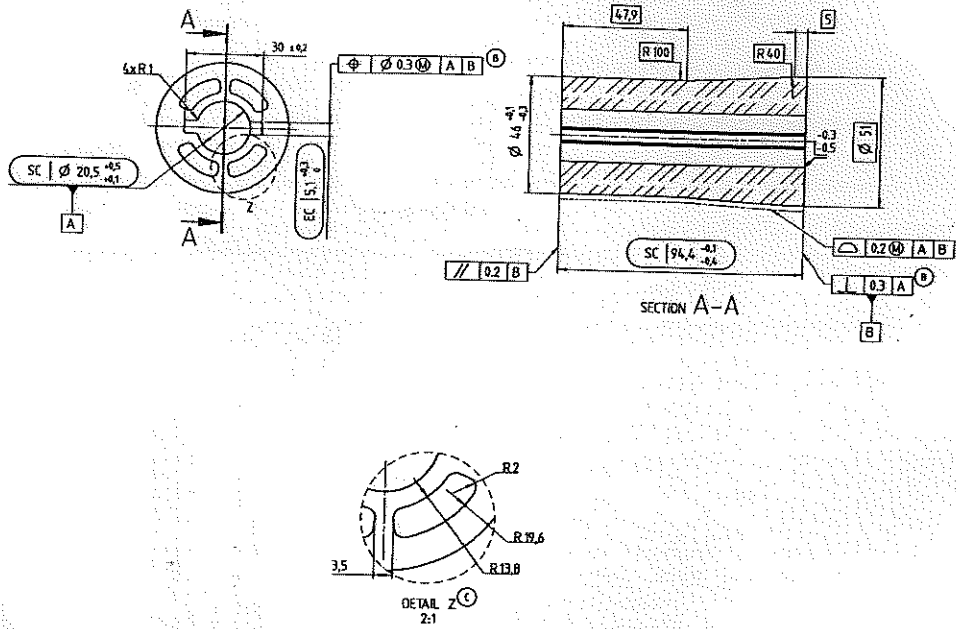
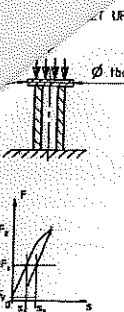


BLOCK 1

STIFFNESS TESTING

TEST MACHINE SET-UP		
MAX. ERROR FORCE	F_p	± 1 kN
MIN. RESOLUTION (DISPLACEMENT)	F_p	0.5 μ m
TEST MACHINE STIFFNESS	C_s	≥ 200 kN/mm
* means effective test machine stiffness and test set up stiffness by use of extensometer		
TEST PARAMETERS		
MEASURING SPEED	V_t	2 mm/min
PRELOAD	F_p	1 kN
TEST LOAD 1	F_t	58 kN
TEST LOAD 2	F_t	116 kN
TEST LOAD 3	F_t	58 kN
HOLDING TIME AT F_p	Δt	5 sec
REQUIREMENTS		
COMPRESSION	SC	$s_2 - s_1 \leq 0.19$ mm

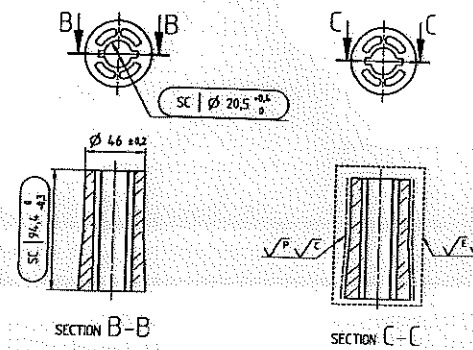


REV.	CHG.	FIELD	ECR. NO.	CHANGE DESCRIPTION	DATE	NAME
1	A			INITIAL RELEASE	18-Mar-2023	Singh, Gurvinder
2	B	DB	007023/002	AS PER FSI	18-Mar-2023	Singh, Gurvinder
3	C	FB	007023/004	WEIGHT REDUCTION CAVITIES 1 DE DIA. VIEW ADDED	21-Apr-2023	Joshi, Rajat

