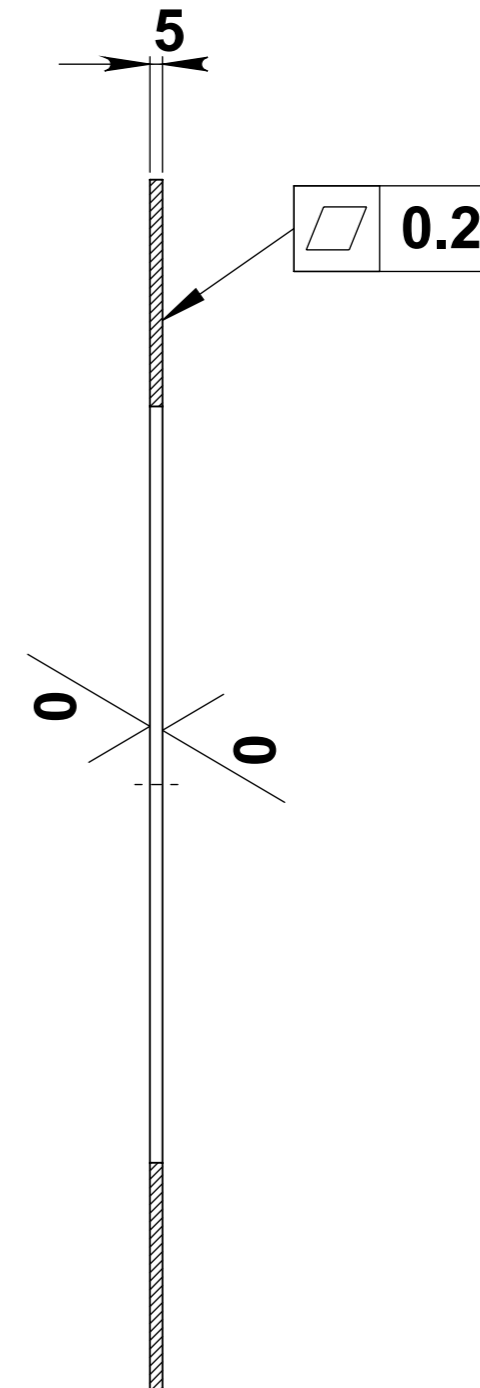
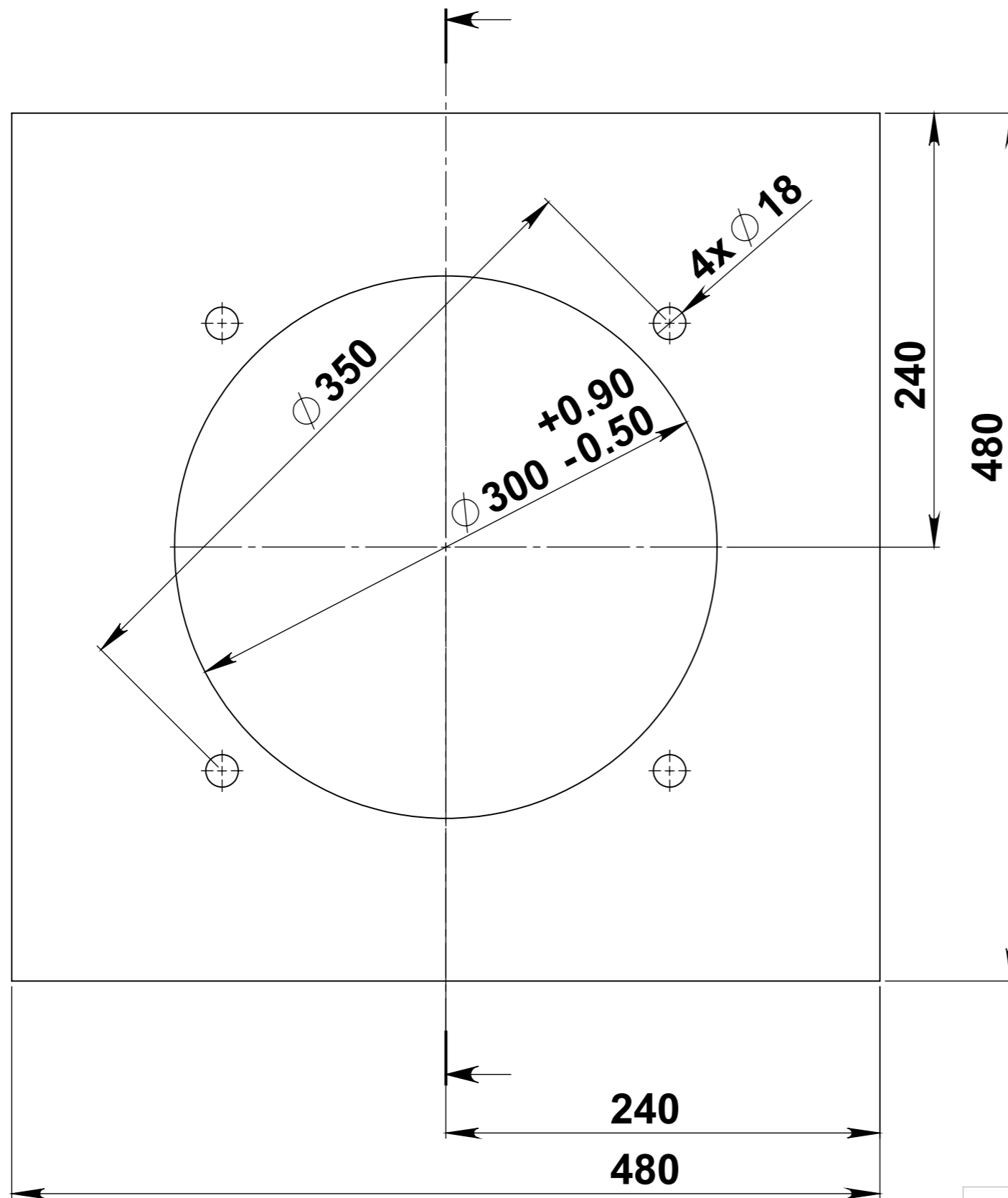
DATA: oct. 2017  
MATERIAL: S235JR  
MASA: 0.630 Kg

