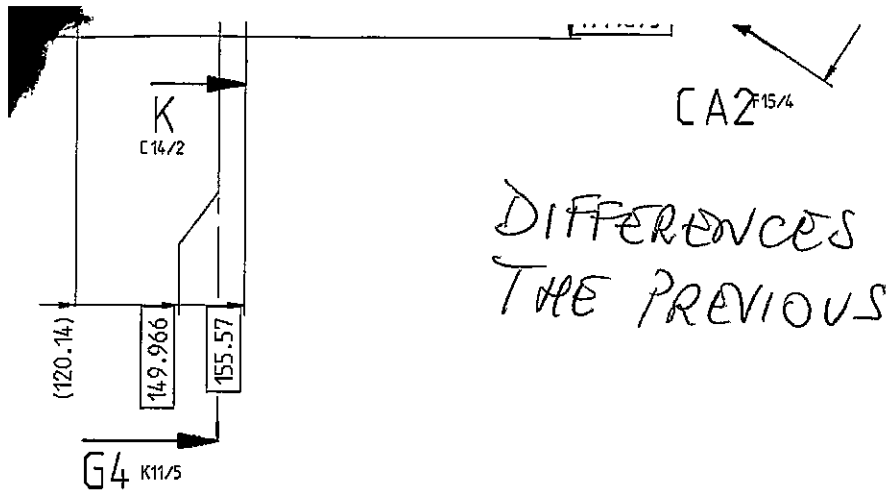
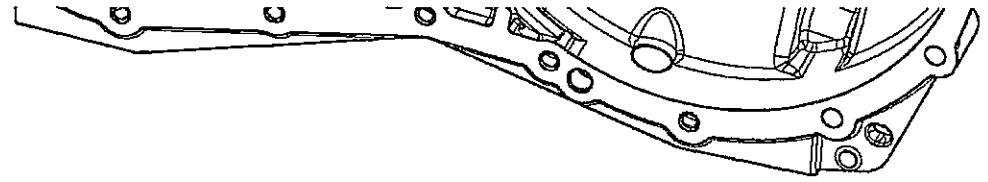


DIFFERENCES RESPECT
THE PREVIOUS INDEX



GENERAL SPECIFICATIONS:

EXAMINATION AND HANDLING ACCORDING TO GN 4317

RAW CASTING NO.: 250.0.3532.95
ACCORDING TO CAD-DATASET FROM 2012-03-06

CAST MAX. 0.8 RAISED E.G. FORM A5-20 DIN 30640
(TO BE PLACED INSIDE)
CAST DIMENSIONS WITHOUT TOLERANCE SPECIFICATIONS PER:
DIN 1688 SHEET 4 GTA 14/5 (DIECASTING) ±0.5
PROFILE SHAPE ACCORDING TO CAD-DATASET IN COMPLIANCE TO
DIN EN ISO 1101 | ⌓ | 1.6 | CP | RP1 | RP1-RP2 |

GENERAL WALL THICKNESS ACCORDING TO CAD-DATASET $^{+0.5}_{-0.3}$

UNDIMENSIONED DRAFT ANGLE ACCORDING TO CAD-DATASET ±30'
DRAFT ANGLE AT BOLT HEAD LOCATIONS 30' MAX.

UNDIMENSIONED RADIUS ACCORDING TO CAD-DATASET $^{+2}$

TRIM RIBS ACCORDING TO CAD-DATASET $^{+1.5}$ RAISED
GATES AND PARTING LINE FLASH
AT INTERNAL AREA 0.5 MAX. PROTRUDING ALLOWED

EJECTOR PIN ACCORDING TO CAD-DATASET
EJECTOR PIN BOSSES 1mm LARGER IS PERMISSIBLE
ON UNMACHINED SURFACES FROM FLUSH TO 0.8 RECESSED
ON MACHINED SURFACES FROM FLUSH TO 0.5 RAISED

POROSITY, IF NOT DEFINED OTHERWISE:
SEE DRAWING 250.0.9515.00

TECHNICAL CLEANLINESS ACCORDING TO GN 4340-1

LEAK TEST BY PRESSURE DIFFERENCE:
PERMISSIBLE LEAK RATE MAX 12 ccm/min.
ABOVE OIL LEVEL EXCEPTION ACCEPTBLE
TEST PRESSURE: 0.8-1.2 bar

PART WITH A LEAK RATE TO 50 ccm/min MAY GET
IMPREGNATED
PARTS WITH LARGER LEAK RATE ARE TO BE SCRAPPED

SHOT-BLASTING / SPARK COATING IS PERMISSIBLE

M1 (Oberflaechenhaerte): Min. 80 HB 5 / 250 / 30
M1 (SURFACE HARDNESS): MIN. 80 HB 5 / 250 / 30

Mittelwert am Teil
Min. Wert im Prozess
AVERAGE VALUE AT PART
MIN. VALUE FOR PROCESS

YIELD STRENGTH Rp0.2 140 N/mm² min.

