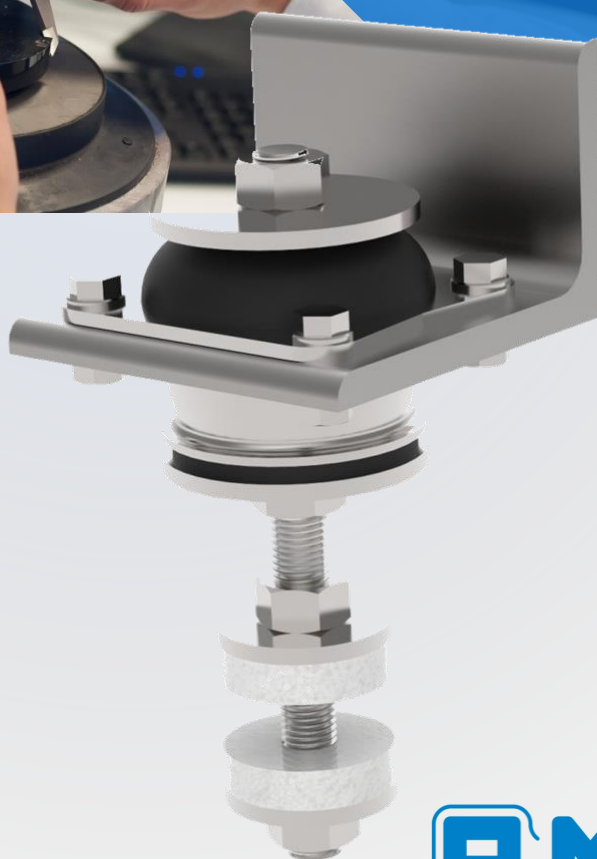




MARINE
EXHAUST MOUNTS
AMC MECANOCAUCHO®



AMC
MECANOCAUCHO

DESCRIPTION OF THE PRODUCT

ST MARINE EXHAUST MOUNTS

The ST Marine Exhaust mounts from AMC-MECANOCAUCHO are designed for to suspend exhaust ducts in Marine applications. Their particular design allows the duct to displace when exposed to thermal expansions and contractions. There are 11 different models to suit hanging loads from 40Kg to 2000Kg.

All the ST Marine Exhaust mounts are equipped with interlocking metal parts to withstand to high compression and traction loads. This failsafe feature provides an extra safety for the application.

SFT MARINE EXHAUST MOUNTS

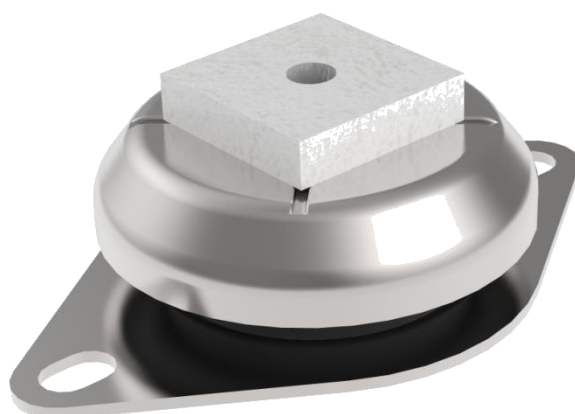
The SFT Marine Exhaust mounts from AMC-MECANOCAUCHO are designed for to suspend exhaust ducts in Marine applications. Their particular design suspend ducts and provide a lateral stability. There are 11 different models to suit hanging loads from 40Kg to 2000Kg.

All the SFT Marine Exhaust mounts are equipped with interlocking metal parts to withstand to high compression and traction loads. This failsafe feature provides an extra safety for the application.

SFC MARINE EXHAUST MOUNTS

The SFC Marine Exhaust mounts from AMC-MECANOCAUCHO are designed for to support exhaust ducts in Marine applications. Their particular design support ducts and provide a lateral stability. There are 4 different models to suit hanging loads from 270Kg to 3400Kg.

All the SFC Marine Exhaust mounts are equipped with interlocking metal parts to withstand to high compression and traction loads. This failsafe feature provides an extra safety for the application. They also incorporate a thermal insulation plate to prevent the compound to be exposed to high temperatures that may put in risk the thermostability of the elastic compound.



DESCRIPTION OF THE PRODUCT

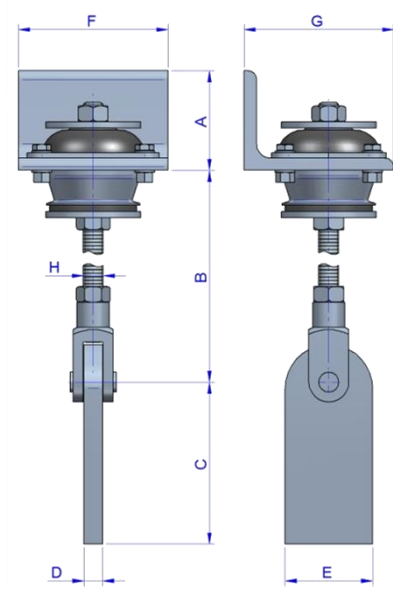
EXPANSION JOINTS

Expansion joints for marine exhausts are designed to absorb movement, vibration and thermal expansion in boat exhaust systems, protecting the line and reducing stress on engines, manifolds, silencers and supports.

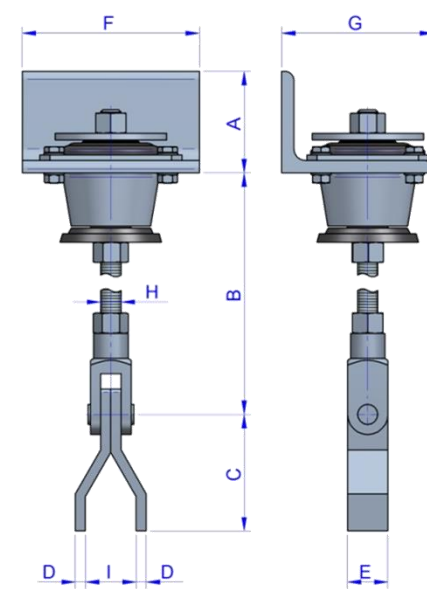
They play a key role in improving the reliability of the assembly, minimising mechanical fatigue and contributing to quieter and more stable operation, even under demanding service conditions.



