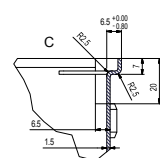
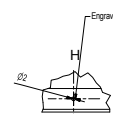
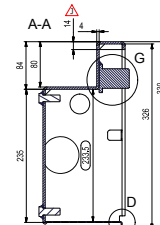
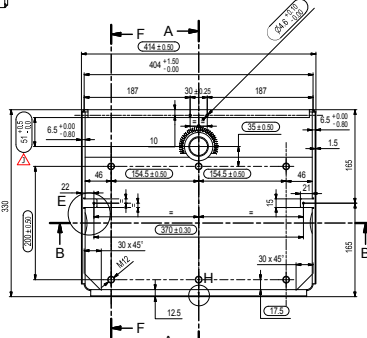
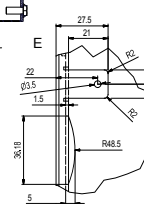
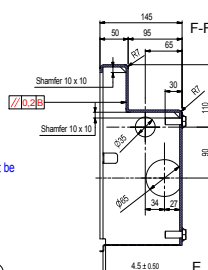
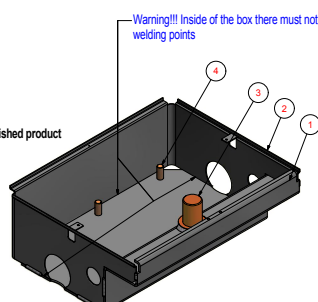
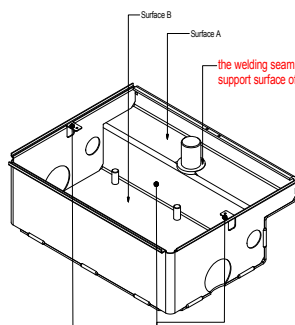
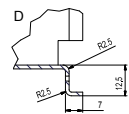
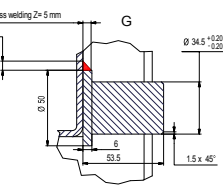
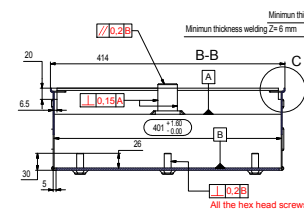
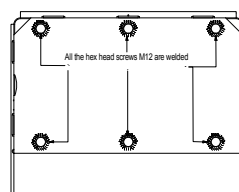
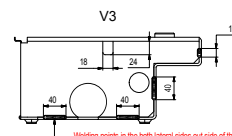
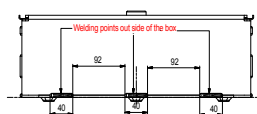
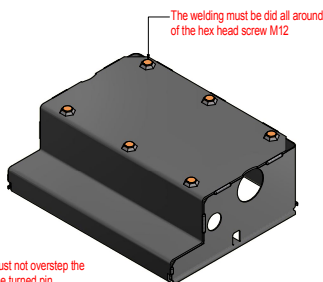


- 1- No sheet metal deformation after all working process
- 2- All the welding points must be well done
- 3- Parallelism tolerance of plan A and B must NOT be more than 0.1 mm
- 4- All the holes must be without fillings (No burrs)
- 5- The film thickness must be as requested 15 - 35 micron
- 6- The finished product must not have scratches on the paint , dents and sharp edges.
- 7- The welding points must be out side of the box

TEST DATA CATAPHORESIS			DATI DI COLLAUDO CATAFORESIS		
FILM THICKNESS	15 - 35 MICRON		SPESSORE FILM	15 - 35 MICRON	
SALTY FOG	ASTM B117 - 95	500 HOURS	NEBBIA SALINA	ASTM B117 - 95	500 ORE
HARDNESS	ASTM D3363 - 92A	2H	DUREZZA	ASTM D3363 - 92A	2H
ADHERENCE	ASTM D3359 - 95	4B - 5B	ADERENZA	ASTM D3359 - 95	4B - 5B
DIRECT IMPACT	ASTM D2794 - 93	1KJ / 25 cm	IMPATTO DIRETTO	ASTM D2794 - 93	1KJ / 25 cm



