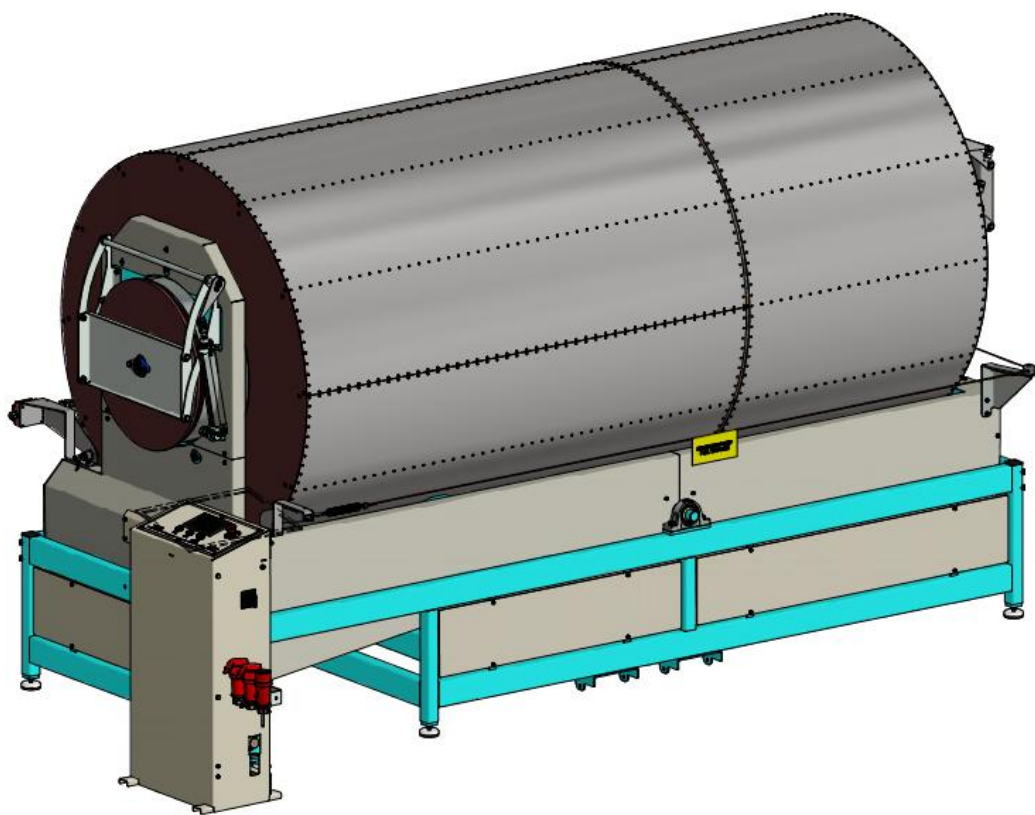




SPARE PARTS



HG self emptying XL
Bodydrum Ø150

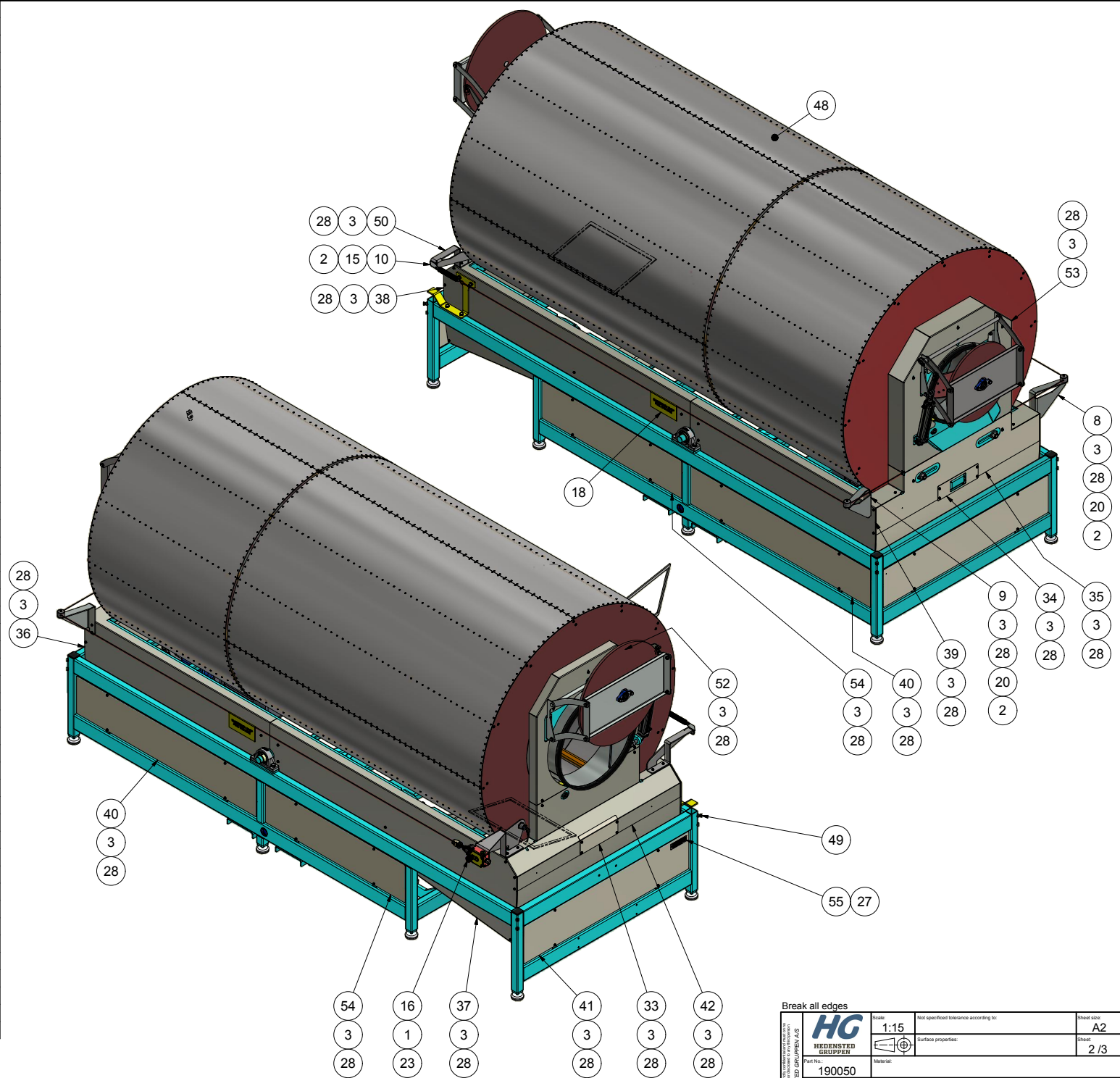
Table of contents.

1. Table of content.
2. Spare parts.
3. Electric diagrams.
4. Air diagrams.

Exploded view diagram of a two-station industrial saw machine. The diagram shows two identical saw stations positioned on a common frame. Each station includes a motor (43), a drive pulley (44), a timing pulley (46), a timing belt (45), and a saw blade (47). The frame consists of a main longitudinal beam (6) and a cross beam (4). Other components labeled include a support bracket (29), a guide pulley (56), and a base plate (49). The diagram is numbered 190050.

Break all edges		Scale:		Not specified tolerance according to:	Sheet size:
 HEDENSTEN GRUPPEN	 1:1		Surface properties:		A2
	Material:				Sheet:
	Part No.:		190050		1 / 3
Description 1: HG Self emptying XL bodydrum Ø150					
Description 2: 3x400+0+PE (Capacity 200 Males)					

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10205040	Hexagon cylinder head M5x40 FZB
2	6	10206010	Hexagon cylinder head M6x10 FZB
3	78	11406016	Hexagon bolt M6x16 FZB
4	4	11410020	Hexagon bolt M10x20 FZB
5	1	16361	Mount electric box on machine
6	1	190413	Cylinder assembly for loading
7	1	190414	Cylinder assembly f.unloading
8	1	190760	Brace 1 for wire
9	1	190765	Brace 2 for wire
10	1	190770	Brace 3 for wire
11	12,5 m	216116	Air hose Ø6mm PUR Red
12	12,5 m	216118	Air hose Ø6mm PUR Blue
13	10,0 m	216122	Air hose Ø8mm PUR Red
14	10,0 m	216124	Air hose Ø8mm PUR Blue
15	1	425933	Expansion spring Ø3,2 D23 L180
16	1	425934	Wire emergency stop 2N/C
17	1	425938	Wire connector
18	2	425942	Emergency logo for wire
19	2	430450	Axle for wire emergency stop - short
20	2	430460	Housing for wire emergency stop - short
21	2	430465	Wheel for wire emergency stop
22	7,0 m	600138	Cable CY-JZ 4x2,5mm² PVC w/screen
23	1	600455	Cabel gland M20 Ø5-12
24	4,5 m	600528	Cable OZ 4x0,75mm² PVC
25	1	600832	Cable w. elbow plug M12 4P 20M
26	1	600835	Sensor M30 inductive, w. socket m12 4p
27	2	7003208	Blind rivet Ø3.2x8 (4-5,5)
28	78	82106000	Washer M6 FZB
29	4	82110000	Washer M10 FZB
30	2	89710000	Seeger ring for shaft Ø10
31	8,5 m	M100039	Inox wire 7x7 Ø3
32	1	M102513	Stand for controls assembly, ø150 bodydrum
33	1	M102623	Cover for wheel
34	1	M102624	Cover
35	1	M102625	Rear Cover
36	1	M102629	Cover
37	1	M102630	Cover
38	1	M102631	Cover
39	1	M102632	Cover
40	2	M102633	Cover
41	2	M102644	Cover
42	1	M102649	Front Cover
43	1	M102655	Gearmotor complete f.body drum
44	1	M102656	Gable for loading lid
45	1	M102657	Gable for unloading lid
46	1	M102658	Loading Lid Complete
47	1	M102659	Unloading lid complete
48	1	M102661	Drum for Bodydrum
49	1	M102664	Frame assembly for drum
50	1	M102665	Bracket Expansion Spring
51	1	M102666	Bracket for Wire emergency stop
52	1	M102675	Cover for gable Ø 600
53	1	M102676	Upper cover for chain
54	2	M102678	Cover
55	1	M102779	Id plate for XL Body drum
56	1	M103158	Tranportation bracket
57	1	M14919	Sticker 190050
58	9	M201165	Base for cable black 25x25mm



Revision:	Approved	Date:	Revision Description
4	KKS	28-11-2018	Description changed

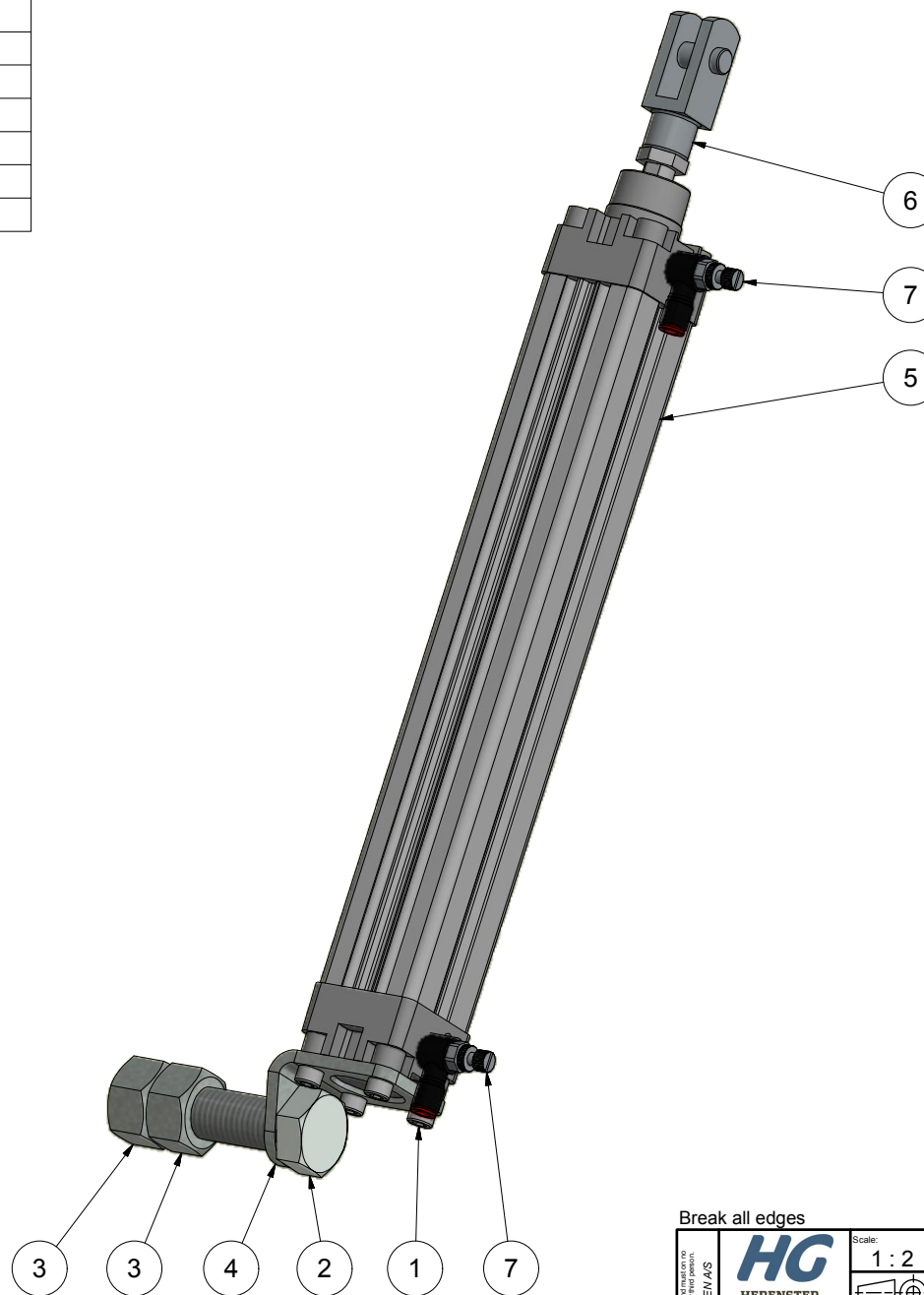
Break all edges HG HEIDENSTEDT GRUPPEN Part No. 190050	Scale: 1:15 Surface properties: 	Not specified tolerance according to: Material: Sheet size: A2 Sheet: 2 / 3
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Description 1:	HG Self emptying XL bodydrum Ø150
Description 2:	3x400+0+PE (Capacity 200 Males)

32

Revision:	Approved	Date:	Revision Description
4	KKS	28-11-2018	Description changed

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10206016	Hexagon cylinder head M6x16 FZB
2	1	11420075	Hexagon bolt M20x75 FZB
3	2	1520000	Nut M20 FZB
4	1	190710	Hinge part 10
5	1	212062	Cylinder PRA/18232/M/250
6	1	214115	F-Bracket QM/8025/25
7	2	215105	Flow banjo control Ø6 x 1/8"



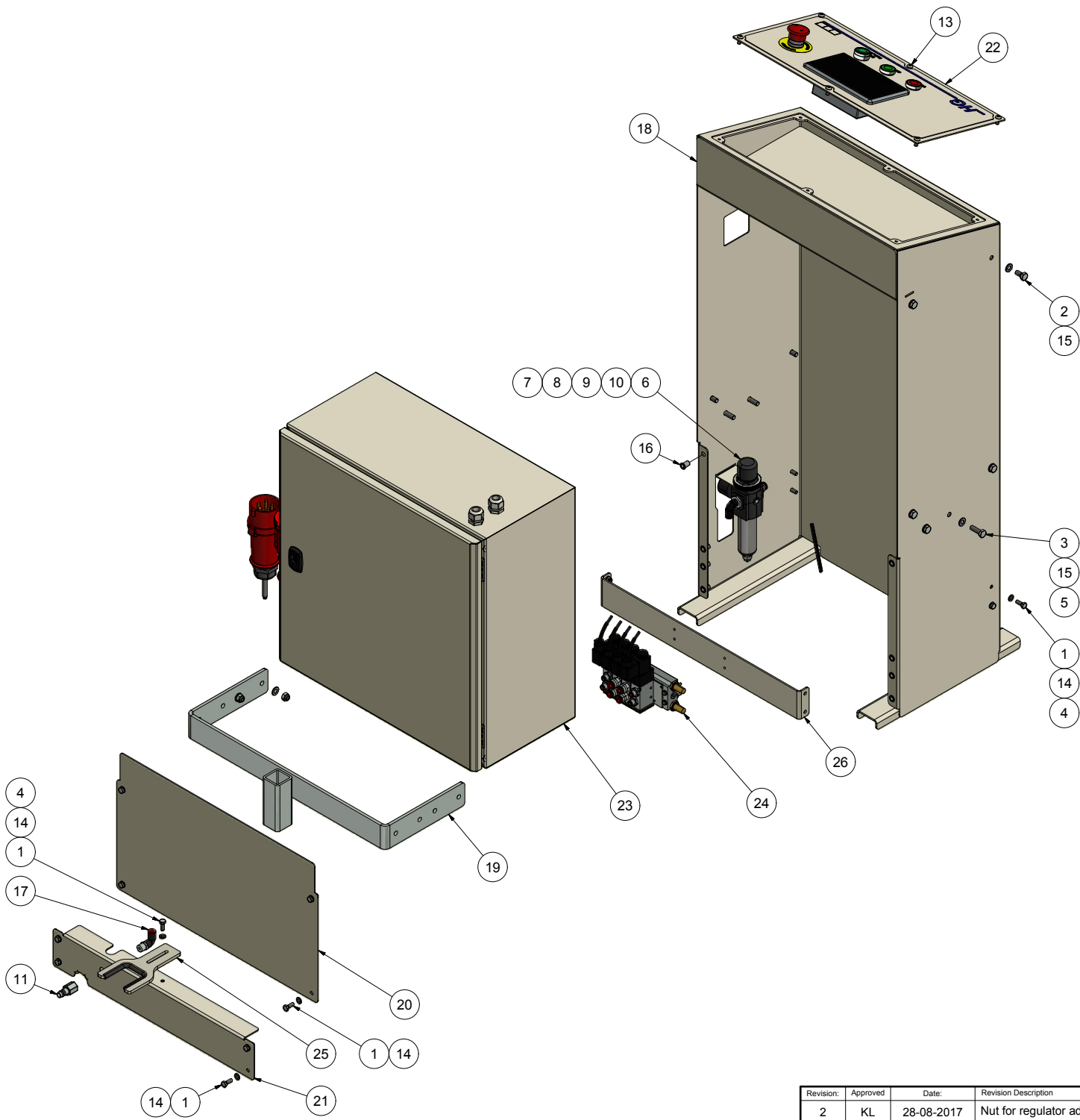
Break all edges				
This document is subject to copyright and shall not be reproduced, copied or disseminated in any form or by any means without the prior written permission of HEDENSTEDT GRUPPEN A/S		Scale:	Not specified tolerance according to:	Sheet size:
		1 : 2	DS/ISO 2768-m	A3
			Surface properties:	Sheet:
				1 / 1
	Part No.:	Material:		
190413				
Description 1:				
Cylinder assembly for loading				
Description 2:				
lid				

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10206016	Hexagon cylinder head M6x16 FZB
2	1	212063	Cylinder PRA/182032/M/200
3	1	214115	F-Bracket QM/8025/25
4	1	214156	D-Bracket QA/8032/23
5	2	215105	Flow banjo control Ø6 x 1/8"

Revision:	Approved	Date:	Revision Description
1	MBO	25-04-2017	Valve changed

Break all edges

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			Surface properties:		Sheet:	1 / 1	
	Part No.:	190414					
	Material:						
	Description 1:						
Cylinder assembly f.unloading							
Description 2:							
lid							



PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	13	11406016	Hexagon bolt M6x16 FZB
2	8	11408016	Hexagon bolt M8x16 FZB
3	4	11408025	Hexagon bolt M8x25 FZB
4	5	17906000	Self-locking nut M6 FZB
5	12	17908000	Self-locking nut M8 FZB
6	1	210178	Regulator with filter 1/4" 0,3-10 bar (AutoDrain)
7	1	215530	Nut, panel mount 4248-01
8	1	215550	Gauge 0-10 bar 1/8" Ø40
9	1	215934	Straight connector Ø8 x 1/4"
10	1	216537	Elbow swivel Ø8 x 1/4"
11	1	217040	Quick release coupling Plug 1/4" female
12	0,2 m	423431	Edge protection strip
13	6	76006012	Buttonhead bolt M6x12 FZB
14	18	82106000	Washer M6 FZB
15	24	82108000	Washer M8 FZB
16	8	9306014	Blindnut rivet M6x14,5 (0,5-2,3)
17	1	M101466	Elbow swivel Ø8 x 1/4"t
18	1	M102515	Stand for controls, ø150 bodydrum
19	1	M102516	Transport bracket for stand
20	1	M102517	Top coverplate for stand
21	1	M102518	Bottom coverplate for stand
22	1	M102521	Control board ø150cm bodydrum
23	1	M102522	Electric box for ø150 bodydrum
24	1	M102636	Valve Assembly
25	1	M102637	Fork
26	1	M102640	Plate for Air Components