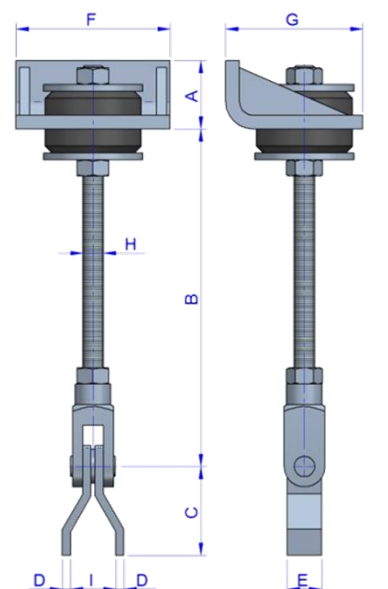
RANGE ST



TYPE A

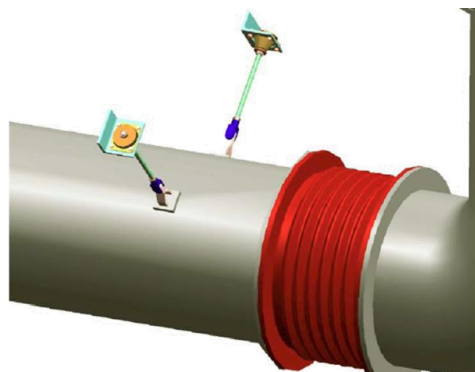


TYPE B

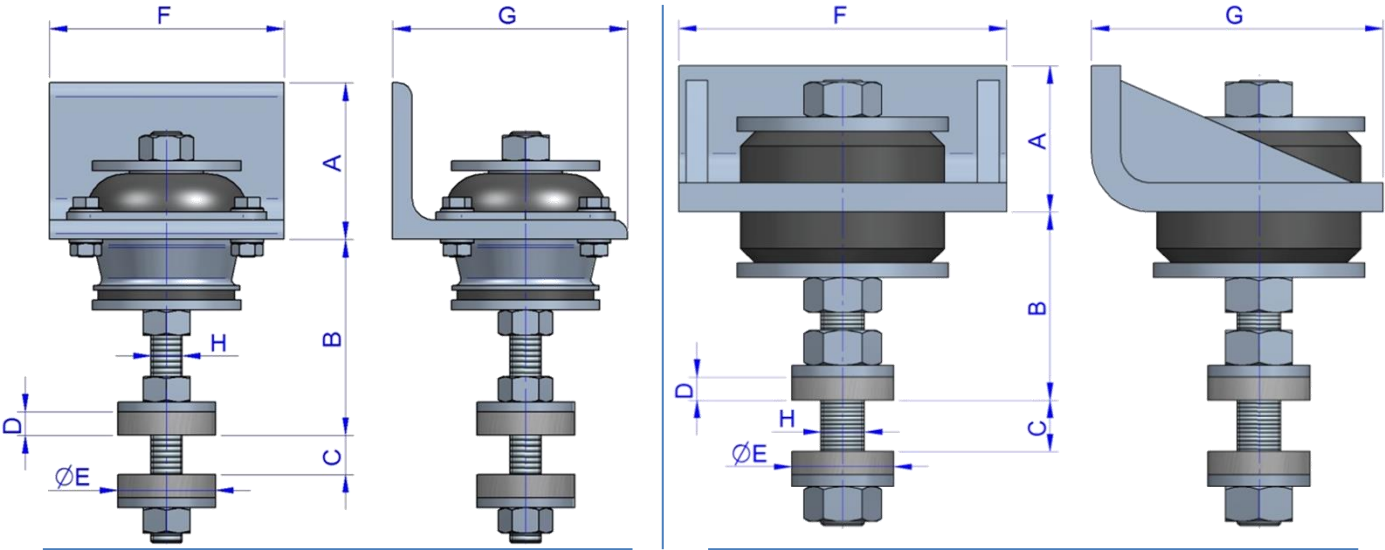


TYPE C

Code	Description	Type	A	B	C	D	E	F	G	H	I	Hardness	Max. Load (kg)
709101	ST-100 45Sh	A	50	325	118	10	50	110	100	M12	-	45Sh	75
709105	ST-100 60Sh	A	50	325	118	10	50	110	100	M12	-	60Sh	140
709111	ST-150 45Sh	A	50	325	118	10	50	110	100	M12	-	45Sh	100
709115	ST-150 60Sh	A	50	325	118	10	50	110	100	M12	-	60Sh	180
709121	ST-250 40Sh	A	80	477	130	15	70	120	120	M16	-	40Sh	140
709125	ST-250 60Sh	A	80	477	130	15	70	120	120	M16	-	60Sh	300
709131	ST-500 60Sh	A	80	477	130	15	70	120	120	M16	-	60Sh	500
709135	ST-500 70Sh	A	80	477	130	15	70	120	120	M16	-	70Sh	750
709141	ST-1000 65Sh	B	100	485	115	10	40	175	150	M20	50	65Sh	1100
709145	ST-1000 75Sh	B	100	485	115	10	40	175	150	M20	50	75Sh	1560
709151	ST-2000 60Sh	C	100	500	130	12	50	225	200	M30	66	60Sh	2000



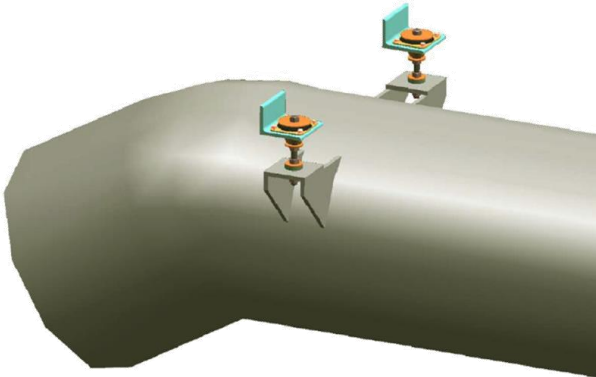
RANGE SFT



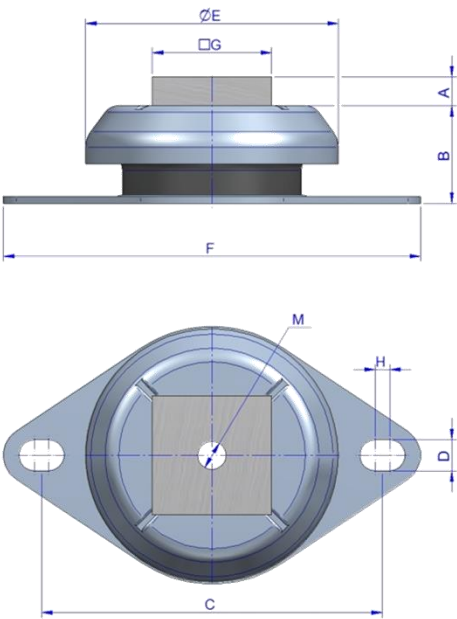
TYPE A

TYPE B

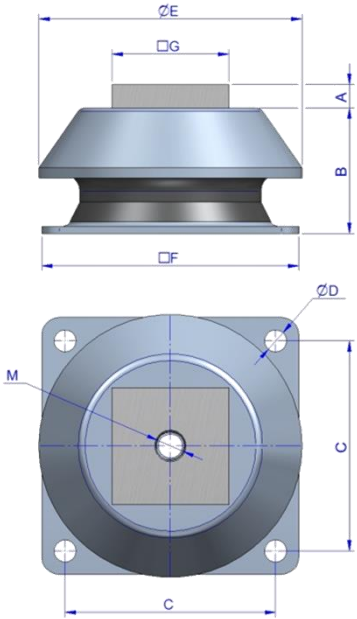
Code	Description	Type	A	B (min)	C (max)	D	E	F	G	H	Hardness	Max. Load (kg)
709201	SFT-100 45Sh	A	50	51,5	20	12	36	110	100	M12	45Sh	75
709205	SFT-100 60Sh	A	50	51,5	20	12	36	110	100	M12	60Sh	140
709211	SFT-150 45Sh	A	50	51,5	20	12	36	110	100	M12	45Sh	100
709215	SFT-150 60Sh	A	50	51,5	20	12	36	110	100	M12	60Sh	180
709221	SFT-250 40Sh	A	80	80	40	12	50	120	120	M16	40Sh	140
709225	SFT-250 60Sh	A	80	80	40	12	50	120	120	M16	60Sh	300
709231	SFT-500 60Sh	A	80	80	40	12	50	120	120	M16	60Sh	500
709235	SFT-500 70Sh	A	80	80	40	12	50	120	120	M16	70Sh	750
709241	SFT-1000 65Sh	A	100	100	50	12	60	175	150	M20	65Sh	1100
709245	SFT-1000 75Sh	A	100	100	50	12	60	175	150	M20	75Sh	1560
709251	SFT-2000 60Sh	B	100	120	50	16	70	225	200	M30	60Sh	2000



