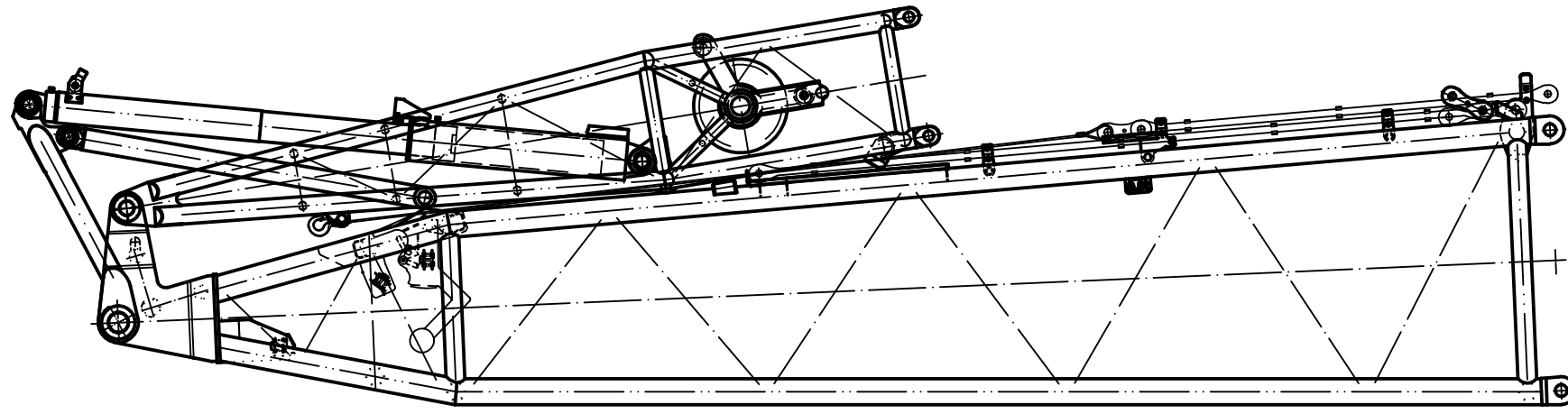


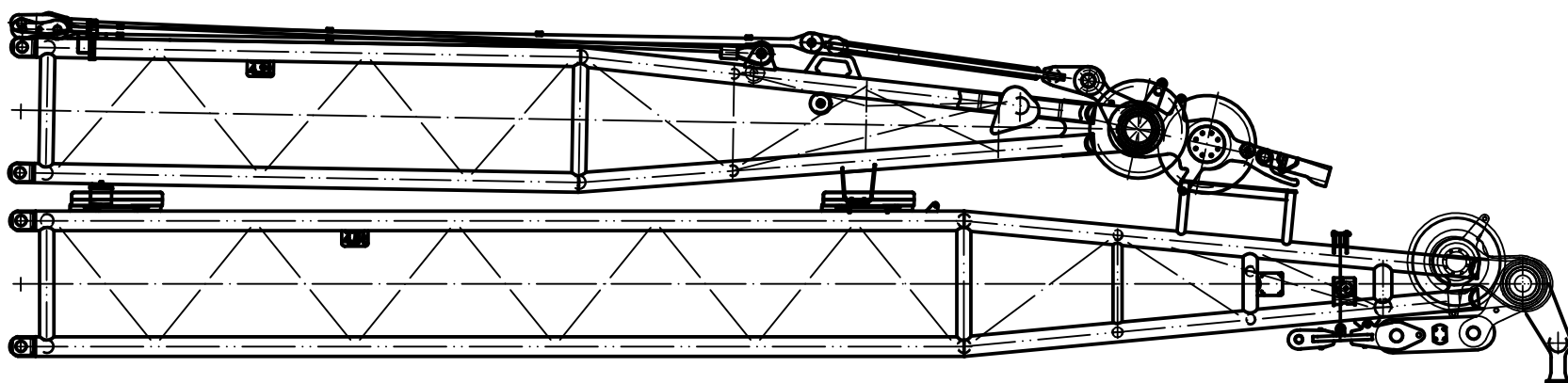
Transport unit 1 approx.10t

W-pivot section
WA-frame 1 pivot section
W-relapse retainer



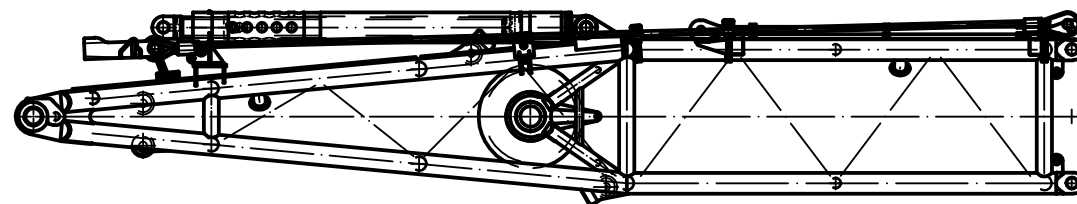
Transport unit 2 approx.9t

WA-frame 1 end section
WA-frame 2 end section

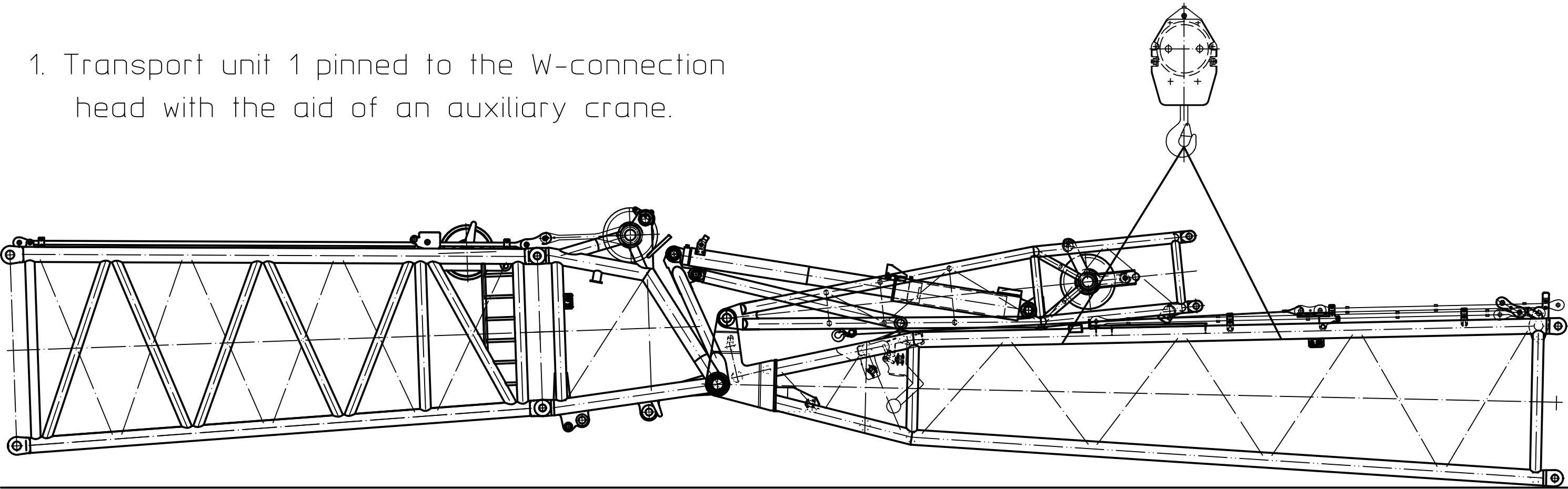


Transport unit 3 approx.4t

