

ISO 13270 Steel Casting	Nom. Size		Class
	L mm	Ham	
<100	6.0	0.8	
<630	4.0	0.7	
<400	3.0	0.6	
<250	3.0	0.4	
100	2.0	0.2	
	4.0	1.5, 2.0	
ISO 2768 General Tolerances	Nom. Size		Class
L mm	Ham	L mm	
<4000	2.0	0.4	
<2000	1.2	0.4	
<1000	0.8	0.3	
<400	0.5	0.3	
30-120	0.3	0.2	
2-30	0.2	0.1	
L mm	Ham	L mm	Class
>20000	9.0	8.0	
>10000	8.0	7.0	
<16000	7.0	6.0	
<12000	6.0	5.0	
<8000	5.0	4.0	
<4000	3.0	2.0	
<1000	2.0	1.5	
<400	1.0	1.0	
30-120	1.0	0.5	
2-30	1.0	0.5	
L mm	Ham	L mm	Class

GENERAL SPECIFICATION

Casting manufacturing and test method accordig 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 8 (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: R0.5
- Not dimensioned chamfer 0.5x45°
- Non specified machined surface roughness: Ra 6.3
- All dimension shall be measured before painting

Technical Specifications	-				
Technical Document	-				
Fixture/Mould Asset ID.	-				
Coating/Heat Tre./Roughness	-	1	CHANGED MATERIAL	2011/2019	D.CARLINO
Paint/Color	-	Modf.No	Modification Description	Date	Sign

Radiographic inspection (EN12681)

					GE360 (DIN EN12933-2015)	22.7
No	Parça Adı Designation Name of Item	Aдет Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Ağırlık Weight (Kg.)
	ISO 1302 ISO 8015 EN 22553		General Tol.	ISO 2768 f □ m□ H □ K □		
	EN 15085-2 Certification Level	CL1 □ CL2 □ CL3 □ CL4 □	Weld Pro. Cast Steel	ISO 13920 A □ B □ E □ F □ ISO 12708 Lm2 □ Lr2 □ Sm2 □ Ssr2 □		
	Approved P.Farina		Scale			
	Checked M.Borio		1:2			
	Prepared S.Ponzo					
		Anti-yaw support RH				
TYP	Date:02/07/2018			Sheet:1/1	Size:A1	Rev:01