NIKO d.o.o. Železniki
Otoki 16
SI-4228 Železniki
www.niko.si

METAL DISCS ϕ21 x 3
Specification for surface treatment

Datum:
5.7.2023

Project No.:
A22023-03

Background and short project description :

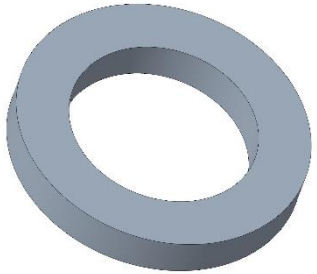
- For potential new project, after stamping operations, the surface treatment is required:

VW 13750 TL240 b140

Cleanliness acc. to PTL 140455

- The parts are used for automotive industry.

Metal Disc



Base data:

- Part dimensions: ϕ21 / ϕ 13,5 x 3 mm.
- Base material: DC01 C590, EN 10139, thickness 3,0 mm.
- The parts comes on surface treatment operation in bulk condition. On pieces are residuals lubricants form stamping.
- Quantity scenario: approx. 800.000 pieces per year, project lifetime 2023 – 27.
- Please take request for »***Cleanliness acc. to PTL 14045"***« into account – see original drawing attached.
- **The certificate of compliance with the requirements is necessary to be submitted for each shipment**.
- More detailed agreement about technical specifications will be done later.
- For other technical data, please see page 2.

By:
Boris Kavčič, 5.7.2023

Tehnični podatki

Part:
METAL DISC
Part no.: 013895

Outside dimension [mm]:
ϕ21 / ϕ 13,5 x 3 mm

Base material:
DC01 +C590, EN 10139

Sheet metal thickness: 3,0 mm

Surface area: 731 mm^2

Volume: 610 mm^3

Part wight: 0,0048 kg

Quantities:
Approx. 800.000 pcs / year
Project lifetime 2023-27

VW 13750 TL240 b140

Surface protection type	Test duration and type of test	Requirement
Ofl-b140	6 h salt spray test as per DIN EN ISO 9227-NSS (e.g., for head and shank on screws), thread area: 4 h salt spray test as per DIN EN ISO 9227-NSS (NSS – neutral salt spray test)	No base metal corrosion

3.5 Mass per unit area

Testing as per DIN EN ISO 3892

Requirement: 2 g/m^2 to 7 g/m^2

Cleanliness acc. to PTL 140455
permissible total amount of particles max. 1.5 mg
- metallic particles max. 0.5 mg
- non-metallic particles max. 1.0 mg
permissible particle size
- metallic particles max 0.3mm
- non-metallic particles max. 0.8mm
-fibers max. 2.0 mm allowed