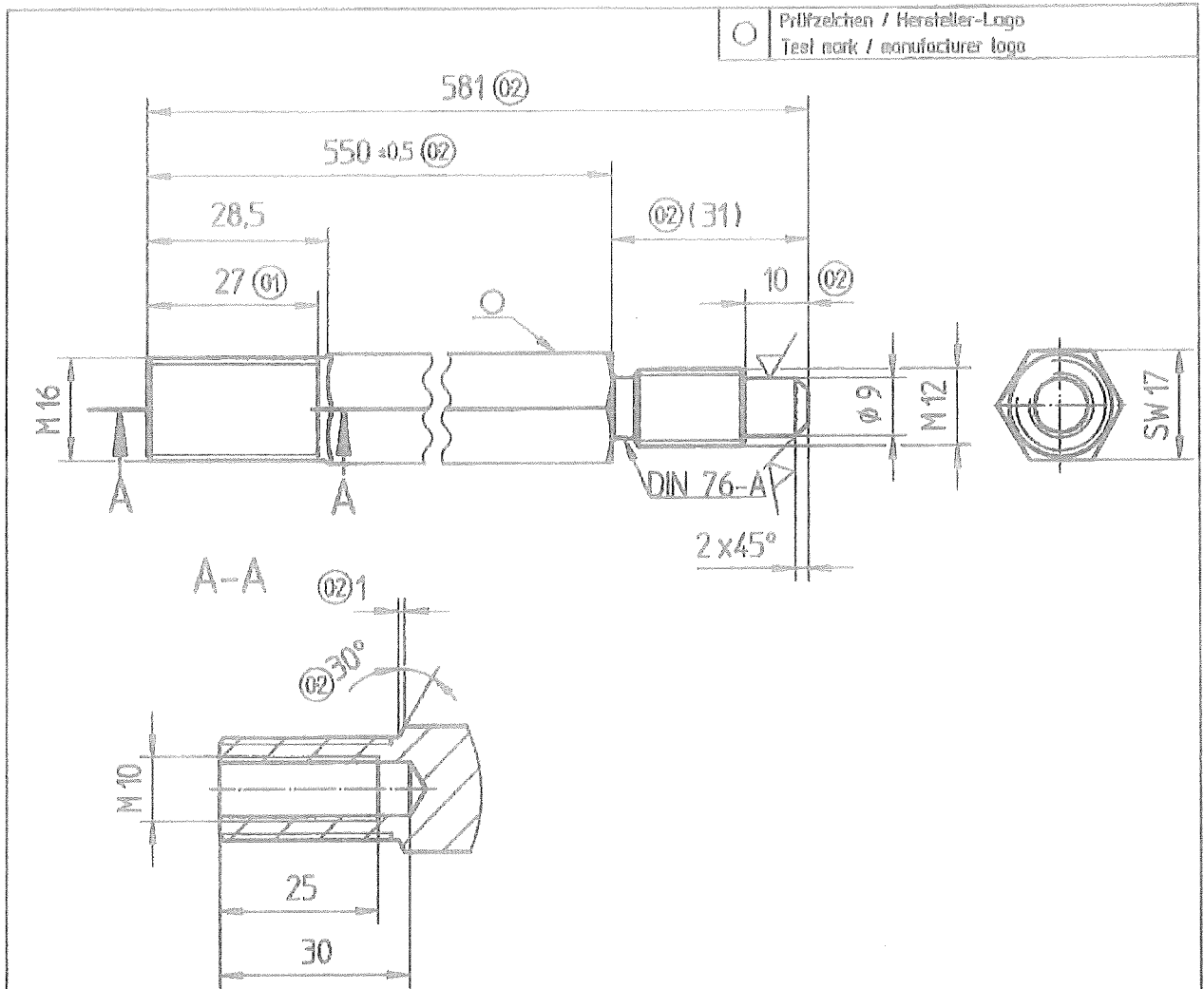



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03 Galvanische Oberflächenbeschichtung nach WN 0250 Blatt 17 silber
Galvanic coating according to factory standard 0250 page 17 silver