RANGE SFC



TYPE A



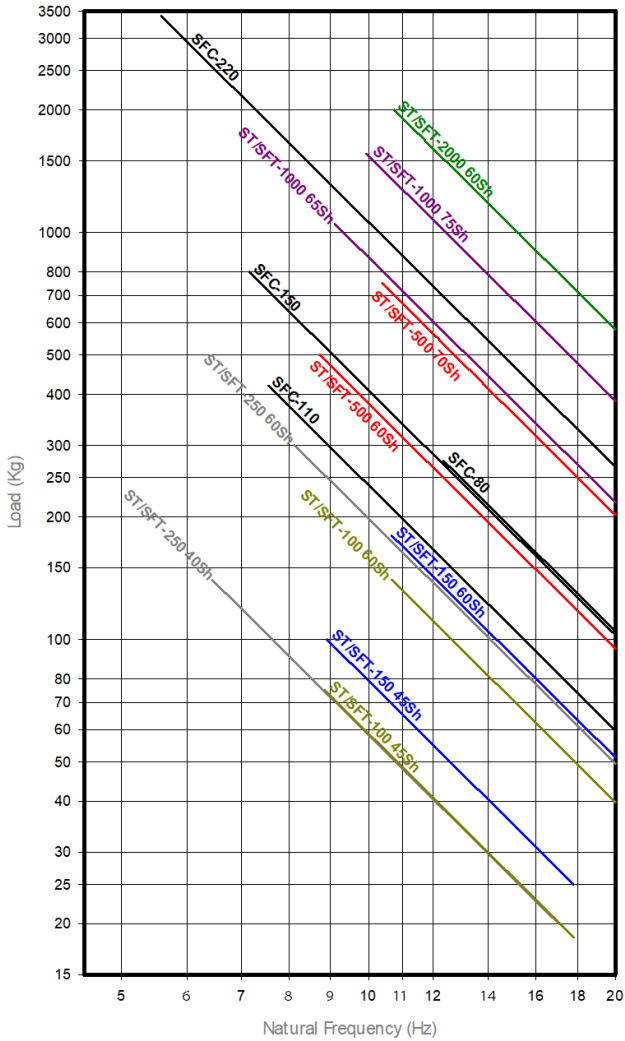
TYPE B

Code	Description	Type	A	B	C	D	E	F	G	H	M	Hardness	Max. Load (kg)
709301	SFC-80	A	12	34	123,2	10	92	150	45	4,4	M12	60Sh	270
709305	SFC-110	A	12	41	143	13	106	175	50	6	M12	60Sh	420
709311	SFC-150	A	16	53,5	182	14,5	156	218	80	6	M16	60Sh	800
709315	SFC-220	B	20	105	180	19	230	220	100	-	M24	60Sh	3400

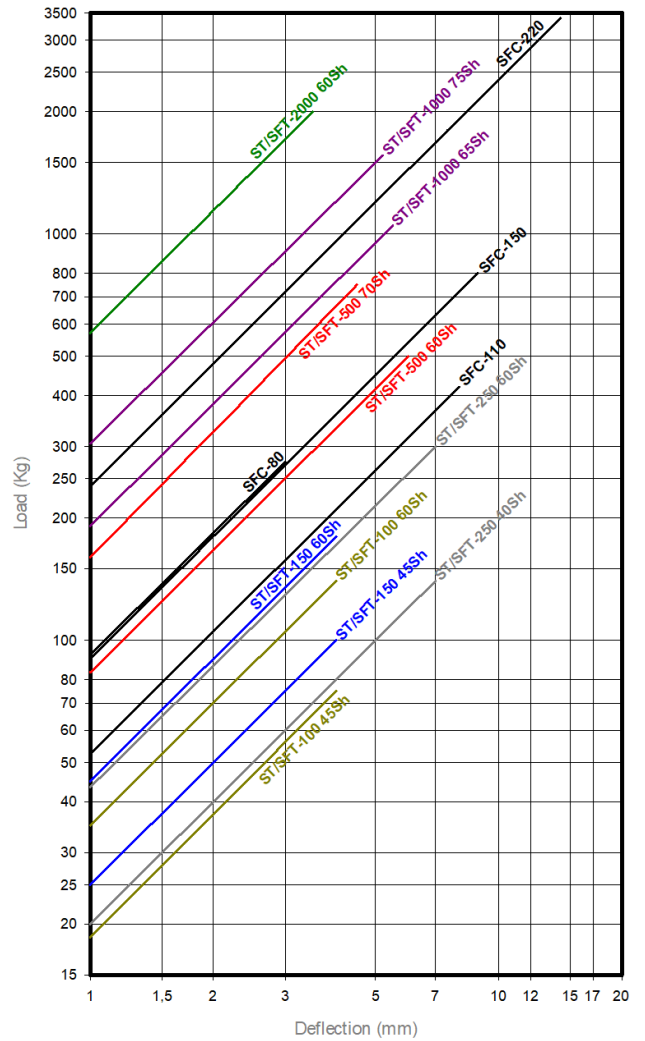


TECHNICAL CHARACTERISTICS

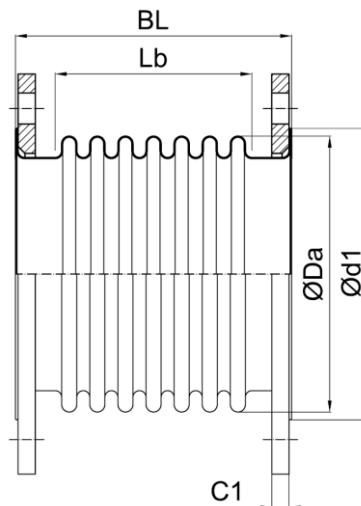
NATURAL FREQUENCY
AMC MECANOCAUCHO® EXHAUST MOUNTS



LOAD DEFLECTION GRAPH
AMC MECANOCAUCHO® EXHAUST MOUNTS



EXPANSION JOINTS



Expansion joints available on request up to DN 2400.

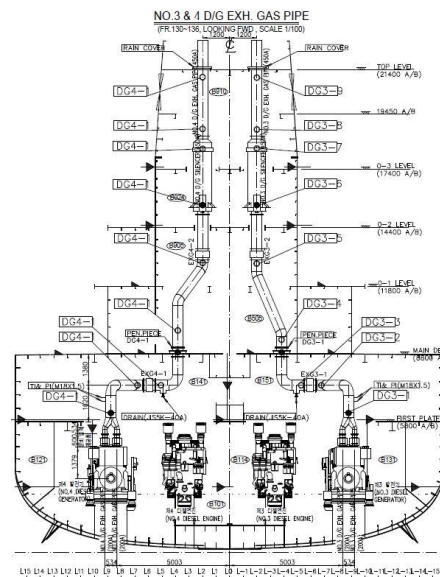
Nominal diameter DN	Axial absorption Δx (mm)	Length BL (mm)	Weight (kg)	Flange thickness C1 (mm)	External diameter $\varnothing Da$ (mm)	Corrugated length Lb (mm)	Radial absorption Δy (mm)	Axial adjustment force $C\Delta x$ (N/mm)	Radial adjustment force $C\Delta y$ (N/mm)
100	39	140	5.8	14	140	80	8	124	473
100	86	235	6.2	14	140	172	38	57	47
100	119	300	6.4	14	140	238	74	42	18
125	58	130	7	14	172	89	11	79	362
125	117	225	7.5	14	172	178	44	40	46
125	149	300	7.9	14	170	252	81	35	20
150	49	150	7.9	14	205	66	5	100	1196
150	122	250	8.6	14	205	164	35	40	77
150	184	340	11	14	205	255	84	41	33
175	51	360	13	16	234	69	5	109	1569
175	129	365	19	16	234	172	34	44	101
175	186	370	23	16	234	250	72	46	51
200	67	160	12	16	263	72	6	75	1244
200	117	210	12	16	263	126	20	43	233
200	186	340	15	16	263	258	66	46	60
250	72	160	14	16	319	77	6	79	1741
250	144	235	15	16	319	154	24	40	218
250	206	355	18	16	319	275	63	49	85
300	51	160	19	16	374	63	3	208	9712
300	138	265	21	16	374	167	21	78	513
300	210	365	23	16	372	271	54	54	133
350	56	160	24	16	408	68	3	202	9735
350	132	250	26	16	408	157	18	87	767
350	210	385	28	16	403	292	53	62	157
400	63	170	27	16	462	71	3	193	10823
400	106	210	28	16	462	118	9	116	2338
400	212	330	31	16	462	236	38	58	293
450	72	170	31	16	517	77	3	175	10508
450	120	220	32	16	517	128	10	105	2270
450	216	325	35	16	517	231	34	59	390
500	78	175	34	16	574	83	3	149	9501
500	130	230	36	16	574	138	11	90	2053
500	234	345	39	16	574	249	35	50	352
550	79	185	48	20	627	84	3	148	11009
550	132	240	49	20	627	140	10	89	2378
550	237	355	53	20	625	252	33	54	442
600	81	190	52	20	680	87	3	147	12239
600	136	245	54	20	680	144	10	89	2644
600	244	360	57	20	675	260	32	61	553

REFERENCES:

DAEWOO SHIPBUILDING & MARINE ENGINEERING (DSME)

Rescue ship with reference H 7060.