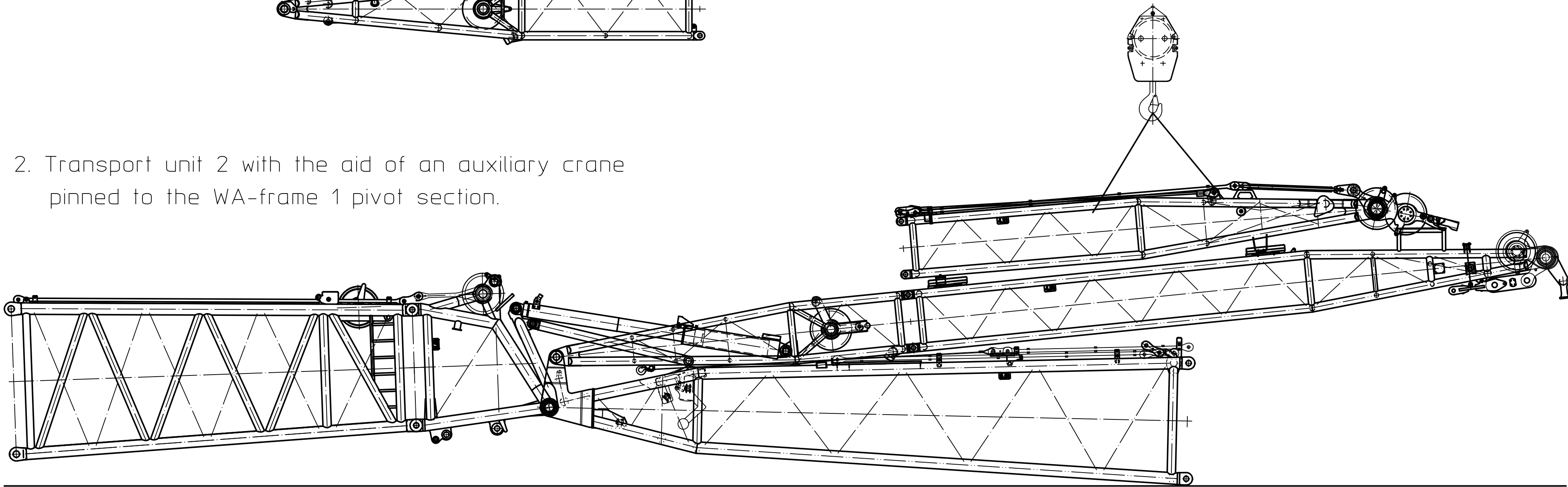
WA-frame 2 pivot section



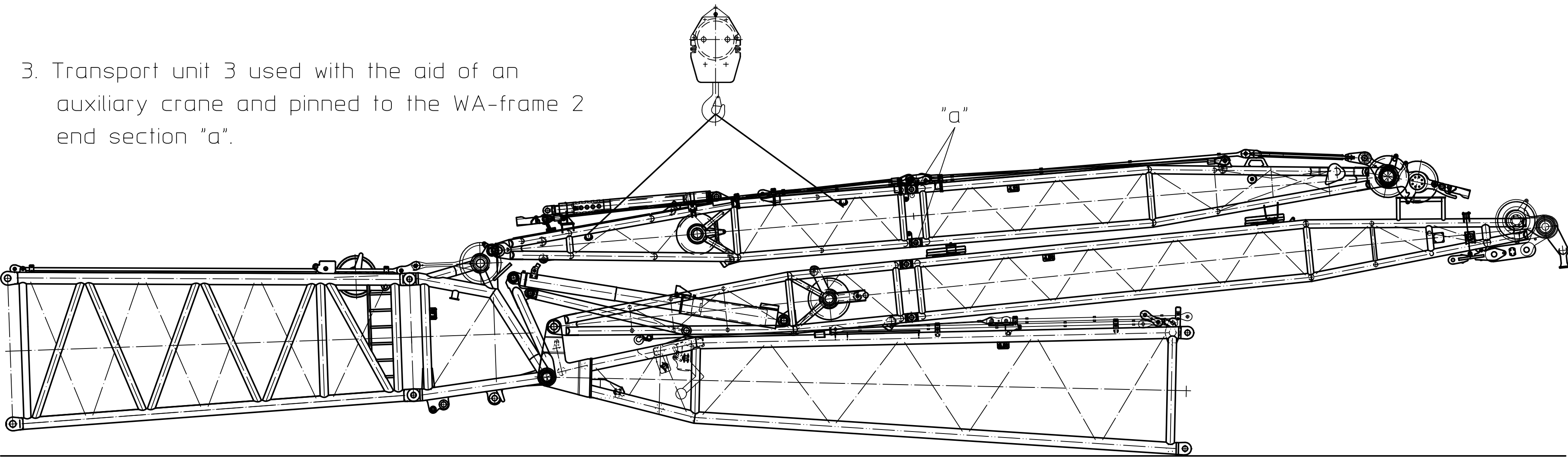
1. Transport unit 1 pinned to the W-connection head with the aid of an auxiliary crane.



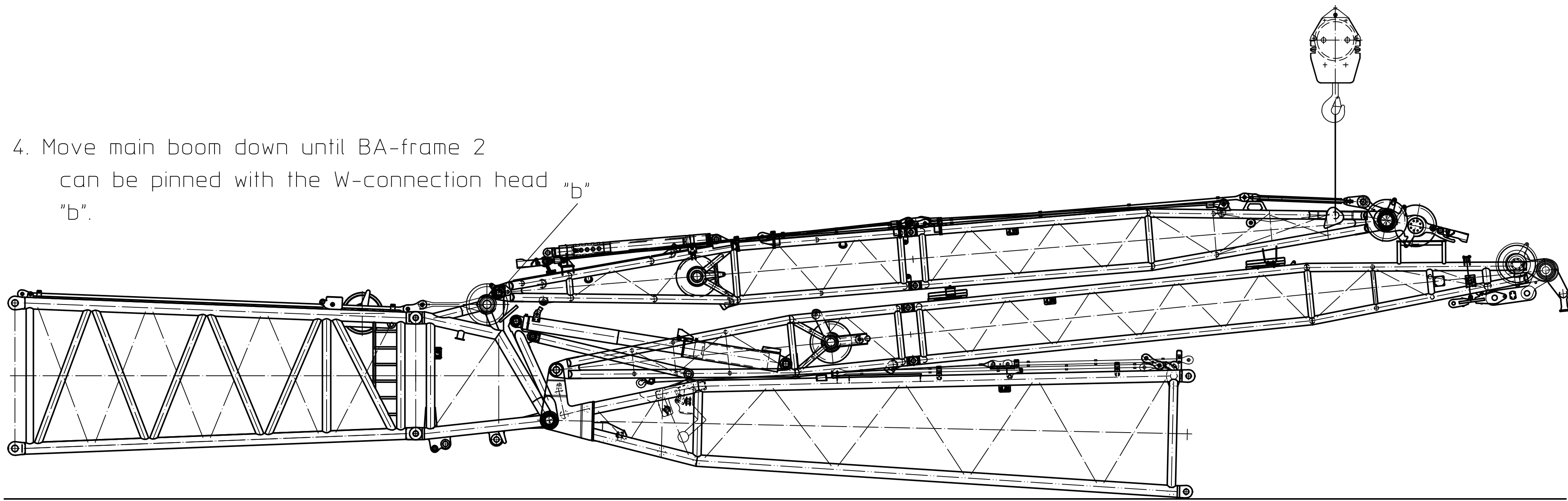
2. Transport unit 2 with the aid of an auxiliary crane pinned to the WA-frame 1 pivot section.



