

GENERAL SPECIFICATION

Casting manufacturing and test method according to Tech. Spec.: BLUE_TS_CST_01

EN 12990

Moulding tooling definition and draft values shall comply with this standard for steel casting obtained by sand method

Dimensional and geometrical tolerances according to EN ISO 8062-3:

- DCTG 11 (Dimensional)

- GCTG 5 (Geometrical)

- RMAG F (Overthickness)

Visual Inspection (VT) according to EN 1370

Surface quality discontinuities (unmachined surfaces):

- roughness quality to be greater than: -3S1 (BNiF) or A3 (SCRATA)

Surface quality discontinuities (machined surfaces): LEVEL -A-

MARKING

- Material designation

- Model number

- Date of casting

- Identification of batch number

- Supplier code number (optional)

MACHINING PART

- Sharp edge pulled down


- Not dimensioned radius: R3


- Not dimensioned chamfer 0.5x45°

- Non specified machined surface roughness: Ra 6.3

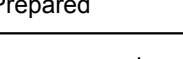
- All dimension shall be measured before painting

Painting in accordance with TECH SPEC:

- Protect from painting all threaded holes and machined surfaces marked with 

- Protect only with primer all surfaces marked with 

----- Radiographic inspection (EN12681)

No	Parga Ardy Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Olçu Dimension	Ağırlık Weight (Kg.)	116.3
	ISO 1302 ISO 8015 EN 22553		General Tol.	ISO 2768	M0 H0	K0	
	EN 15085-2 Certification Level	CL10 CL12	Weld Pro.	ISO 13920	A0 B0	E0 F0	F0
Approved	P.FARINA	CL12 CL14	Cast Steel	ISO 12178	Lm0 Lx0	Sm0 Sz0	
Checked	M.BORLO		1:2				
Prepared	V.COUCUÇI						
	Center Pivot						
	TYP						
	Date 01/07/2018				Sheet 1/1	Size A0	Rev 00