- 1- Test report of raw material (metal sheet thickness 4 mm and 1.5 mm, turned pin),
- 2- Dimensional report made by the supplier according to the drawing,
- 3- Report of assembly test (use the item D612242, D731054, D731055, D731056, D731057, D731058, D731059, D731060, D731061, D731062, D731063, D731064, D731065, D731066, D731067, D731068, D731069, D731070, D731071, D731072, D731073, D731074, D731075, D731076, D731077, D731078, D731079, D731080, D731081, D731082, D731083, D731084, D731085, D731086, D731087, D731088, D731089, D731090, D731091, D731092, D731093, D731094, D731095, D731096, D731097, D731098, D731099, D731100, D731101, D731102, D731103, D731104, D731105, D731106, D731107, D731108, D731109, D731110, D731111, D731112, D731113, D731114, D731115, D731116, D731117, D731118, D731119, D731120, D731121, D731122, D731123, D731124, D731125, D731126, D731127, D731128, D731129, D731130, D731131, D731132, D731133, D731134, D731135, D731136, D731137, D731138, D731139, D731140, D731141, D731142, D731143, D731144, D731145, D731146, D731147, D731148, D731149, D731150, D731151, D731152, D731153, D731154, D731155, D731156, D731157, D731158, D731159, D731160, D731161, D731162, D731163, D731164, D731165, D731166, D731167, D731168, D731169, D731170, D731171, D731172, D731173, D731174, D731175, D731176, D731177, D731178, D731179, D731180, D731181, D731182, D731183, D731184, D731185, D731186, D731187, D731188, D731189, D731190, D731191, D731192, D731193, D731194, D731195, D731196, D731197, D731198, D731199, D731200, D731201, D731202, D731203, D731204, D731205, D731206, D731207, D731208, D731209, D731210, D731211, D731212, D731213, D731214, D731215, D731216, D731217, D731218, D731219, D731220, D731221, D731222, D731223, D731224, D731225, D731226, D731227, D731228, D731229, D731230, D731231, D731232, D731233, D731234, D731235, D731236, D731237, D731238, D731239, D731240, D731241, D731242, D731243, D731244, D731245, D731246, D731247, D731248, D731249, D731250, D731251, D731252, D731253, D731254, D731255, D731256, D731257, D731258, D731259, D731260, D731261, D731262, D731263, D731264, D731265, D731266, D731267, D731268, D731269, D731270, D731271, D731272, D731273, D731274, D731275, D731276, D731277, D731278, D731279, D731280, D731281, D731282, D731283, D731284, D731285, D731286, D731287, D731288, D731289, D731290, D731291, D731292, D731293, D731294, D731295, D731296, D731297, D731298, D731299, D731300, D731301, D731302, D731303, D731304, D731305, D731306, D731307, D731308, D731309, D731310, D731311, D731312, D731313, D731314, D731315, D731316, D731317, D731318, D731319, D731320, D731321, D731322, D731323, D731324, D731325, D731326, D731327, D731328, D731329, D731330, D731331, D731332, D731333, D731334, D731335, D731336, D731337, D731338, D731339, D731340, D731341, D731342, D731343, D731344, D731345, D731346, D731347, D731348, D731349, D731350, D731351, D731352, D731353, D731354, D731355, D731356, D731357, D731358, D731359, D731360, D731361, D731362, D731363, D731364, D731365, D731366, D731367, D731368, D731369, D731370, D731371, D731372, D731373, D731374, D731375, D731376, D731377, D731378, D731379, D731380, D731381, D731382, D731383, D731384, D731385, D731386, D731387, D731388, D731389, D731390, D731391, D731392, D731393, D731394, D731395, D731396, D731397, D731398, D731399, D731400, D731401, D731402, D731403, D731404, D731405, D731406, D731407, D731408, D731409, D731410, D731411, D731412, D731413, D731414, D731415, D731416, D731417, D731418, D731419, D731420, D731421, D731422, D731423, D731424, D731425, D731426, D731427, D731428, D731429, D731430, D731431, D731432, D731433, D731434, D731435, D731436, D731437, D731438, D731439, D731440, D731441, D731442, D731443, D731444, D731445, D731446, D731447, D731448, D731449, D731450, D731451, D731452, D731453, D731454, D731455, D731456, D731457, D731458, D731459, D731460, D731461, D731462, D731463, D731464, D731465, D731466, D731467, D731468, D731469, D731470, D731471, D731472, D731473, D731474, D731475, D731476, D731477, D731478, D731479, D731480, D731481, D731482, D731483, D731484, D731485, D731486, D731487, D731488, D731489, D731490, D731491, D731492, D731493, D731494, D731495, D731496, D731497, D731498, D731499, D731500, D731501, D731502, D731503, D731504, D731505, D731506, D731507, D731508, D731509, D731510, D731511, D731512, D731513, D731514, D731515, D731516, D731517, D731518, D731519, D731520, D731521, D731522, D731523, D731524, D731525, D731526, D731527, D731528, D731529, D731530, D731531, D731532, D731533, D731534, D731535, D731536, D731537, D731538, D731539, D731540, D731541, D731542, D731543, D731544, D731545, D731546, D731547, D731548, D731549, D731550, D731551, D731552, D731553, D731554, D731555, D



