

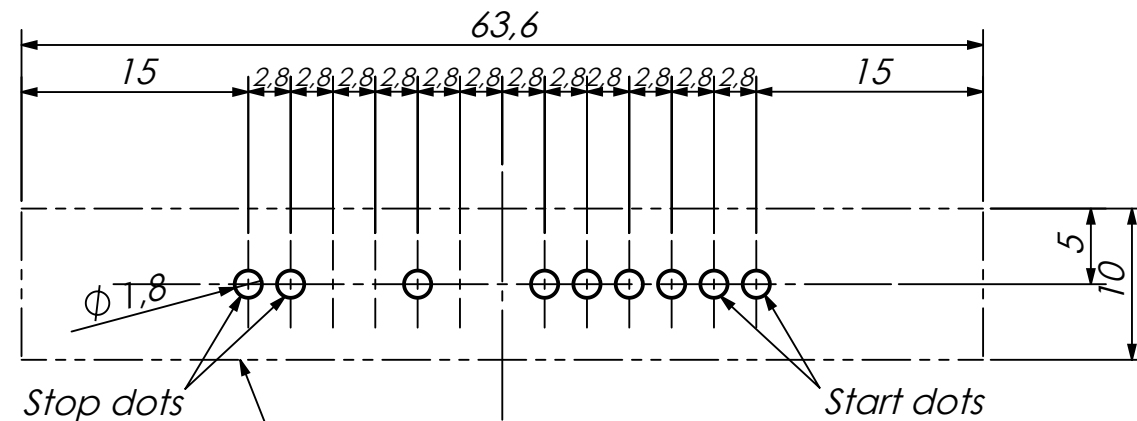
Dot position detail ("o" represent engraved "dots")

Cavity No.	14	13	12	11	10	9	8	7	6	5	4	3	2	1
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Mould cavity view

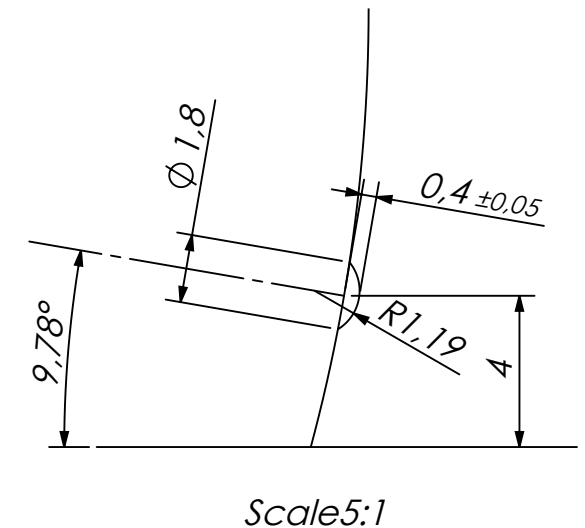
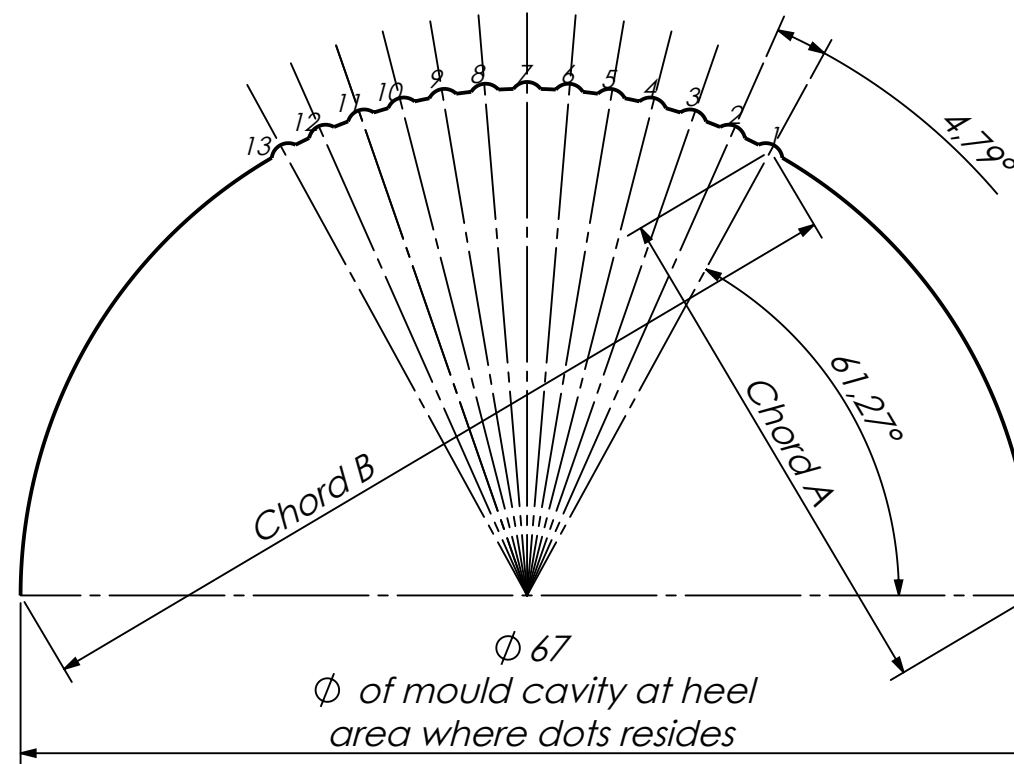
The chart shows the dot patterns as they appear when looking into the mould cavity held vertically in front of observer