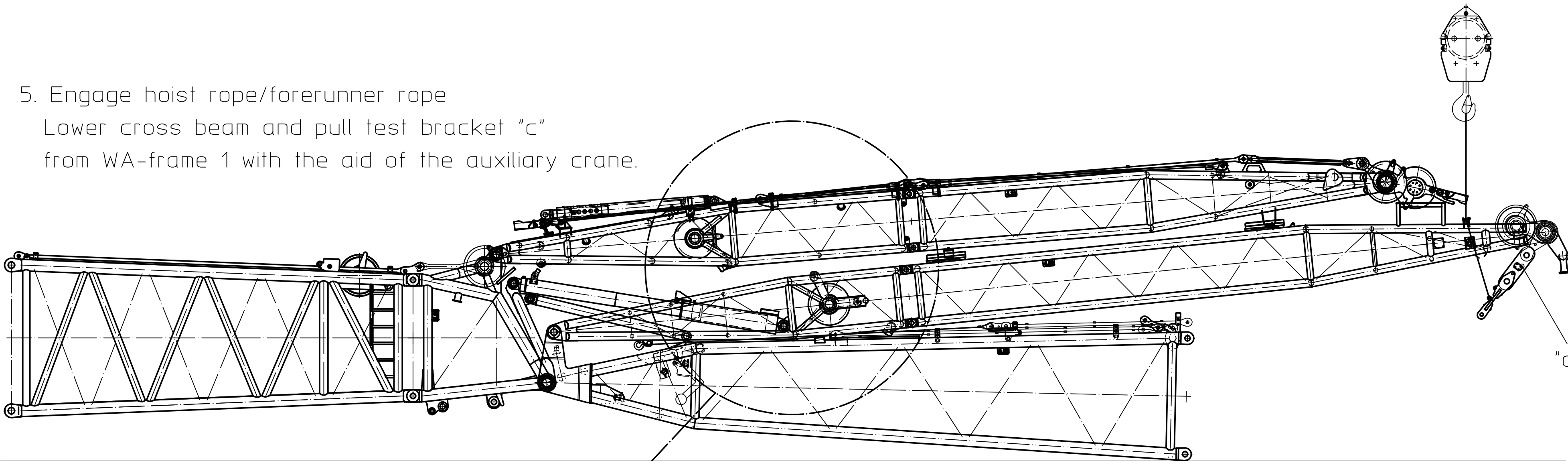
3. Transport unit 3 used with the aid of an auxiliary crane and pinned to the WA-frame 2 end section "a".



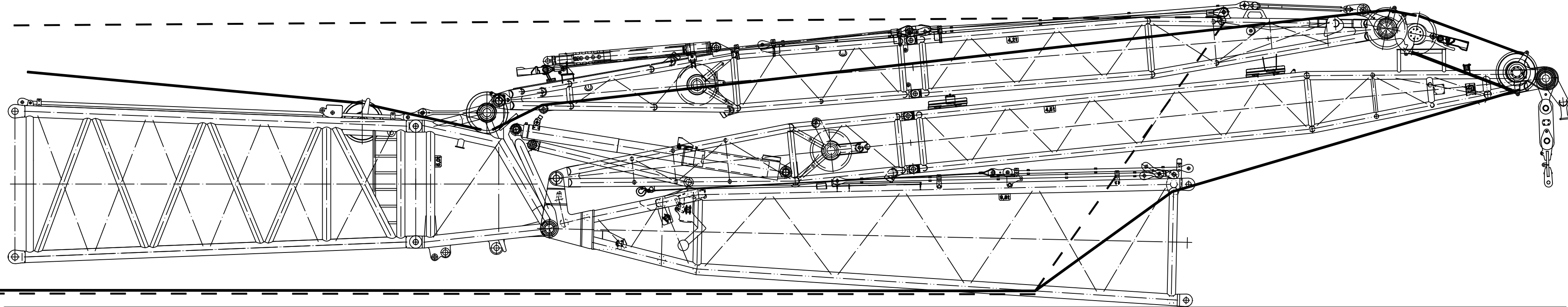
4. Move main boom down until BA-frame 2 can be pinned with the W-connection head "b".



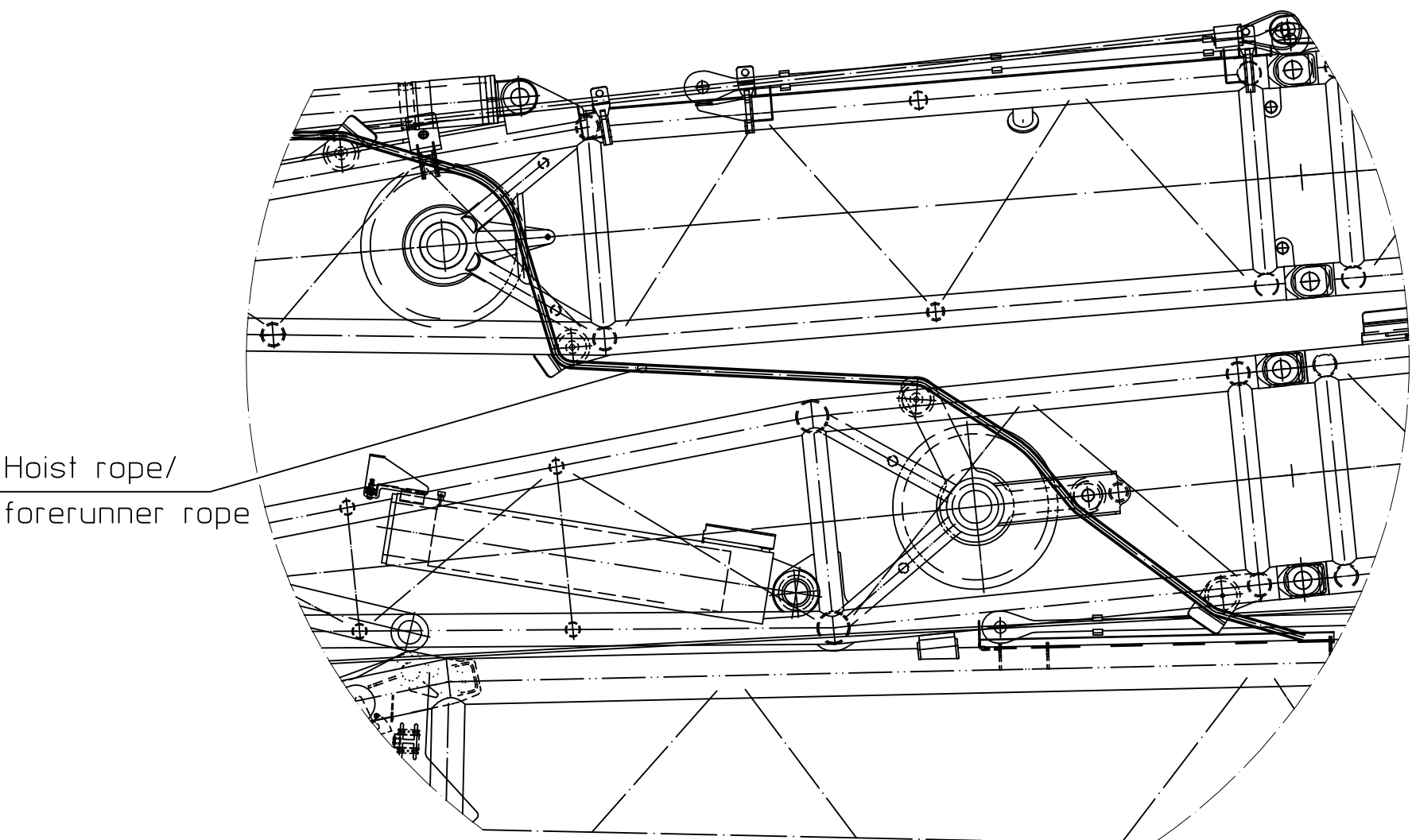
5. Engage hoist rope/forerunner rope
Lower cross beam and pull test bracket "c" from WA-frame 1 with the aid of the auxiliary crane.