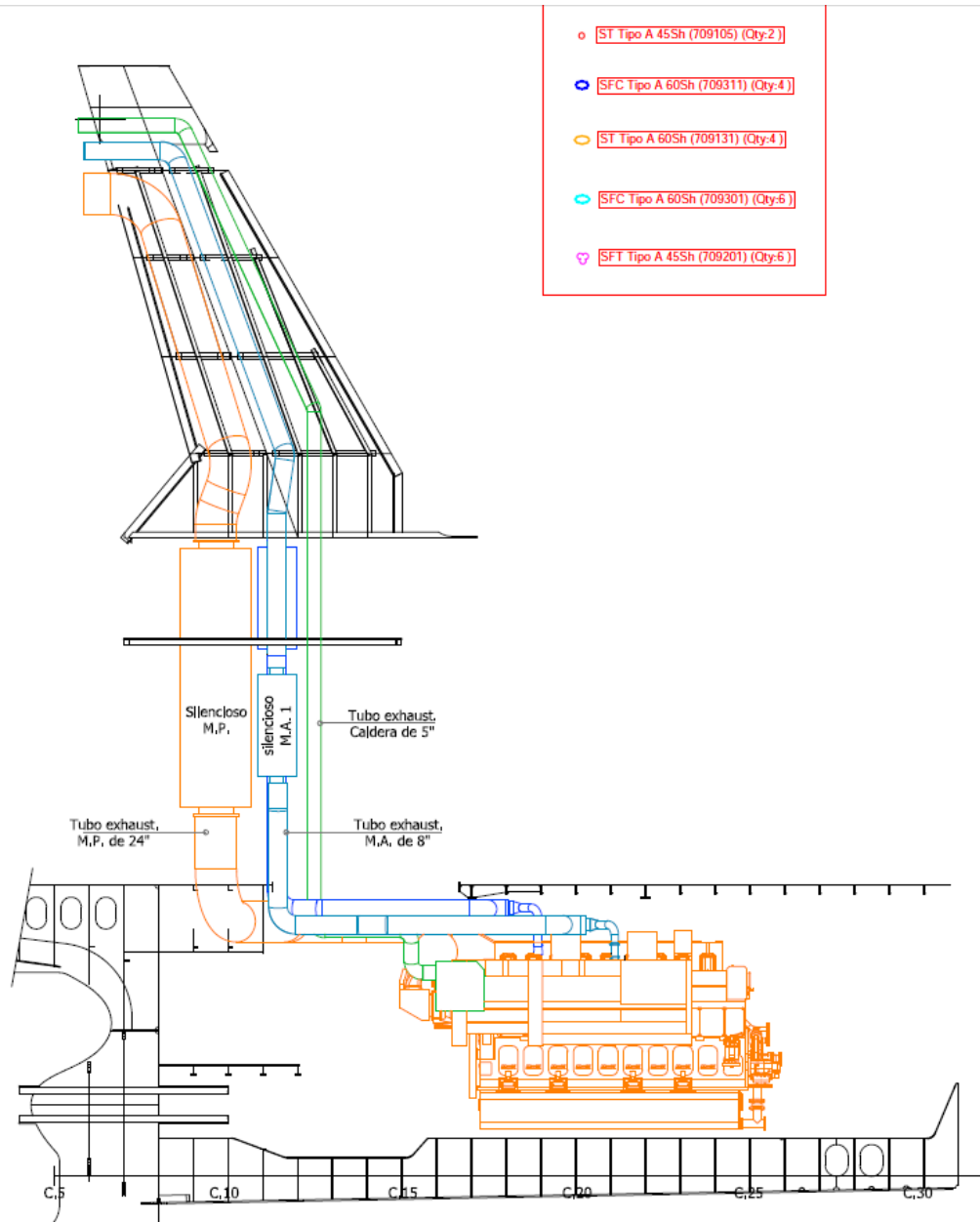
Fixation Point	Fixed/Sliding	Qty.	Description	Reference	Qty per section	Average load per mount (kg)	Theoretical natural frequency at average load (Hz)
DG1-1	Fixed	2	SFT-500 60Sh	709231	22	181	15,06
DG1-2	Sliding	2	ST-500 60Sh	709131			
DG1-3	Fixed	2	SFT-500 60Sh	709231			
DG1-4	Sliding	2	ST-500 60Sh	709131			
DG1-5	Sliding	2	ST-500 60Sh	709131			
DG1-6	Sliding	2	ST-500 60Sh	709131			
DG1-7	Fixed	2	SFT-500 60Sh	709231			
DG1-8	Sliding	2	ST-500 60Sh	709131			
DG1-9	Sliding	2	ST-500 60Sh	709131			
DG1-11	Sliding	2	ST-500 60Sh	709131			
DG1-12	Sliding	2	ST-500 60Sh	709131			
DG1-14	Fixed	4	SFC-150	709311	4	258	12,61
DG1-15	Sliding	2	ST-500 60Sh	709131	6	64	25,32
DG1-16	Sliding	2	ST-500 60Sh	709131			
DG1-17	Sliding	2	ST-500 60Sh	709131	24	165	15,77
DG2-1	Fixed	2	SFT-500 60Sh	709231			
DG2-2	Sliding	2	ST-500 60Sh	709131			
DG2-3	Sliding	2	ST-500 60Sh	709131			
DG2-4	Fixed	2	SFT-500 60Sh	709231			
DG2-5	Sliding	2	ST-500 60Sh	709131			
DG2-6	Sliding	2	ST-500 60Sh	709131			
DG2-7	Sliding	2	ST-500 60Sh	709131			
DG2-8	Sliding=> Fixed	2	SFT-500 60Sh	709131			
DG2-9	Sliding	2	ST-500 60Sh	709131			
DG2-10	Sliding	2	ST-500 60Sh	709131			
DG2-13	Sliding	2	ST-500 60Sh	709131			
DG2-14	Sliding	2	ST-500 60Sh	709131			
DG2-15	Fixed	4	SFC-150	709311	4	258	12,61
DG2-16	Sliding	2	ST-500 60Sh	709131	6	64	25,32
DG2-17	Sliding	2	ST-500 60Sh	709131			
DG2-18	Sliding	2	ST-500 60Sh	709131	10	149	16,60
DG3-1	Fixed	2	SFT-500 60Sh	709231			
DG3-2	Sliding	2	ST-500 60Sh	709131			
DG3-3	Sliding	2	ST-500 60Sh	709131			
DG3-4	Sliding	2	ST-500 60Sh	709131			
DG3-5	Sliding	2	ST-500 60Sh	709131			
DG3-6	Fixed	4	SFC-150	709311	4	258	12,61
DG3-7	Sliding	2	ST-500 60Sh	709131	6	65	25,13
DG3-8	Sliding	2	ST-500 60Sh	709131			
DG3-9	Sliding	2	ST-500 60Sh	709131			
DG4-1	Fixed	2	SFT-500 60Sh	709231	10	150	16,54
DG4-2	Sliding	2	ST-500 60Sh	709131			
DG4-3	Sliding	2	ST-500 60Sh	709131			
DG4-4	Sliding	2	ST-500 60Sh	709131			
DG4-5	Sliding	2	ST-500 60Sh	709131	4	258	12,61
DG4-6	Fixed	4	SFC-150	709311			
DG4-7	Sliding	2	ST-500 60Sh	709131	6	65	25,13
DG4-8	Sliding	2	ST-500 60Sh	709131			
DG4-9	Sliding	2	ST-500 60Sh	709131			
DE1-1	Fixed	2	SFT-500 70Sh	709235	10	199	20,18
DE1-2	Sliding	2	ST-500 70Sh	709135			
DE1-3	Sliding	2	ST-500 70Sh	709135			
DE1-5	Sliding	2	ST-500 70Sh	709135			
DE1-6	Sliding	2	ST-500 70Sh	709135			
DE1-7	Fixed	4	SFC-220	709315			
DE1-8	Sliding	2	ST-500 70Sh	709135	4	794	11,58
DE1-9	Sliding	2	ST-500 70Sh	709135			
DE1-10	Sliding	2	ST-500 70Sh	709135	6	128	25,16
DE2-1	Fixed	2	SFT-500 70Sh	709235			
DE2-2	Sliding	2	ST-500 70Sh	709135	10	199	20,18
DE2-3	Sliding	2	ST-500 70Sh	709135			
DE2-5	Sliding	2	ST-500 70Sh	709135			
DE2-6	Sliding	2	ST-500 70Sh	709135			
DE2-7	Fixed	4	SFC-220	709315			
DE2-8	Fixed	2	SFT-500 70Sh	709235			
DE2-9	Sliding	2	ST-500 70Sh	709135	6	128	25,16
DE2-10	Sliding	2	ST-500 70Sh	709135			
DE3-1	Fixed	2	SFT-500 70Sh	709235	6	255	17,83
DE3-3	Fixed	2	SFT-500 70Sh	709235			
DE3-4	Sliding	2	ST-500 70Sh	709135			
DE3-5	Fixed	4	SFC-220	709315	4	794	11,58
DE3-6	Sliding	2	ST-500 70Sh	709135	6	127	25,26
DE3-7	Sliding	2	ST-500 70Sh	709135			
DE3-8	Sliding	2	ST-500 70Sh	709135	6	255	17,83
DE4-1	Fixed	2	SFT-500 70Sh	709235			
DE4-3	Fixed	2	SFT-500 70Sh	709235			
DE4-4	Sliding	2	ST-500 70Sh	709135	4	794	11,58
DE4-5	Fixed	4	SFC-220	709315			
DE4-6	Sliding	2	ST-500 70Sh	709135	6	127	25,26
DE4-7	Sliding	2	ST-500 70Sh	709135			
DE4-8	Sliding	2	ST-500 70Sh	709135			