**PRf - 20.3.0**

**Picior batiu**

A3



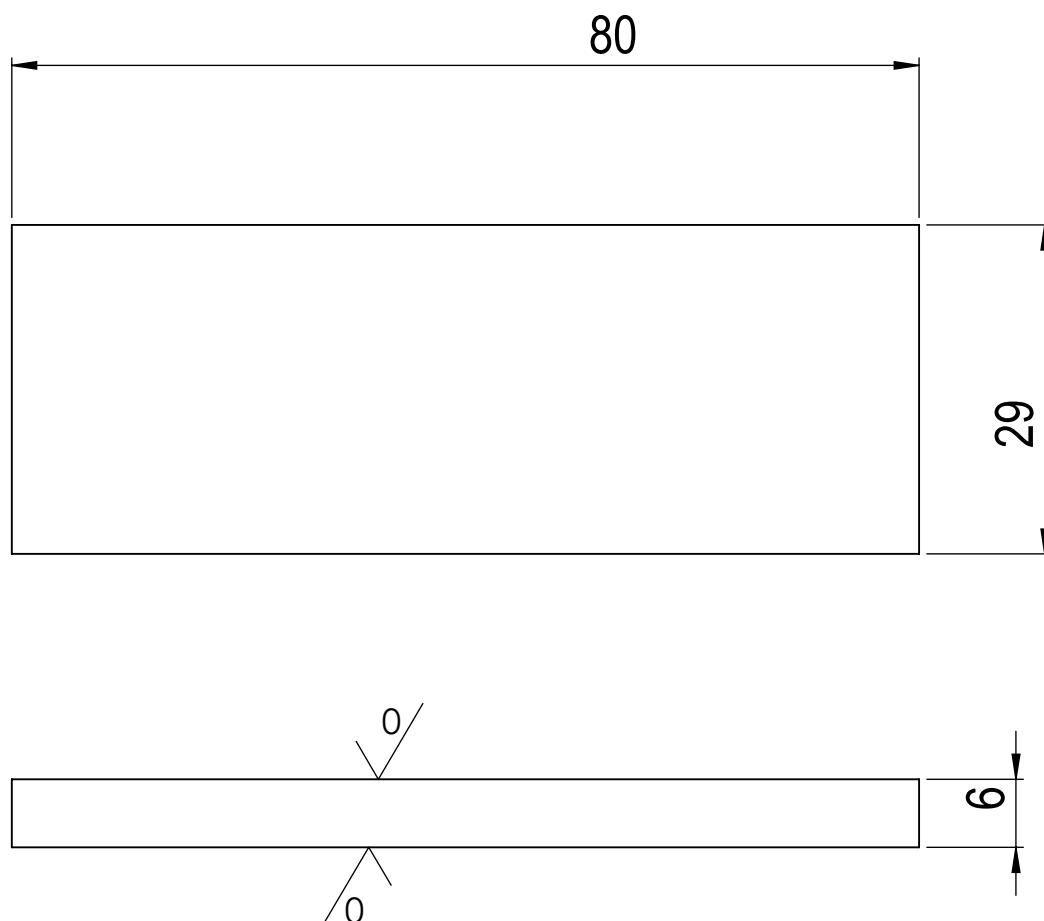


25 (✓)

**CONDITII TEHNICE:**

- Muchile necotate se tesesc 0,3x45°
- Executie mijlociecf. SREN 22768-2/95

Proiectat	Lucian Ionescu				
Desenat	Baicu Ionut				
Verificat	Bogdan Duran				
Contr. STAS	Bogdan Duran				
Aprobat	Preda Dragos			DATA: oct. 2017	
<b>SC. ROLIX IMPEX SERIES SRL</b>			MATERIAL: S235JR	<b>PRf - 20.2</b>	
			MASA: 6.189 Kg	<b>Placa baza batiu</b>	
					A3