6. Pull the W-control rope in.



Hoist rope run



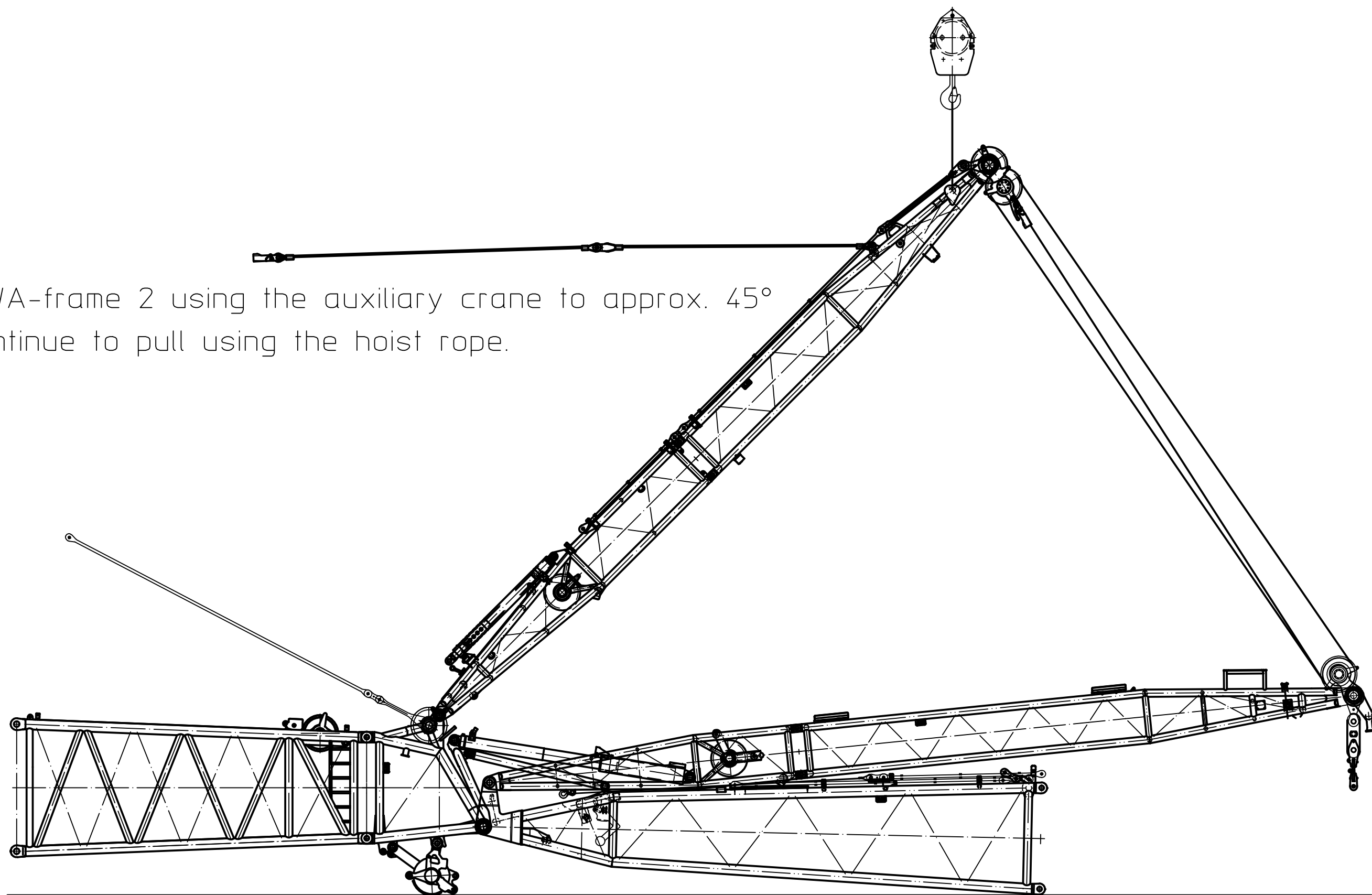
--- Rope run for getting the W-control rope
— Rope run for pulling in the N-control rope

Static inspected: Administrator Date Name
Dep. manager
Comment: Change 003 statically irrelevant.