Revision: 2
Approved: KL
Date: 28-08-2017
Revision Description: Nut for regulator added

Break all edges

HEIDENSTEDT GRUPPEN A/S

HG

HEIDENSTEDT GRUPPEN

Part No: M102513

Description 1: Stand for controls assembly, ø150 bodydrum

Description 2: Model 2017

Scale: 1 : 5

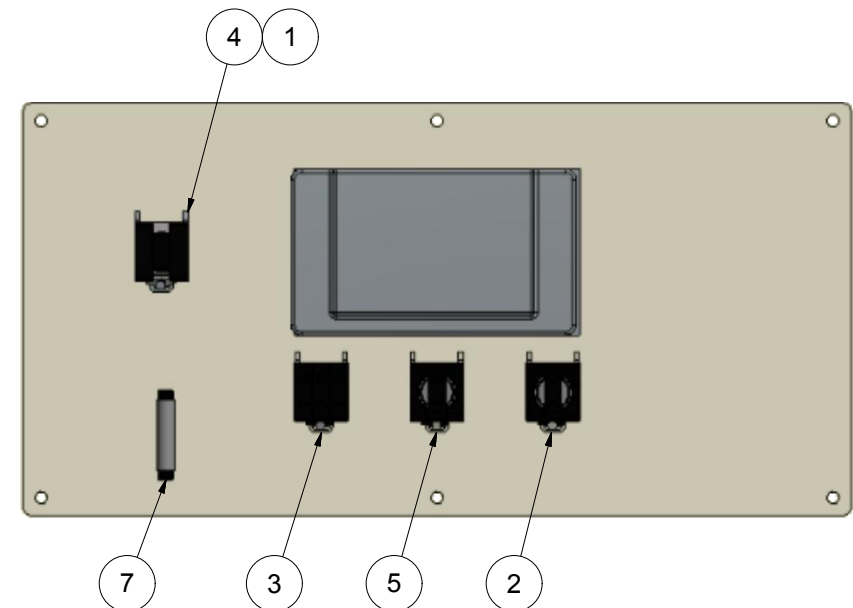
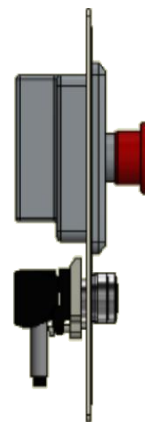
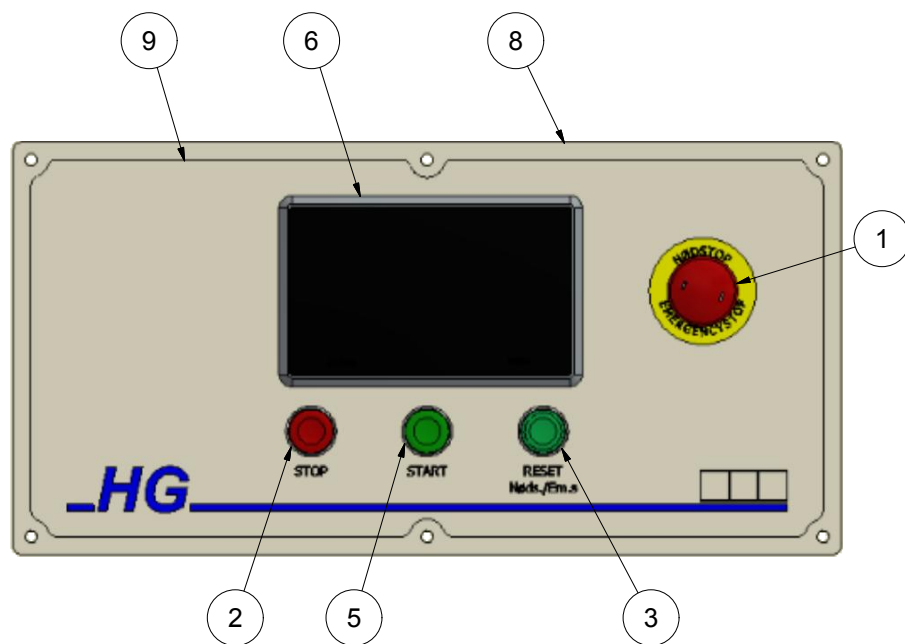
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Material:

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Sheet: 1 / 1

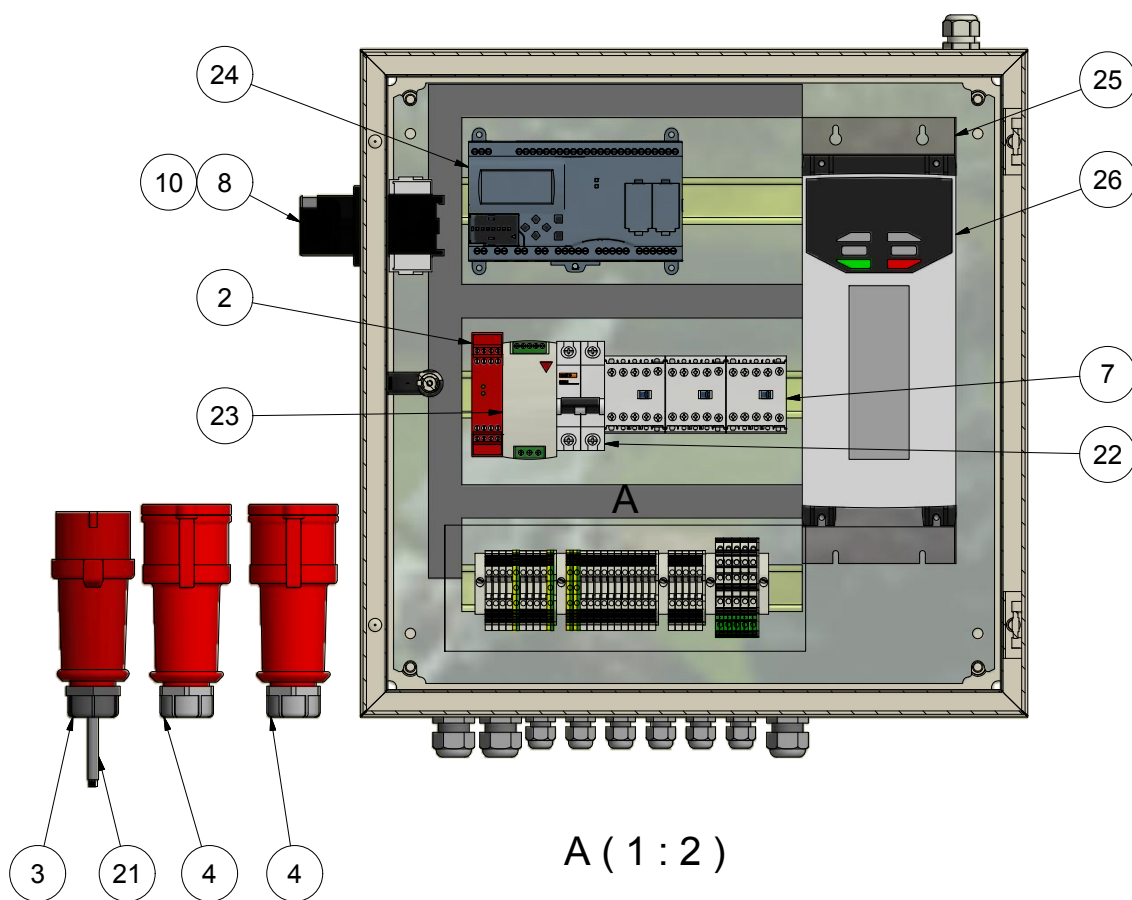
PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	600100	Push button Emergency stop
2	1	600345	Push button red 1NC XB4BA42
3	1	600350	Push button green/light 1NO+1NC XB4BW33B5
4	1	600375	Switch block ZB4BZ104 2NC
5	1	600788	Push button green 1NO XB4BA31
6	1	600924	Panel, touch 5" X2 Base 5 - F2
7	1,2 m	601005	Cable JZ 12x0,75mm² PVC
8	1	M102514	Plate for controlboard ø150 bodydrum
9	1	M102519	Label for ø150 bodydrum model 2017



Revision:	Approved	Date:	Revision Description
1	MBO	28-04-2017	Made

Break all edges

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	HEDENSTEDT GRUPPEN			Surface properties: No	Sheet: 1 / 1
	Part No.: M102521		Material:		
	Description 1: Control board ø150cm bodydrum				
Description 2: Model 2017					

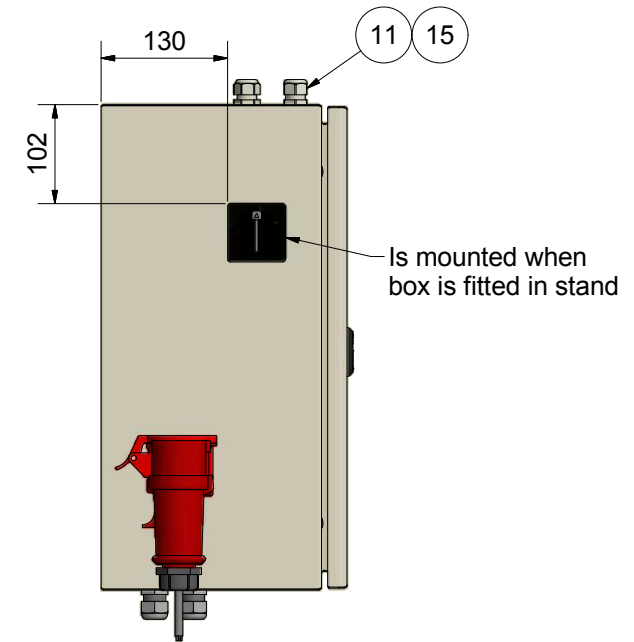
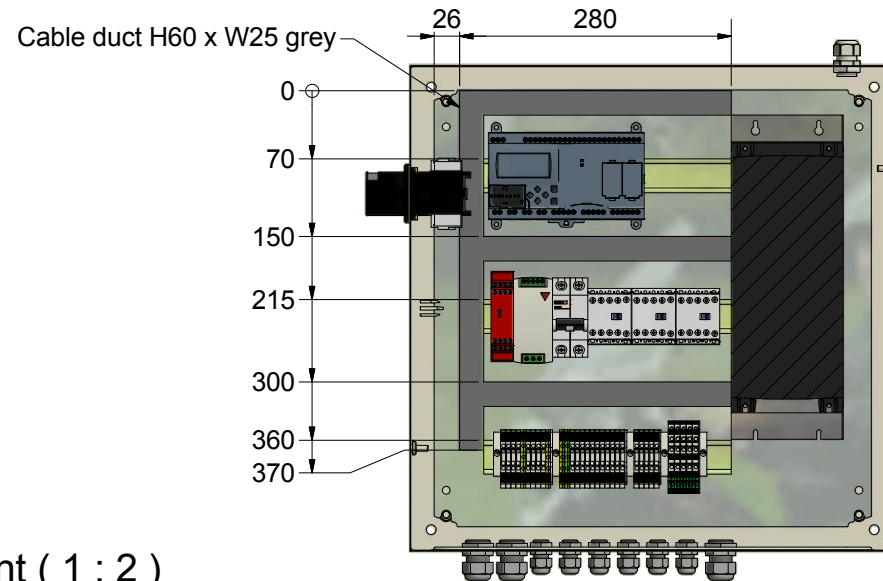
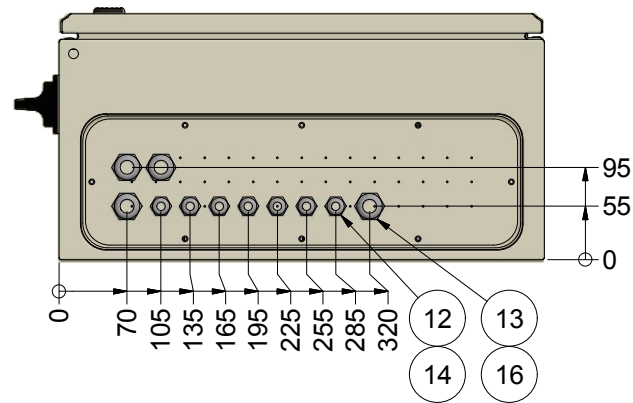


PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	16360	Electric mounting ø150cm drum
2	1	206731	Safety controller 24VAC/DC Cat3
3	1	50171	CEE Plug male 5P/16A/400V Phase inverter
4	2	50175	CEE Plug female 5P/16A/400V
5	5	600105	Terminal block DLD 2,5 PE
6	1	600114	End plate AP-DLD 2,5/PE
7	3	600282	Contacteur LP1K0901B 9A 3NO-1NC
8	1	600358	Main switch VBF-01 20A 3P Black
9	1	600359	Main switch zero terminal VZ-11
10	1	600369	Main switch ground terminall VZ-14
11	2	600455	Cabel gland M20 Ø5-12
12	7	600460	Cable gland M16 Ø2,5-8
13	4	600465	Cable gland M25 Ø7-14
14	7	600470	Cable gland nut polyamid M16
15	2	600475	Cable gland nut polyamid M20
16	4	600480	Cable gland nut polyamid M25
17	24	600550	Terminal block WDU_2,5
18	3	600555	End plate WAP 2,5-10
19	4	600585	Terminal block WPE 2,5
20	5	600590	End bracket EW 35
21	12,0 m	600640	Cable JZ 5x2,5mm² PVC
22	1	601095	Automatic fuse 10A C 1P+N
23	1	601275	Power supply 1P 24V 2,5A
24	1	M102121	PLC Idec SmartAxis - FT1A-B40RSA
25	1	M102511	Low Leak filter for M200-04
26	1	M102512	Freq. inverter 5.5kW 3x400V Emerson
27	1	M102626	Box metal 500x500x250

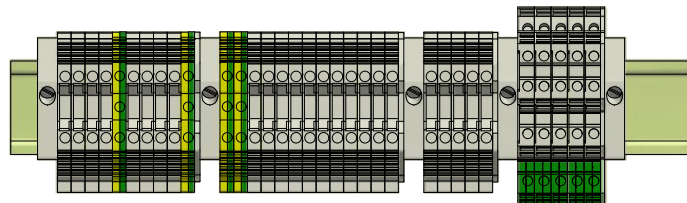
Break all edges

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	Part No.:	M102522	Material:	No	Sheet:	1/2
	Description 1:	Electric box for ø150 bodydrum				
	Description 2:	Model 2017				

Revision:	Approved	Date:	Revision Description
2	KL	23-08-2017	Contacts for conveyor added



Terminal assignment (1 : 2)



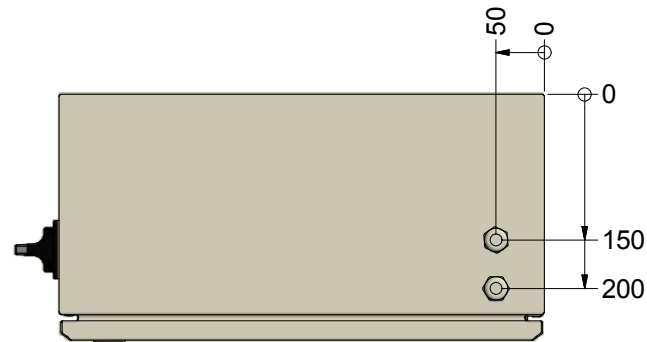
1U1, 1V1,
1W1, 1N1,
PE.

PE, PE, 1, 2, 3, 4,
5, 6, 7, 8, 9, 10, 11

I2, I3,
I4, +, -

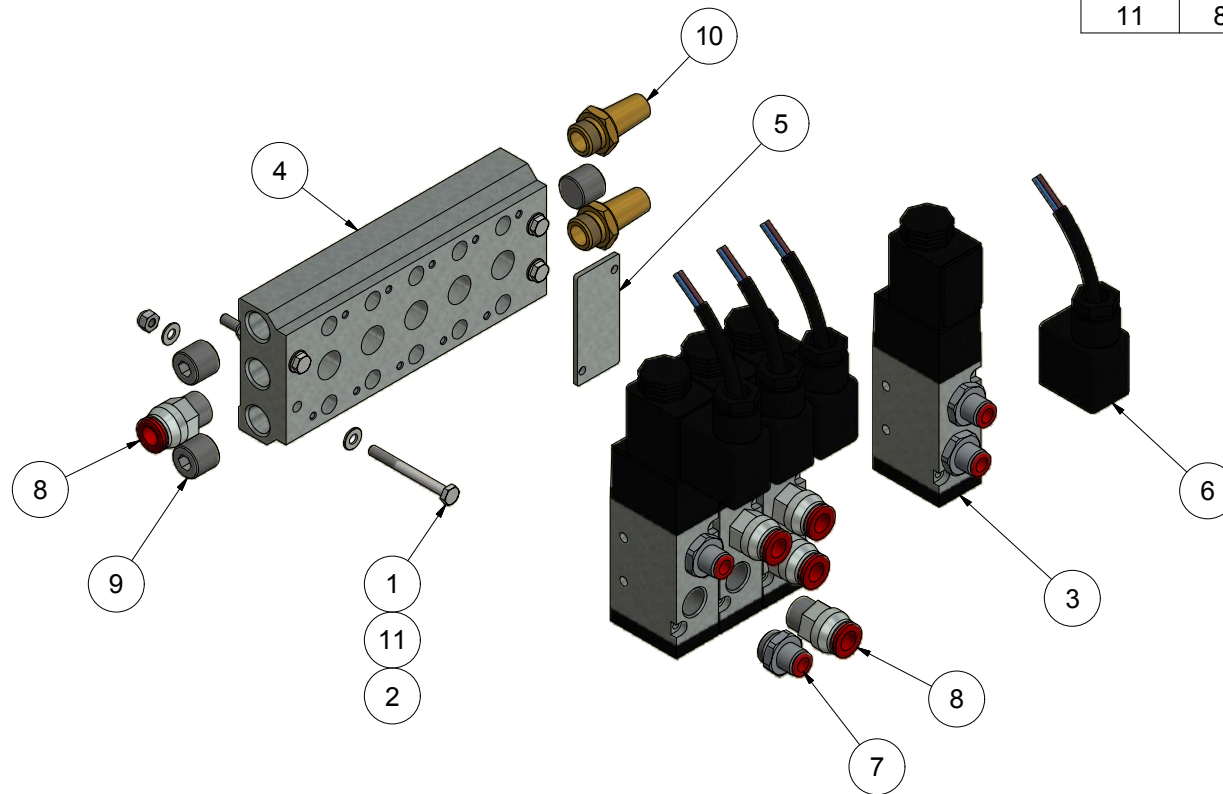
Q0, Q1, Q2,
Q3, Q4

2U1, 2V1,
2W1, 2N1,
PE.