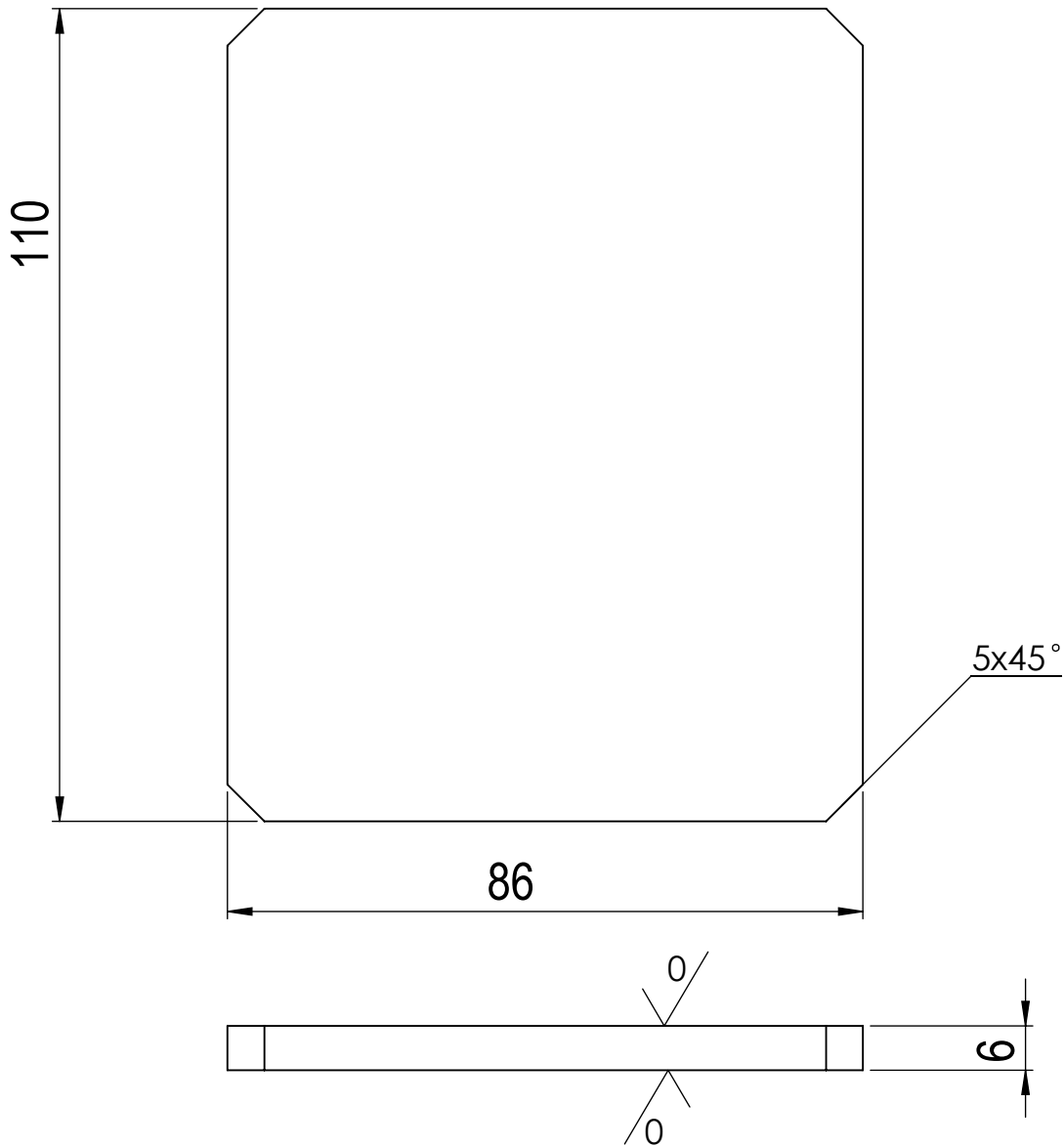


### CONDITII TEHNICE:

- Muchiile necotate se tesesc 0,5x45°
- Executie mijlocie cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

12.5/ (✓)

Proiectat		Lucian Ionescu					
Desenat		Baicu Ionut					
Verificat		Bogdan Duran					
Contr. STAS		Bogdan Duran					
Aprobat		Preda Dragos					
SC. ROLIX IMPEX SERIES SRL			MATERIAL: S235 JR		PRf-11.11.2		
			Masa: 0.108Kg		Plug rumegus - nervura		
							A4