REFERENCES:

NODOSA SHIPYARD

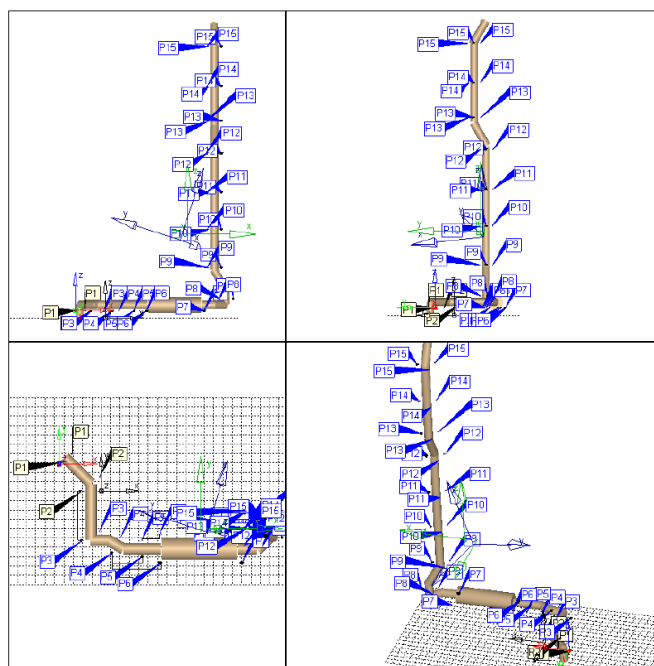
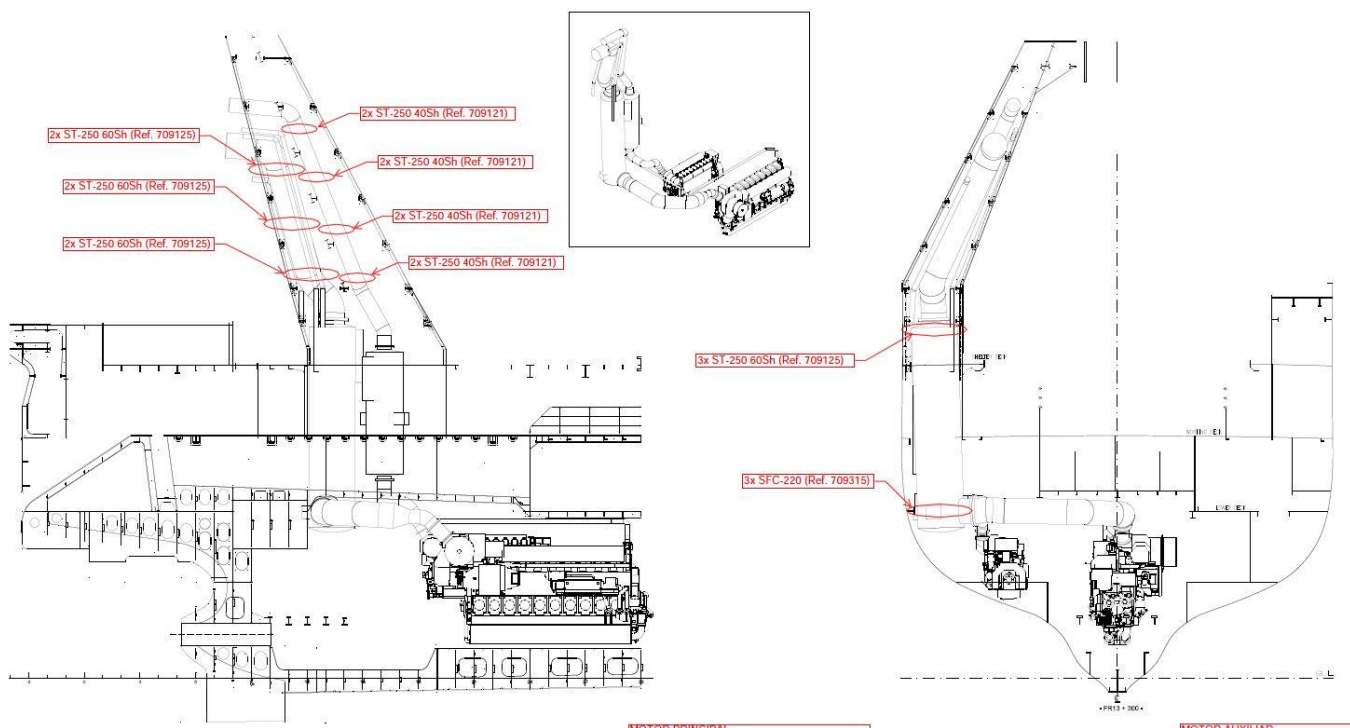
Fishing boat reference C300.



REFERENCES:

NODOSA SHIPYARD

Fishing boat reference C299.