Revision:	Approved	Date:	Revision Description
2	KL	23-08-2017	Contacts for conveyor added

Break all edges			
 HEDENSTED GRUPPEN A/S The information is only a reference and does not constitute a contract. The user is responsible for the correct use of the product.	Scale:	Not specified tolerance according to:	Sheet size:
	1:4	DS/ISO 2768-m	A3
	Material:	Surface properties:	Sheet:
	M102522	No	2 / 2
Description 1:			
Electric box for ø150 bodydrum			
Description 2:			
Model 2017			



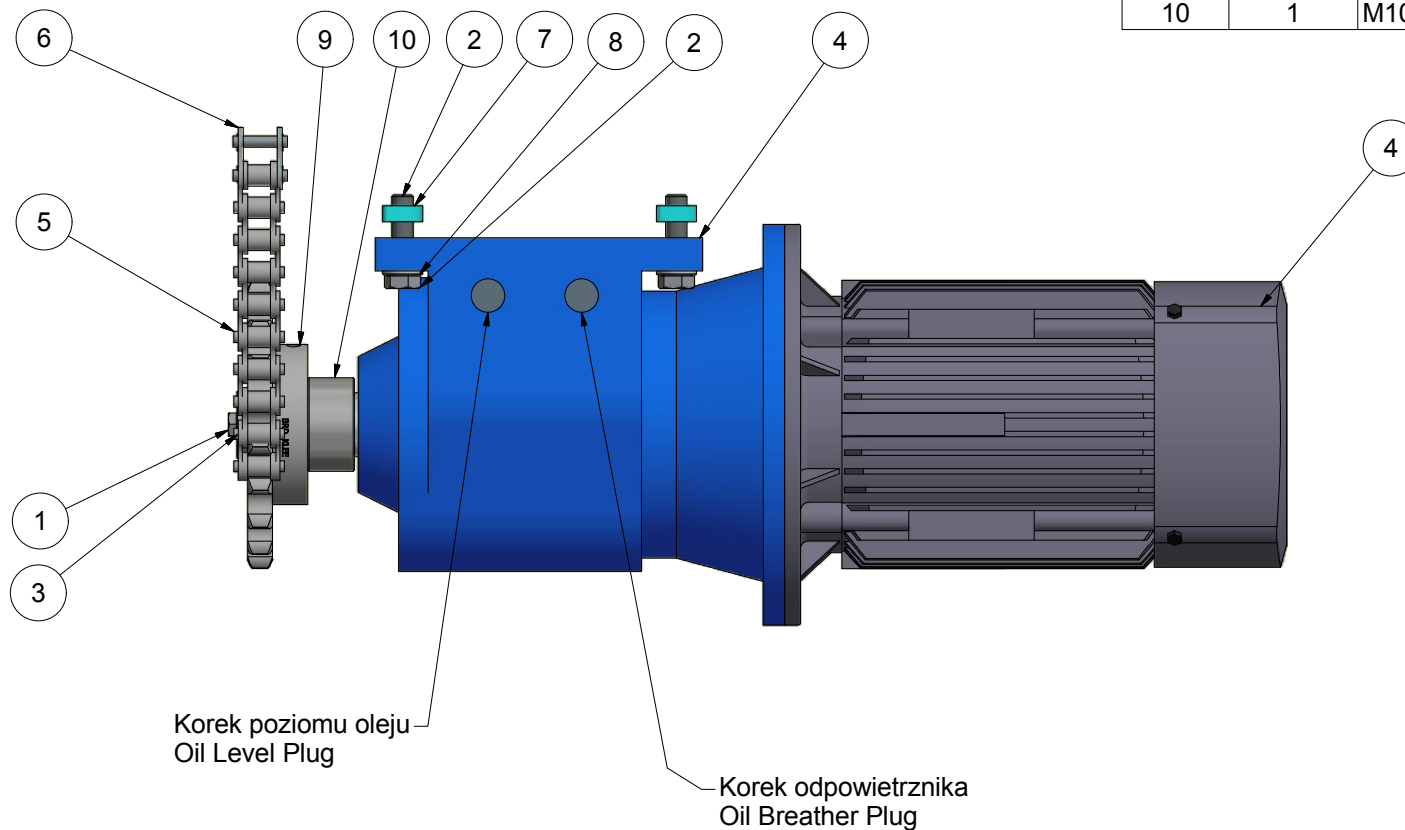
PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	11104040	Hexagon bolt M4x40 FZB
2	4	17904000	Self-locking nut M4 FZB
3	4	195396	Valve 5/2 1/4" 24VDC/Spring
4	1	195397	Manifold V51 for 5x5/2 valves
5	1	195399	Blanking plate for V51 manifold
6	4	215185	Cable w. elbow plug 22mm 3P 1M 250v
7	4	215930	Straight connector Ø6 x 1/4"
8	5	215934	Straight connector Ø8 x 1/4"
9	3	216743	Plug 1/4" inside hex
10	2	216797	Filter sintered 1/4"
11	8	82104000	Washer M4 FZB

Break all edges

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			Surface properties:	Sheet:
	Part No:		No	1 / 1
	M102636		Material:	
	Description 1:			
	Valve Assembly			
	Description 2:			

Revision:	Approved	Date:	Revision Description
1	MBO	28-04-2017	Made

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	11410025	Hexagon bolt M10x25 FZB
2	4	11416060	Hexagon bolt M16x60 FZB
3	1	190517	Washer for gear </td
4	1	190530	Gearmotor for body drum Ø150cm EU
5	3,7 m	190580	Roller chain 16B1 1"
6	1	190582	Chain connection link 16B
7	2	190595	Sheet part 18
8	4	82116000	Washer M16 FZB
9	1	M102592	Sprocket 16B1 1" Z20 Ø40H7 with key
10	1	M102845	Bushing for sprocket



Sprawdzić czy są zamontowane wszystkie korki oraz czy z dobrej strony

Check is all plugs are mounted and are mounted from correct side
Break all edges

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	Part No.:	M102655	Material:		Sheet:	1 / 1
	Description 1:	Gearmotor complete f.body drum				
	Description 2:					

Revision:	Approved	Date:	Revision Description
2	KKS	24-08-2017	Bushing and sprocket updated

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	16075	Motor IEC 132 B5 5,5kw 1500 O
2	1	16070	Gear AMP 80/2 Ø40 1:19,4

Product data/Specyfikacja:

Gear/przekładnia: STM - AMP 80 / 2

Ratio/przełożenie: 1/19,4

Flange/flansza: IEC 132 B5

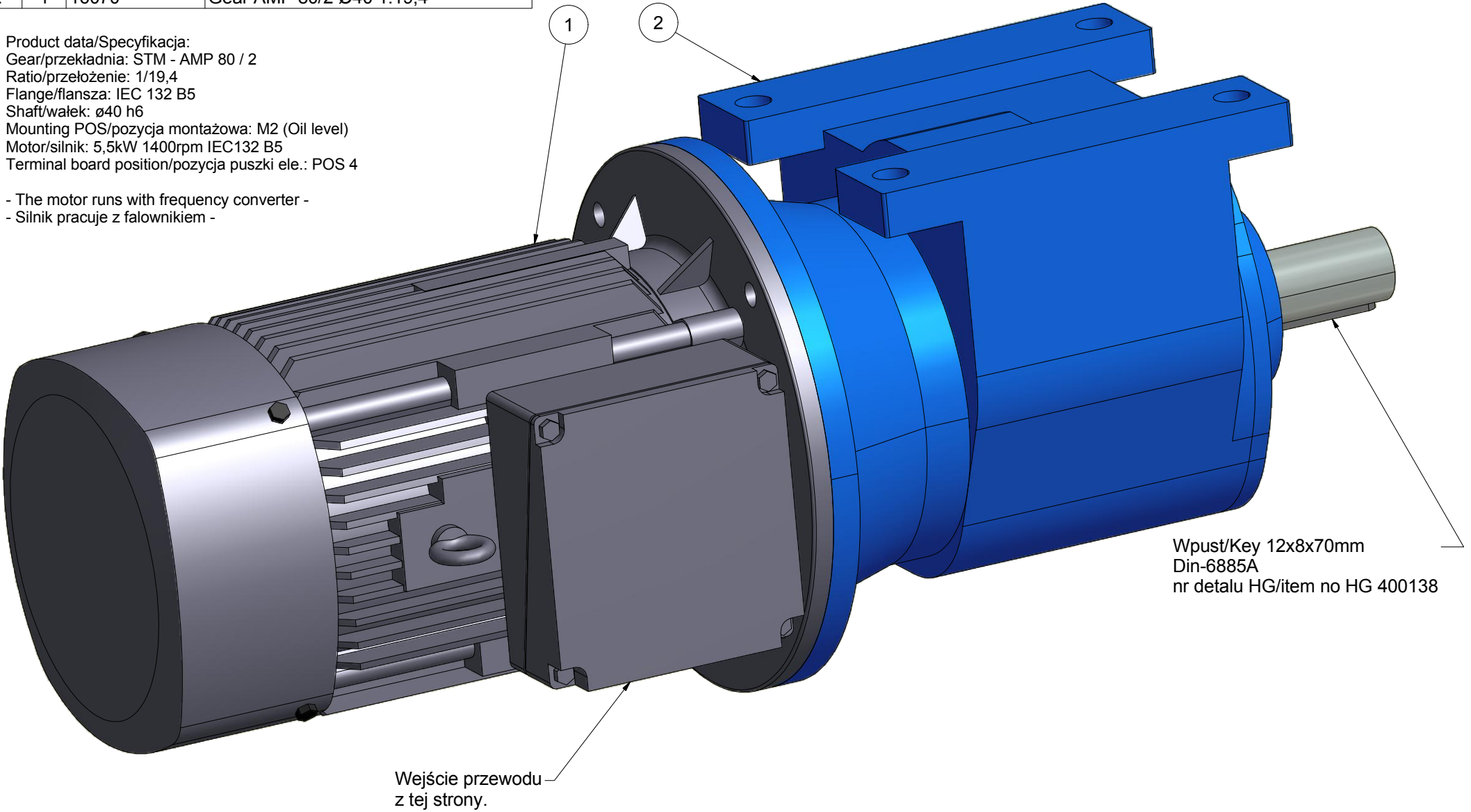
Shaft/walek: $\varnothing 40$ h6

Mounting POS/pozycja montażowa: M2 (Oil level)

Motor/silnik: 5,5kW 1400rpm IEC132 B5

Terminal board position/pozycja puszeki ele.: POS 4

- The motor runs with frequency converter -
- Silnik pracuje z falownikiem -



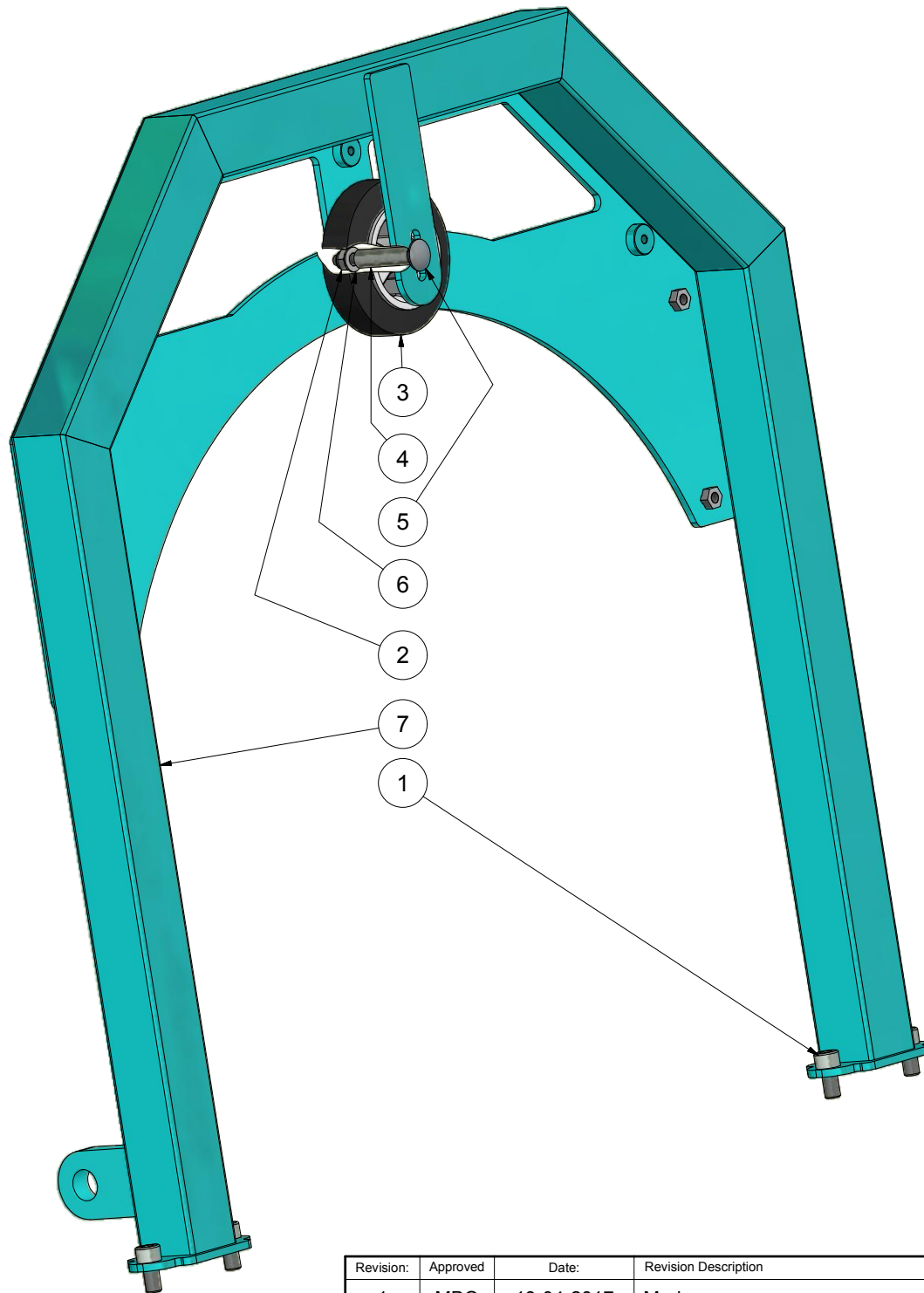
Wejście przewodu z tej strony.

Cabel inlet
on this side.

Revision:	Approved	Date:	Revision Description
1	HG	28-09-2015	Revision changed to numeric

Break all edges

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			Surface properties:	Sheet: 1 / 1
	Part No.: 190530	Material:		
	Description 1: Gearmotor for body drum Ø150cm EU			
	Description 2: 5.5kW 1500rpm 1:19,4 3x400V			

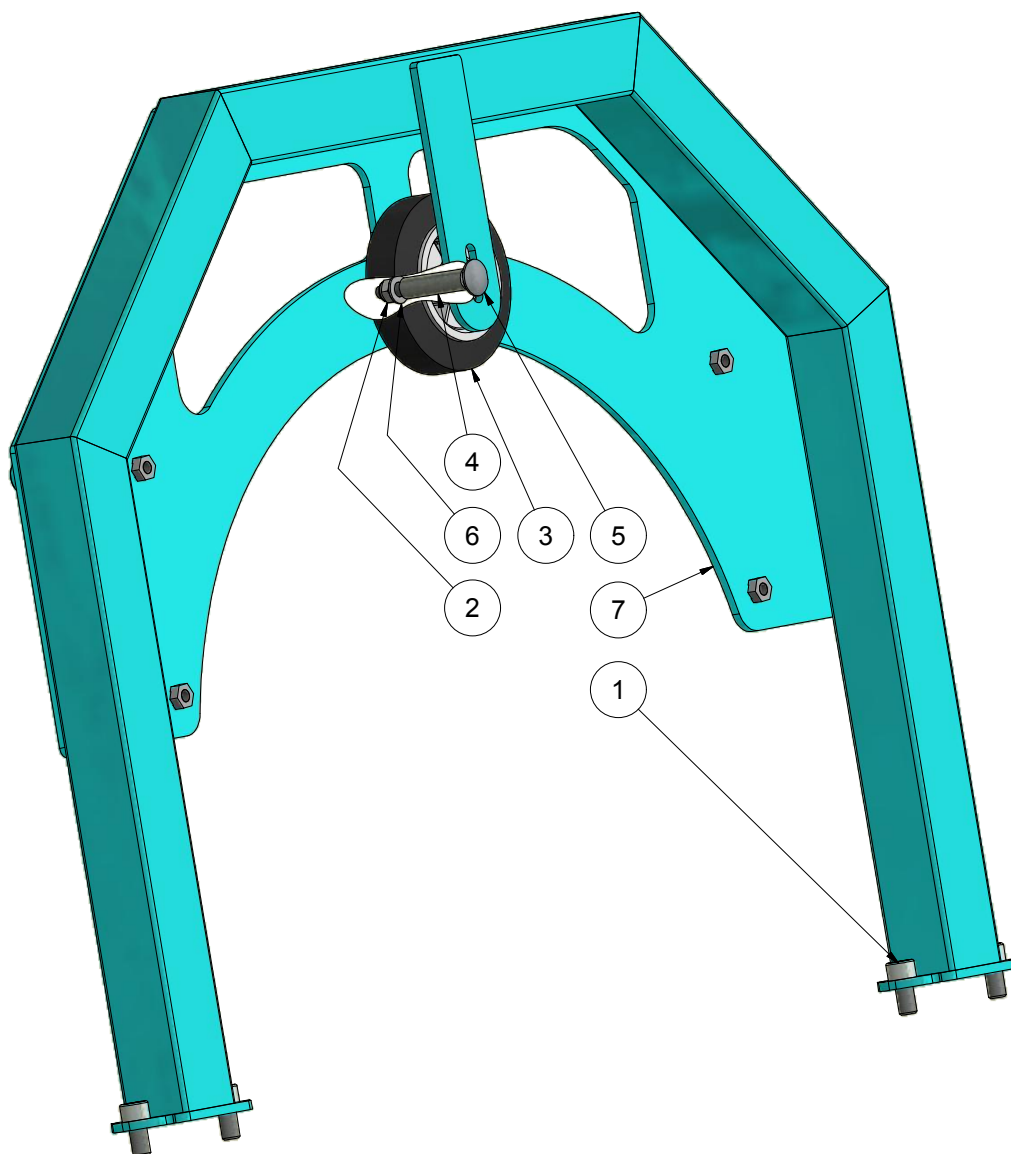


Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10210020	Hexagon cylinder head M10x20 FZB
2	1	17908000	Self-locking nut M8 FZB
3	1	19003	Wheel Ø100xØ12x39,5
4	1	190775	Bushing for wheel
5	1	64408070	Cup head square neck bolt M8x70 FZB
6	1	82108000	Washer M8 FZB
7	1	M102651	Gable for Ø600

Break all edges

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		1 : 3	DS/ISO 2768-m	A3
		Surface properties:		Sheet:
				1 / 1
	Part No.:	Material:		
M102656				
Description 1:				
Gable for loading lid				
Description 2:				

Revision:	Approved	Date:	Revision Description
1	MBO	18-04-2017	Made

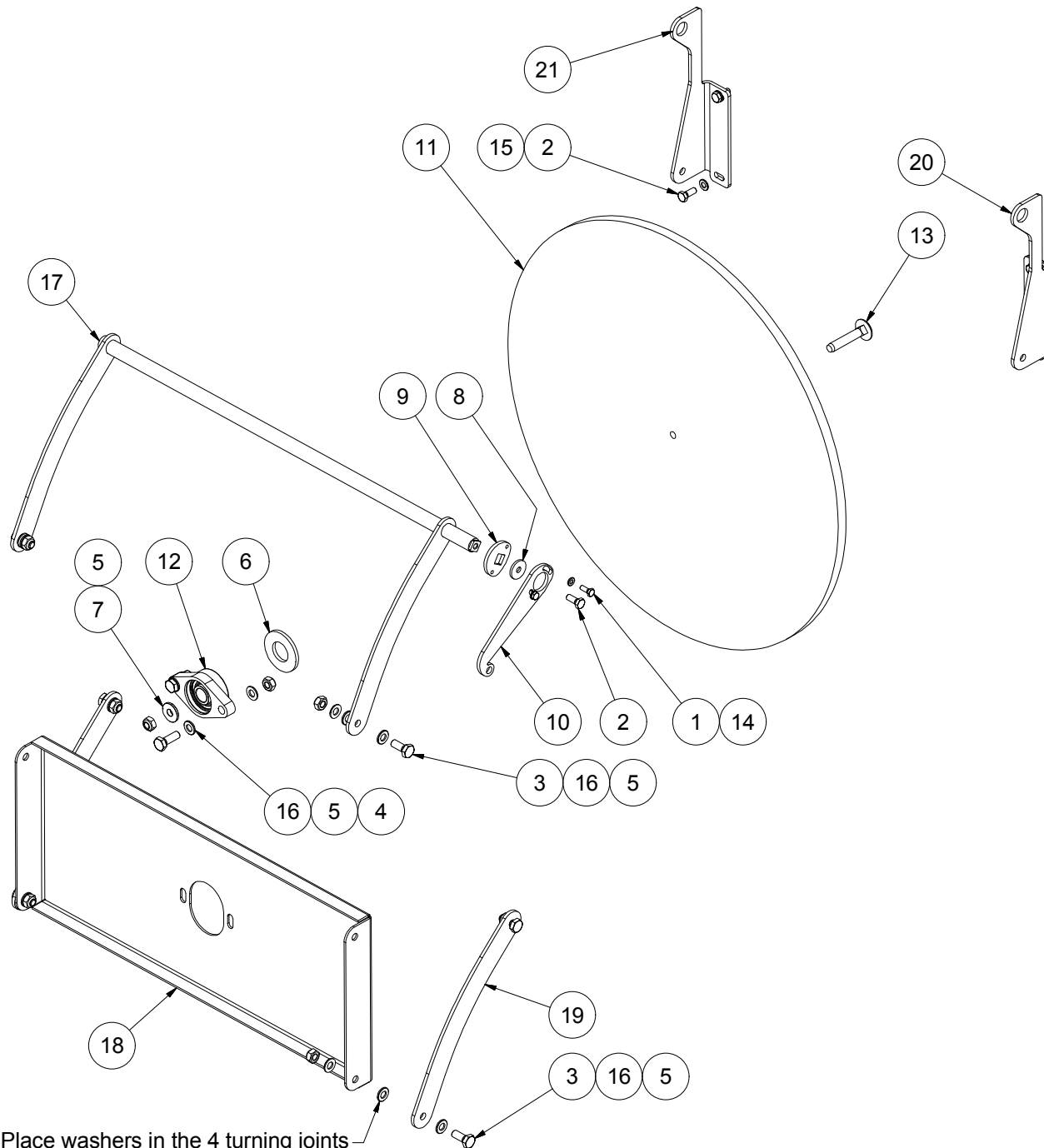


Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10210020	Hexagon cylinder head M10x20 FZB
2	1	17908000	Self-locking nut M8 FZB
3	1	19003	Wheel Ø100xØ12x39,5
4	1	190775	Bushing for wheel
5	1	64408070	Cup head square neck bolt M8x70 FZB
6	1	82108000	Washer M8 FZB
7	1	M102652	Gable for Ø457