Tolerance between dots ± 0.25

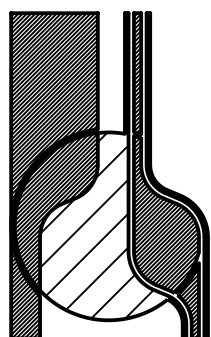


Window designating clear area around dotcode
(No heel engraving within windows specified area)

	Chord A	Chord B
1	34,14	57,65
2	36,52	56,17
3	38,83	54,6
4	41,08	52,93
5	43,26	51,17
6	45,36	49,31
7	47,38	47,38
8	49,31	45,36
9	51,17	43,26
10	52,93	41,08
11	54,6	38,83
12	56,17	36,52
13	57,65	34,14



INVERT CENTRE : -
'H' DIMENSION : -
ASSEMBLY : -
SCALE : 2:1

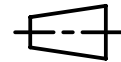


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DO NOT SCALE DRAWING
IF IN DOUBT ASK

TOLERANCES UNLESS OTHERWISE SPECIFIED
DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05
REMOVE BURRS & SHARP EDGES IN
ACCORDANCE TO STANDARD PRACTICE



THIRD ANGLE
PROJECTION

SURFACE FINISH
CAST: ~ ROUGH ~ FINE: ~ POLISH: ~

JOB NAME 2-500-18 DESANT

ITEM POWERS 16049A DOTCODE

CUSTOMER BELSTEKLOPROM

ORDER NO. 20180155

MATERIAL -

MACHINE Heye 5" BB DG

QUANTITY -

REF. NO.

