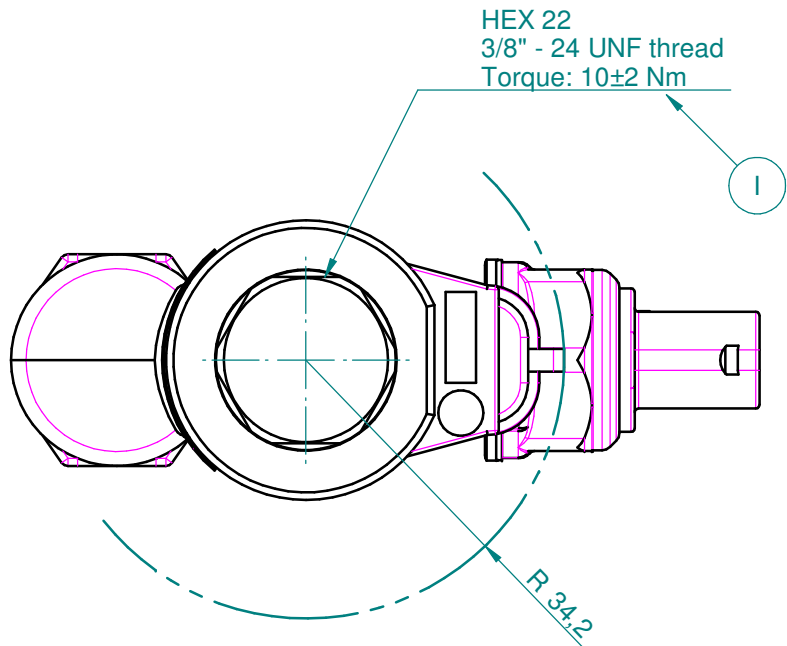
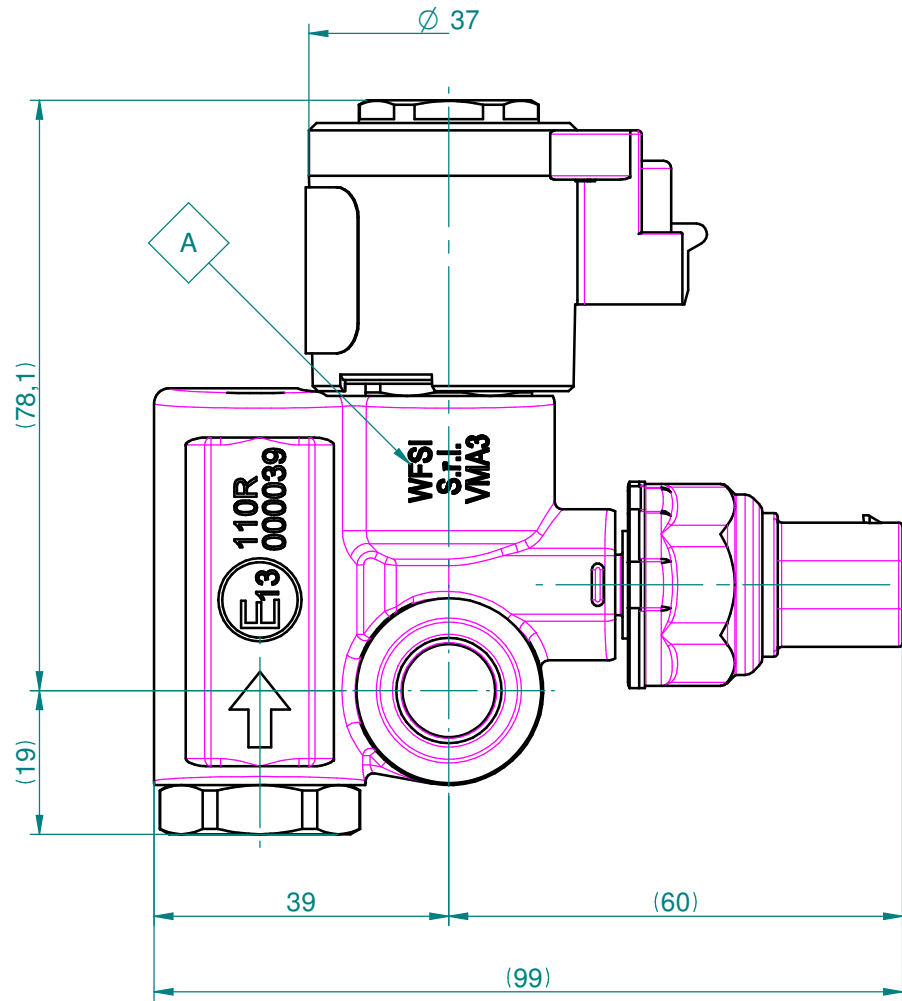
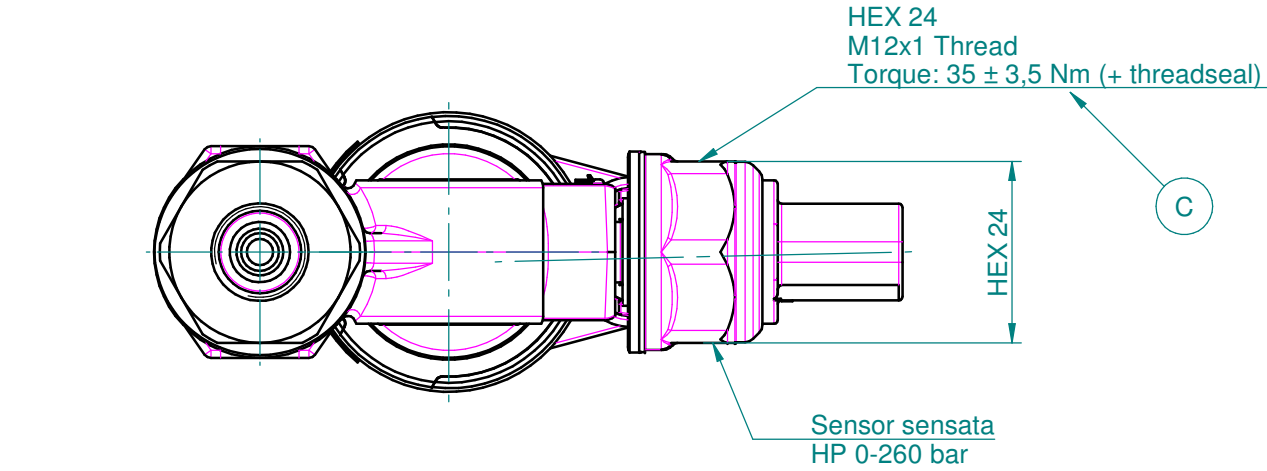


Internal standards
for non toleranced
fillets and chamfers

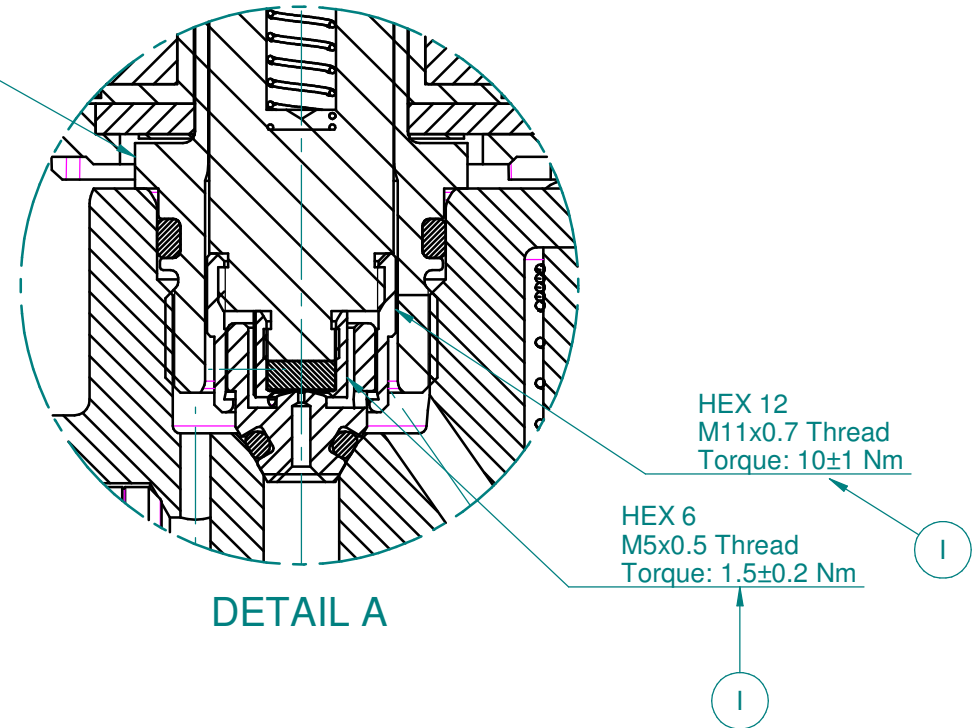
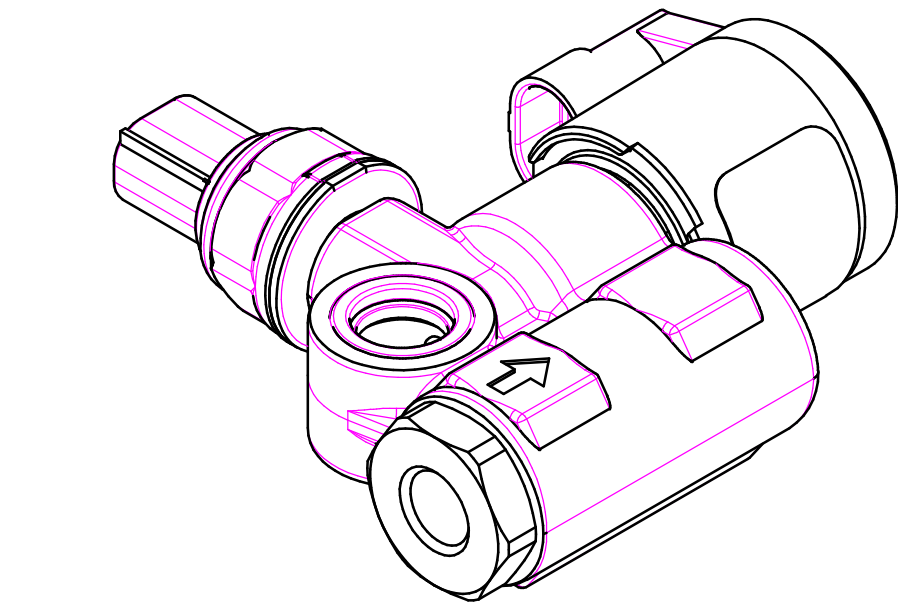
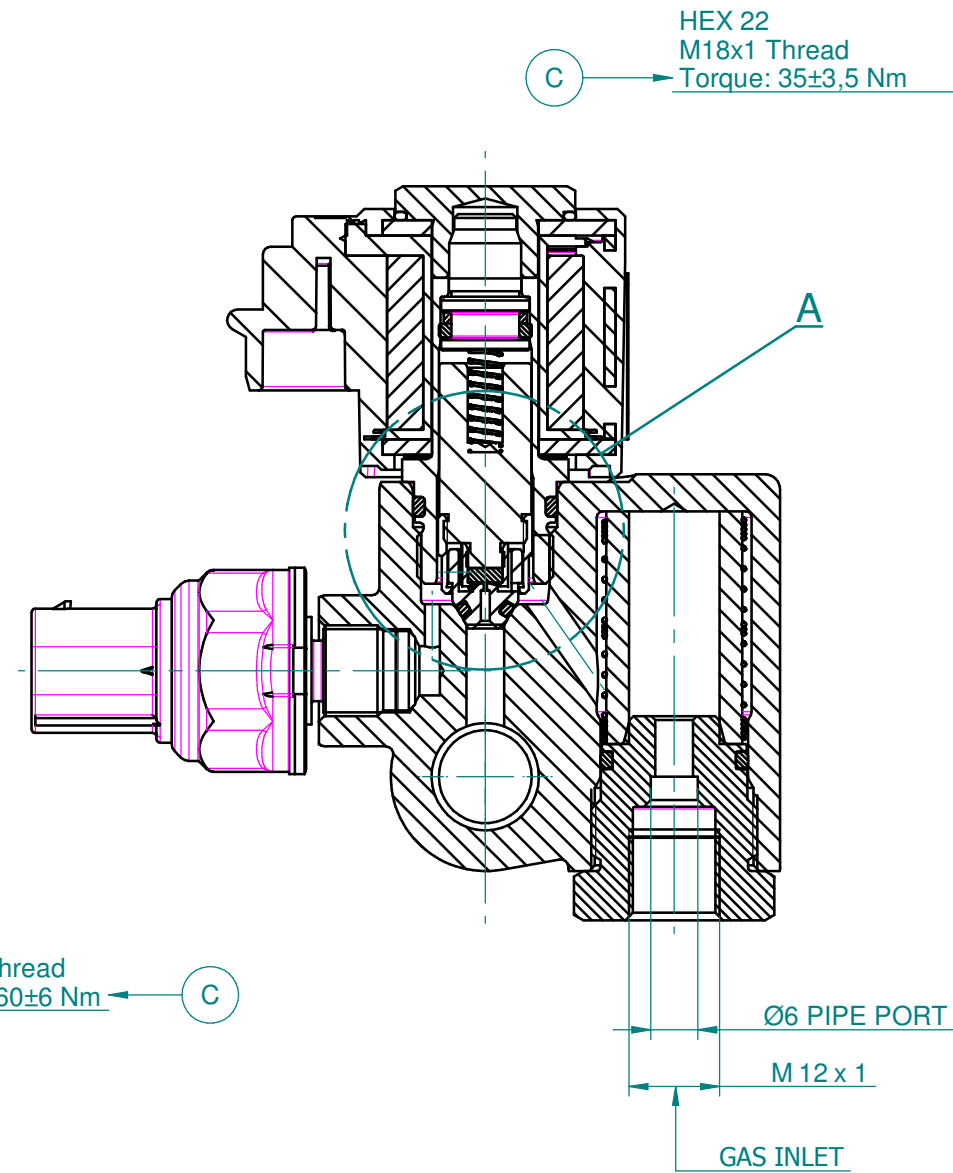
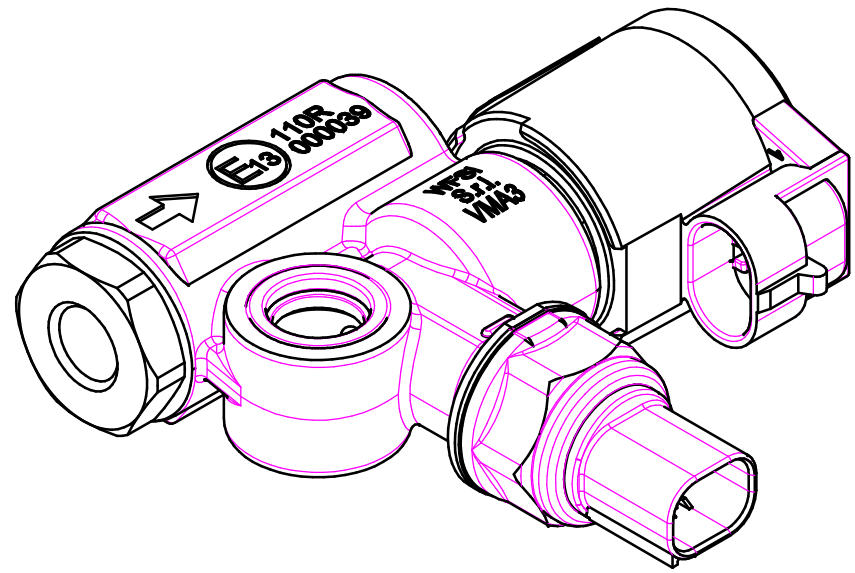
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linear dim.	f	m	c	v	linear dim.	f	m	c	v	minor angle side	f	m	c	v	Fillets/Cham.