Break all edges

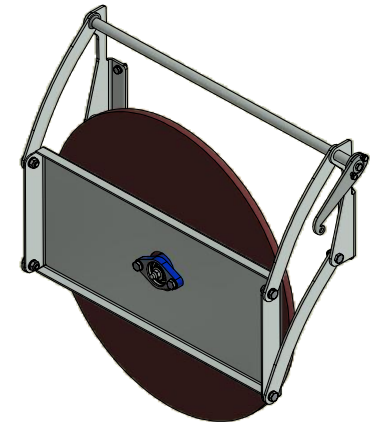
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			Surface properties:	Sheet:			
	Part No.:		M102657				
	Material:						
	Description 1:						
Gable for unloading lid							
Description 2:							

Revision:	Approved	Date:	Revision Description
1	MBO	18-04-2017	Made



Place washers in the 4 turning joints between M102671, M102672 and M102648

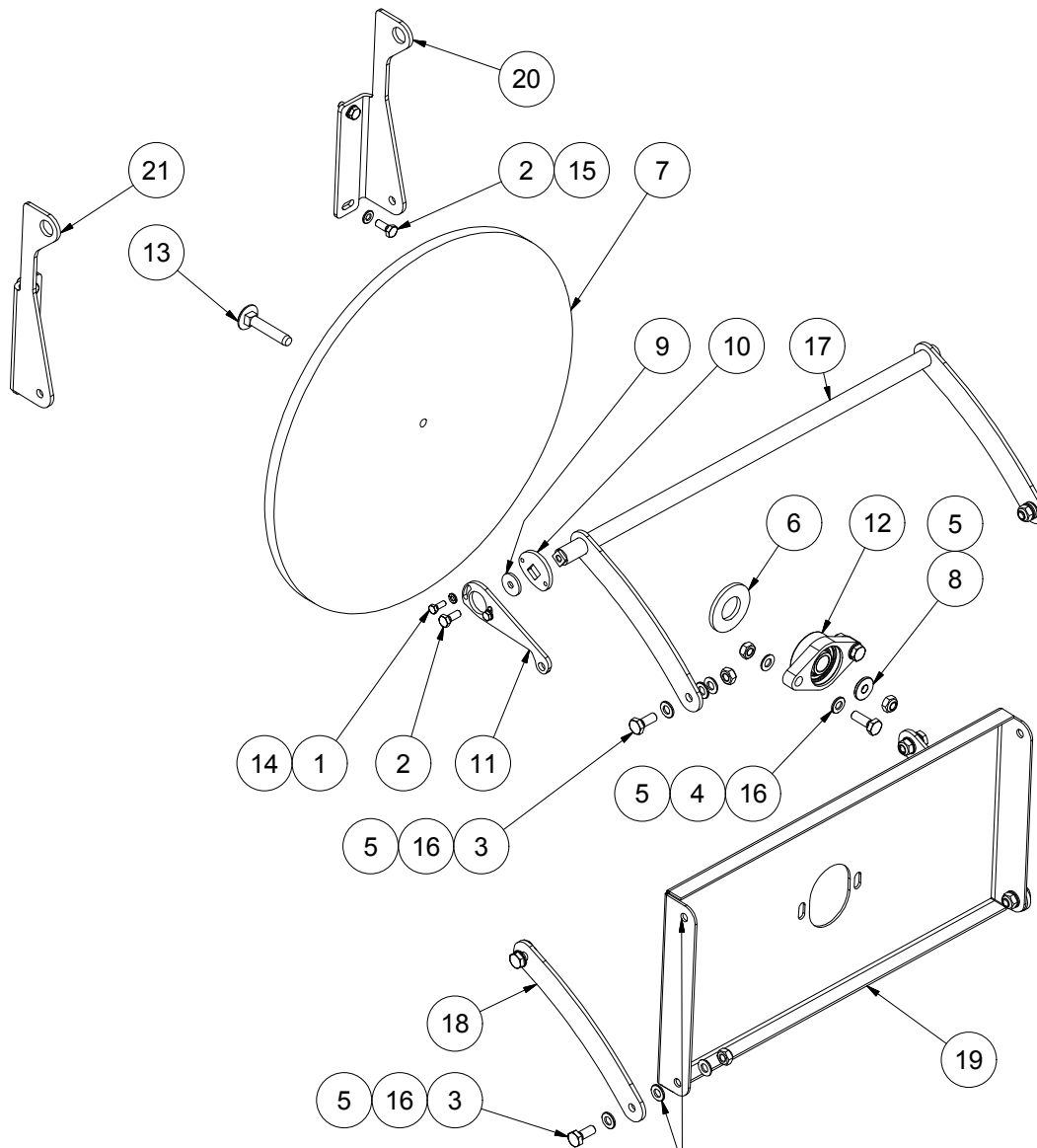
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11406016	Hexagon bolt M6x16 FZB
2	5	11408020	Hexagon bolt M8x20 FZB
3	6	11410025	Hexagon bolt M10x25 FZB
4	2	11410030	Hexagon bolt M10x30 FZB
5	9	17910000	Self-locking nut M10 FZB
6	1	190535	Spacer for door
7	1	190640	Washer for door
8	1	190695	Hinge part 6
9	1	190700	Hinge part 8
10	1	190705	Hinge part 9
11	1	190740	Door for Body drum
12	1	473101	Y-bearing oval Ø20
13	1	64410065	Cup head square neck bolt M10x65 FZB
14	2	82106000	Washer M6 FZB
15	4	82108000	Washer M8 FZB
16	19	82110000	Washer M10 FZB
17	1	M102648	Hinge assembly 1
18	1	M102671	Hinge part 1
19	2	M102672	Hinge part 5
20	1	M102673	Hinge part 3
21	1	M102674	Hinge part 2



Break all edges

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		1 : 6	DS/ISO 2768-m	A3
			Surface properties:	Sheet:
				1 / 1
	Part No.: M102658		Material:	
	Description 1: Loading Lid Complete			
	Description 2:			

Revision:	Approved	Date:	Revision Description
3	KKS	17-12-2018	Washers added to lid hinge



Add washers in the 4 joints between M102670, M102669 and M102647.

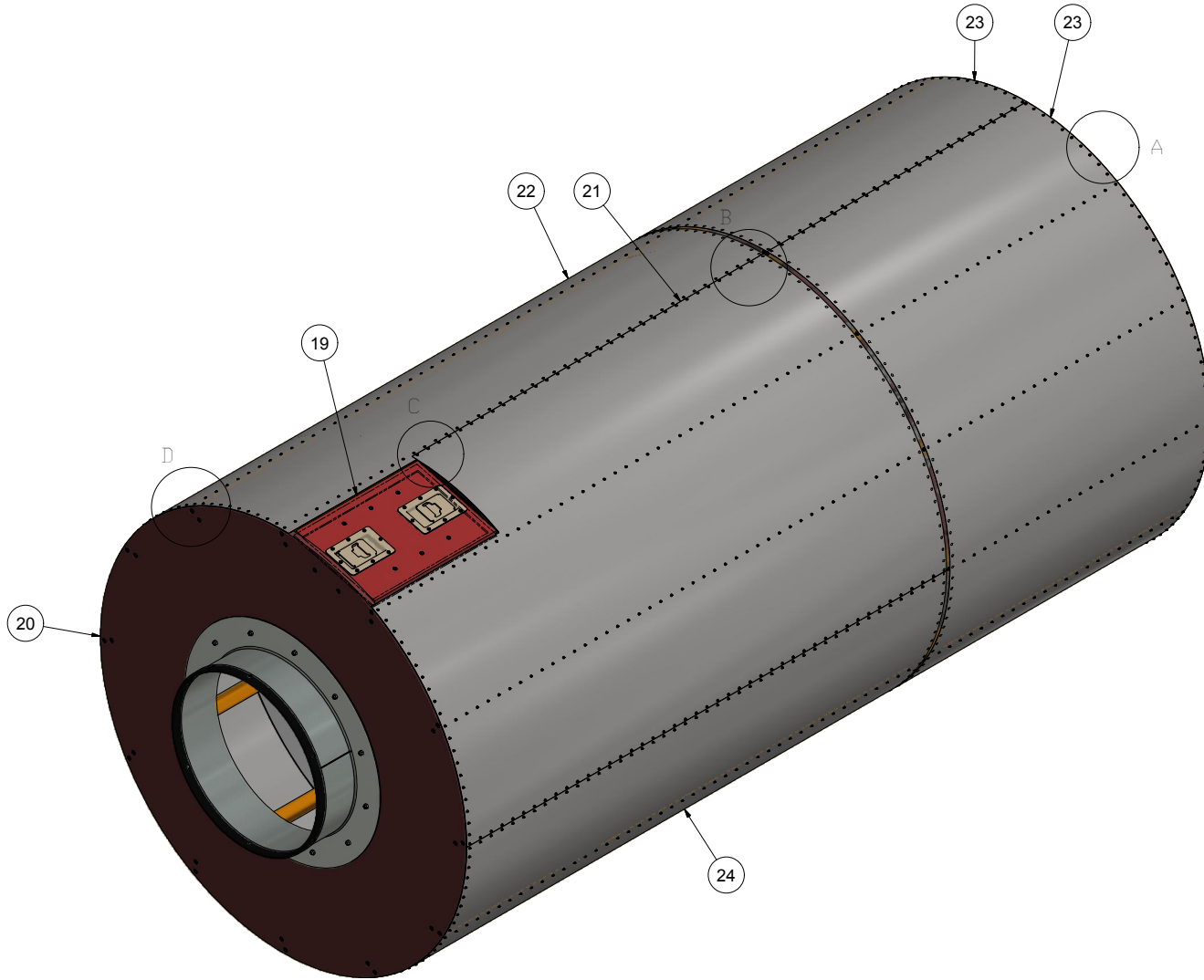
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11406016	Hexagon bolt M6x16 FZB
2	5	11408020	Hexagon bolt M8x20 FZB
3	6	11410025	Hexagon bolt M10x25 FZB
4	2	11410030	Hexagon bolt M10x30 FZB
5	9	17910000	Self-locking nut M10 FZB
6	1	190535	Spacer for door
7	1	190555	Door for body drum
8	1	190640	Washer for door
9	1	190695	Hinge part 6
10	1	190700	Hinge part 8
11	1	190735	Hinge part 15
12	1	473101	Y-bearing oval Ø20
13	1	64410065	Cup head square neck bolt M10x65 FZB
14	2	82106000	Washer M6 FZB
15	4	82108000	Washer M8 FZB
16	20	82110000	Washer M10 FZB
17	1	M102647	Hinge assembly 2
18	2	M102669	Hinge part 14
19	1	M102670	Hinge part 11
20	1	M102673	Hinge part 3
21	1	M102674	Hinge part 2



Break all edges

The document is a safety, confidential and must not be account to copied or disclosed to any third person. HEDENSTED GRUPPEN AS	 HEDENSTED GRUPPEN	Scale:	1:6	Not specified tolerance according to:	DS/ISO 2768-m	Sheet size:	A3	
			Surface properties:				Sheet:	1/1
		Part No.:	M102659					
		Material:						
	Description 1:							
	Unloading lid complete							
Description 2:								

Revision:	Approved	Date:	Revision Description
3	KKS	17-12-2018	Washers added to hinge



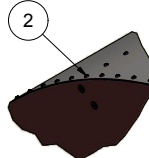
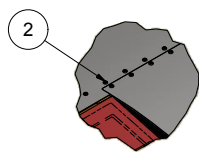
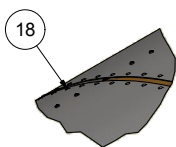
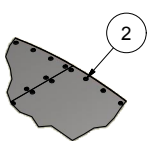
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	11406016	Hexagon bolt M6x16 FZB
2	1242	140854	Wood screw pan head 3,5 x 20
3	4	190455	Guide for cone
4	4	190460	Guide for drum
5	4	190462	Battern for guide
6	4	190480	Joint 1 for guide
7	4	190485	Joint 2 for guide
8	4	190490	Joint 3 for guide
9	4	190495	Joint 4 for guide
10	4	190500	Joint 5 for guide
11	1	190505	Joint 6 for guide
12	12	190510	Tension plate for Joint
13	48	190771	Bolt battenhead large head
14	105	190772	Bolt battenhead large head
15	105	19206000	Drive in nut M6 FZB
16	20	2704040	Wood screw countersunk head 4 x 40
17	60	64485025	Wood screw pan head 4,5 x 35
18	246	7003208	Blind rivet Ø3.2x8 (4-5,5)
19	1	M102660	Hatch complete
20	1	M102663	Drum assembly 1
21	1	M102679	Cover 1 long XL drum
22	1	M102680	Cover 2 long, XL drum
23	2	M102681	Cover for grating cone
24	2	M102787	Cover 3 long, XL drum

A < 1 : 6 >

B < 1 : 6 >

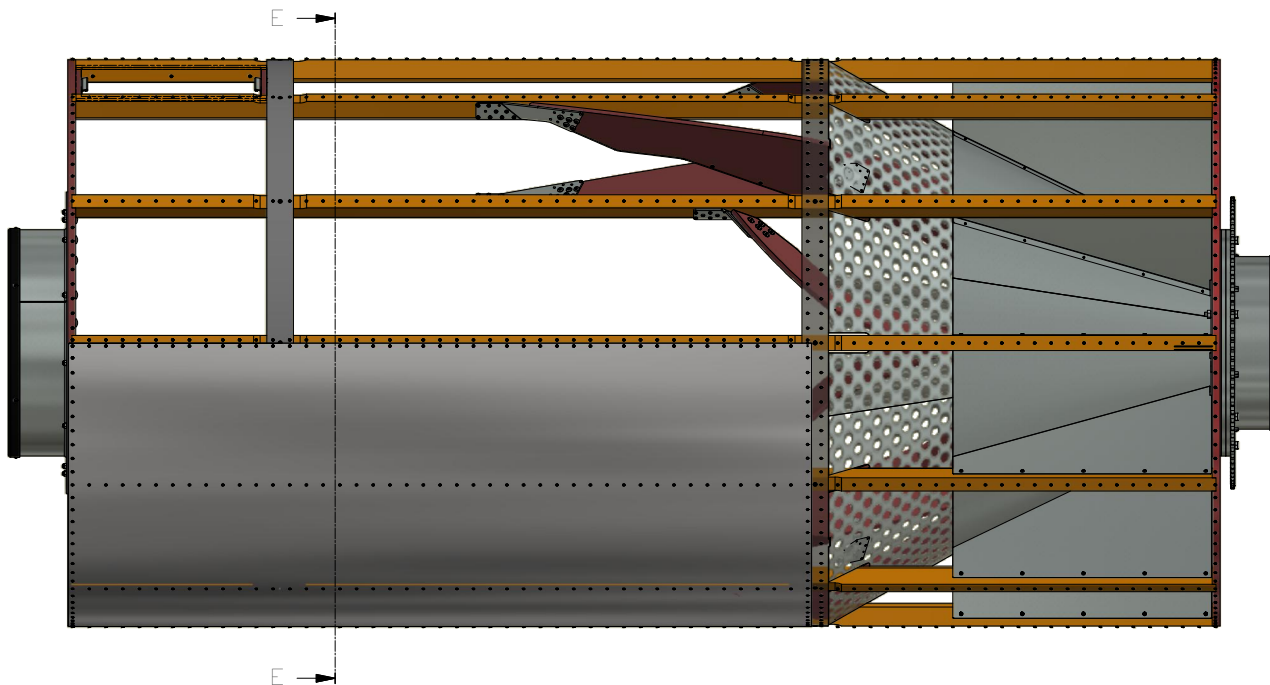
C < 1 : 6 >

D < 1 : 6 >



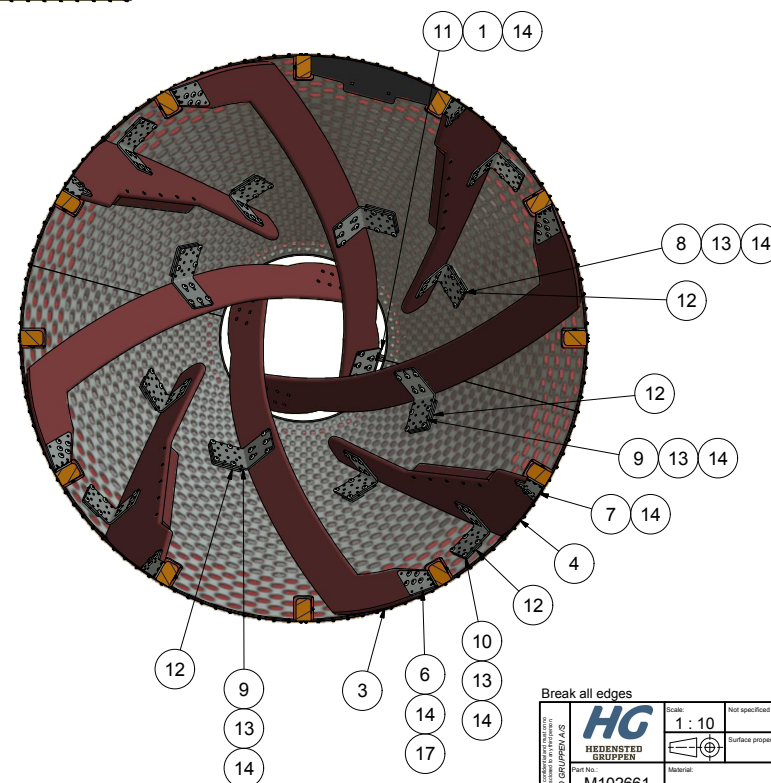
Revision:	Approved	Date:	Revision Description
2	KL	30-06-2017	Covers changed

Break all edges		Scale: 1 : 10	Not specified tolerance according to: DS/ISO 2768-m	Sheet size: A2
HEDENSTED GRUPPEN A/S		Surface properties:	Material:	Sheet: 1 / 3
Part No: M102661		Description 1: Drum for Bodydrum		
		Description 2:		



E-E < 1 : 10 >

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	11406016	Hexagon bolt M6x16 FZB
2	1242	140854	Wood screw pan head 3,5 x 20
3	4	190455	Guide for cone
4	4	190460	Guide for drum
5	4	190462	Battern for guide
6	4	190480	Joint 1 for guide
7	4	190485	Joint 2 for guide
8	4	190490	Joint 3 for guide
9	4	190495	Joint 4 for guide
10	4	190500	Joint 5 for guide
11	1	190505	Joint 6 for guide
12	12	190510	Tension plate for Joint
13	48	190771	Bolt battenhead large head
14	105	190772	Bolt battenhead large head
15	105	19206000	Drive in nut M6 FZB
16	20	2704040	Wood screw countersunk head 4 x 40
17	60	64485025	Wood screw pan head 4,5 x 35
18	246	7003208	Blind rivet Ø3.2x8 (4-5,5)
19	1	M102660	Hatch complete
20	1	M102663	Drum assembly 1
21	1	M102679	Cover 1 long XL drum
22	1	M102680	Cover 2 long, XL drum
23	2	M102681	Cover for grating cone
24	2	M102787	Cover 3 long, XL drum



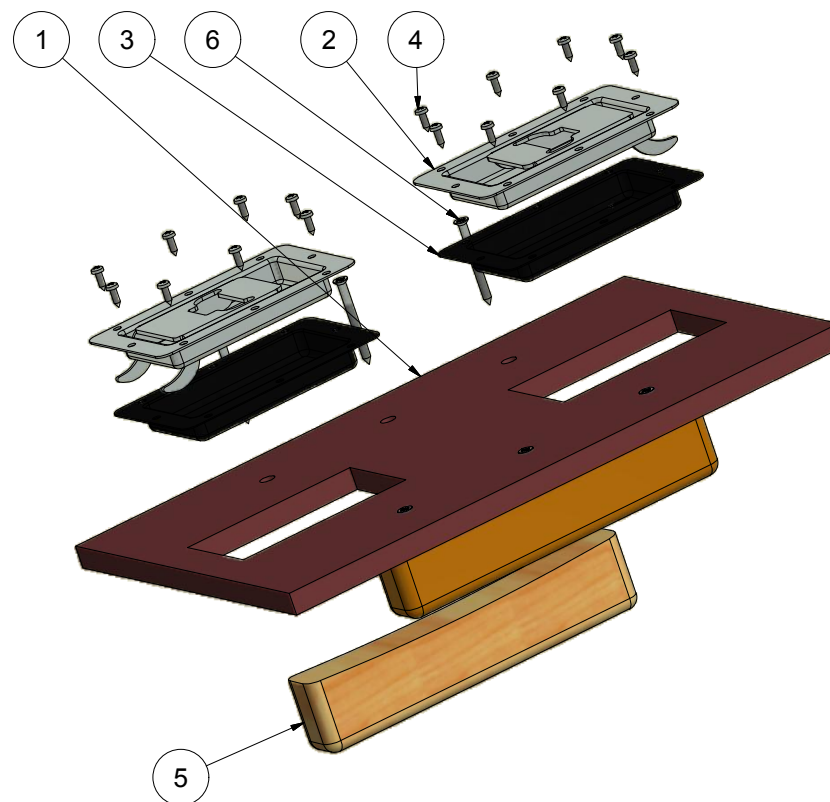
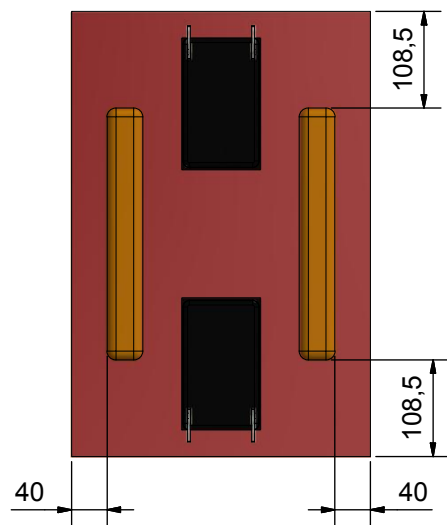
Detal 190462 jest zamontowany w równych odstępach od końców.
Montować za pomocą 5 śrub w odstępach co 109mm.