POSITION	DESCRIPTION	QTY	MATERIAL	NOTES	DESCRIPTION / DESCRIPTION
1	SHEET METAL THICKNESS = 4 MM	1	Fe 3608 - UNI EN 10025		CASSA FONDAZIONE BTFC-250 CATAFORESI FOUNDATION BOX BTFC - 250
2	SHEET METAL THICKNESS = 1.5 MM	1	Fe 3608 - UNI EN 10025		
3	TURNED PIN	1	PR80 (36SMnPb14) - UNI 10087		
4	HEX HEAD SCREW M12	8.8			

GENERAL TOLERANCE ISO 2768 - Class m (medium)			
PERMISSIBLE DEVIATIONS FOR LINEAR DIMENSIONS			
Size 10 to 30	±0.1	Size 120 up to 400	±0.5
Size 30 to 50	±0.15	Size 400 to 630	±0.6
Size 50 to 80	±0.2	Size 630 to 1000	±0.8
Size 80 to 120	±0.25	Size 1000 to 1600	±1.0
Size 120 up to 180	±0.3	Size 1600 to 2500	±1.2
Size 180 to 250	±0.35	Size 2500 to 4000	±1.5
PERMISSIBLE DEVIATIONS FOR ROUNDED OFF EDGES IN mm			
Radius R	±0.1	Radius R	±0.5
Size 10 to 30	±0.1	Size 120 up to 400	±0.5
Size 30 to 50	±0.15	Size 400 to 630	±0.6
Size 50 to 80	±0.2	Size 630 to 1000	±0.8
Size 80 to 120	±0.25	Size 1000 to 1600	±1.0
Size 120 up to 180	±0.3	Size 1600 to 2500	±1.2
Size 180 to 250	±0.35	Size 2500 to 4000	±1.5
PERMISSIBLE DEVIATIONS FOR ANGLES IN mm			
Angle α	±0.1	Angle α	±0.5
Size 10 to 30	±0.1	Size 120 up to 400	±0.5
Size 30 to 50	±0.15	Size 400 to 630	±0.6
Size 50 to 80	±0.2	Size 630 to 1000	±0.8
Size 80 to 120	±0.25	Size 1000 to 1600	±1.0
Size 120 up to 180	±0.3	Size 1600 to 2500	±1.2
Size 180 to 250	±0.35	Size 2500 to 4000	±1.5
PERMISSIBLE DEVIATIONS FOR SURFACES OF FINISHING			
Surface finish	±0.1	Surface finish	±0.5
Size 10 to 30	±0.1	Size 120 up to 400	±0.5
Size 30 to 50	±0.15	Size 400 to 630	±0.6
Size 50 to 80	±0.2	Size 630 to 1000	±0.8
Size 80 to 120	±0.25	Size 1000 to 1600	±1.0
Size 120 up to 180	±0.3	Size 1600 to 2500	±1.2
Size 180 to 250	±0.35	Size 2500 to 4000	±1.5
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Size 80 to 120	±0.25	Size 1000 to 1600	±1.0
Size 120 up to 180	±0.3	Size 1600 to 2500	±1.2
Size 180 to 250	±0.35	Size 2500 to 4000	±1.5
PERMISSIBLE DEVIATIONS FOR SURFACES OF FINISHING			
Surface finish	±0.1	Surface finish	±0.5
Size 10 to 30	±0.1	Size 120 up to 400	±0.5
Size 30 to 50	±0.15	Size 400 to 630	±0.6
Size 50 to 80	±0.2	Size 630 to 1000	±0.8
Size 80 to 120	±0.25	Size 1000 to 1600	±1.0
Size 120 up to 180	±0.3	Size 1600 to 2500	±1.2
Size 180 to 250	±0.35	Size 2500 to 4000	±1.5
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