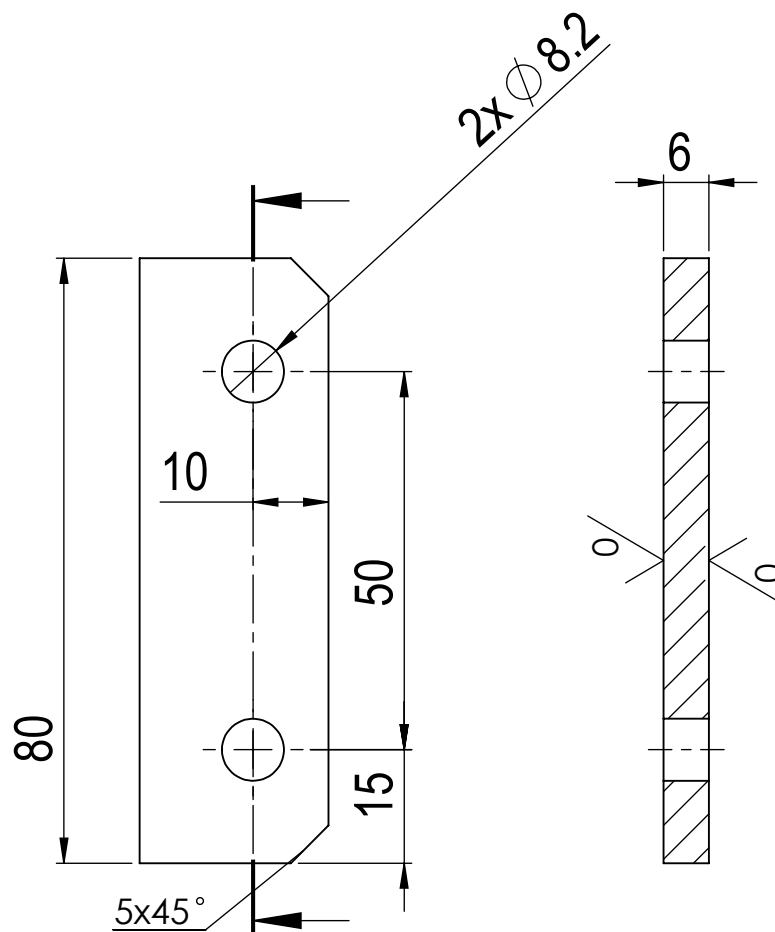


### CONDITII TEHNICE:

- Muchiile necotate se tesesc 0,5x45°
- Executie mijlocie cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

12.5/ (✓)

Proiectat		Lucian Ionescu						
Desenat		Baicu Ionut						
Verificat		Bogdan Duran						
Contr. STAS		Bogdan Duran						
Aprobat		Preda Dragos						
SC. ROLIX IMPEX SERIES SRL			MATERIAL: S235JR		PRf- 11.11.3  Plug rumegus - razator			A4
			Masa: 0.440Kg					