Item 190462 is placed with even space in each end.
Mounted with 5 screws with 109mm between.

Revision:	Approved	Date:	Revision Description
2	KL	30-06-2017	Covers changed

 HEGENSTED GRUPPEN A/S Part No.: M102661 Description 1: Drum for Bodydrum Description 2:	Scale: 1 : 10	Not specified tolerance according to: DS/ISO 2768-m	Sheet size: A2
	Surface properties:		Sheet: 3 / 3
	Material:		

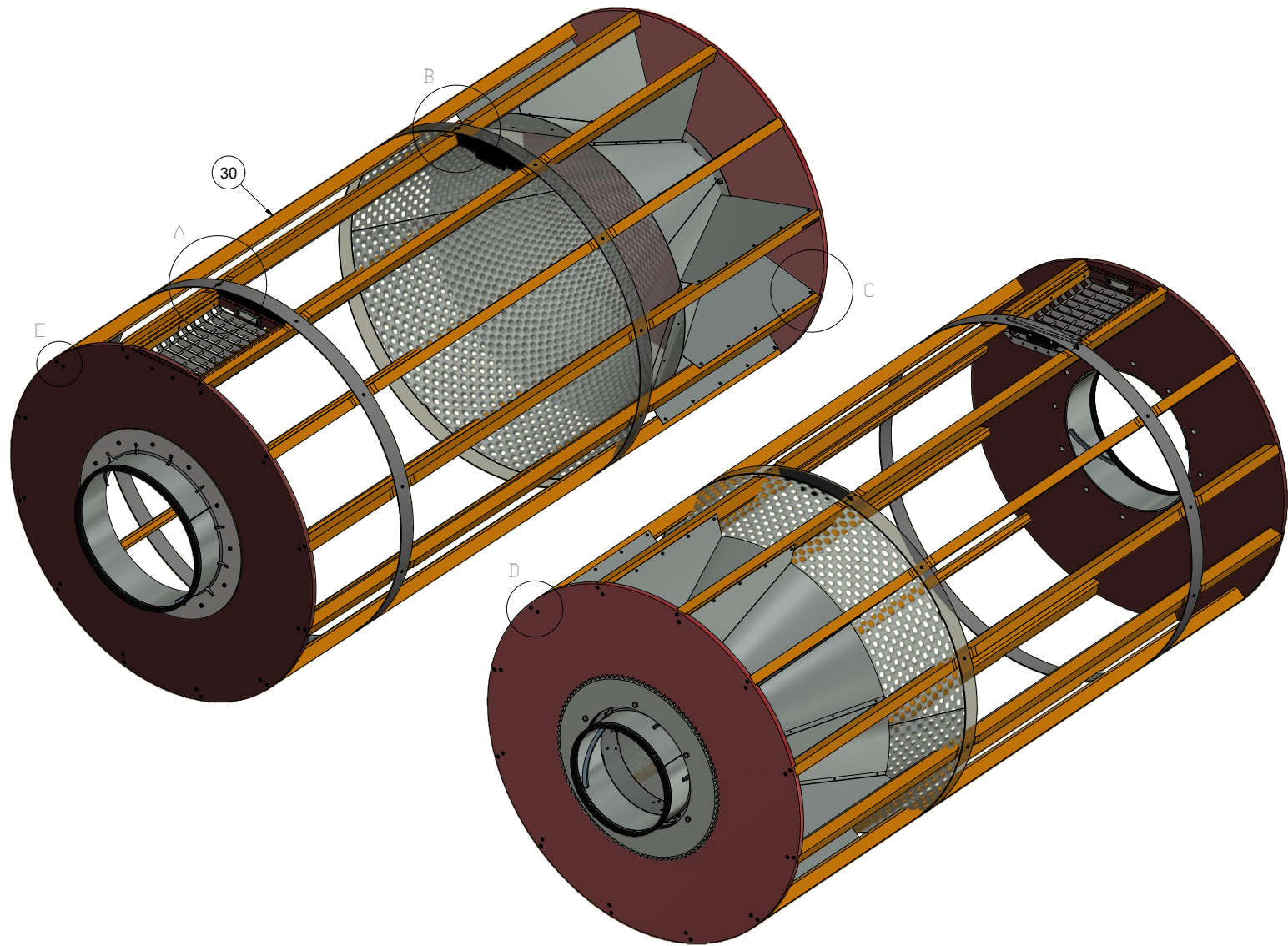
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	M102643	Trap Door
2	2	190585	Clamp for hatch
3	2	190586	Gasget for clamp
4	16	140872	Wood screw pan head 5 x 16
5	2	M102682	Battern for hatch
6	6	2706070	Wood screw countersunk head 6 x70



Revision:	Approved	Date:	Revision Description
1	MBO	04-04-2017	Made

Break all edges

The document is strictly confidential and must not be made available to anyone outside the company without the express written consent of the company. HEDENSTEDT GRUPPEN A/S	HC HEDENSTEDT GRUPPEN	Scale: 1 : 4	Not specified tolerance according to: DS/ISO 2768-m	Sheet size: A3
			Surface properties:	Sheet: 1 / 1
	Part No.: M102660	Material:		
	Description 1: Hatch complete			
	Description 2:			



Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	6	10208040	Hexagon cylinder head M8x40 FZB
2	6	11412080	Hexagon bolt M12x80 FZB
3	12	1508000	Nut M8 FZB
4	1	190400	Grating cone f/ body drum Ø150
5	1	190408	Sawdust cone assembly 1
6	1	190435	End bearing Ø457
7	1	190445	End sheet 1
8	1	190450	End sheet 2
9	1	190515	Sprocket for drum Z95-1inch
10	2	190525	Shim for sprocket
11	2	190550	Plate for Clamp
12	2	190587	Closing plate
13	1,7 m	190745	Celular rubber band 15x8mm
14	2	20406045	Hexagon countersunk head M6x45 FZB
15	3,5 m	20424	Edging band
16	4	22906000	Hexagon dome Lock nut M6 FZB
17	6	2703035	Wood screw countersunk head 3,5 x 35
18	28	2705050	Wood screw countersunk head 5 x 50
19	48	2706070	Wood screw countersunk head 6 x 70
20	2	64406030	Cup head square neck bolt M6x30 FZB
21	12	64408035	Cup head square neck bolt M8x35 FZB
22	60	64485025	Wood screw pan head 4,5 x 35
23	6	66705050	Wood screw pan head 5,0 x 50
24	12	7004016	Blind rivet Ø4x16 (11-12,5)
25	12	82104000	Washer M4 FZB
26	2	87606000	Washer Ø6,4x17x3 FZB
27	1	M102590	Reinforcement for Drum
28	1	M102604	Reinforcement for Drum
29	2	M102677	Wood strip
30	12	M102683	Battern for body drum
31	1	M103149	Safetygrid for XL bodydrum Ø150
32	1	M103160	End bearing Ø600

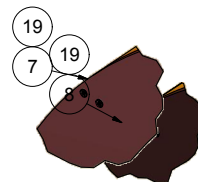
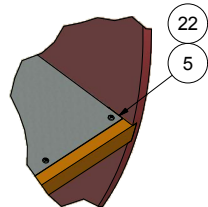
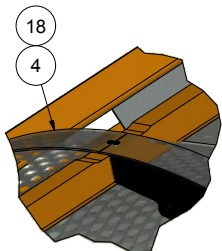
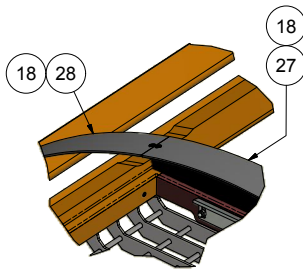
A (1 : 6)

B (1 : 6)

C (1 : 6)

D (1 : 6)

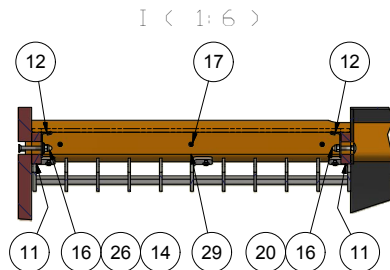
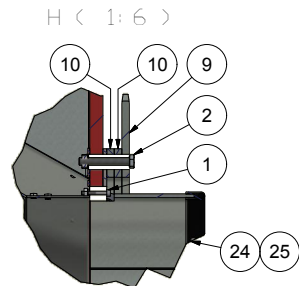
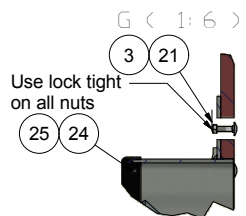
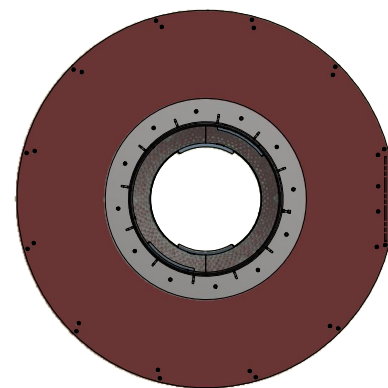
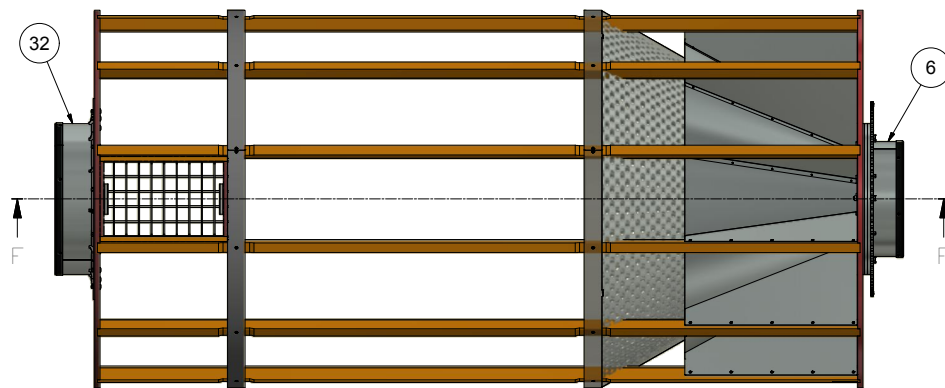
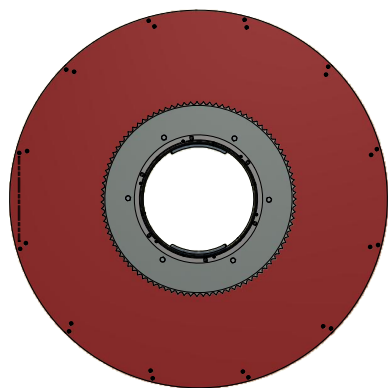
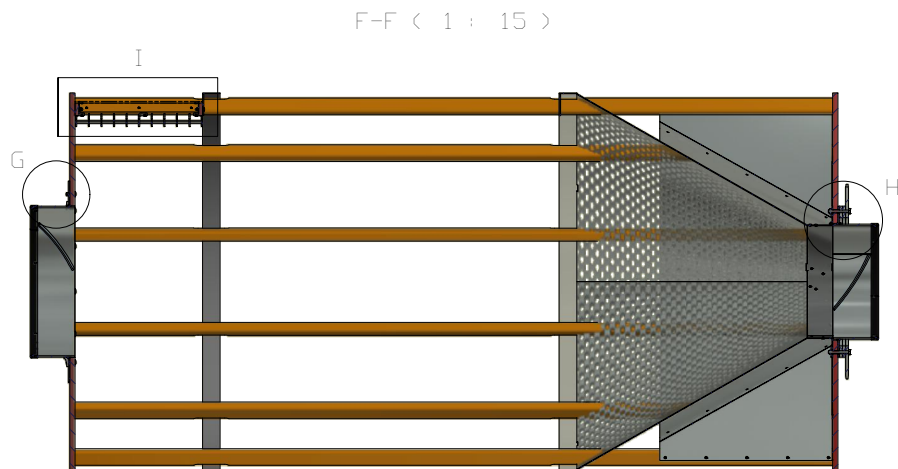
E (1 : 6)



Break all edges

	Scale:	1:12	Not specified tolerance according to:	Sheet size:
	Material:	Surface properties:		Sheet: 1/4
Part No. M102663				
Description 1: Drum assembly 1				
Description 2:				

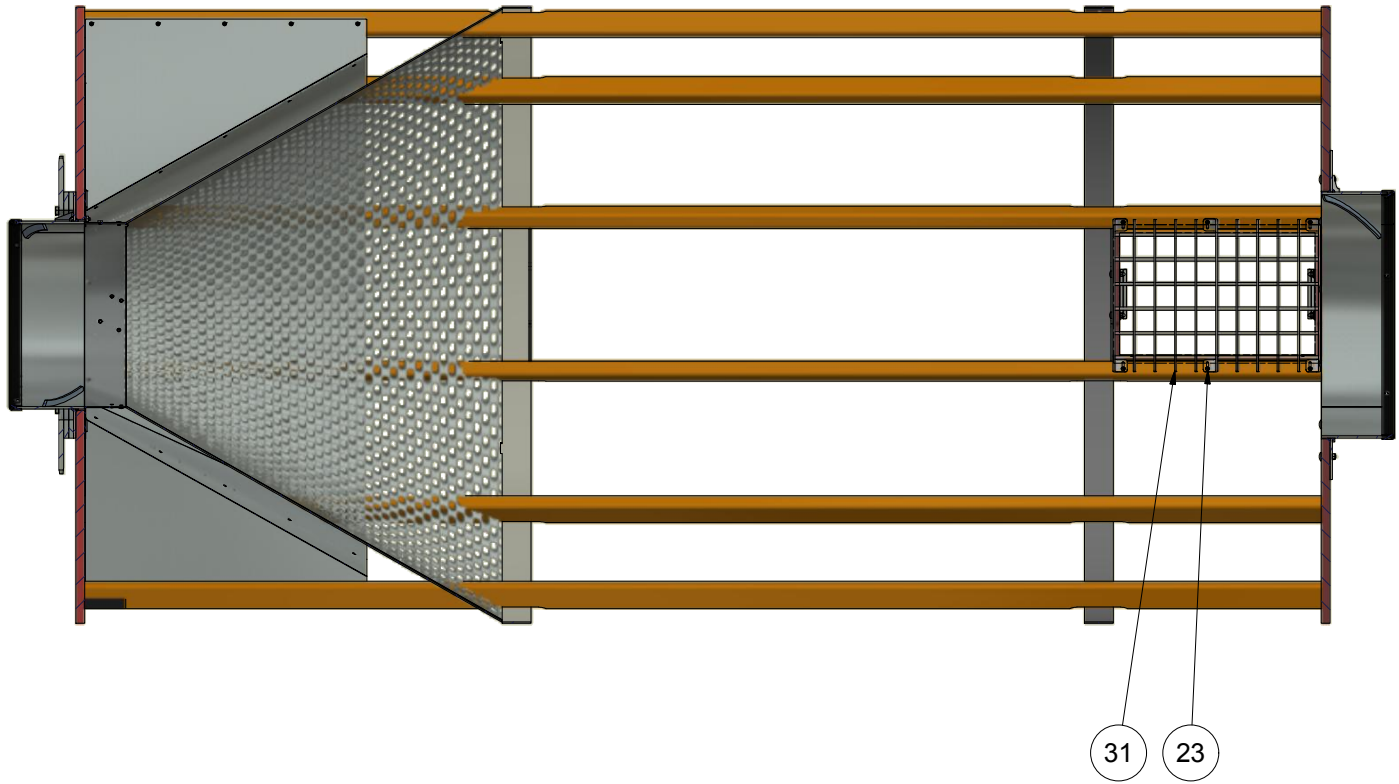
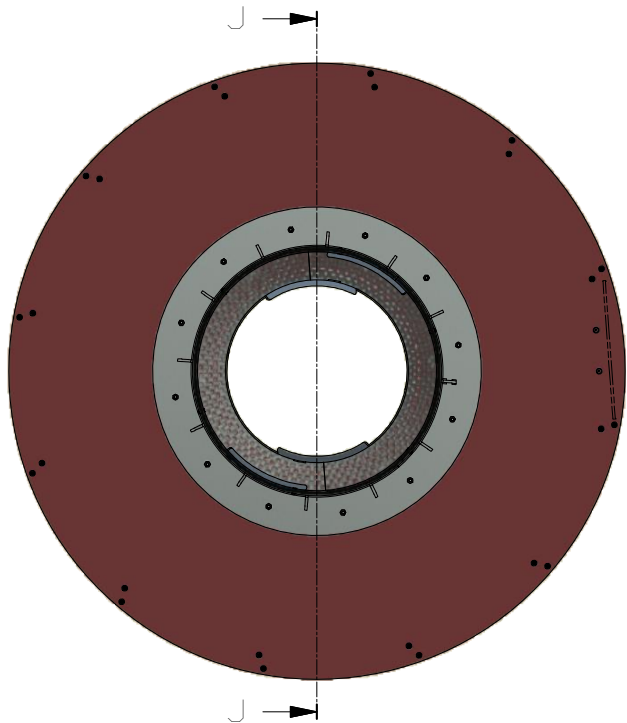
Revision:	Approved	Date:	Revision Description
3	KKS	19-12-2018	M103160 changed + nuts changed



Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	6	10208040	Hexagon cylinder head M8x40 FZB
2	6	11412080	Hexagon bolt M12x80 FZB
3	12	1508000	Nut M8 FZB
4	1	190400	Grating cone f/ body drum ø150
5	1	190408	Sawdust cone assembly 1
6	1	190435	End bearing Ø457
7	1	190445	End sheet 1
8	1	190450	End sheet 2
9	1	190515	Sprocket for drum Z95-1inch
10	2	190525	Shim for sprocket
11	2	190550	Plate for Clamp
12	2	190587	Closing plate
13	1,7 m	190745	Celular rubber band 15x8mm
14	2	20406045	Hexagon countersunk head M6x45 FZB
15	3,5 m	20424	Edging band
16	4	22906000	Hexagon dome Lock nut M6 FZB
17	6	2703035	Wood screw countersunk head 3,5 x 35
18	28	2705050	Wood screw countersunk head 5 x 50
19	48	2706070	Wood screw countersunk head 6 x 70
20	2	64406030	Cup head square neck bolt M6x30 FZB
21	12	64408035	Cup head square neck bolt M8x35 FZB
22	60	64485025	Wood screw pan head 4,5 x 35
23	6	66705050	Wood screw pan head 5,0 x 50
24	12	7004016	Blind rivet Ø4x16 (11-12,5)
25	12	82104000	Washer M4 FZB
26	2	87606000	Washer Ø6,4x17x3 FZB
27	1	M102590	Reinforcement for Drum
28	1	M102604	Reinforcement for Drum
29	2	M102677	Wood strip
30	12	M102683	Battern for body drum
31	1	M103149	Safetygrid for XL bodydrum Ø150
32	1	M103160	End bearing Ø600

Break all edges			
	Scale:	1:12	Not specified tolerance according to:
	Part No.:	M102663	Material:
	Description 1:	Drum assembly 1	
	Description 2:		
Revision:	Approved:	Date:	Revision Description:
3	KKS	19-12-2018	M103160 changed + nuts changed

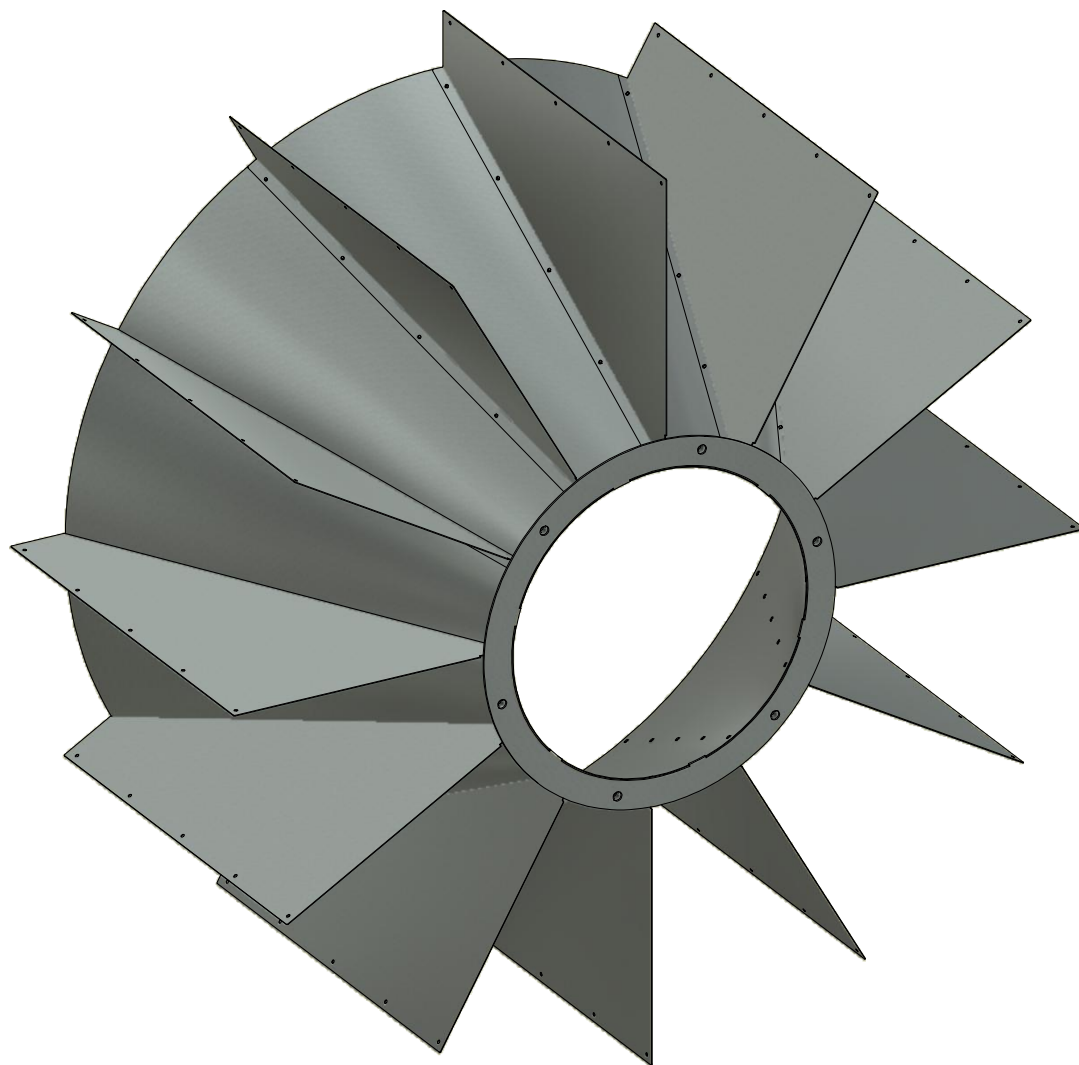
J-J (1 : 13)



Break all edges

Revision:	Approved	Date:	Revision Description
3	KKS	19-12-2018	M103160 changed + nuts changed

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		1 : 12		A3
			Surface properties:	Sheet:
				4 / 4
	Part No.:	Material:		
M102663				
Description 1:				
Drum assembly 1				
Description 2:				

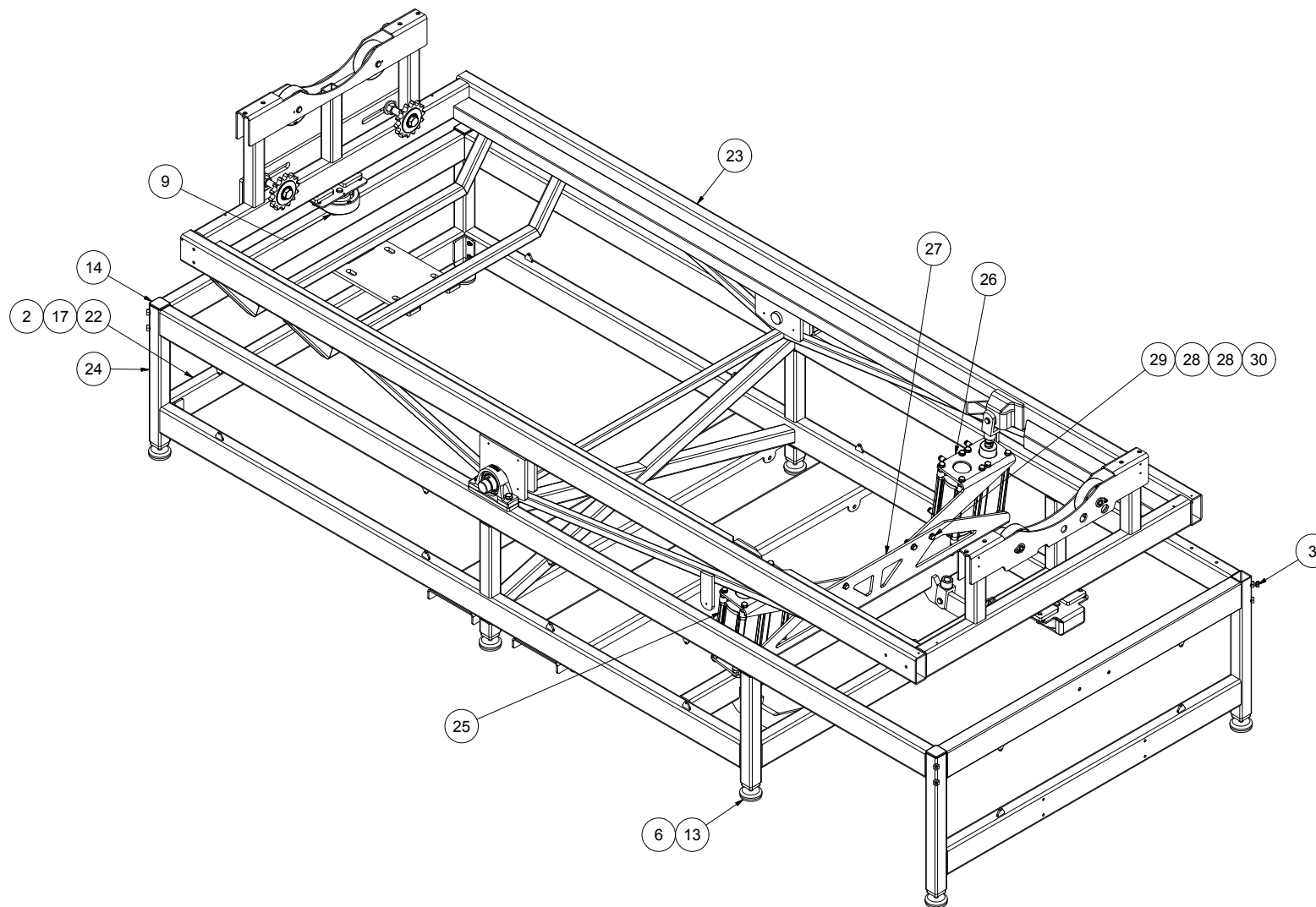


Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	12	190465	Partition for sawdust cone
2	1	190410	Sawdust cone for bodydrum
3	60	7003208	Pop rivet ø3.2x8mm

Break all edges

* The dimensions shown in this drawing are for reference only and are not to be used for manufacturing purposes. The dimensions shown in this drawing are for reference only and are not to be used for manufacturing purposes. HEDENSTED GRUPPEN AS	HG HEDENSTED GRUPPEN	Scale: 1 : 8	Not specified tolerance according to: DS/ISO 2768-m	Sheet size: A3
	Part No.: 190408		Surface properties: 	Sheet: 1 / 1
	Material:			
	Description 1: Sawdust cone assembly 1			
	Description 2:			

Revision:	Approved	Date:	Revision Description
1	HG	28-09-2015	Revision changed to numeric

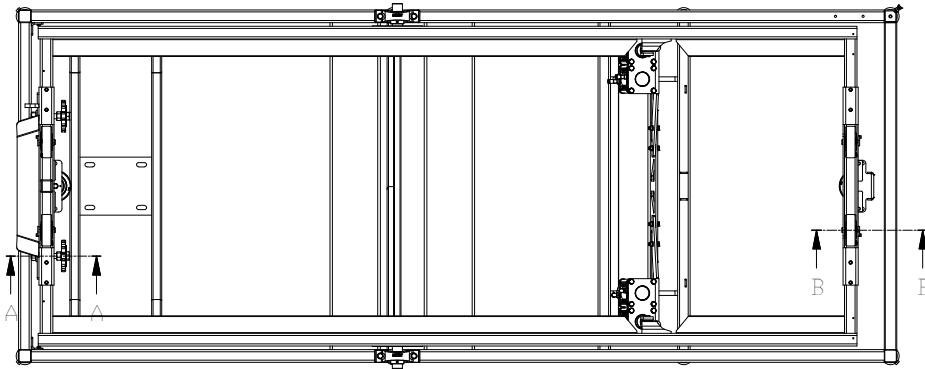
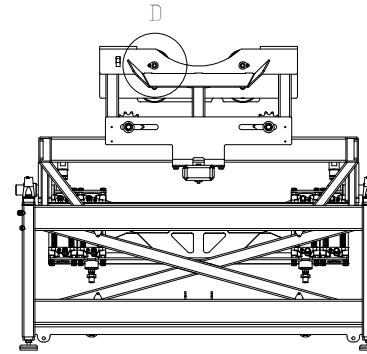
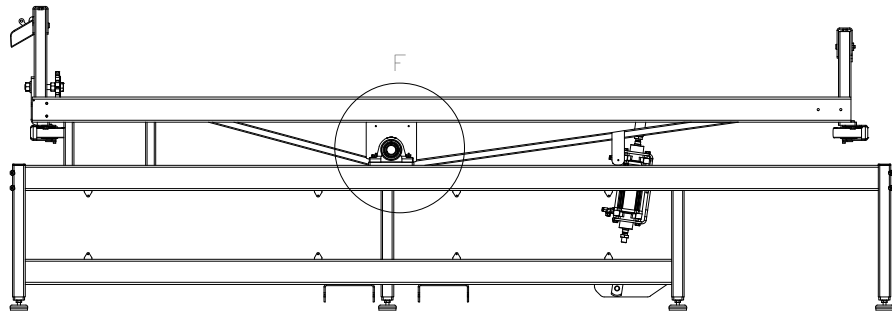


Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10206010	Hexagon cylinder head M6x10 FZB
2	4	11406016	Hexagon bolt M6x16 FZB
3	1	11410025	Hexagon bolt M10x25 FZB
4	4	11412035	Hexagon bolt M12x35 FZB
5	2	11420140	Hexagon bolt M20x140 FZB
6	8	1512000	Nut M12 FZB
7	6	1520000	Nut M20 FZB
8	4	190284	Wheel Ø125xØ20x46
9	2	190419	Support wheel assembly
10	4	190521	Washer for sprocket
11	2	190522	Tension sprocket16B1 Z14
12	4	190610	Shaft with flange
13	8	197350	Machine shoe M12x70xØ70
14	3	222380	End cap 50x50mm Black
15	2	473038	Bearing Ø20xØ47x14
16	2	473093	Y-Bearing block Ø40
17	4	82106000	Washer M6 FZB
18	4	82112000	Washer M12 FZB
19	4	82120000	Washer M20 FZB
20	8	88720100	Shim washer Ø20x28x1,0
21	2	89847000	Seeger ring for hole Ø47
22	1	M102634	Frame Insert
23	1	M102653	Frame for drum
24	1	M102654	Stand for body drum
25	1	M103169	Lifting cylinder
26	1	M103170	Lifting cylinder
27	1	M103174	Lifting cylinder support 1
28	8	82110000	Washer M10 FZB
29	4	11410035	Hexagon bolt M10x35 FZB
30	4	17910000	Self-locking nut M10 FZB

Break all edges

This document is a technical drawing and must be read in conjunction with the HEDENSTED GROUPPEN standard drawing conditions.		Scale:	1 : 10	Not specified tolerance according to:	DS/ISO 2768-m	Sheet size:	A2
			Surface properties:			Sheet:	1 / 2
		Part No.:	M102664	Material:			
Description 1:		Frame assembly for drum					
Description 2:							

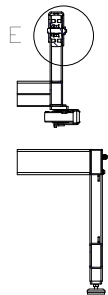
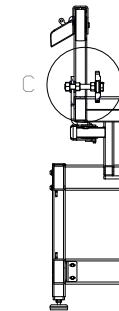
Revision:	Approved	Date:	Revision Description
2	KKS	30-01-2018	Cylinder stabilizer + center legs added



Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10206010	Hexagon cylinder head M6x10 FZB
2	4	11406016	Hexagon bolt M6x16 FZB
3	1	11410025	Hexagon bolt M10x25 FZB
29	4	11410035	Hexagon bolt M10x35 FZB
4	4	11412035	Hexagon bolt M12x35 FZB
5	2	11420140	Hexagon bolt M20x140 FZB
6	8	1512000	Nut M12 FZB
7	6	1520000	Nut M20 FZB
30	4	17910000	Self-locking nut M10 FZB
8	4	190284	Wheel Ø125xØ20x46
9	2	190419	Support wheel assembly
10	4	190521	Washer for sprocket
11	2	190522	Tension sprocket16B1 Z14
12	4	190610	Shaft with flange
13	8	197350	Machine shoe M12x70xØ70
14	3	222380	End cap 50x50mm Black
15	2	473038	Bearing Ø20xØ47x14
16	2	473093	Y-Bearing block Ø40
17	4	82106000	Washer M6 FZB
28	8	82110000	Washer M10 FZB
18	4	82112000	Washer M12 FZB
19	4	82120000	Washer M20 FZB
20	8	88720100	Shim washer Ø20x28x1,0
21	2	89847000	Seeger ring for hole Ø47
22	1	M102634	Frame Insert
23	1	M102653	Frame for drum
24	1	M102654	Stand for body drum
25	1	M103169	Lifting cylinder
26	1	M103170	Lifting cylinder
27	1	M103174	Lifting cylinder support 1

A-A < 1 : 15 >

B-B < 1 : 15 >

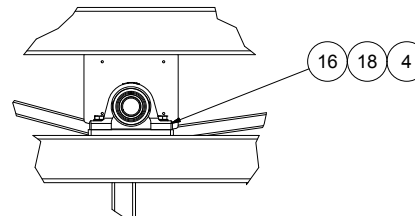
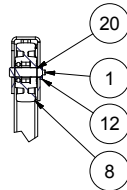
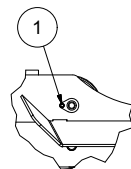
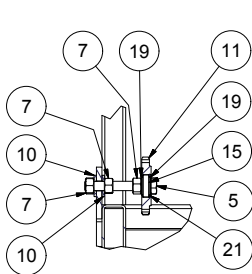


C < 1:8 >

D < 1:8 >

E < 1:8 >

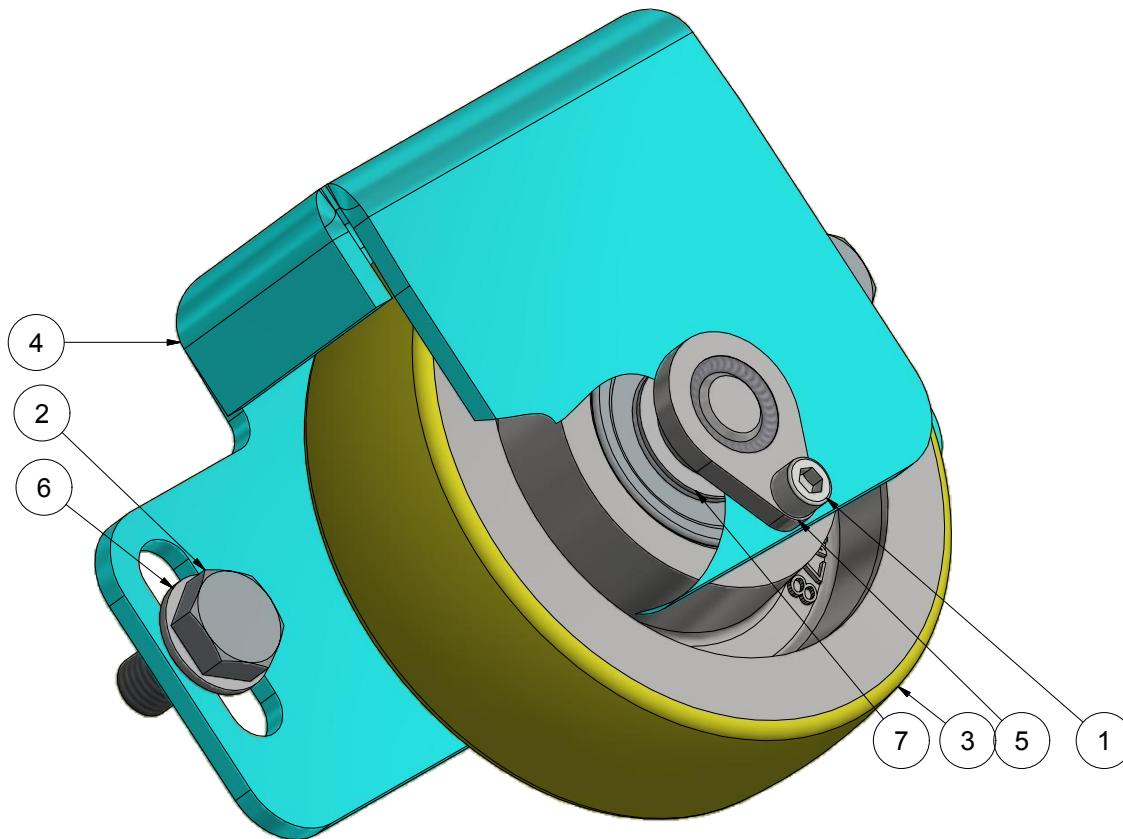
F < 1:8 >



Break all edges

	Scale:	1 : 10	Not specified tolerance according to:	DS/ISO 2768-m	Sheet size:	A2
	Part No.:	M102664	Surface properties:		Sheet:	2 / 2
	Description 1:	Frame assembly for drum				
	Description 2:					

Revision:	Approved	Date:	Revision Description
2	KKS	30-01-2018	Cylinder stabilizer + center legs added