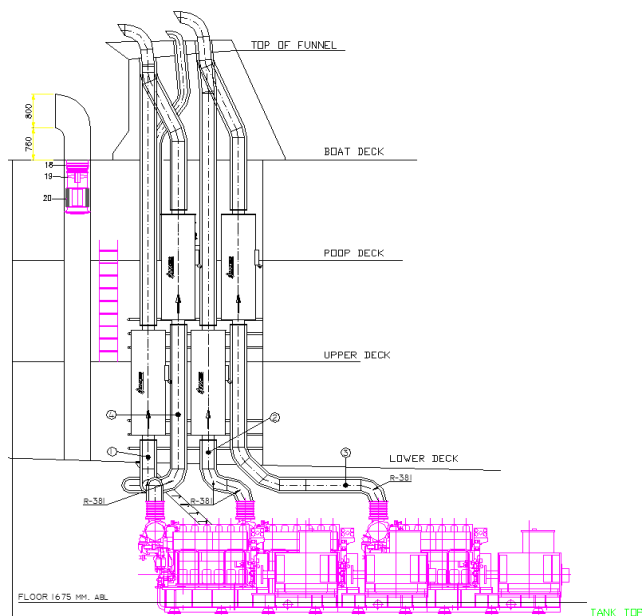
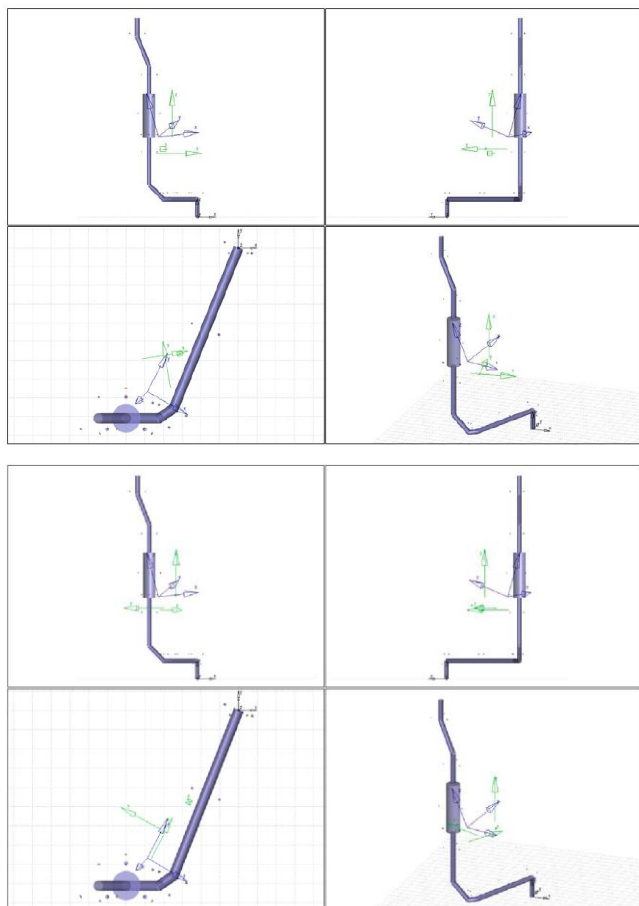
Static Loads Isolators

Name	ref. to	Fx [kN]	Fy [kN]	Fz [kN]
P1	Machine	0.04069	-0.004997	-1.125
P1	Machine	0.03793	-0.001581	-1.115
P2	Machine	0.07348	0.000471	-0.9441
P2	Machine	0.06775	0.008015	-0.9327
P3	Machine	0.09263	0.0009062	-0.9547
P3	Machine	0.08929	0.007652	-0.9455
P4	Machine	0.09734	0.01258	-0.9448
P4	Machine	0.09125	0.01599	-0.9376
P5	Machine	0.09879	0.02426	-0.9331
P5	Machine	0.09255	0.02441	-0.9293
P6	Machine	0.0653	0.02018	-1.101
P6	Machine	0.05805	0.02037	-1.093
P7	Machine	0.0653	0.04058	-1.06
P7	Machine	0.05805	0.04058	-1.052
P8	Machine	0.07159	-1.686	0.04031
P8	Machine	0.03893	-1.706	-0.04964
P8	Machine	0.0971	-1.696	-0.009624
P9	Machine	0.04596	-1.698	0.02151
P9	Machine	0.02035	-1.719	-0.02866
P9	Machine	0.0526	-1.71	-0.007436
P10	Machine	0.02248	-1.698	-0.001137
P10	Machine	-0.005918	-1.719	-0.006834
P10	Machine	0.002851	-1.71	-0.008267
P11	Machine	-0.000236	-0.7561	-0.01443
P11	Machine	-0.02732	-0.7654	0.008942
P11	Machine	-0.0395	-0.7611	-0.00567
P12	Machine	-0.05827	-0.01591	-1.041
P12	Machine	-0.05588	-0.02111	-1.054
P12	Machine	-0.06042	-0.02055	-1.048
P13	Machine	-0.03831	-0.7527	-0.04293
P13	Machine	-0.07494	-0.7621	0.03541
P13	Machine	-0.1252	-0.7578	-0.007713
P14	Machine	-0.05685	-0.7527	-0.05577
P14	Machine	-0.09568	-0.7621	0.04777
P14	Machine	-0.1645	-0.7578	-0.008183
P15	Machine	-0.08964	-1.691	-0.1127
P15	Machine	-0.1371	-1.712	0.09908
P15	Machine	-0.2405	-1.702	-0.01396

REFERENCES:

NODOSA SHIPYARD

Fishing boat reference C282.



EXHAUST 1:

3x SFT-100 60Sh (ref. 709205)
20x ST-150 45Sh (ref. 709111)
3x SFC-110 (ref. 709305)

EXHAUST 2:

3x SFT-100 60Sh (ref. 709205)
16x ST-150 45Sh (ref. 709111)
3x SFC-110 (ref. 709305)

EXHAUST 3:

3x SFT-100 60Sh (ref. 709205)
20x ST-150 45Sh (ref. 709111)
3x SFC-110 (ref. 709305)

EXHAUST 4:

3x SFT-100 60Sh (ref. 709205)
18x ST-150 45Sh (ref. 709111)
3x SFC-110 (ref. 709305)

Static Loads Isolators

Name	rel. to	Fx [kN]	Fy [kN]	Fz [kN]
Isolator1 - SFT-100 60Sh	Machine	-0.009751	-0.1343	-0.577
Isolator2 - SFT-100 60Sh	Machine	-0.00609	-0.1329	-0.5691
Isolator3 - SFT-100 60Sh	Machine	-0.00609	-0.1358	-0.5679
Isolator4 - ST-150 45Sh	Machine	0.3711	-0.1475	-0.2754
Isolator5 - ST-150 45Sh	Machine	-0.3865	0.03907	-0.2889
Isolator6 - ST-150 45Sh	Machine	0.388	-0.1517	-0.2966
Isolator7 - ST-150 45Sh	Machine	-0.4092	0.04473	-0.3015
Isolator8 - ST-150 45Sh	Machine	0.4049	-0.1559	-0.3137
Isolator9 - ST-150 45Sh	Machine	-0.4318	0.05038	-0.3141
Isolator10 - ST-150 45Sh	Machine	-0.004622	0	-0.004126
Isolator11 - ST-150 45Sh	Machine	0.004691	0	9.198e-005
Isolator12 - ST-150 45Sh	Machine	-0.004832	0	0.004035
Isolator13 - SFC-110	Machine	-0.003454	0.02486	-1.039
Isolator14 - SFC-110	Machine	0.0006243	0.02721	-1.072
Isolator15 - SFC-110	Machine	0.0006243	0.02251	-1.067
Isolator16 - ST-150 45Sh	Machine	0.0004002	0	0.02992
Isolator17 - ST-150 45Sh	Machine	-0.03813	0	-0.01322
Isolator18 - ST-150 45Sh	Machine	0.03089	0	-0.0167
Isolator19 - ST-150 45Sh	Machine	0.006805	0	0.06396
Isolator20 - ST-150 45Sh	Machine	-0.07957	0	-0.02652
Isolator21 - ST-150 45Sh	Machine	0.068	0	-0.03744
Isolator22 - ST-150 45Sh	Machine	0.01264	0	0.09728
Isolator23 - ST-150 45Sh	Machine	-0.1209	0	-0.03939
Isolator24 - ST-150 45Sh	Machine	0.1035	0	-0.05789