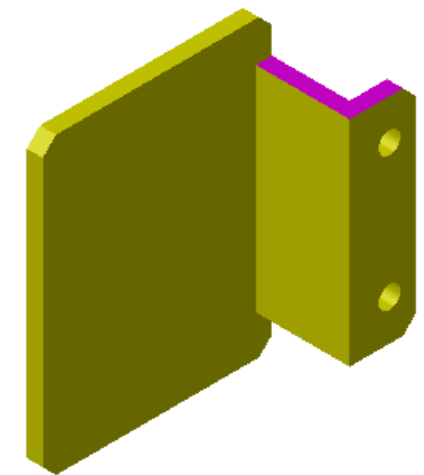
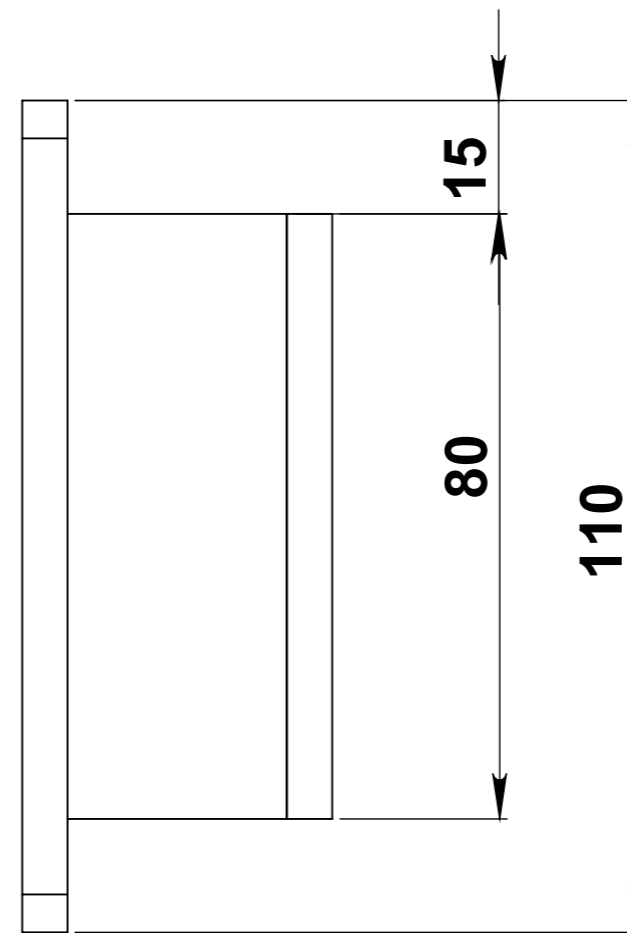
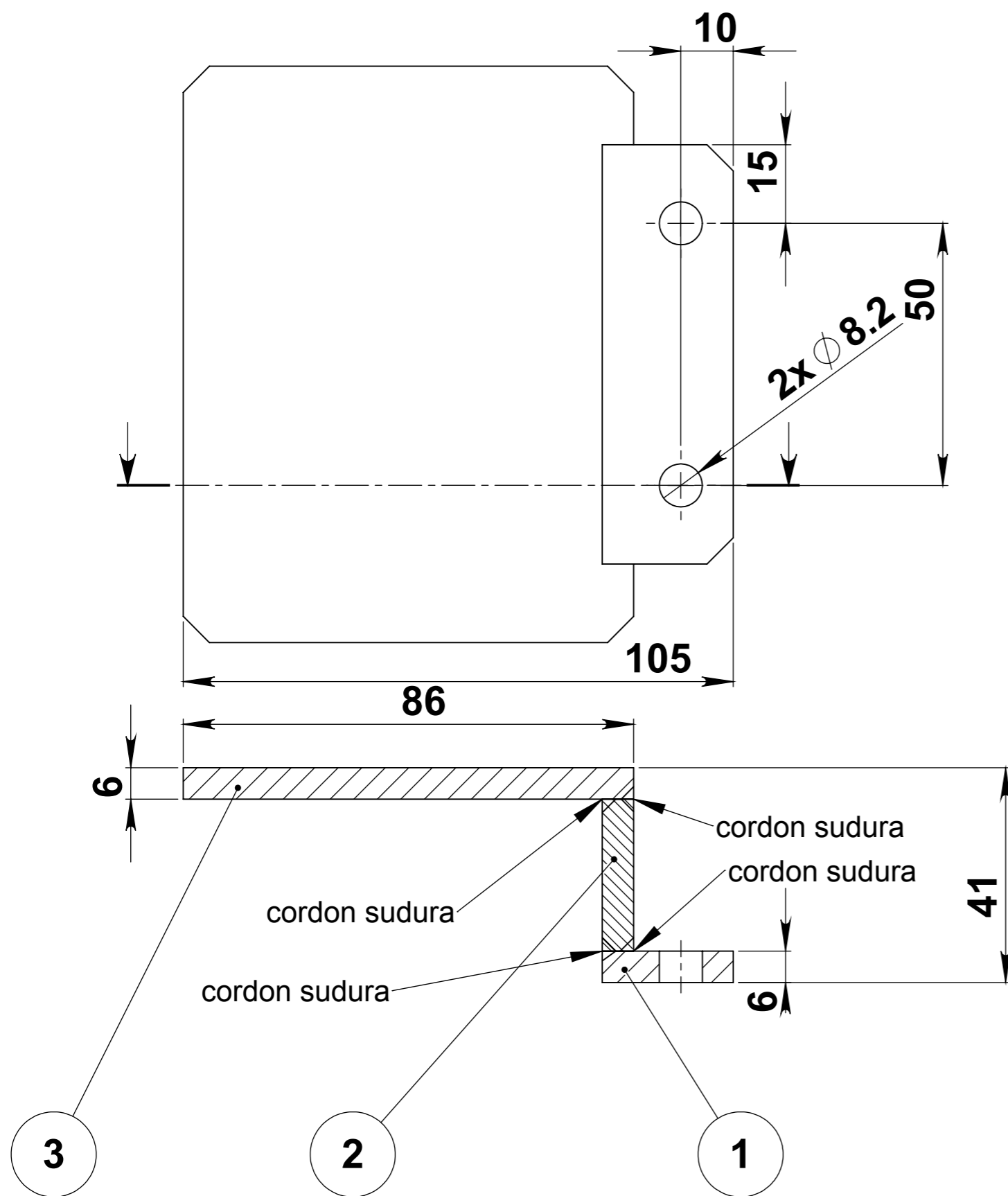


### CONDITII TEHNICE:

- Muchiile necotate se tesesc 0,5x45°
- Executie mijlocie cf. SREN 22768-2/95
- Cotele sunt valabile pentru piesa in ansamblul finit
- Adaosurile de prelucrare se stabilesc de tehnolog

12.5/ (✓)

