



GENERAL TOLERANCE  
ISO 2768 - Class mK (medium)

PERMISSIBLE DEVIATIONS FOR LINEAR DIMENSIONS

from 0.5 up to 3	±0.1	over 3 up to 6	±0.15	over 6 up to 30	±0.2	over 30 up to 120	±0.3	over 120 up to 400	±0.5	over 400 up to 1000	±0.6	over 1000 up to 2000	±0.7	over 2000 up to 4000	±0.8
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up to 10	±1°	over 10 up to 30	±0.5°	over 30 up to 50	±0.6°	over 50 up to 120	±0.8°	over 120 up to 400	±1.0°	over 400 up to 1000	±1.2°	over 1000 up to 2000	±1.4°	over 2000 up to 4000	±1.6°
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from 0.5 up to 3	±0.2	over 3 up to 6	±0.3	over 6 up to 30	±0.5	over 30 up to 120	±0.8	over 120 up to 400	±1.0	over 400 up to 1000	±1.2	over 1000 up to 2000	±1.4	over 2000 up to 4000	±1.6
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Descrizione / Description  
FLANGIA PRINCIPALE XPASS.12 IMPR. - zincatura  
MAIN FLANGE XPASS.12 IMPR. - galvanizing

Materiale / Material  
GHISA GRIGIA EN-JL-250

Trattamento 1 / Treatment 1  
ZINCATURA / GALVANIZING

Trattamento 2 / Treatment 2  
norme o materiale altern. / standards or alt. material

UNI ISO 2081 - Fe/Zn 12/C

nome o materiale altern. / standards or alt. material  
BFC

disegnato da / drawn by  
D735209

rev.  
A.1

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<div><div>VERNICIATURA CON POLVERI POLIESTERE</div><div>CHISA</div><div>Materiale base: Catodi resine Trattamento: Vernice in polvere termoisolante a base di resina poliesterica Prodotto RAL 7015: INVER 53664 - POLIESTERE IGIC FREE TRIBO BT BUCC.GR. RAL7015 Prodotto RAL 7031: INVER 60004 - PE/P BT TX GRIGIO RAL 7031 (BUCCIATO) Prodotto RAL SPEC.: da definire Applicazione: Pistola a polo negativo 60/80 KV Tempo/temperatura di cottura: 20 min. a 160°C (temp. del supporto) Tempo/temperatura di cottura buccato: 20÷40 min. a 160°C (temp. del supporto)</div><div>RESISTENZA ALLA CORROSIONE Nebbia salina UNI ISO 9227 dopo 1000h: penetraz. lungo la croce di 3-6 mm Umidità UNI EN ISO 6270-2 dopo 500: nessuna variazione</div><div>CARATTERISTICHE TECNOLOGICHE Spessore: 60 ÷ 80 micron Resistenza all'impatto UNI 8901: &gt;25 cm.kg Inibizione Eichen UNI EN ISO 1520: &gt;5 mm Aderenza (2mm) (G1) UNI EN ISO 2409: 00 Piegatura UNI EN ISO 6860: &gt;10 mm</div><div>POLYESTER POWDER COATING Raw material: Steel Treatment: Cathodesis Type: Thermosetting powder paint based on polyester resin Product RAL 7015: INVER 53664 - POLIESTERE IGIC FREE TRIBO BT BUCC.GR. RAL7015 Product RAL 7031: INVER 60004 - PE/P BT TX GRIGIO RAL 7031 (BUCCIATO) Product RAL SPEC.: to be defined Application: 60/80 KV negative pole gun Time/temperature curing: 20 min. at 160°C (substrate temperature) Time/temperature orange peel curing: 20÷40 min. at 160°C (substrate temperature)</div><div>CORROSION RESISTANCE Salt spray test UNI ISO 9227 after 1000h: 3-6 mm of penetration along the cross-hatch Humidity test UNI EN ISO 6270-2 after 500h: no variation</div><div>TECHNOLOGICAL FEATURES Thickness: 60 ÷ 80 micron Impact resistance UNI 8901: &gt;25 cm.kg Eichen inhibition UNI EN ISO 1520: &gt;5 mm Adhesion (2mm) (G1) UNI EN ISO 2409: 00 Cylindrical bending UNI EN ISO 6860: &gt;10 mm</div></div>																			
REV.		DESCRIZIONE / DESCRIPTION										DATA / DATE		FIRMA / SIGN					
1		CRONOLOGIA REVISIONI / REVISION HISTORY																	
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<div><div>597</div><div>597</div><div>28</div><div>597</div></div>																			
<div><div>FLANGIA PRINCIPALE XPASS.12 IMPR. - vern. RAL 7015</div><div>MAIN FLANGE XPASS.12 IMPR. - painting RAL 7015</div><div>CHISA GRIGIA EN-IGL-250</div><div>Trattamento 1 / treatment 1</div><div>VERNICIATURA / PAINTING</div><div>Trattamento 2 / treatment 2</div><div>norme o materiale alieni / standards of alt. material</div><div>R.F. 1484</div></div>																			
<div><div>GENERAL TOLERANCE</div><div>ISO 2768 - Class mk (medium)</div><div>PERMISSIBLE DEVIATIONS FOR LINEAR DIMENSIONS</div><div>from 0.5 up to 3 ±0.1 over 3 up to 6 ±0.1 over 6 up to 30 ±0.2 over 30 up to 120 ±0.3 over 120 up to 400 ±0.5 over 400 up to 600 ±0.6 over 600 up to 1000 ±0.7 over 1000 up to 2000 ±0.8 over 2000 up to 4000 ±1.0 over 4000 up to 6000 ±1.2 over 6000 up to 10000 ±1.5</div><div>PERMISSIBLE DEVIATIONS FOR RANGES OF LENGTHS IN mm OF SHORTER SIDE OF THE ANGLE CONCERNED</div><div>up to 10 ±1 over 10 up to 30 ±0.5 over 30 up to 120 ±0.6 over 120 up to 400 ±0.8 over 400 up to 600 ±1.0 over 600 up to 1000 ±1.2 over 1000 up to 2000 ±1.5 over 2000 up to 4000 ±1.8 over 4000 up to 6000 ±2.0 over 6000 up to 10000 ±2.5</div><div>PERMISSIBLE DEVIATIONS FOR BROKEN EDGES</div><div>from 0.5 up to 3 ±0.2 over 3 up to 6 ±0.5 over 6 up to 10 ±1 over 10 up to 30 ±1.5 over 30 up to 120 ±2.0 over 120 up to 400 ±2.5 over 400 up to 600 ±3.0 over 600 up to 1000 ±3.5 over 1000 up to 2000 ±4.0 over 2000 up to 4000 ±4.5 over 4000 up to 6000 ±5.0 over 6000 up to 10000 ±5.5</div></div>																			
<div><div>massa / mass</div><div>22.94 kg</div><div>In fase di elaborazione</div><div>disegnato da / drawn by</div><div>17/01/2023</div><div>codice / code</div><div>D731867</div><div>REV.</div><div>A.1</div></div>																			

