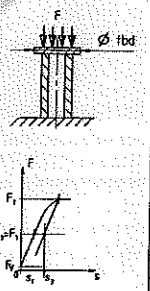
...lues have to be defined.

...OMPRESSION STIFFNESS TESTING

...ICH TEST SET UP



TEST MACHINE SET-UP		
MAX. ERROR FORCE	F_F	±1 kN
MIN. RESOLUTION DISPLACEMENT	F_s	0,5 µm
TEST MACHINE STIFFNESS	C_m	≥200 kN/mm ++
++ means effective test machine stiffness and test set up stiffness by use of extensometer		
TEST PARAMETERS		
MEASURING SPEED	V_1	2 mm/min
PRELOAD	F_V	1 kN
TEST LOAD 1	F_1	44 kN
TEST LOAD 2	F_2	88 kN
TEST LOAD 3	F_3	44 kN
HOLDING TIME AT F_1	Δt	5 sec
REQUIREMENTS		
COMPRESSION	SC | $s_3 - s_1 \leq 0.18$ mm	

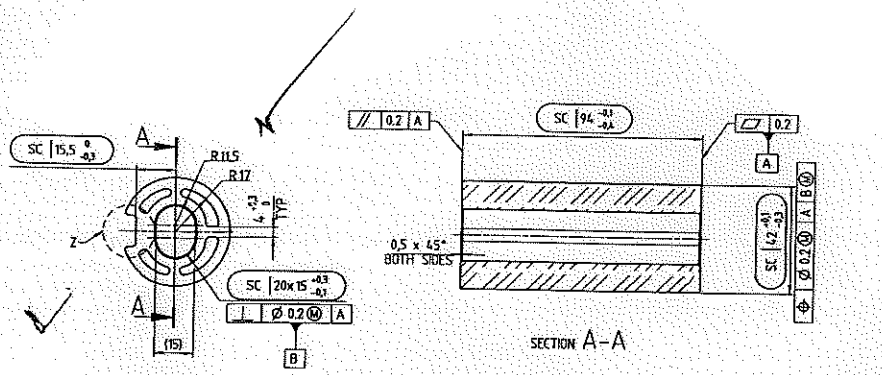
BLOCK 1

REV	CNT	FIELD	ECR-NO.	CHANGE DESCRIPTION	DATE	NAME
A				INITIAL RELEASE	18.01.2023	Kumar, Vinay

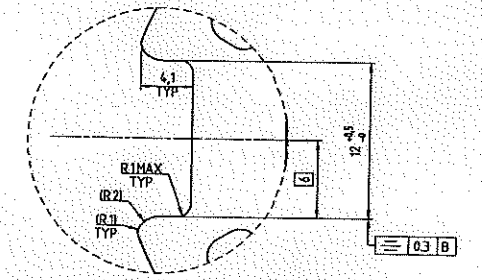
Regretted due to the CNC machine is not available for Turning process

NOTE :

1) PART MUST COMPLY WITH THE REQUIREMENTS OF ELV & HAZARDOUS MATERIAL CONTENT AS SPECIFIED IN M&M STANDARD F001474 (REV-2), AS PER THE MARKET REQUIREMENTS. IN CASE OF MULTIPLE MARKETS, PART MUST COMPLY WITH ALL LEGISLATIVE REQUIREMENTS OF THE RESPECTIVE MARKET
2) DEFAULT PROFILE ⌓ | 0.10 | A | B Ⓜ | C Ⓜ