Proiectat		Lucian Ionescu					
Desenat		Baicu Ionut					
Verificat		Bogdan Duran					
Contr. STAS		Bogdan Duran					
Aprobat		Preda Dragos					
SC. ROLIX IMPEX SERIES SRL			MATERIAL: S235 JR	PRf - 11.11.1			
			Masa: 0.087Kg	Plug rumegus - talpa			A4



**ATENTIE:**

Vor fi respectate  
COTELE si CONDITIILE TEHNICE  
indicate pe desenele componentelor

12.5

( ✓ )

3	Plug rumegus-razator	PRf-11.11.3	1	S235 JR		0.440
2	Plug rumegus-nervura	PRf-11.11.2	1	S235 JR		0.108
1	Plug rumegus-talpa	PRf-11.11.1	1	S235 JR		0.087
<b>Poz</b>	<b>Denumire</b>	<b>Nr.Desen</b>	<b>Buc</b>	<b>Material</b>	<b>Obs.</b>	<b>Masa</b>

**CONDITII TEHNICE:**

- Muchiile necotate se tesesc 0,2x45°;
- Executie mijlocie cf. SREN 22768-2/95;
- Sudura de rezistenta, executata ingrijit;

Proiectat	Lucian Ionescu
Desenat	Baicu Ionut
Verificat	Bogdan Duran
Contr. STAS	Bogdan Duran
Aprobat	Preda Dragos

DATA: oct. 2017

SC. ROLIX IMPEX  
SERIES SRL

MATERIAL:

MASA: 0.635Kg

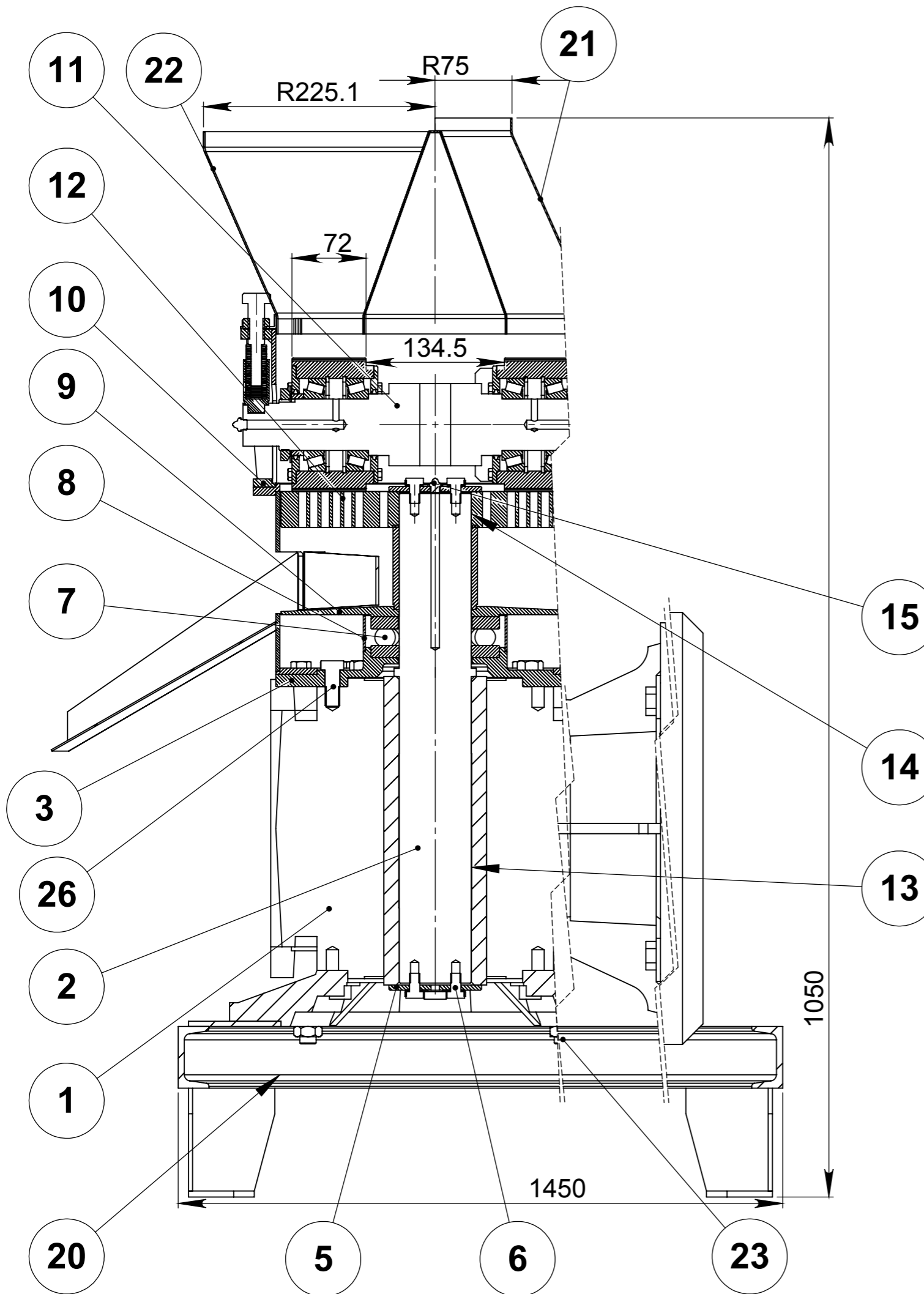
**PRf - 11.11.0**

**Plug rumegus b**

A3

**NOTA:**

Pozitiile 21 si 22 sunt optionale.  
 Pentru alimentare mecanizata se utilizeaza Difuzorul poz.21;  
 pentru o alimentare manuala se utilizeaza Palnia poz.22



26	Surub M14x35	ISO 4017	7	Gr.8.8		0.497
25	Piulita M8	ISO-4034	10	Gr.8		0.060
24	Surub M8x25	ISO 4017	10	Gr.8.8		0.150
23	Surub M16x40	ISO 4017	4	Gr.8.8		0.404
22	Palnie rumegus	PRf-22.0	1	S235 JR		3.671
21	Difuzor rumegus	PRf-21.0	1	S235 JR		2.576
20	Batiu presa peleti PF	PRf-20.0	1			35.600
19	Surub M16 presare role	PRf-19	2	C45		0.250
18	Piulita M16	ISO 4034	6	Gr.8		0.174
17	Arc disc d10.2D20x1.5	0200/13	64	60Si15A	Set 16x2	0.512
16	Pahar arc disc	PRf-16	2	S235 JR		0.154
15	Ungator cu bila M10x1	SR 1116	1			0.007
14	Pana C20x12x45	SR 1004	1	St 50		0.098
13	Pana A20x12x270	SR 1004	1	St 50		0.534
12	Sita motoare	PRf-12	1	C45		14.914
11	Ax cu role presoare fixe PRf	PRf-11.0	1			18.547
10	Carcasa role presoare fixe	PRf-10.0	1	S235 JR		7.055
9	Deflector peleti	PRf-9.0	1	S235 JR		3.728
8	Inel protectie rulment axial	PRf-8	1	S235 JR		0.236
7	Rulment axial 51314	SKF	1		φ70xφ125x40	2.050
6	Surub M10x18	ISO 4017	12	Gr.8.8		0.281
5	Saiba frontala ax motor	PRf-5	2	S235 JR		0.478
4	Carcasa baza	PRf-4.0	1			8.983
3	Flansa baza V1	PRf-3	1	S235 JR		7.334
2	Arbore motor	PRf-2	1	41 Cr4		13.890
1	Motoreductor B143UC10.84		1		Corner Prod	80.500
Poz	Denumire	Nr.Desen	Buc	Material	Obs.	Masa

Proiectat Lucian Ionescu  
 Desenat Baicu Ionut  
 Verificat Bogdan Duran  
 Contr. STAS Bogdan Duran  
 Aprobat Preda Dragos

DATA: oct. 2017

**SC. ROLIX IMPEX  
 SERIES SRL**

MATERIAL:

MASA: 189.969Kg

**PRf- 0**

**Presă peleti -sita motoare**

A3