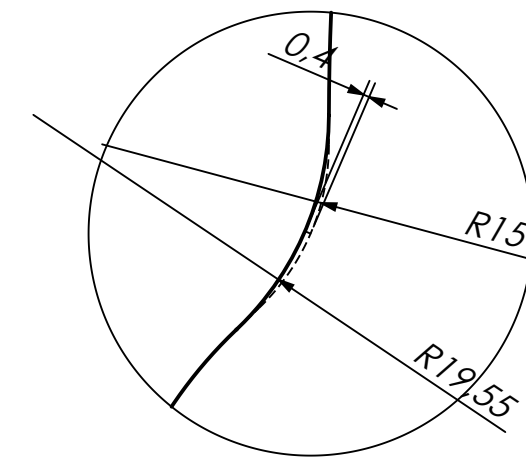
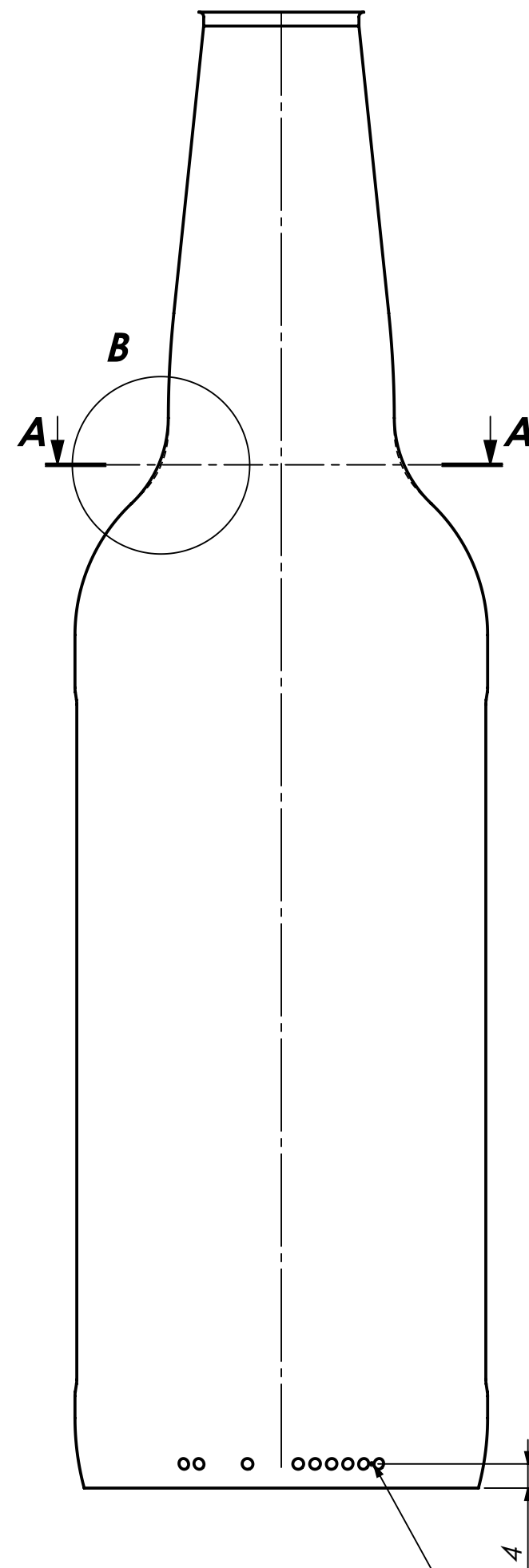
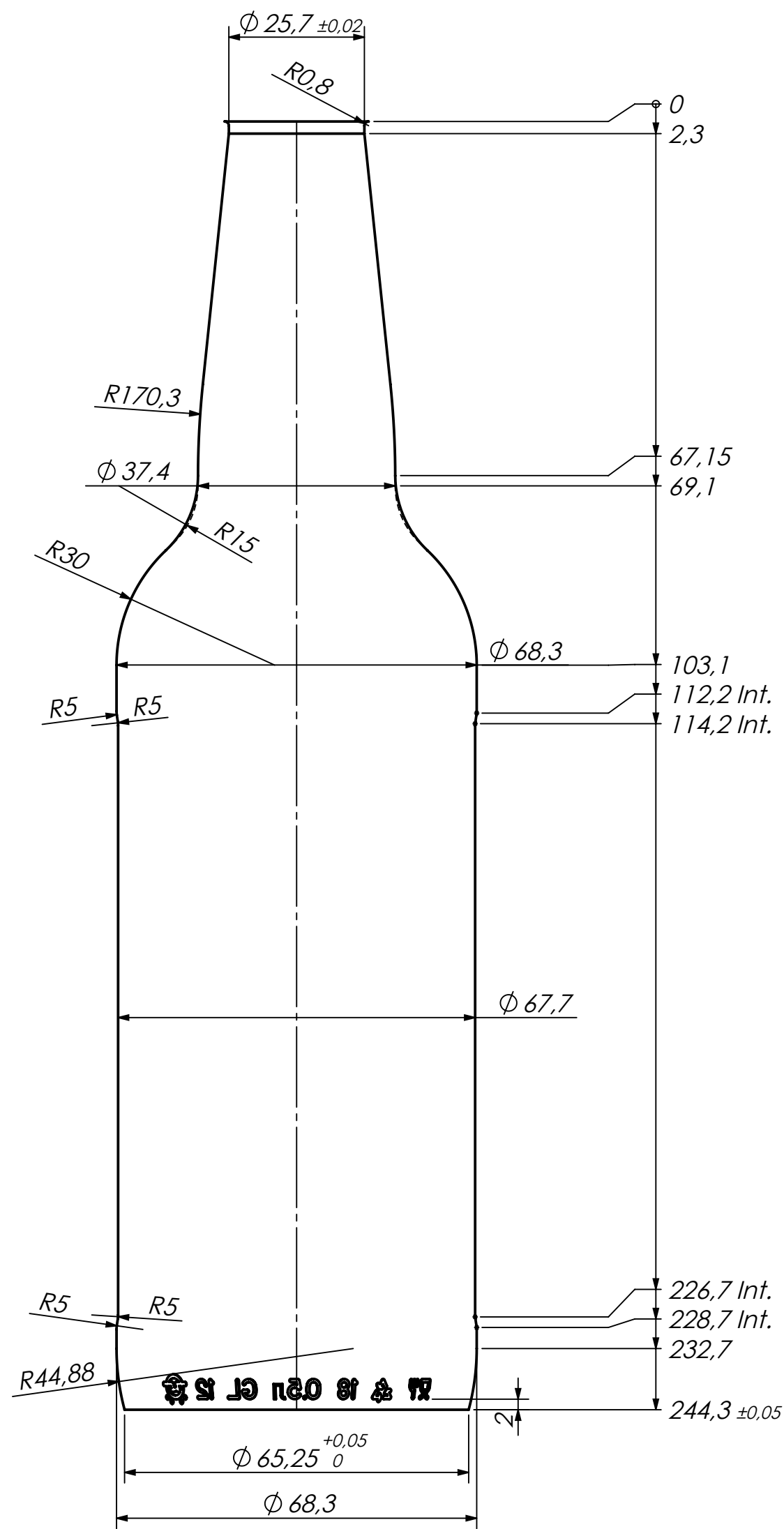
DRAWN BY JBB