≥0,5÷3	±0,05	±0,1	±0,2	-	>120÷400	±0,2	±0,5	±1,2	±2,5	≥10	±1°	±1°	±1°	±1°	≥0,5÷3
>3÷6	±0,05	±0,1	±0,3	±0,5	>400÷1000	±0,3	±0,8	±2	±4	>10÷50	±1°	±1°	±1°	±1°	>3÷6
>6÷30	±0,1	±0,2	±0,5	±1	>1000÷2000	±0,5	±1,2	±3	±6	>50÷120	±1°	±1°	±1°	±1°	>6
>30÷120	±0,15	±0,3	±0,8	±1,5	>2000÷4000	-	±2	±4	±8	>120÷400	±1°	±1°	±1°	±1°	>6



Solenoid Valve - Final test procedure

Low pressure	
Internal leakage	< 15 cm3/h @ 10 ± 1 bar
External leakage	< 15 cm3/h @ 10 ± 1 bar
Flow	> 15.000 NI/h @ 5 ± 0,5 bar
High pressure	
Internal leakage	< 15 cm3/h @ 300 ± 30 bar
Opening current	< 1 A @ 200 ± 20 bar
External leakage	< 15 cm3/h @ 300 ± 30 bar



A		Updated manufacturing	03.06.2021	M.Degiovanni
-		Improvements about plunger housing, valve body, o-ring	25.09.2019	M.Degiovanni
N°ECR	REV.	Description	DATE	DRAWN
VMA3/E-BJ MY09 CNG VALVE - M12X1 - MANUFACTURING DWG				
Code E160M20036		Drawn M.Degiovanni	Dim. unit mm	According to CDF01
Project nr. 2443	Drawing nr. 61773	Checked A.Coraglia	Mass [g] 598.37	Symbol 4 3 5
Approval Date 03.06.2021		Approved A.Coraglia	System CF1	Traceability YES
Scale 1:1	Sheet size A2	Sheet 1 / 1	General Tolerances for dimensions acc. to: ISO 2768-	Packaging (GSTP08)
1		2	3	4
5		6	7	8
9		10	11	12

Westport
Fuel Systems
Westport Fuel
Systems Italia S.r.l.
Cherasco (Cn), Italy