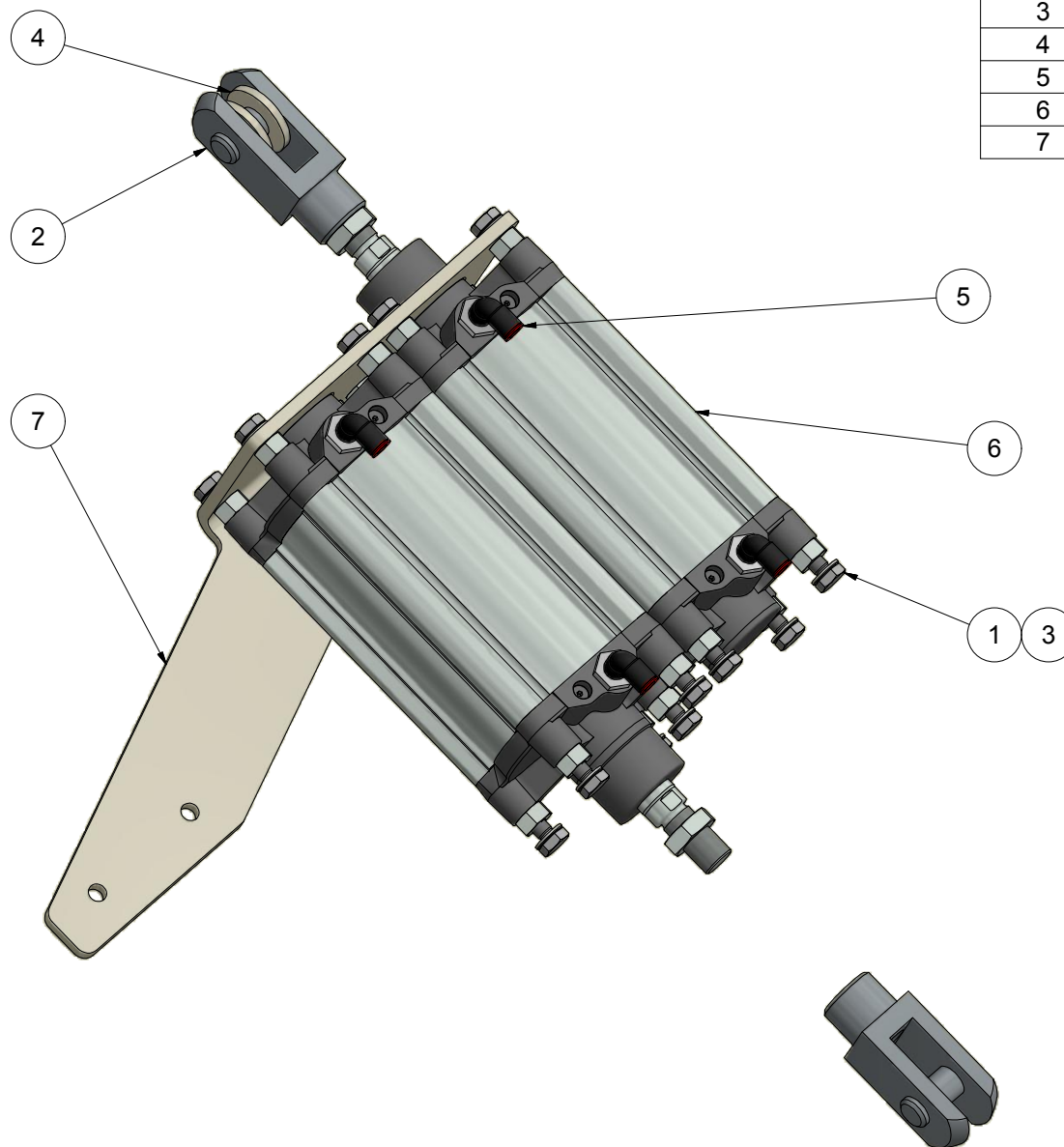


Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	10206010	Hexagon cylinder head M6x10 FZB
2	2	11412025	Hexagon bolt M12x25 FZB
3	1	190284	Wheel Ø125xØ20x46
4	1	190600	Sheet part 19
5	1	190610	Shaft with flange
6	2	82112000	Washer M12 FZB
7	2	88720100	Shim washer Ø20x28x1,0

Break all edges

The document is strictly confidential and shall not be made available to the outside world without the account being copied or disclosed to any third person. HEDENSTED GRUPPEN AS	 HEDENSTED GRUPPEN	Scale:	1:1	Not specified tolerance according to:	DS/ISO 2768-m	Sheet size:	A3	
			Surface properties:				Sheet:	1 / 1
	Part No.:		190419					
	Material:							
	Description 1:							
Support wheel assembly								
Description 2:								

Revision:	Approved	Date:	Revision Description
1	HG	28-09-2015	Revision changed to numeric

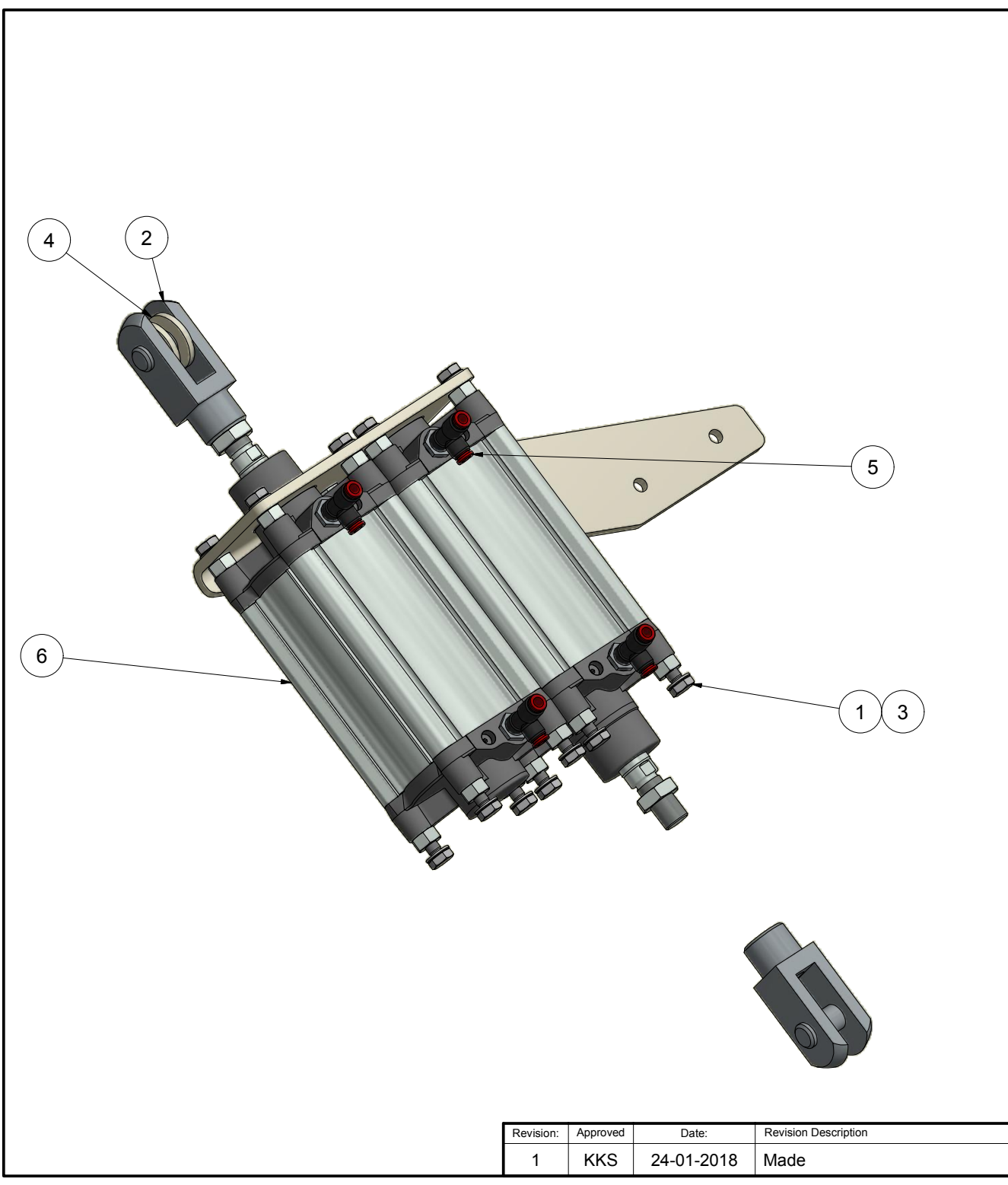


PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	16	11410020	Hexagon bolt M10x20 FZB
2	2	214128	F-Bracket QM/8080/25
3	16	82110000	Washer M10 FZB
4	2	M102613	Disc
5	4	215774	Elbow swivel Ø8 x 1/2"t
6	2	M103173	Cylinder PRA/802100/M/125
7	1	M103176	Lifting cylinder support 2

Break all edges

Technical drawing of a lifting cylinder assembly. HEDENSTED GRUPPEN AS	 HEDENSTED GRUPPEN	Scale:	1 : 3	Not specified tolerance according to:	DS/ISO 2768-m	Sheet size:	A3
			Surface properties:	No		Sheet:	1 / 1
	Part No.:		M103169				
	Description 1: Lifting cylinder						
	Description 2:						

Revision:	Approved	Date:	Revision Description
2	KKS	17-12-2018	Fittings changed to plastic



PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	16	11410020	Hexagon bolt M10x20 FZB
2	2	214128	F-Bracket QM/8080/25
3	16	82110000	Washer M10 FZB
4	2	M102613	Disc
5	4	M103168	L-connector 1/2" x Ø8 x Ø8
6	2	M103173	Cylinder PRA/802100/M/125
7	1	M103180	Lifting cylinder support 3

Revision:	Approved	Date:	Revision Description
1	KKS	24-01-2018	Made

Break all edges				
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			Surface properties: No	Sheet: 1 / 1
		Part No.: M103170	Material:	
		Description 1: Lifting cylinder		
Description 2:				

Customer: Hedensted Gruppen A/S

Project: Ø150 Bodydrum 2017

Hedensted Gruppen A/S
Vejlevej 15a
DK-8722 Hedensted
TLF: 75 89 12 44
FAX: 75 89 11 80

VS AUTOMATIC

Ormhøjgårdvej 15
DK-8700 Horsens Tlf. 75641899

Project title: Ø150 Bodydrum 2017

Customer: Hedensted Gruppen A/S

Last printed: 22-05-2018

14:48:19

Last checked: 22-08-2017 13:34:56

Filename: Bodydrum XL 2017-02

Case no.: Bodydrum X

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Information

WIRE IDENTIFICATION:

The wire is identified with the terminal number of the component.

WIRE COLOUR:

MAIN CIRCUIT:	Phase	Black
	Neutral	Light blue
DC CONTROL CIRCUIT: 24VDC		Dark blue
	0VDC	White

THE FOLLOWING COLOUR ID IS TAKEN FROM DS/EN 60757

BK	BLACK
BN	BROWN
RD	RD
OG	ORANGE
YE	YELLOW
GN	GREEN
BU	BLUE
VT	VIOLET
GY	GREY
WH	WHITE
PK	PINK

ALL SYMBOLS USED IS TAKEN FROM DS/EN 166

DECLARATION OF INCORPORATION

Directive 2006/42/EF, Annex II, B

Manufacturer

Firm: VS AUTOMATIC A/S
Address: Ormhøjgårdvej 15
DK-8700 Horsens
Phone: +45 75 64 18 99
Fax: +45 75 64 18 09
Email: info@vs-automatic.dk

Herewith declares that

Component: Controlpanel
Type: Bodydrum XL 2017-02 Year of manufator: 2017

is intended to be incorporated into machinery or to be assembled with other machinery to constitute machinery covered by Directive 2006/42/EC

does therefor not in every respect comply with the provisions of this directive
does comply with the provisions of the following other EC directives

EC directives

EC machine directive 89/392/EEC, as per 91/386/EEC, 93/68/EEC, 93/44/EEC

EC low-voltage directives 73/23/EEC, as per 93/68/EEC, 93/465/EEC

EC EMC directive 89/336/EEC as per 92/31/EEC, 93/68/EEC, 93/465/EEC

Harmonized standards

EN60204-1 Safety of Machinery Electrical Equipment of Machines

EN60439-1 Low-voltage switchgear and controlgear assemblies part 1: Type-tested and partially type-tested assemblies

And furthermore declares that it is not allowed to put the machinery into service until the machinery into which it is to be incorporated or of which it is to be a component has been found and declared to be in conformity with the provisions of Directive 98/37/EC and with national implementation legislation i.e. as a whole, including the machinery referred to in this declaration

Machine: Ø150 Bodydrum 2017
Machine No.:
Type: Year of manufactor: 2017
Manufacturer: Hedensted Gruppen A/S

Identification of signature:

Firm: VS AUTOMATIC A/S
Address: Ormhøjgårdvej 15
DK-8700 Horsens

Date: 22-05-2018

Signature



Torben Steffensen

VS AUTOMATIC

Ormhøjgårdvej 15
DK-8700 Horsens
Tlf. 75641899

Type: Hedensted Gruppen A/S

Project: Ø150 Bodydrum 2017

Printed: 22-05-2018

14:48:19

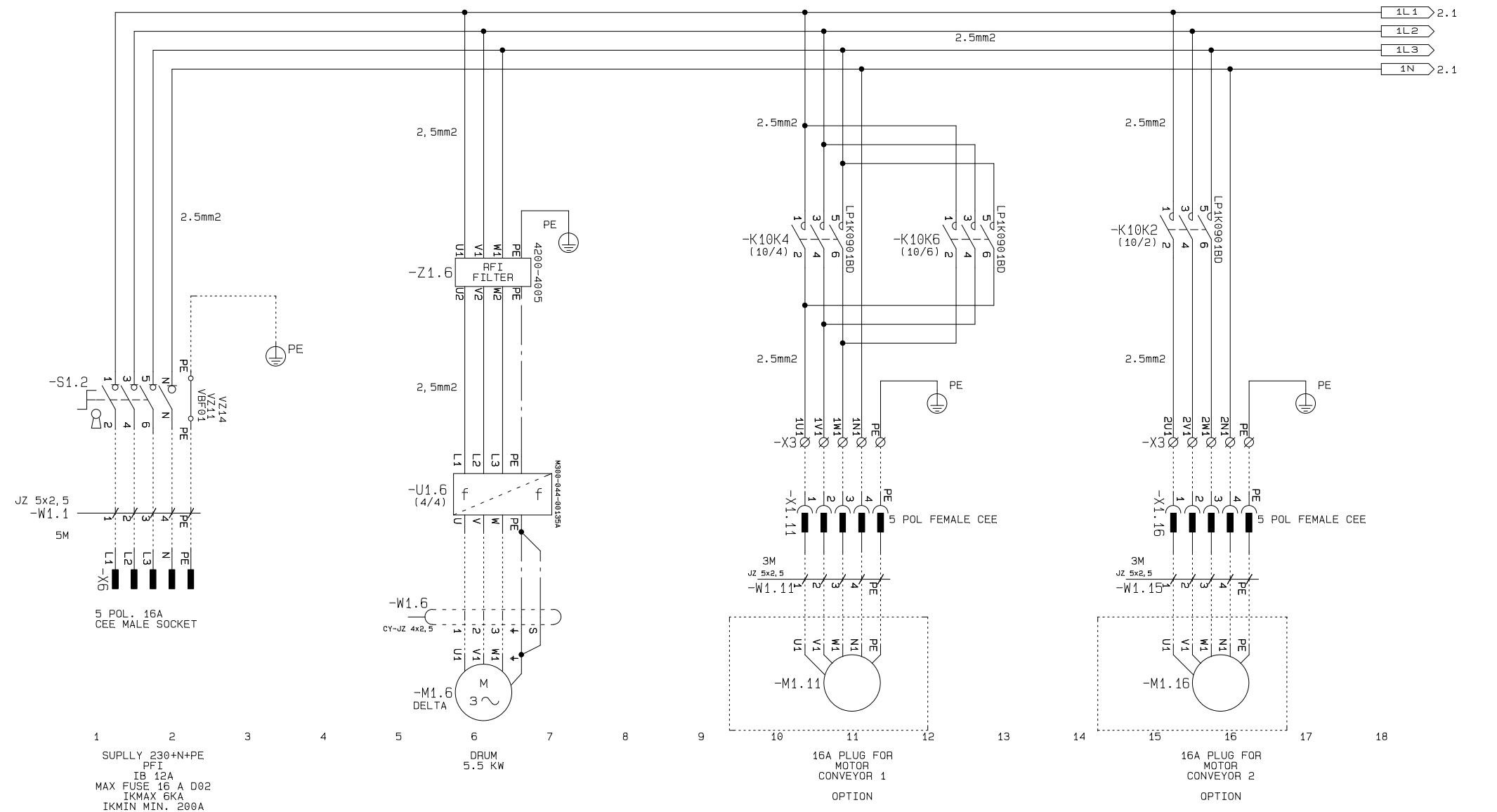
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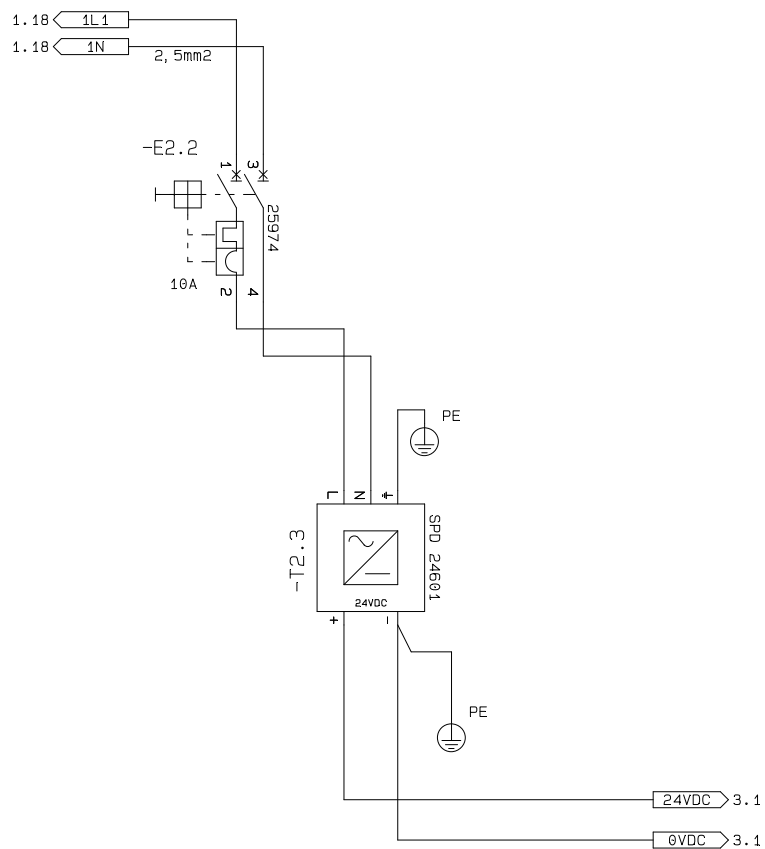
File: Bodydrum XL 2017-02

Case no.: Bodydrum X

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1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18

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En del af **TS GRUPPEN** - Danmarks stærkeste El & Energi installer