CHECKED BY

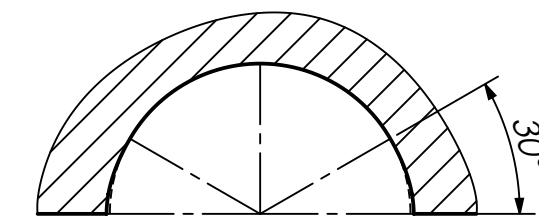
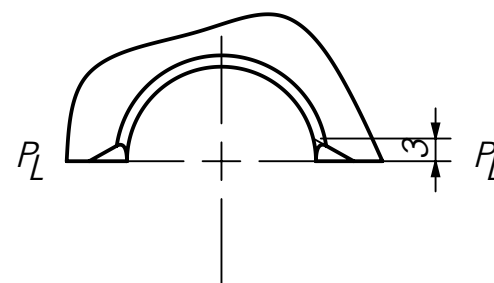
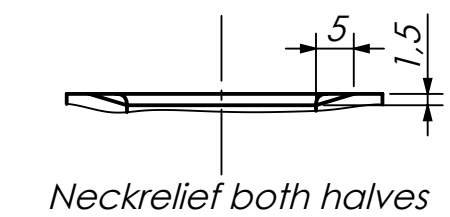
DATE 4-8-2018

REVISIONS

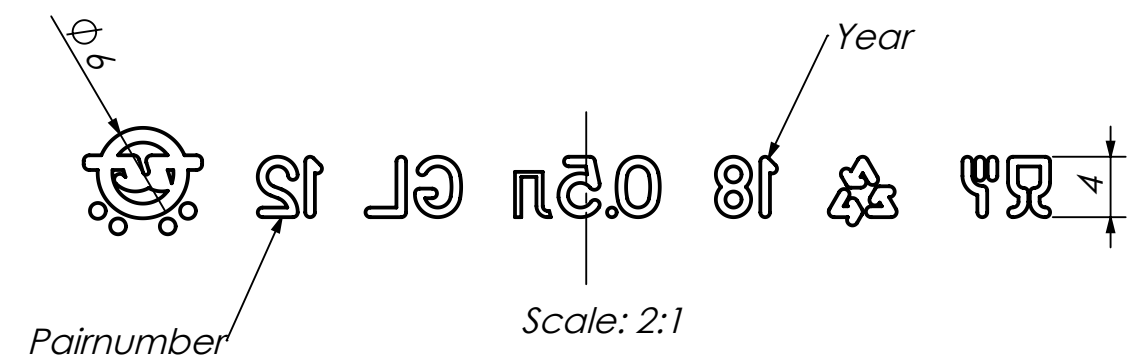
DRG No: BIEB781-09



B (2 : 1)



A-A

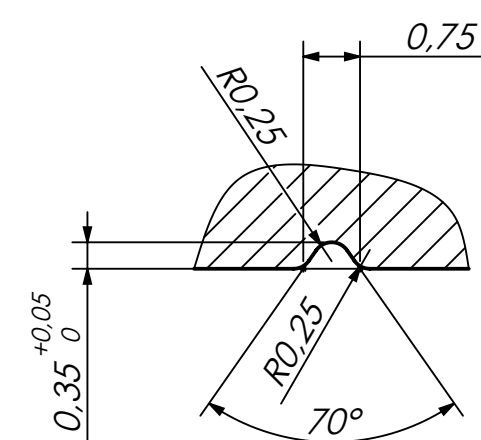


9 dot heel code
see drawing AS781-03-13

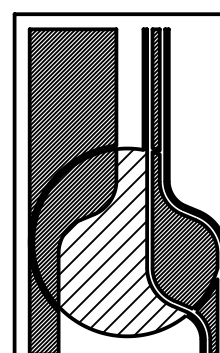
Volume mould+botto	655,30 ml	653,47 gr	+/- 0,8
Volume mould	649,60 ml	647,79 gr	
Volume bottom	5,70 ml		