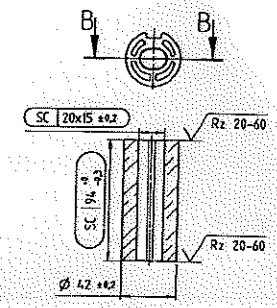
SECTION A-A



DETAIL Z
SCALE 5:1

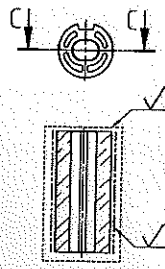
BLOCK 2

FINAL PART DIMENSION AFTER GRIT BLASTING
SCALE 1:2



SECTION B-B

BONDING AND PREPARATION
SCALE 1:2



SECTION C-C

* PREPARATION TABLE

CONDITION		SYMBOL	SPECIFICATION	REFERENCE STANDARD	RESPONSIBLE
PREPARATION ITEM			DETAILED SPECIFICATION IN THIS AREA IF NO REFERENCE STANDARD, OR SPECIAL RESTRICTION IF EMPHASIS IS NEEDED ON SOME CHARACTERISTICS	RELATED REFERENCE STANDARD	DEFINE RESPONSIBLE
DELIVERY			EXC. FREE FROM ALL POSSIBLE CONTAMINANTS THAT COULD NOT BE REMOVED BY STANDARD VE DEGREASING PROCESS	OPI 01-7.4-0006	COMPONENT SUPPLIER
PREPARATION SURFACE 14480.79 mm²	DEGREASING	√ E	ALKALINE WASH	TES-10100_2 Rev.6	BONDING SUPPLIER
	GRIT-BLASTING	√ S	STEEL SHOT	TES-10400_1/2 Rev.7	BONDING SUPPLIER
BONDING SURFACE 12944.85 mm²	PRIMER	√ P	CHEMLOK 205	TES-22002_1 Rev.7	BONDING SUPPLIER
	COVER	√ C	CHEMLOK 6411	TES-22002_1 Rev.7	BONDING SUPPLIER

PREPARATION AREA MARKED	
BONDED AREA MARKED	
IF NEEDED, ADHESIVE THICKNESS CONTROL ON DEFINED AREA : ADHESIVE THICKNESS GAUGE AREA	
IF NEEDED, TREATMENT THICKNESS CONTROL ON DEFINED AREA : TREATMENT THICKNESS GAUGE AREA	
IF NEEDED, ROUGHNESS CONTROL ON DEFINED AREA : ROUGHNESS GAUGE AREA	

METAL PART CHANGES DUE TO THE REVISION IN CONNEXION WITH METAL PART DRAWING ARE CONSIDERED

	ALUMINIUM	STEEL
INCREASE OF LENGTH (mm)	-0.1	-0.05
BORE CONTRACTION (mm)	-0.1	-0.05
INCREASE OF OUTER Ø (mm)	-0.1	-0.05

* TO BE DEFINED / FINALISED AFTER RESULTS OF PRODUCTION PARTS

AS NECESSARY MARKING MUST APPEAR IN LOCATION NOTED ON DRAWING AND SHOULD BE READABLE

PART MUST BE FREE OF BURRS, SHARP EDGES OR FLASHING WHICH MAY BE DETRIMENTAL TO SATISFACTORY ASSEMBLY, SAFE HANDLING, APPEARANCE OR FUNCTION

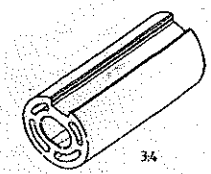
THIS PRINT SUPERSEDES ALL INDUSTRY STANDARDS NOT SHOWN

FEATURES FOR MANUFACTURING PURPOSES PERMISSIBLE PER VIBRACOUSTIC ENGINEERING APPROVAL

FOR FEATURES WITHOUT DIMENSION REFER TO 3D MODEL

NO CHANGES ALLOWED WITHOUT VIBRACOUSTIC APPROVAL

SPECIAL CHARACTERISTICS
CC/CC@ISC/EC ⬭
ACC. TO GP-01-7.4-0007



3:4

GENERAL TOLERANCES
UNLESS OTHERWISE SPECIFIED

CAST IRON WITH SPHEROIDAL GRAPHITE/ CAST IRON ISO 1083-3 GCTG 35	LIGHT METAL ALLOYS ISO 8062-3 GCTG 6 GCTG 5	ALUMINIUM FORGINGS DIN EN 586-3 DROP FORGINGS DIN EN 10243-3 FORGING GRADE F	
ICERS ISO 1370	RUBBER ISO 3302-1 M3	ALUMINIUM ALLOY/EXTRUDED ROD BAR TUBE AND PROFILES EN 755-9	
SINTERED ISO 5755	PLASTIC MOULDED PARTS ISO 20457 TG4		
	STAMPED PARTS DIN 7168-2 m	GEOMETRICAL TOLERANCES FOR FEATURES WITHOUT INDIVIDUAL TOLERANCE INDICATIONS ISO 2768-1 H ISO 2768-2 H	
FIRST ANGLE PROJECTION ISO 5456-2	WELDMENTS FOR WELDED CONSTRUCTIONS DIN EN ISO 13920 B	GEOMETRICAL TOLERANCING ISO 8015	

	NAME	DATE
DRAWN BY	Kumar, Vinay	17.01.2023
CHECKED BY	Singh, Gurwinder	25.07.2023
APPROVED BY	Saiwal, Naveen	25.07.2023
RELEASE STATUS	designed	

MATERIAL: EN AW-6005 (T6 AS PER EMS5-2
WEIGHT: 209,1

DESCRIPTION: CORE
SCALE: 1:1
SIZE: 1
SHEET: 1:1
DRAWING NUMBER: XC-FE0608-301
REV.: A

Vibracoustic

THE MATHEMATICAL DATA IS THE MASTER FOR THIS PART. ENGLISH VERSION IS THE AUTHORITATIVE VERSION. MANUAL CHANGES ARE NOT ALLOWED