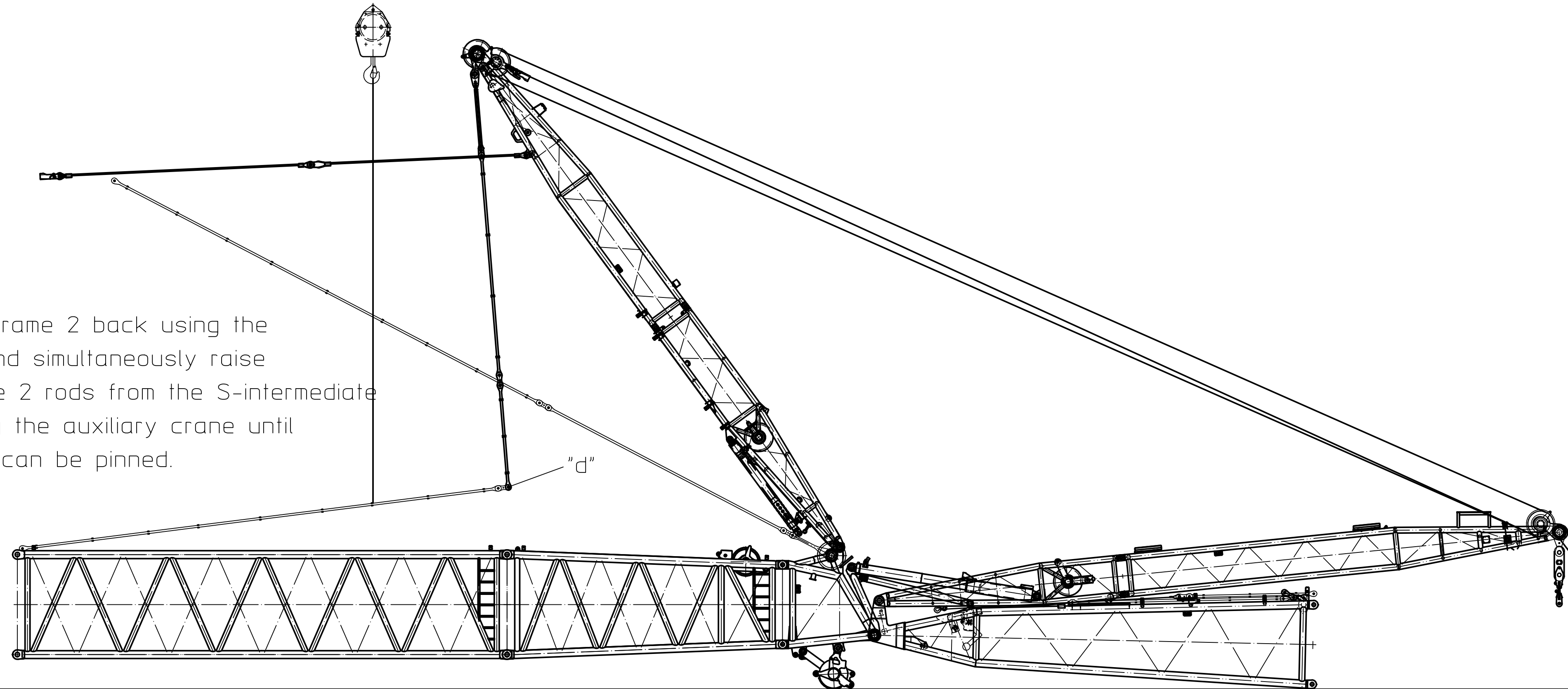
Page 01 from 03

Fertiggewicht/Weight/Poids		Toleranz Tolerance tolérance	ISO 8015	Weitere Anforderungen siehe Teilkonzerte further specifications see parts master record autres spécifications cf. nomenclature	
Dokumentation Documentation		Bearbeitung/Finish/Usinage	Rechtbearbeitung rectifying venage mécanique	ISO 2768-mk	
			Schweißkonstruktionen welded structure Constructions soudées	ISO 13920 BF	Für die Herstellung der Liefergegenstände gönnen die aktuellen Fertigungsunterlagen for the delivery of all items the newest documents apply
			Brandschneiden thermal cutting coupage thermique	ISO 9013-442	Les documents de fabrication actuels à appliquer s'y lisent référer de l'ordre de livraison
Projektion E Scale Echelle		Datum Date/Date	Name Name/Non	AO	
150		15.02.2008	SAR	LIEBHERR LIEBHERR-WERK EHINGEN GMBH	
Bezeichnung/Description/Dénomination		Zeichnungs Nr./Drawing No./N°de dessin			
W-ASSEMBLY		1666-720.00.03.002-003			
		Ident Nr./Ident No./N°d'ident			
		9866 563 08			

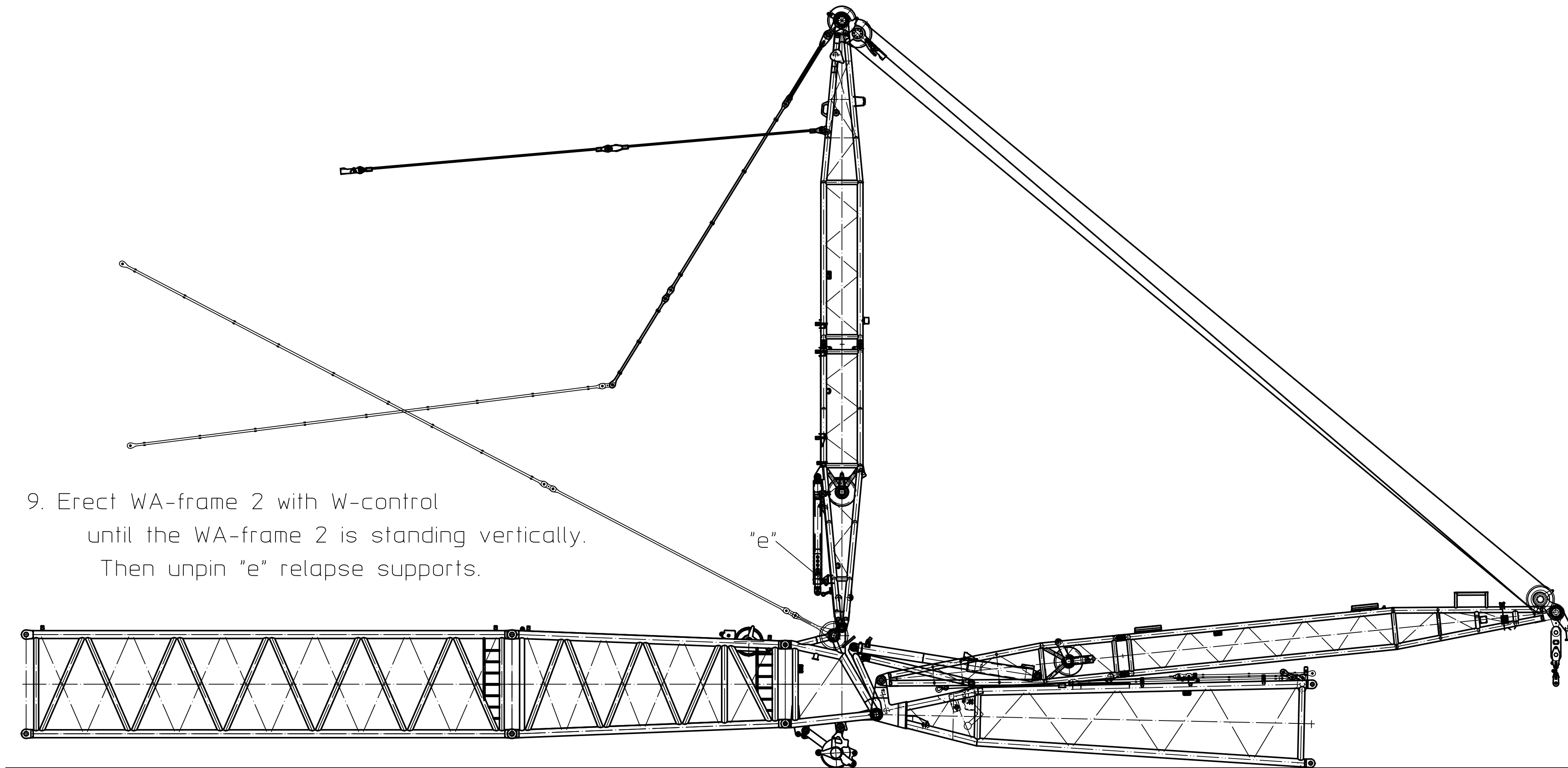
7. Pull the WA-frame 2 using the auxiliary crane to approx. 45° then continue to pull using the hoist rope.