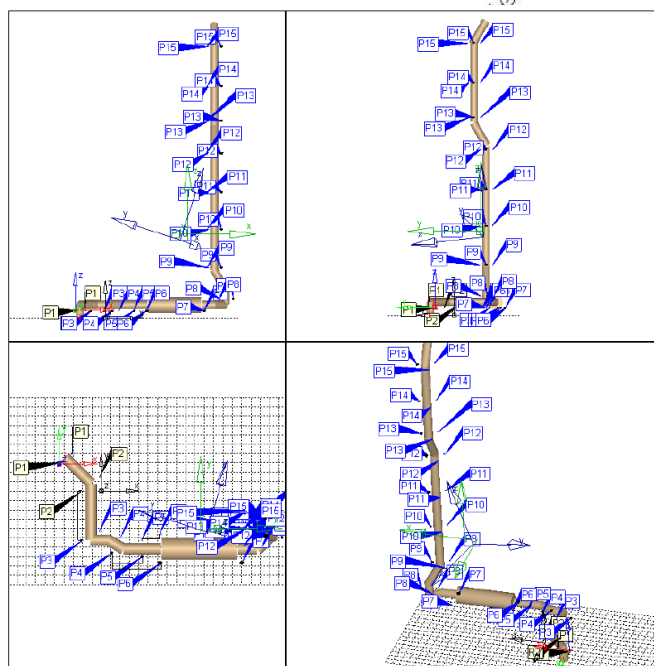
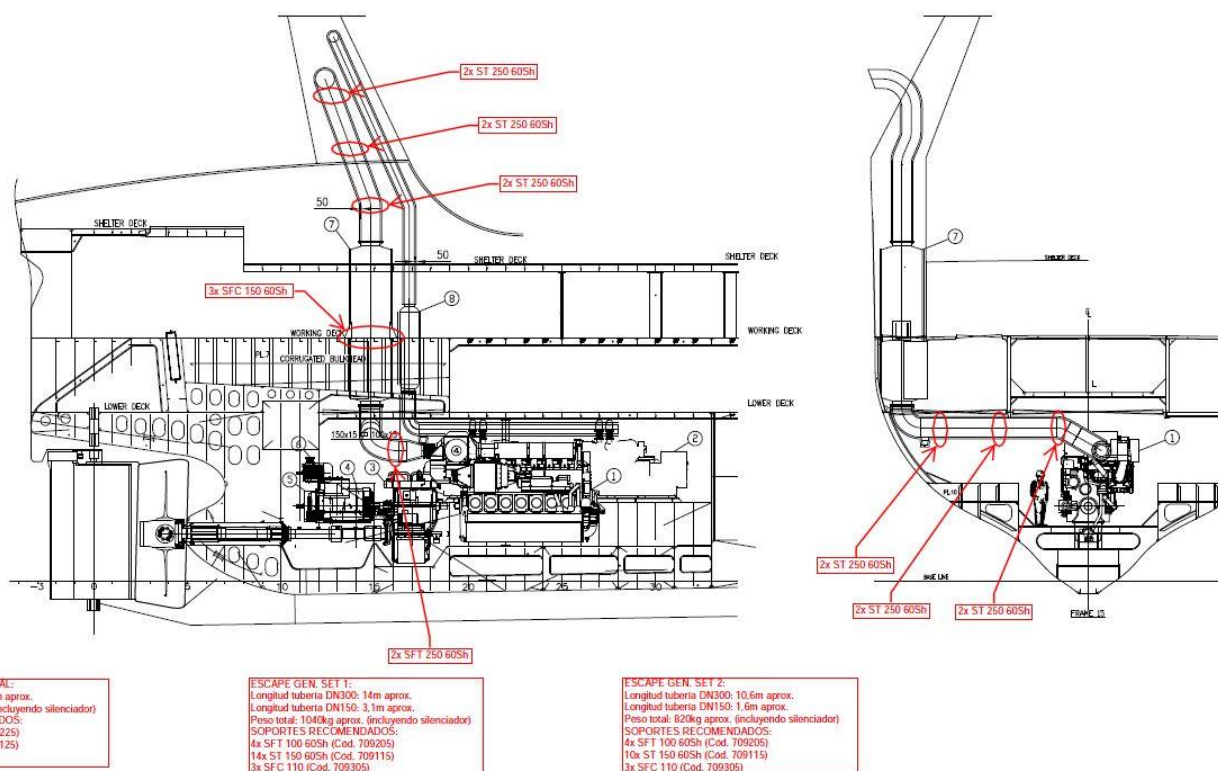
Static Displacements Isolators

Name	rel. to	x [mm]	y [mm]	z [mm]
Isolator1 - SFT-100 60Sh	Machine	-0.009751	-0.2005	-1.649
Isolator2 - SFT-100 60Sh	Machine	-0.00609	-0.1984	-1.626
Isolator3 - SFT-100 60Sh	Machine	-0.00609	-0.2026	-1.623
Isolator4 - ST-150 45Sh	Machine	1.114	-0.443	-1.118
Isolator5 - ST-150 45Sh	Machine	-1.161	0.1173	-1.156
Isolator6 - ST-150 45Sh	Machine	1.165	-0.4557	-1.186
Isolator7 - ST-150 45Sh	Machine	-1.229	0.1343	-1.206
Isolator8 - ST-150 45Sh	Machine	1.216	-0.4683	-1.255
Isolator9 - ST-150 45Sh	Machine	-1.297	0.1513	-1.256
Isolator10 - ST-150 45Sh	Machine	-0.01388	1.83	-0.01651
Isolator11 - ST-150 45Sh	Machine	0.01409	1.786	0.0003679
Isolator12 - ST-150 45Sh	Machine	-0.01451	1.779	0.01614
Isolator13 - SFC-110	Machine	-0.00628	0.0452	-1.832
Isolator14 - SFC-110	Machine	0.001135	0.04948	-1.786
Isolator15 - SFC-110	Machine	0.001135	0.04092	-1.779
Isolator16 - ST-150 45Sh	Machine	0.001202	1.844	0.1197
Isolator17 - ST-150 45Sh	Machine	-0.1145	1.781	-0.05287
Isolator18 - ST-150 45Sh	Machine	0.09277	1.771	-0.0668
Isolator19 - ST-150 45Sh	Machine	0.02043	1.83	0.2558
Isolator20 - ST-150 45Sh	Machine	-0.2389	1.786	-0.1061
Isolator21 - ST-150 45Sh	Machine	0.2042	1.779	-0.1498
Isolator22 - ST-150 45Sh	Machine	0.03795	1.826	0.3891
Isolator23 - ST-150 45Sh	Machine	-0.3631	1.782	-0.1576
Isolator24 - ST-150 45Sh	Machine	0.3109	1.775	-0.2316

REFERENCES:

NODOSA SHIPYARD

Fishing boat reference C288.