NOTE:
 1) PART MUST COMPLY WITH THE REQUIREMENTS OF EIV & HAZARDOUS MATERIAL CONTENT AS SPECIFIED IN M&M STANDARD F001674 (REV-3), AS PER THE MARKET REQUIREMENTS IN CASE OF MULTIPLE MARKETS, PART MUST COMPLY WITH ALL LEGISLATIVE REQUIREMENTS OF THE RESPECTIVE MARKET

MAIN DIMENSION AFTER GRIT LASTING SCALE 1:2

BONDING AND PREPARATION SCALE 1:2



* PREPARATION TABLE

CONDITION	SYMBOL	SPECIFICATION	REFERENCE STANDARD	RESPONSIBLE
PREPARATION ITEM		RECALLED SPECIFICATION IN THIS AREA IF NO REFERENCE STANDARD; ON SPECIAL RESTRICTION IF EMPHASIS IS NOTED ON SOME CHARACTERISTICS	RELATED REFERENCE STANDARD	DEFINE RESPONSIBLE
DELIVERY		EX: FREE FROM ALL POSSIBLE CONTAMINANTS THAT COULD NOT BE REMOVED BY STANDARD VC DEGRASSING PROCESS	SPR 01-74-3006	COMPONENT SUPPLIER
PREPARATION SURFACE	DEGREASING	✓ E ALKALINE WASH	TES-1000.2 Rev.6	BONDING SUPPLIER
	GRIT-BLASTING	✓ S STEEL SHOT	TES-1000.1 Rev.2	BONDING SUPPLIER
	PRIMER	✓ P CHEMLOCK 205	TES-1000.1 Rev.2	BONDING SUPPLIER
	COVER	✓ C CHEMLOCK 108	TES-2000+	BONDING SUPPLIER

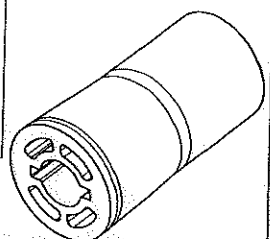
PREPARATION AREA MARKED
 BONDING AREA MARKED
 IF NEEDED, ADHESIVE THICKNESS CONTROL ON DEFINED AREA - ADHESIVE THICKNESS GAUGE AREA
 IF NEEDED, TREATMENT THICKNESS CONTROL ON DEFINED AREA - TREATMENT THICKNESS GAUGE AREA
 IF NEEDED, ROUGHNESS CONTROL ON DEFINED AREA - ROUGHNESS GAUGE AREA

NOTE: PART GRANTED DUE TO THE PREPARATION IS COMPARED WITH NEW PART DRAWING LINE (UNCOATED)	ALUMINUM	STEEL
INCREASE OF LENGTH (mm)	+0.1	-0.05
BOTH CONTRACTIONS (mm)	-0.1	-0.05
INCREASE OF OUTER Ø (mm)	+0.1	-0.05

BLOCK 2

* TO BE DEFINED / FINALISED AFTER RESULTS OF PROTOTYPE 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
 CCC@JSCIEC
 ACC. TO GP-01-74-0007



GENERAL TOLERANCES		ALL	DATE	NAME	INITIALS
UNLESS OTHERWISE SPECIFIED		11.03.2023	18-Mar-2023	Singh, Gurvinder	DB 04-005 (14)
		08.02.2023	08.02.2023	Singh, Gurvinder	AS PER DM 705
				Gethika, Vign	
				designed	checked
					SCALE 1:1
					SIZE 1
					THE REPRODUCED DRAWING IS THE PROPERTY OF VIBRACOUSTIC AND ITS UTILIZATION OF THIS DRAWING AS WELL AS ANY OTHERS WITHOUT EXPRESS AUTHORIZATION IS PROHIBITED. OFFENDERS WILL BE HELD LIABLE FOR THE BREACH OF DAMAGES. ALL RIGHTS RESERVED IN THE EVENT OF GRANT OF A BREVET, PATENT, TRADE MARK OR OTHER RIGHTS.
					THE HORIZONTAL LINE IS THE MARKER FOR THE WALL THICKNESS VARIATION IN THE AUTHORITY VENDOR. MANUAL CHANGES ARE NOT ALLOWED.
					XC-CS2491-200
					Vibracoustic