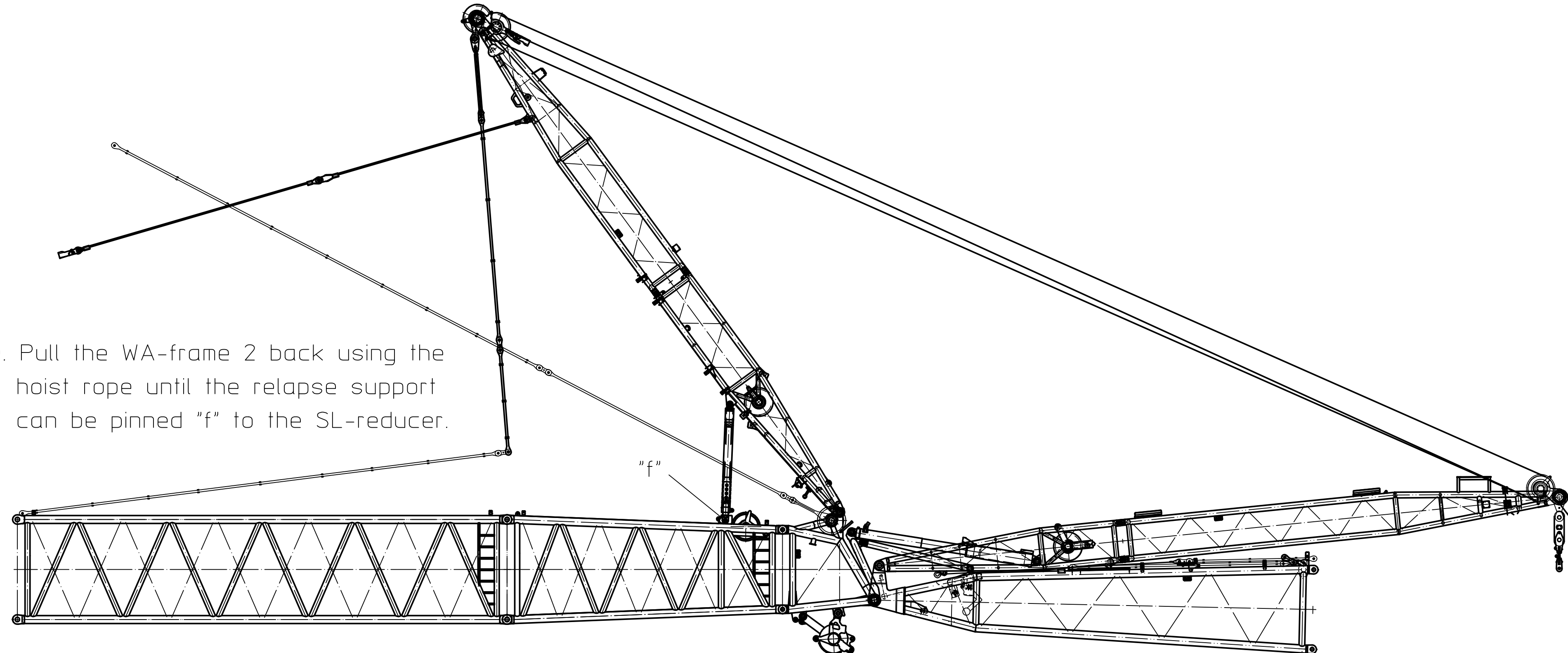
8. Pull the WA-frame 2 back using the hoist rope and simultaneously raise the WA-frame 2 rods from the S-intermediate section using the auxiliary crane until the rods "d" can be pinned.



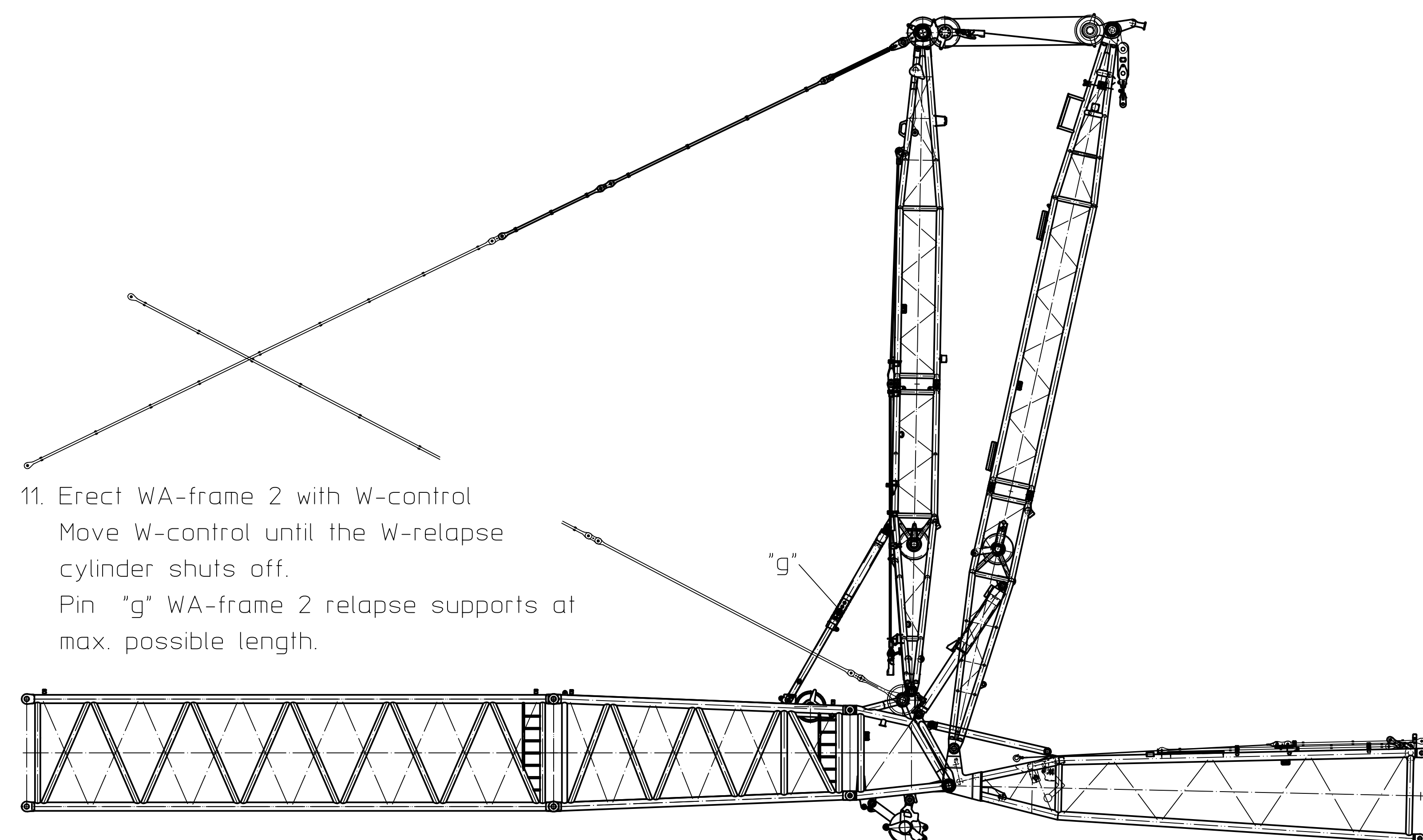
9. Erect WA-frame 2 with W-control until the WA-frame 2 is standing vertically. Then unpin "e" relapse supports.