1,0028 Conversion factor gr ml

INVERT CENTRE :-
'H' DIMENSION :-
ASSEMBLY :-
SCALE : 1:1



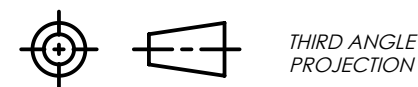
Heel engraving
profile 10:1



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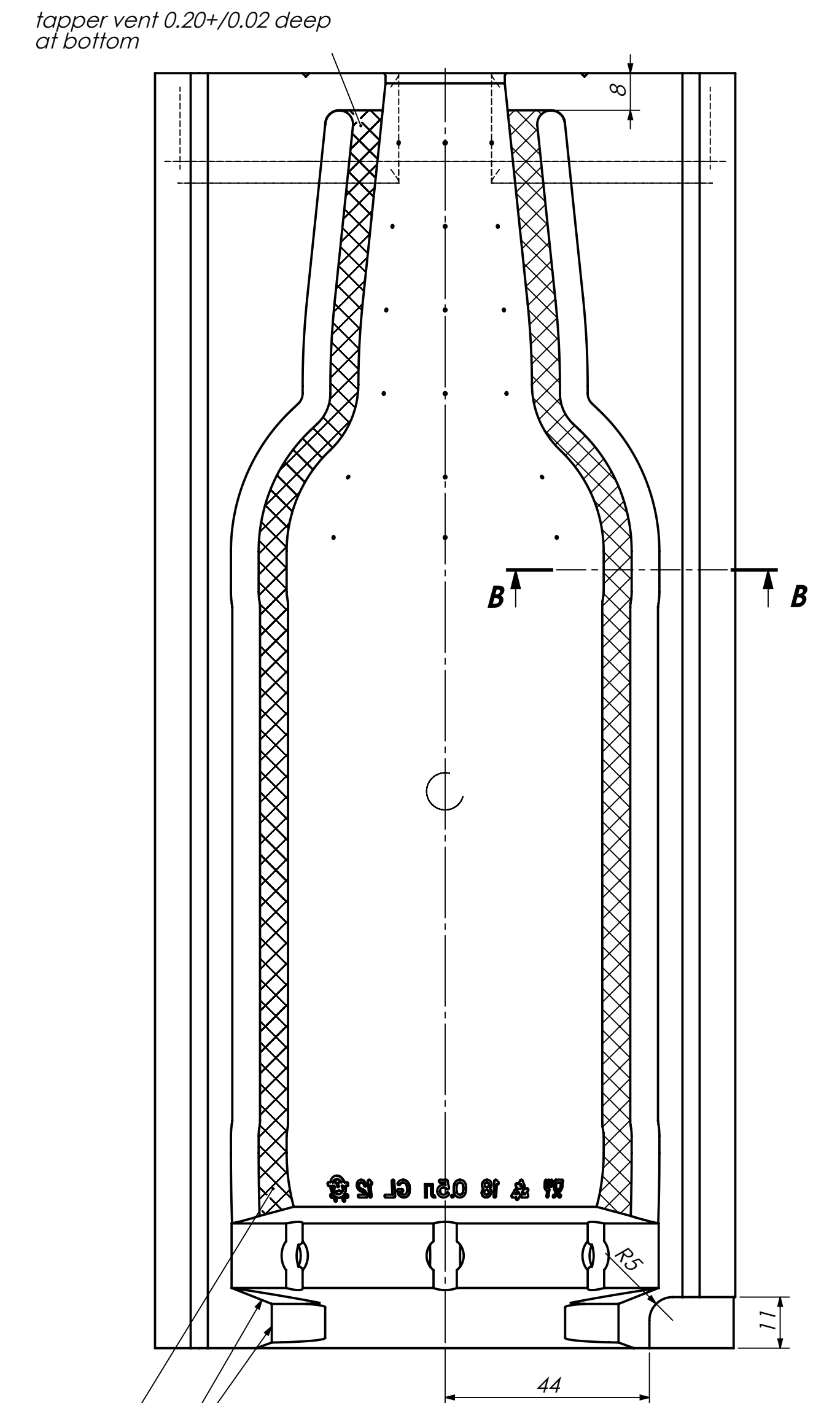
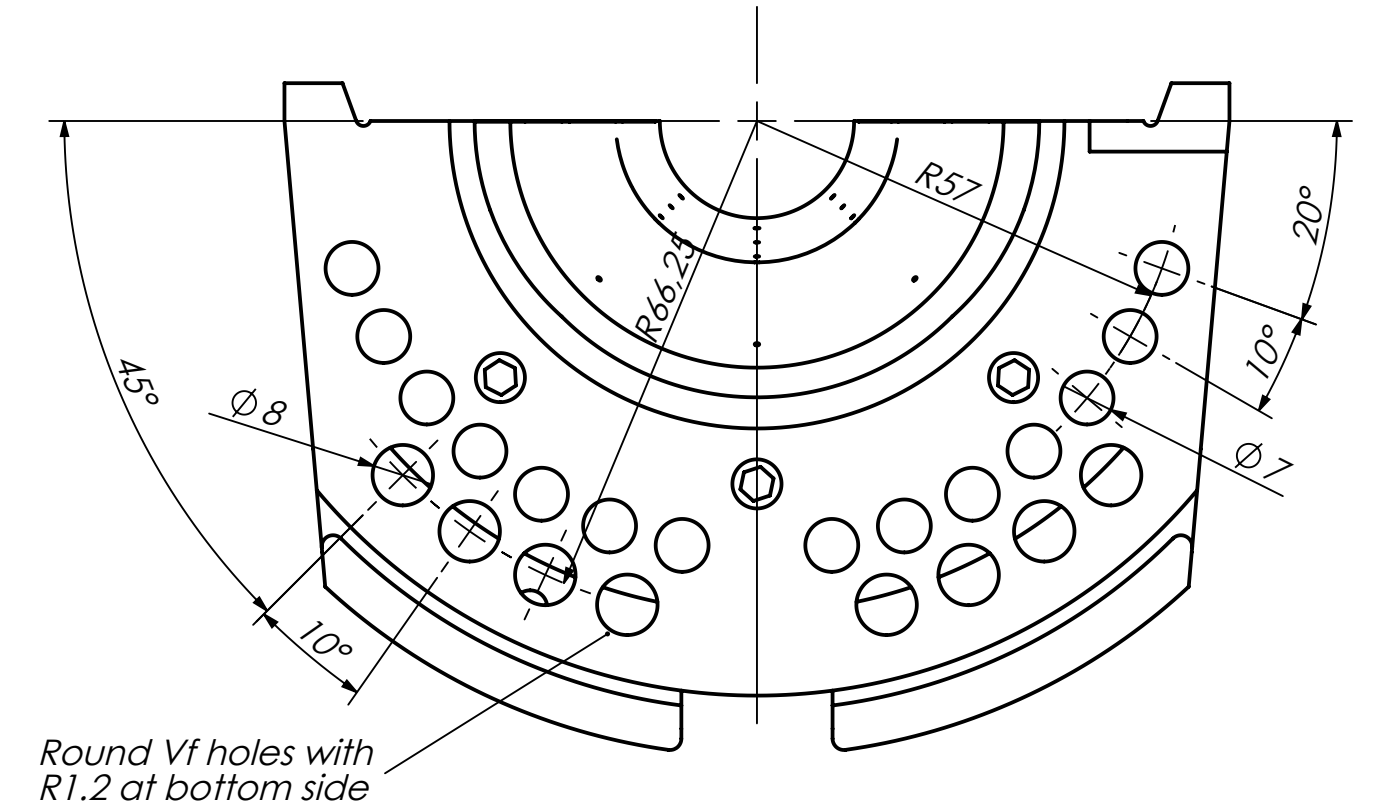
DO NOT SCALE DRAWING
IF IN DOUBT ASK