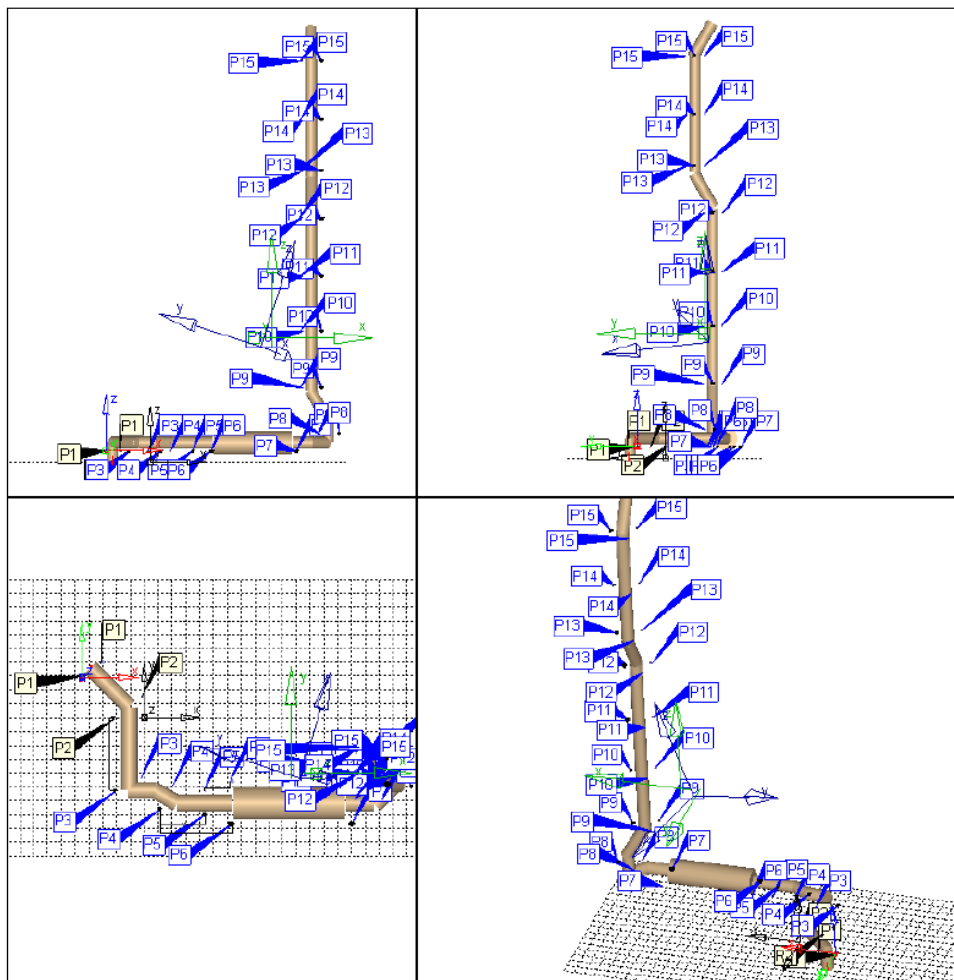
Static Loads Isolators

Name	ref. to	Fx [kN]	Fy [kN]	Fz [kN]
P1	Machine	0.04069	-0.004997	-1.125
P1	Machine	0.03793	-0.001581	-1.115
P2	Machine	0.07348	0.000471	-0.9441
P2	Machine	0.06775	0.008015	-0.9327
P3	Machine	0.09263	0.0009062	-0.9547
P3	Machine	0.08929	0.007652	-0.9455
P4	Machine	0.09734	0.01258	-0.9448
P4	Machine	0.09125	0.01599	-0.9376
P5	Machine	0.09879	0.02426	-0.9331
P5	Machine	0.09255	0.02441	-0.9293
P6	Machine	0.0653	0.02018	-1.101
P6	Machine	0.05805	0.02037	-1.093
P7	Machine	0.0653	0.04058	-1.06
P7	Machine	0.05805	0.04058	-1.052
P8	Machine	0.07159	-1.686	0.04031
P8	Machine	0.03893	-1.706	-0.04964
P8	Machine	0.0971	-1.696	-0.009624
P9	Machine	0.04596	-1.698	0.02151
P9	Machine	0.02035	-1.719	-0.02866
P9	Machine	0.0526	-1.71	-0.007436
P10	Machine	0.02248	-1.698	-0.001137
P10	Machine	-0.005918	-1.719	-0.006834
P10	Machine	0.002851	-1.71	-0.008267
P11	Machine	-0.000236	-0.7561	-0.01443
P11	Machine	-0.02732	-0.7654	0.008942
P11	Machine	-0.0395	-0.7611	-0.00567
P12	Machine	-0.05827	-0.01591	-1.041
P12	Machine	-0.05588	-0.02111	-1.054
P12	Machine	-0.06042	-0.02055	-1.048
P13	Machine	-0.03831	-0.7527	-0.04293
P13	Machine	-0.07494	-0.7621	0.03541
P13	Machine	-0.1252	-0.7578	-0.007713
P14	Machine	-0.05685	-0.7527	-0.05577
P14	Machine	-0.09568	-0.7621	0.04777
P14	Machine	-0.1645	-0.7578	-0.008183
P15	Machine	-0.08964	-1.691	-0.1127
P15	Machine	-0.1371	-1.712	0.09908
P15	Machine	-0.2405	-1.702	-0.01396

REFERENCES:



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Static Loads Isolators

Name	rel. to	Fx [kN]	Fy [kN]	Fz [kN]	Tx [kNm]	Ty [kNm]	Tz [kNm]
P1	Machine	0.04069	-0.004997	-1.125	0	0	0
P1	Machine	0.03793	-0.001581	-1.115	0	0	0
P2	Machine	0.07348	0.000471	-0.9441	0	0	0
P2	Machine	0.06775	0.008015	-0.9327	0	0	0
P3	Machine	0.09263	0.0009062	-0.9547	0	0	0
P3	Machine	0.08929	0.007652	-0.9455	0	0	0
P4	Machine	0.09734	0.01258	-0.9448	0	0	0
P4	Machine	0.09125	0.01599	-0.9376	0	0	0
P5	Machine	0.09879	0.02426	-0.9331	0	0	0
P5	Machine	0.09255	0.02441	-0.9293	0	0	0
P6	Machine	0.0653	0.02018	-1.101	0	0	0
P6	Machine	0.05805	0.02037	-1.093	0	0	0
P7	Machine	0.0653	0.04058	-1.06	0	0	0
P7	Machine	0.05805	0.04058	-1.052	0	0	0
P8	Machine	0.07159	-1.686	0.04031	0	0	0
P8	Machine	0.03893	-1.706	-0.04964	0	0	0
P8	Machine	0.0971	-1.696	-0.009624	0	0	0
P9	Machine	0.04596	-1.698	0.02151	0	0	0
P9	Machine	0.02035	-1.719	-0.02866	0	0	0
P9	Machine	0.0526	-1.71	-0.007436	0	0	0
P10	Machine	0.02248	-1.698	-0.001137	0	0	0
P10	Machine	-0.005918	-1.719	-0.006834	0	0	0
P10	Machine	0.002851	-1.71	-0.008267	0	0	0
P11	Machine	-0.000236	-0.7561	-0.01443	0	0	0
P11	Machine	-0.02732	-0.7654	0.008942	0	0	0
P11	Machine	-0.0395	-0.7611	-0.00567	0	0	0
P12	Machine	-0.05827	-0.01591	-1.041	0	0	0
P12	Machine	-0.05588	-0.02111	-1.054	0	0	0
P12	Machine	-0.06042	-0.02055	-1.048	0	0	0
P13	Machine	-0.03831	-0.7527	-0.04293	0	0	0
P13	Machine	-0.07494	-0.7621	0.03541	0	0	0
P13	Machine	-0.1252	-0.7578	-0.007713	0	0	0
P14	Machine	-0.05685	-0.7527	-0.05577	0	0	0
P14	Machine	-0.09568	-0.7621	0.04777	0	0	0
P14	Machine	-0.1645	-0.7578	-0.008183	0	0	0
P15	Machine	-0.08964	-1.691	-0.1127	0	0	0
P15	Machine	-0.1371	-1.712	0.09908	0	0	0
P15	Machine	-0.2405	-1.702	-0.01396	0	0	0



Aplicaciones Mecánicas del Caucho S.A.

Industrialdea Parc. 35 A. • E-20.159

ASTEASU (Gipuzkoa) Spain

Tel.: + 34 943 69 61 02 • Fax: + 34 943 69 62 19

e-mail: sales@amcsa.es

www.akustik.com

www.mecanocaucho.com