Customer: Hedensted Gruppen A/S

Project: Ø150 Bodydrum 2017

Page title: 230VAC & 24VDC Control Circuit

Designer: tbt

Last prt: 22-05-2018

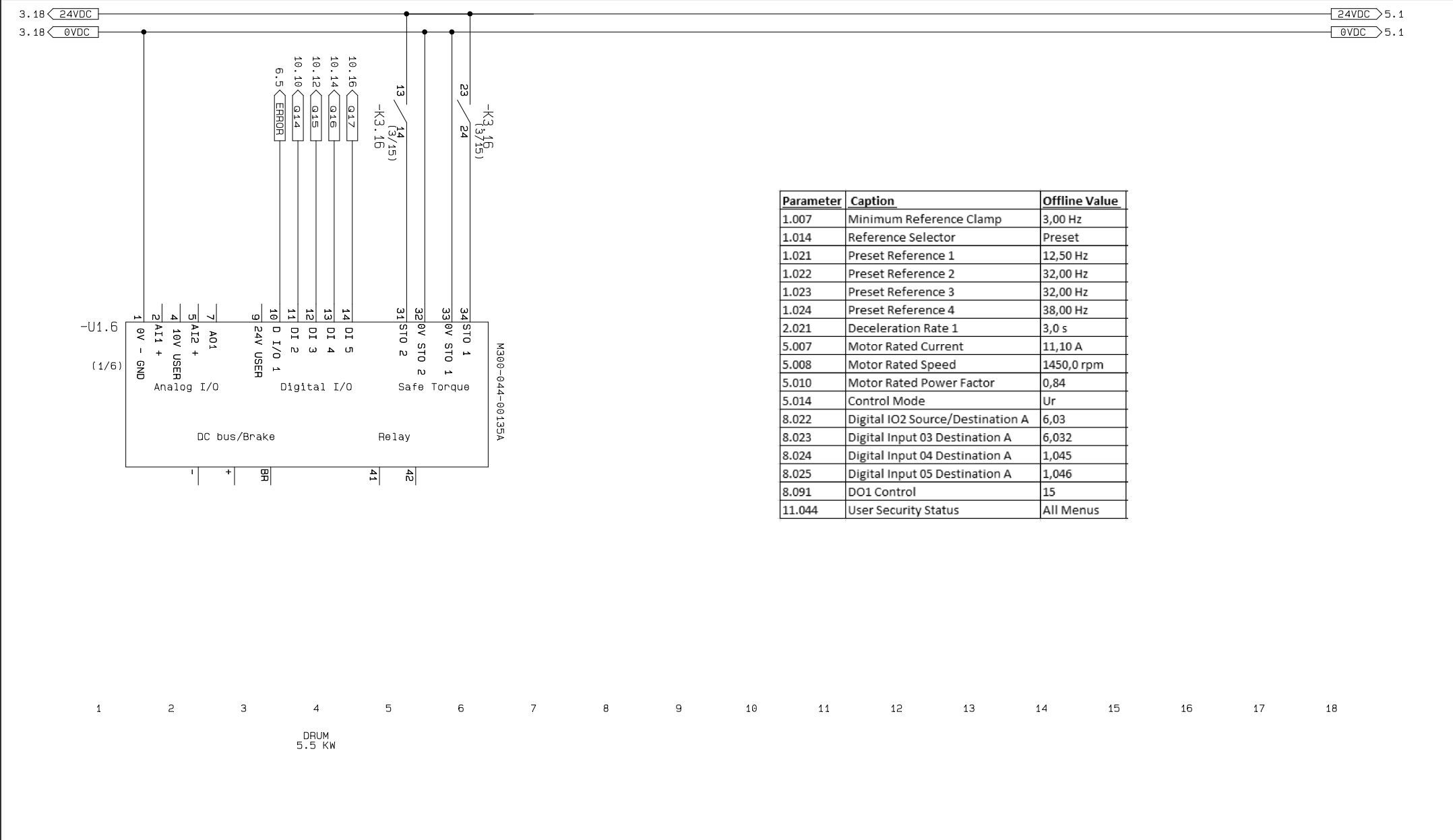
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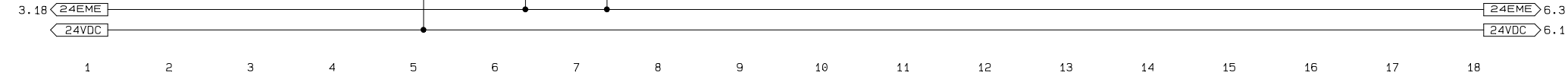
Case no: Bodydrum XL 2017-02

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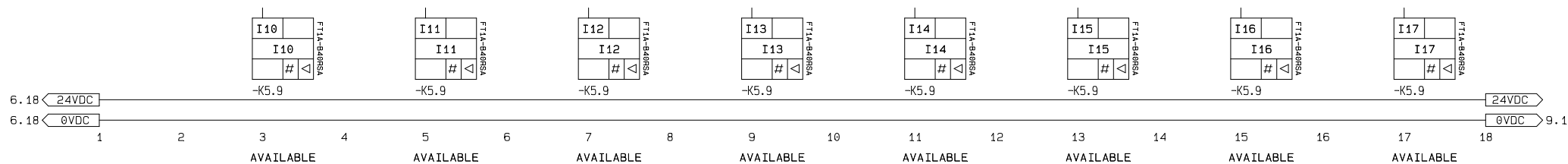


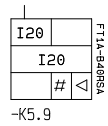


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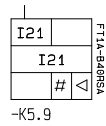
Last changed: 10-10-2017

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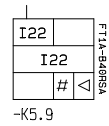




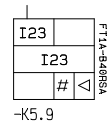
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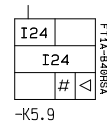
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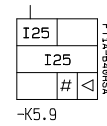
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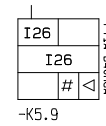
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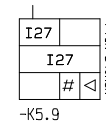
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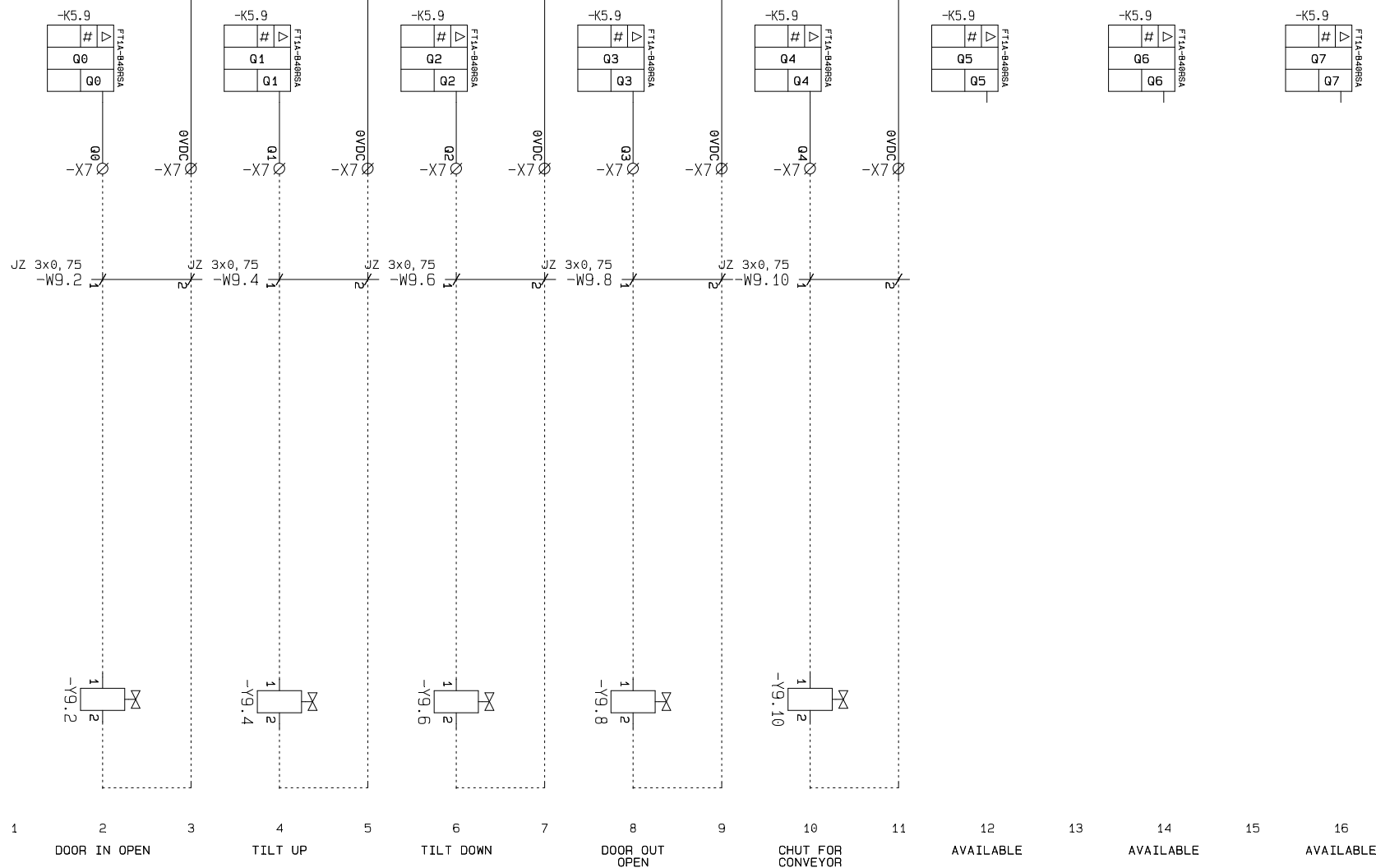


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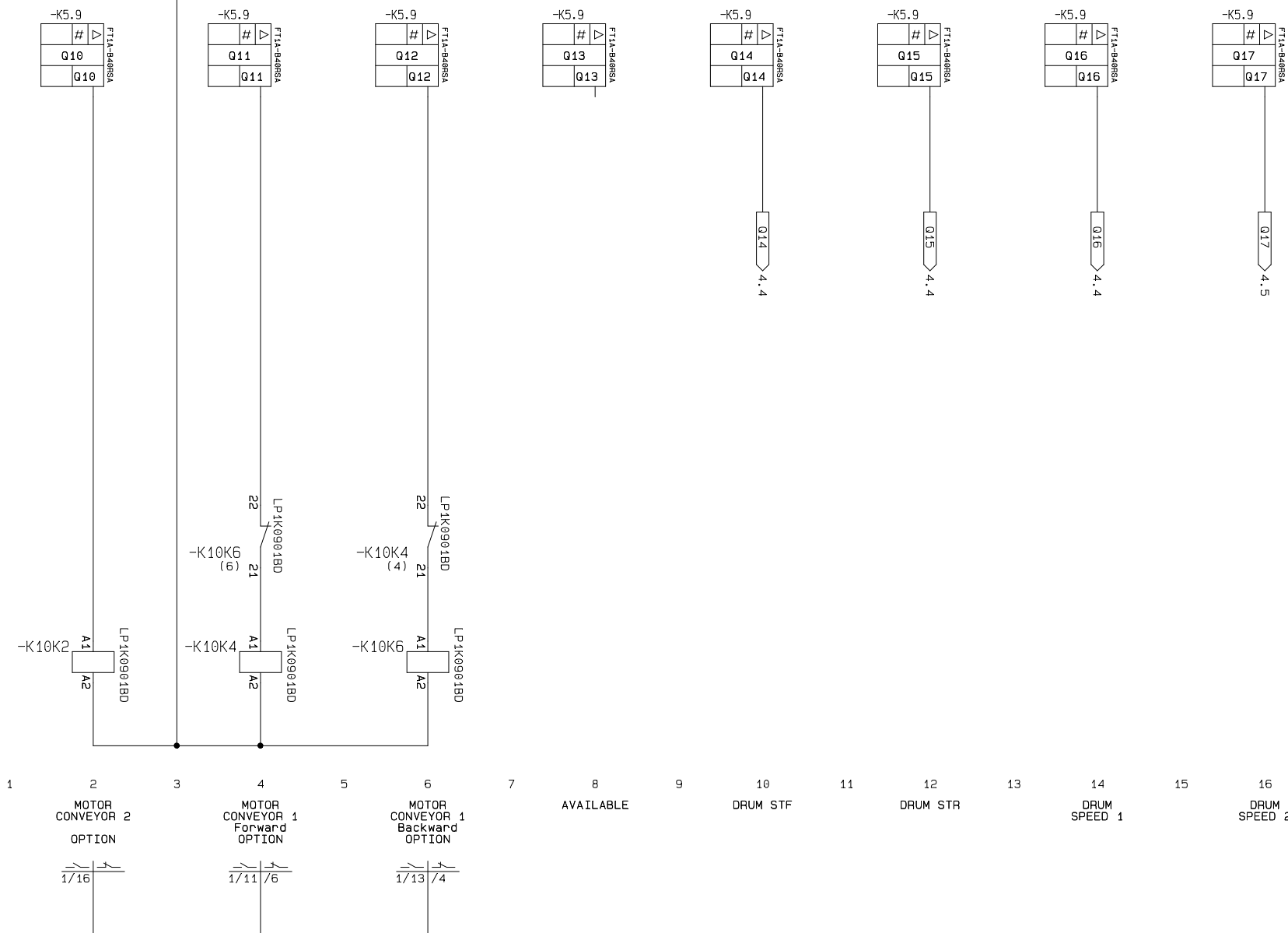


17 18
AVAILABLE

7.18 0VDC 10.1



9. 18 0VDC

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Customer: Hedensted Gruppen A/S

Project: Ø150 Bodydrum 2017

Pagetitle: PLC Output Y10 - Y17

Designer: tbt

Last prt: 22-05-2018

Last changed: 22-08-2017

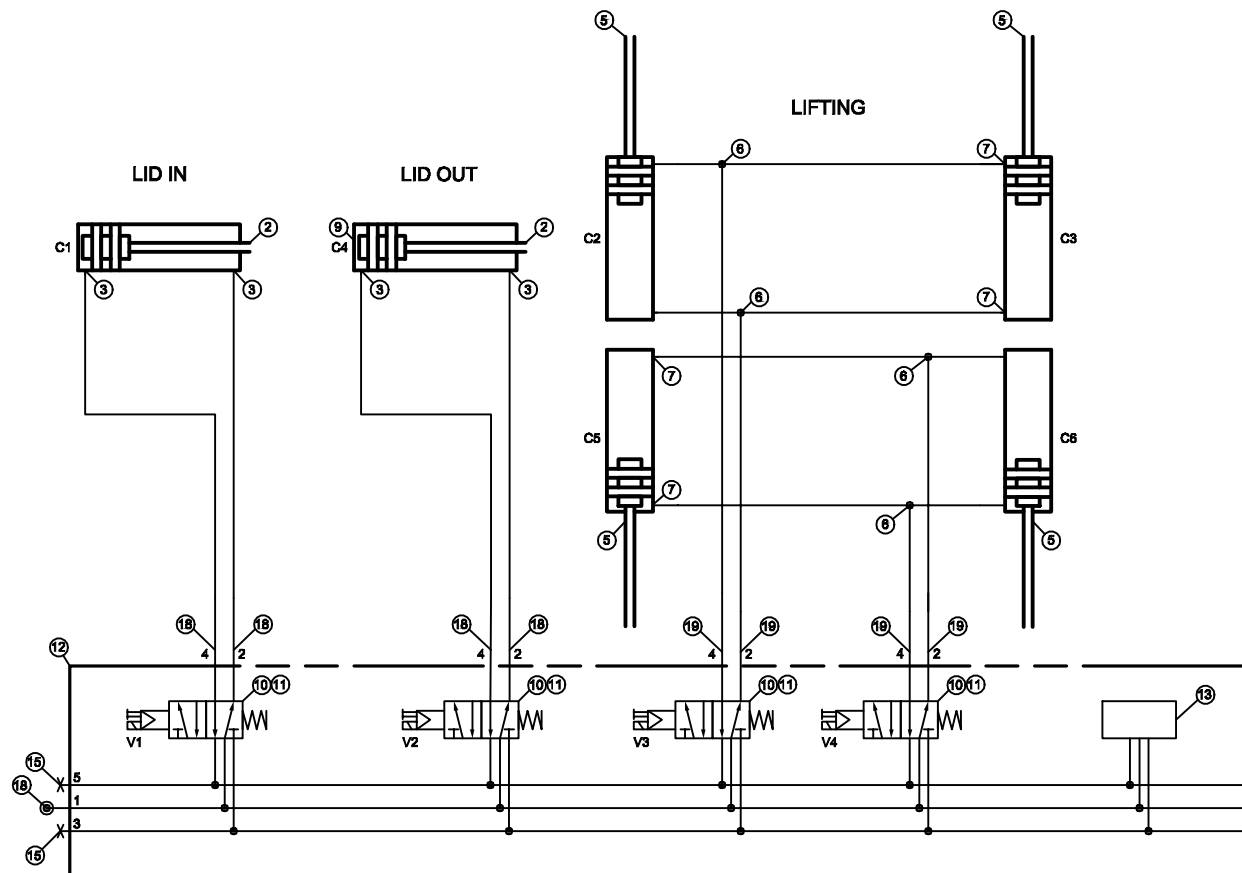
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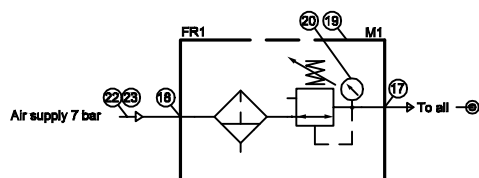
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FROM			CABLE		TO		
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+A0-S1.2:4		1/2	+A0-W1.1:2		+A0-X6:L2	1/2	
+A0-S1.2:6		1/2	+A0-W1.1:3		+A0-X6:L3	1/2	
+A0-S1.2:N		1/2	+A0-W1.1:4		+A0-X6:N	1/2	
+A0-Q1.2:PE		1/2	+A0-W1.1:PE		+A0-X6:PE	1/2	
+A0-U1.6:U		1/6	+A0-W1.6:1		+A0-M1.6:U1	1/6	
+A0-U1.6:V		1/6	+A0-W1.6:2		+A0-M1.6:V1	1/6	
+A0-U1.6:W		1/6	+A0-W1.6:3		+A0-M1.6:W1	1/6	
+A0-U1.6:PE		1/7	+A0-W1.6:S		+A0-M1.6: $\downarrow$	1/7	
+A0-U1.6:PE		1/7	+A0-W1.6: $\downarrow$		+A0-M1.6: $\downarrow$	1/7	
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+A0-S5.16:X1		3/17	+A0-W3.3:7		+A0-X4:11	3/16	
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+A0-X6:I3		6/9	+A0-W3.3:9		+A0-S6.9:22	6/9	
+A0-X4:PE		3/3	+A0-W3.3:PE		+A0-D5.14:PE	5/13	
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+A0-X4:8		3/8	+A0-W5.8:4		+A0-S3.8:1	3/8	
			+A0-W5.9		+A0-D5.14:R232	5/13	
+A0-X6:1+		6/10	+A0-W6.1:1		+A0-S6.4:21	6/4	
+A0-X6:I2		6/7	+A0-W6.1:2		+A0-S6.2:14	6/2	
+A0-X6:I3		6/9	+A0-W6.1:3		+A0-S6.4:22	6/4	
VS AUTOMATIC Ormhøjgårdvej 15 DK-8700 Horsens Tlf. +45 75 64 18 99		Customer: Hedensted Gruppen A/S			Designer: tbt		Case no: Bodydru
		Project: Ø150 Bodydrum 2017			Printed: 22-05-2018		Rev.:
		Pagetitel: Cable list			Checked: 10-10-2017		Page: 12 of 14

[illegible]



Hose colors
 RED = cylinder +
 BLUE = cylinder -



Revision:	Approved	Date:	Revision Description
1	KL	28-08-2017	Made

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			DS/ISO 2768-m	A2
		Surface properties:		Sheet:
	Part No.:	Material:		1 / 1
	190050			
	Diagram:			
	Airdiagram XL Bodydrum 2017_01			
	Parts list:			
	Parts list XL Bodydrum 2017_01			



Hedensted Gruppen A/S

Diagram		Airdiagram XL Bodydrum 2017_01		Rev: 01	
Bom no.		Parts list XL Bodydrum 2017_01		Sign. KL	
Title		HG 150cm XL Bodydrum			
Pos	Qty	Description	HG no.	Supplier no.	Comment
1	1	Cylinder PRA/182032/M/250	212062	PRA/182032/M/250	C1
2	2	F-Joint QM/8025/25	214115	QM/8020/25	
3	4	Flow control banjo Ø6 x 1/8"	215105	C0K510618	
4	4	Cylinder PRA/182080/M/125	M102618	PRA/182080/M/125	C2+C3+C5+C6
5	4	F-Joint QM/8080/25	214128	QM/8080/25	
6	4	L-connector 3/8" x Ø8 x Ø8	216427	C02680838	
7	4	Straight connector Ø8 x 3/8"	215938	C02250838	
8	1	Cylinder PRA/182032/M/200	212063	PRA/182032/M/200	C4
9	1	D-Bracket QA/8032/23	214156	QA/8032/23	
10	4	Valve 5/2 1/4" 24VDC/Spring	195396	V51B517A-A213J	V1+V2+V3+V4
11	4	Cable w. elbow plug 22mm 3P 1M 250v	215185	M/P43313/1	
12	1	Manifold V51 for 5x5/2 valves	195397	V51B505	
13	1	Blanking plate for V51 manifold	195399	V510551	
14	2	Filter sintered 1/4"	216797	T40C-2800	
15	3	Plug 1/4" inside hex	216743	M100028	
16	5	Straight connector Ø6 x 1/4"	215930	C02250628	
17	4	Straight connector Ø8 x 1/4"	215934	C02250828	
18	2	Elbow swivel Ø8 x 1/4"	216537	C02470828	
19	1	Regulator with filter 1/4" 0,3-10 bar (AutoDrain)	210178	B72G-2GK-AL3-RMN	FR
20	1	Gauge 0-10 bar 1/8" Ø40	215550	18-013-989	
21	1	Nut, panel mount 4248-01	215530	4248-01	
22	1	Quick release coupling Plug 1/4" female	217040	CEJN 320	
23	1	Elbow swivel Ø8 x 1/4"t	M101466	C01470828	
24					