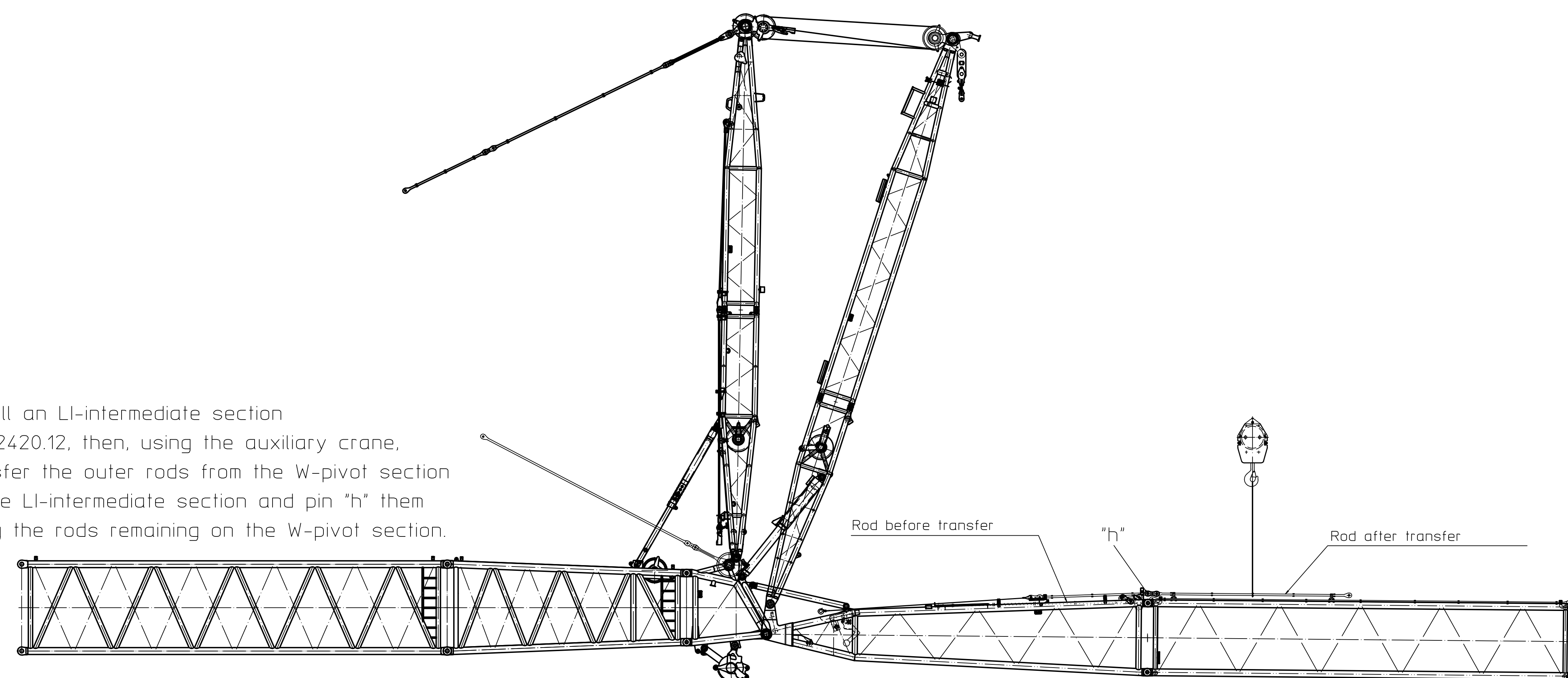
10. Pull the WA-frame 2 back using the hoist rope until the relapse support can be pinned "f" to the SL-reducer.



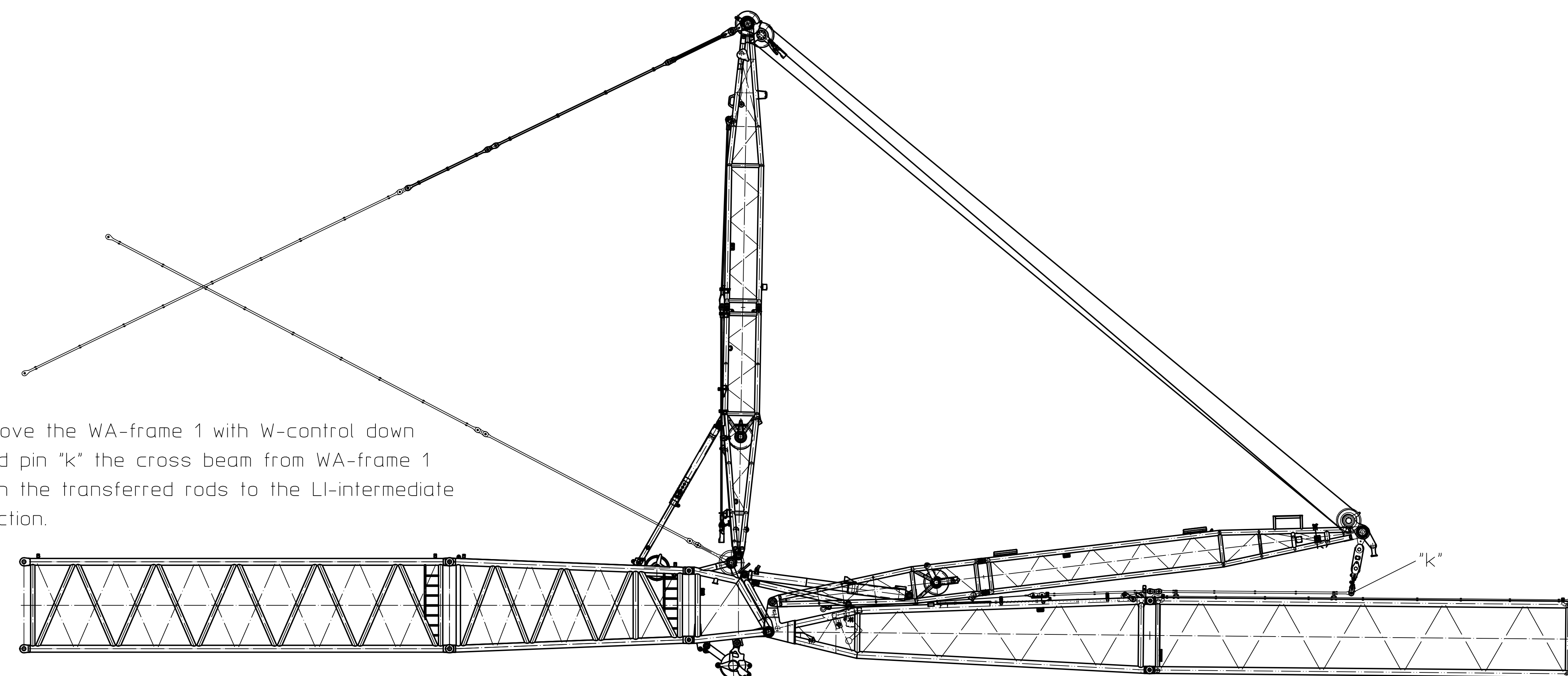
Fertiggewicht/Weight/Poids		Tolerierung Tolerance tolérance	ISO 8015	Weitere Anforderungen siehe Teilkonzert further specifications see parts master record autres spécifications cf. nomenclature
Mechbearbeitung machining usinage mécanique		ISO 2768-mk		
Schweißkonstruktionen welded structure Constructions soudées		ISO 13920 BF		
Brennschneiden thermal cutting coupage thermique		ISO 9013-442		Für die Herstellung der Liefergegenstände geline de schafen Fertigungsaufträgen for the delivery of all items the master documents apply Les documents de fabrication appliqués à tous les articles relatifs de l'ordre de livraison
Dokumentation Distribution Documentation	Bearbeitung/Finish/Usinage	AO		LIEBHERR LIEBHERR-WERK EHINGEN GMBH
Projektion E Projection Représentation isométrique de l'ensemble Représentation isométrique de l'ensemble Représentation isométrique de l'ensemble	Datum Date/Date 15.02.2008	Name Name/Non SAR	Zeichnungs Nr./Drawing No./No de dessin 1666-720.00.03.002-003	
Maßstab Scale Echelle	Bezeichnung/Description/Dénomination W-ASSEMBLY		Ident Nr./Ident No./No d'ident 9866 563 08	