roh/rough (✓) L-0.5

00	THTW-12-0167	Dokument neu						
01	THTW-12-0254	Gewinde M16 war 17 lang						
02	THTW-13-0034	Maß 581 war 585, 31 war 34, 10 war 11, 550 hinzu, Fase hinzu						
03	THTW-17-0246	Anpassung Normen						
Vers.	Änderungs-Nr. Revision-No.	Beschreibung Description						
Darstellungs- methode ISO 128		Halbzeug 6kt-Stahl EN10276-17 h9	Senkfl.Part	Stoff-Nr. Standard-No.	Rohteil-Nr.	Blank-No.	Gewicht Weight [kg]	1,078
Projection- method per ISO 128		Werkstoff S235JR EN 10025	Materiel	1.0038			Maßstab Scale	1:1
wenn nicht anders angegeben unless otherwise specified			Datum 25.09.201	Name	Benennung Title			C A D
Werkstückkanten nach DIN ISO 1375		Edges per DIN ISO 1375	Bearb. 25.09.201	Gepr. 26.09.201	Zuganker Tension rod			
Form- u. Lagertoleranzen nach DIN ISO 1101								
Geometric tolerances per DIN ISO 1101								
Allgemeintoleranzen nach ISO 2768-rt		Maßangaben in Millimeter		Formal E		Zeichnungs-Nr. Drawing-No.		Version 03
General tolerances per ISO 2768-rt		Dimensions are in millimeters		E		92111252		
Oberflächenangaben nach DIN ISO 1302 Ausgabe: 1993-12		Surface texture per DIN ISO 1302 Issue: 1993-12		Gesamtoberfläche [dm2] entire surface [dm2]		3,44		ähnlich Zeichn.-Nr. similar Drawing-No.
								Blatt Sheet
								1 von 1 of 1
								Bl. Sh.

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WERKNORM FACTORY STANDARD			
Benennung Designation	Surface coating Galvanic surface coating of drawing parts	EDV-Werknorm/Factory Standard 0250	Blatt/Page 17
	Werkstoff/Ausführung Material/Type	Ausgabe: Issue:	01/17
		Ersatz für: Replacem. for:	

This factory standard applies to iron material, which is galvanised and then passivated in a Cr(VI)-free medium. The requirements are expressed as general as possible to enable the highest possible availability. The supplier is free to choose the cheapest process, which meets the requirements stated here. The offer must state the process which will be used. Before changing the coating process within the framework of this standard, must be informed of this intention.

Colour:

Drawing entry	Appearance
Galvanic surface coating according to factory standard WN 0250 page 17 silver	Silver, colourful indescence permitted
Galvanic surface coating according to factory standard WN 0250 page 17 black	Black

Corrosion resistance:

All used coatings must have at least the following corrosion resistance and undergo a salt mist test (NSS) according to DIN EN ISO 9227.

No corrosion of the metal coating (white rust)	120 h
No corrosion of the base metal (red rust)	336 h

Parts with threads:

The threads on the parts must be true to gauge after coating (if not stated otherwise: external thread 6g, internal thread 6H).

Parts with fits:

All dimensions, especially fits, are always documented (drawing, ...) in their final condition (coated). The dimensions of fits especially must be determined by the supplier of the mechanical processing in cooperation with the coating company before the coating takes place.

Surface sealing:

Parts passivated in black must be sealed to get a richer shade of black (e.g. in accordance with DIN 50979: T2).

The sealing of silver parts is decided upon by the coater, depending on the required corrosion resistance and the selected coating process.

No special friction reducing coating must be used.

WERKNORM FACTORY STANDARD			
Benennung Designation	Surface coating Galvanic surface coating of drawing parts	EDV-Werknorm/Factory Standard 0250	Blatt/Page 17

Measures to prevent hydrogen embrittlement:

For parts with a stability equal or larger than 1000 N/mm² or a hardness equal or larger than 320 HV, ensure measures to prevent hydrogen embrittlement according to ISO 2081 or DIN 50979. The exact process is agreed upon between the coater and the QA for each part.

Cr(VI)-free:

In accordance with RoHS directive and the REACH regulation, all coatings must be free of hexavalent chromium.

Recommended surface treatments:

The following coatings are only to be viewed as examples; the requirements stated above remain binding.

Drawing entry	Examples of standard coatings
Galvanic surface coating according to factory standard WN 0250 page 17 silver	Galvanic coating DIN 50979 Fe//Zn12//Cr//T0
	Galvanic coating DIN 50979 Fe//Zn12//Cr//T2
	Galvanic coating DIN 50979 Fe//ZnFe8//Cr//T2
	Galvanic coating DIN 50979 Fe//ZnNi5//Cr//T0
	Galvanic coating DIN 50979 Fe//ZnNi5//Cr//T2
Galvanic surface coating according to factory standard WN 0250 page 17 black	Galvanic coating DIN 50979 Fe//ZnFe8//Fe//T2
	Galvanic coating DIN 50979 Fe//ZnNi5//Fe//T2