TOLERANCES UNLESS OTHERWISE SPECIFIED
DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05
REMOVE BURRS & SHARP EDGES IN
ACCORDANCE TO STANDARD PRACTICE



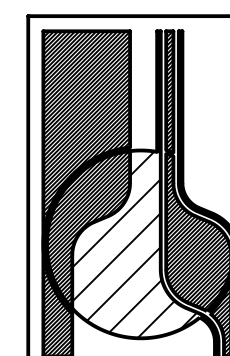
SURFACE FINISH
CAST: ~ ROUGH FINE: ~ POLISH: ~

JOB NAME	2-500-18 DESANT			Rev A neck dia was 25.2	
ITEM	BLOWMOULD CAVITY	QUANTITY	28		
CUSTOMER	BELSTEKLOPPROM	REF. NO.			
ORDER NO.	20180155	DRAWN BY		REVISIONS	
MATERIAL	-	CHECKED BY			
MACHINE	Heye 5" BB DG	DATE	7-8-2018	DRG No: BIEB781-07 A	




SECTION B-B
SCALE (2 : 1)

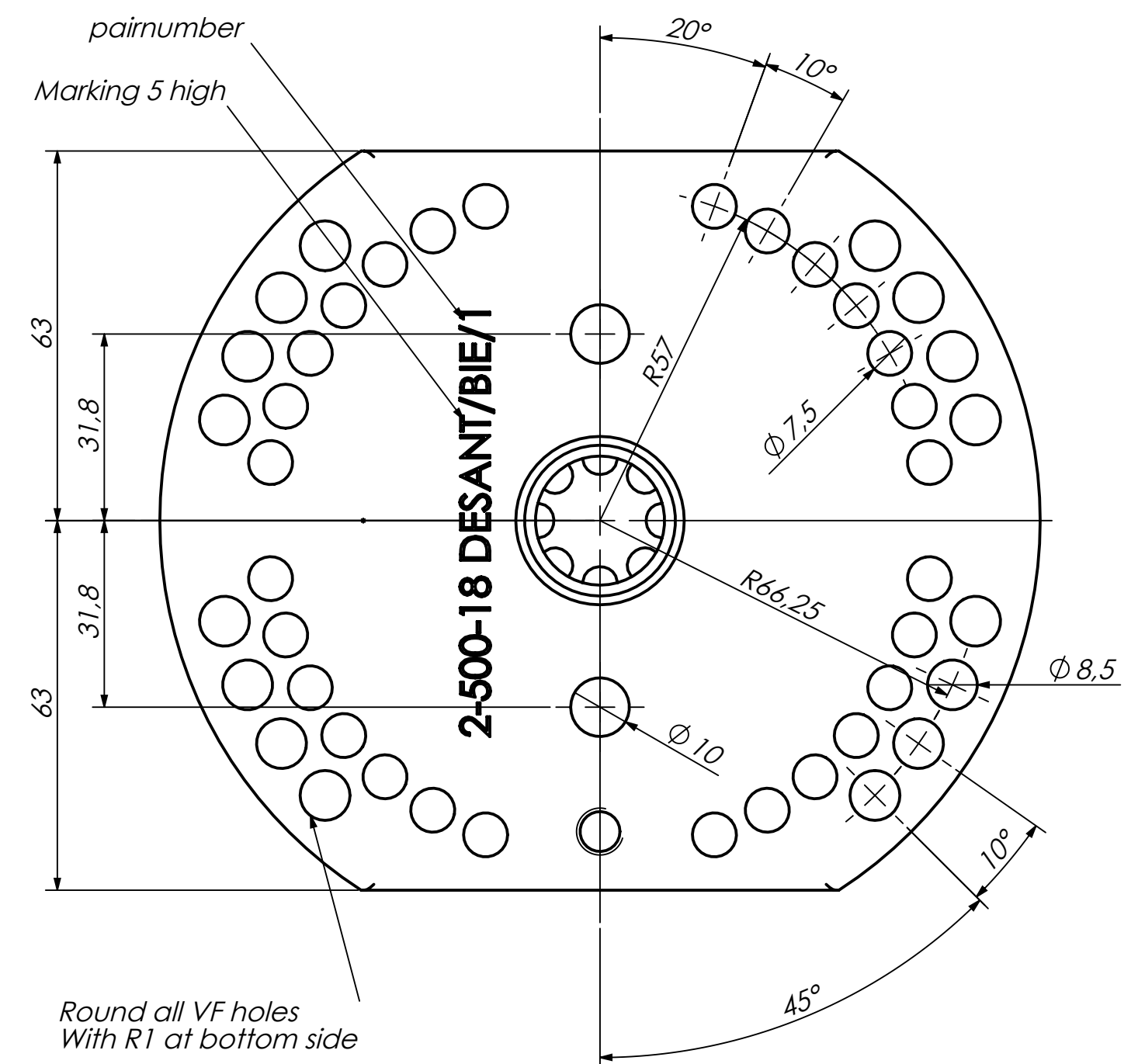
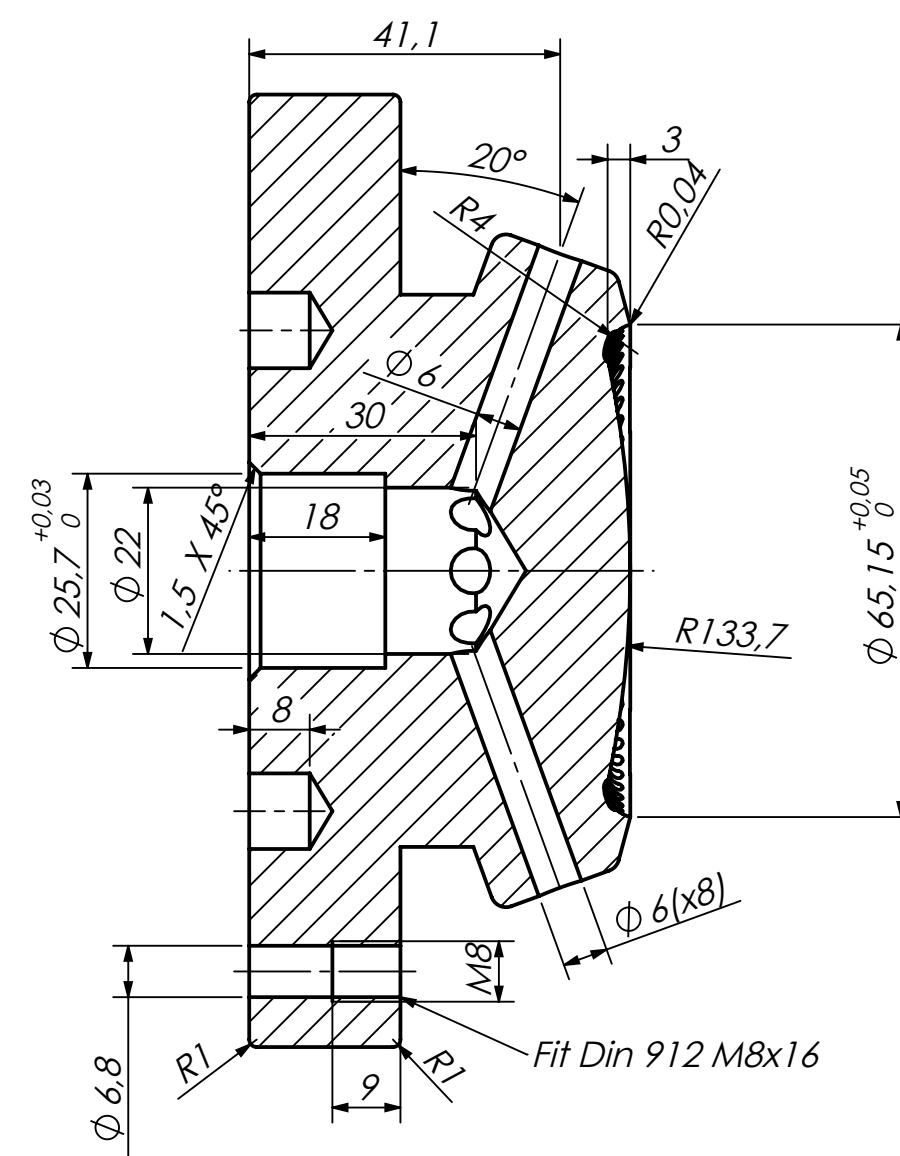
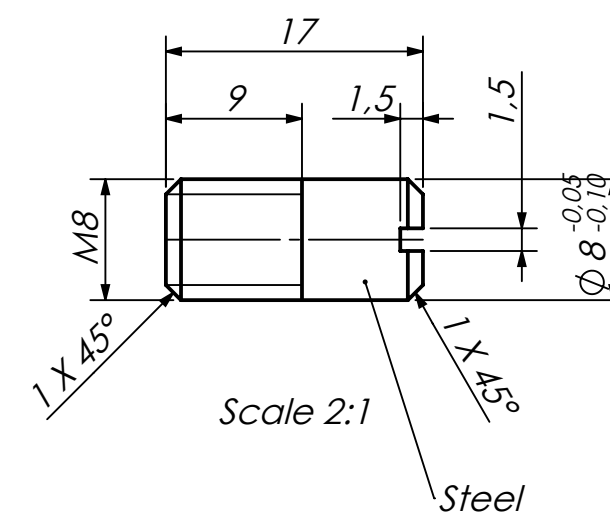
Half & half tolerance 0.05