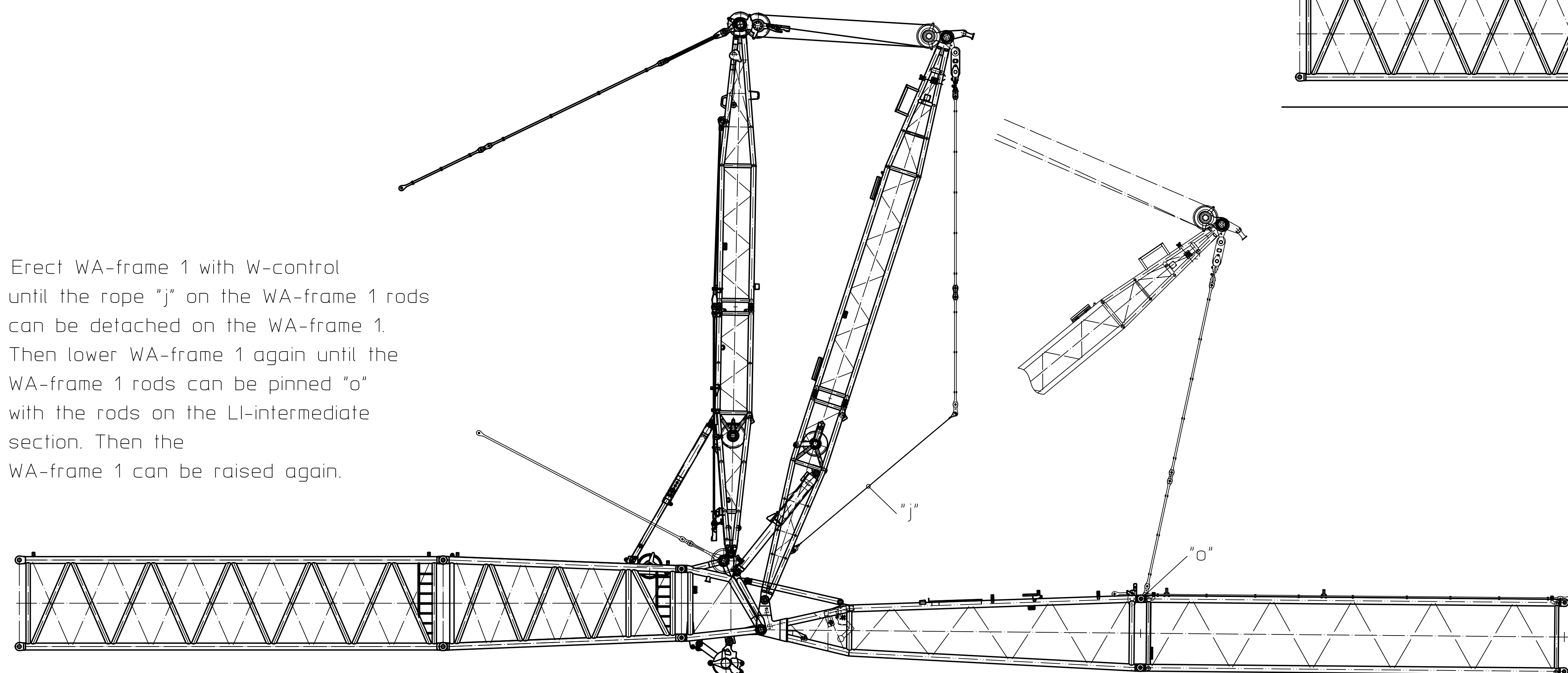
11. Erect WA-frame 2 with W-control
Move W-control until the W-relapse
cylinder shuts off.
Pin "g" WA-frame 2 relapse supports at
max. possible length.



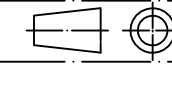
12. Install an LI-intermediate section
12m 2420.12, then, using the auxiliary crane, transfer the outer rods from the W-pivot section to the LI-intermediate section and pin "h" them using the rods remaining on the W-pivot section.



13. Move the WA-frame 1 with W-control down and pin "k" the cross beam from WA-frame 1 with the transferred rods to the LI-intermediate section.



14. Erect WA-frame 1 with W-control until the rope "j" on the WA-frame 1 rods can be detached on the WA-frame 1. Then lower WA-frame 1 again until the WA-frame 1 rods can be pinned "o" with the rods on the LI-intermediate section. Then the WA-frame 1 can be raised again.

Page 03 from 05		Ferligung/Weight/Poids		Toleranz Tolerance tolerance		ISO 80/5		Welche Anforderungen siehe Teilekatalog Sur les specifications voir page notice requi- sitions specifications et nomenclature	
Dokumentation Distribution Documentation		Bearbeitung/Finish/Usinage		Hochbearbeitung machining usinage mécanique		ISO 2768-mk		Für die Herstellung der Liefergegenstände gelten die aktuellen Fertigungsanforderungen For the delivery of all parts the latest documents apply	
Projektion E		Datum Date/Date		Name Nom/Name		ISO 1920 BF		Les documents de fabrication applicables à la fabrication relatifs à l'objet de livraison	
		15.02.2008 SAR		AO		ISO 3013-442		LIEBHERR LIEBHERR-WERK EHINGEN GMBH	
Bezeichnung/Description/Dénomination		W-ASSEMBLY		Zeichnung No./Drawing No./Dwg. dessin		1666-720.00.03.002-003		Ident No./Ident No./No'd ident	
1:75		9866 563 08		1666-720.00.03.002-003		9866 563 08		9866 563 08	