TENSILE STRENGTH Rm 240 N/mm² min.

FRACTURE STRAIN A50 mm % >1 min.

* Werkstoffzusammensetzung COMPOSITION OF MATERIAL	
Si	8.0 - 12.0 %
Fe	0.0 - 1.3 %
Cu	1.5 - 4.0 %
Mn	0.0 - 0.55 %
Mg	0.05 - 0.55 %
Ni	0.0 - 0.55 %
Zn	0.0 - 3.0 %
Sn	0.0 - 0.3 %
Ti	0.0 - 0.25 %
Pb	0.0 - 0.35 %
Cr	0.0 - 0.15 %
Al	Rest/ BALANCE

$^{-0.5}_{-0.1}$ $^{+0.3}$

Rueckzugsriefen
zulaessig bis Rmax 25
RETRACTION MARKS
PERMISSIBLE UNTIL Rmax 25

r = Rz10-Rz16
u = Rz 6.3
v = Rz 10
w = Rz 16
x = Rz 25
y = Rz 40
z = Rz 63

309137

GCG 803001	0	<M>					
	0	<C>					
GN 3010	0	<M>					
	0	<C>					
	0	<A2>					
CAD Prof Engineer			a	-	35 540	see sheet 2	2012-04-20
			-	-	250/4995	MATURITY LEVEL OF SPECIFICATION 3 APPROVED	2012-03-22

Massstab / SCALE: M: 1:1 (--)

Buchst. CHANGE INDEX | Anzahl NUMBER | Aend.-Nr. CHANGE REQUEST NO. | Aenderung MODIFICATION --nur mittels CAD zulaessig; FMEA ueberpruefen-- --ONLY ALLOWED BY CAD; CHECK FMEA-- | Datum DATE

Allgemeintoleranzen fuer Laengenmasse, Form und Lage ISO 2768 - mH gebrochene Kanten, Radien und Winkelmasse ISO 2768 - v
GENERAL TOLERANCES FOR LINEAR DIMENSIONS, FORM AND POSITION ISO 2768 - mH; CHAMFERS, RADII AND ANGULAR DIMENSIONS ISO 2768 - v

Informationen auf dieser Zeichnung sind ohne Angaben zu Verwendung und Freigabe unverbindlich.
INFORMATION ON THIS DRAWING PROVIDED WITHOUT OBLIGATION IF USAGE AND RELEASE ARE NOT SHOWN.

Auswertung der Durchmessermessung erfolgt nach der Gauss-Methode (Arithmetischer Mittelwert)
EVALUATION OF THE DIAMTER MEASUREMENT IS CARRIED OUT ACCORDING TO THE GAUSS METHOD (ARITHMETICAL MEAN VALUE)

Form- und Lagetolerierung FORM AND POSITION TOLERANCES EN ISO 1101 | Tolerierung TOLERANCING ISO 8015 | Oberflaechenangaben SURFACE TEXTURE GN 4005 | Werkstuecककkanten BREAK EDGES ISO 13715

Werkstoff / MATERIAL: *

Halbzeug SEMI-FINISHED: -

oelbenetzte Oberflaeche OIL WETTED SURFACE: 0 mm²

Gesamtoberflaeche SURFACE AREA: 1131043 mm² | Masse MASS: 9.127 kg

GETRAG
Getriebe- und Zahnradfabrik Hermann Hagenmeyer GmbH & Cie KG

Schutzvermerk nach ISO 16016 beachten
PROTECTION PER ISO 16016

Benennung / ITEM NAME: Kupplungsgehaeuse
CLUTCH-HOUSING

Artikel-Nr./ ITEM NO.: 2500353220
CAD-Modell: 2500353220

Blatt/SHEET 1 von/OF 5 | Reifegrad MATURITY: 3 | Format SIZE: A0

Ersatz fuer SUBSTITUTE FOR: -

	INTRALINK DATA	CHECKED IN BY	CHECKED IN ON: dd.mm.yyyy hh:mm:ss	VERSION
	Zchng / DRW:	Blanka.Klein	20.04.2012 10:13:36	32
	MODEL:	Blanka.Klein	20.04.2012 10:13:36	73