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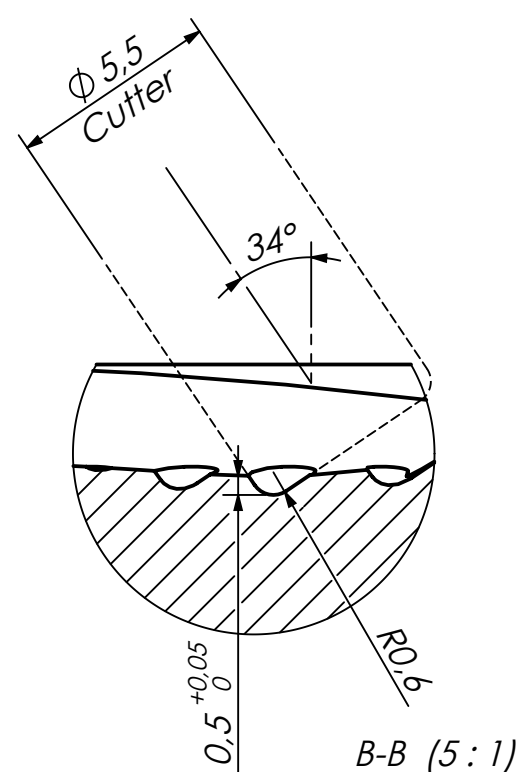
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Fax.: +32(0)51 689182
Email: info@biebouw.com

DO NOT SCALE DRAWING IF IN DOUBT ASK		JOB NAME		2-500-18 DESANT		Rev A neck dia was 25.2/ locator was 13.1	
TOLERANCES UNLESS OTHERWISE SPECIFIED DIM: 0.1-0.2 DIMS: 0.00-0.05 REMOVE BURRS & SHARP EDGES IN ACCORDANCE TO STANDARD PRACTICE		ITEM		BLOWMOULD		QUANTITY 28	
		CUSTOMER		BELSTEKLOPROM		REF. NO.	
 THIRD ANGLE PROJECTION		ORDER NO.		20180155		DRAWN BY JBB	
		MATERIAL		Cast iron Q3		REVISIONS	
SURFACE FINISH CAST: ~ RINE: ~ POLISH: ~		MACHINE		Heye 5" BB DG		CHECKED BY DATE 7-8-2018 DRG No: BIEB781-05 A	

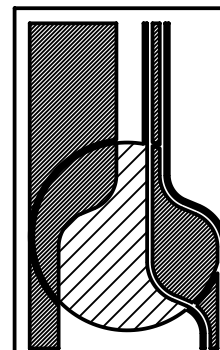


Round all VF holes
With R1 at bottom side

INVERT CENTRE :-
'H' DIMENSION :-
ASSEMBLY :-
SCALE : 1:1



hardweld match 3wide 1.5 deep








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SURFACE FINISH
CAST: ~ ROUGH: ▽ FINE: ▽▽ POLISH: ▽▽▽

MACHINE	Heye 5" BB DG	DATE	7-8
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DRG No: BIEB781-10 A

DO NOT SCALE DRAWING IF IN DOUBT ASK		JOB NAME 2-500-18 DESANT			Rev A Modified to bieb702 bottom	
TOLERANCES UNLESS OTHERWISE SPECIFIED DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05 REMOVE BURRS & SHARP EDGES IN ACCORDANCE TO STANDARD PRACTICE		ITEM	BOTTOMPLATE	QUANTITY	28	
		CUSTOMER	BELSTEKLOPPROM	REF. NO.		
 THIRD ANGLE PROJECTION		ORDER NO.	20180155	DRAWN BY		
		MATERIAL	CI	CHECKED BY		
SURFACE FINISH CAST:  ROUGH  FINE  POLISH: 		MACHINE	Heye 5" BB DG	DATE	7-8-2018	
					DRG No: BIEB781-10 A	