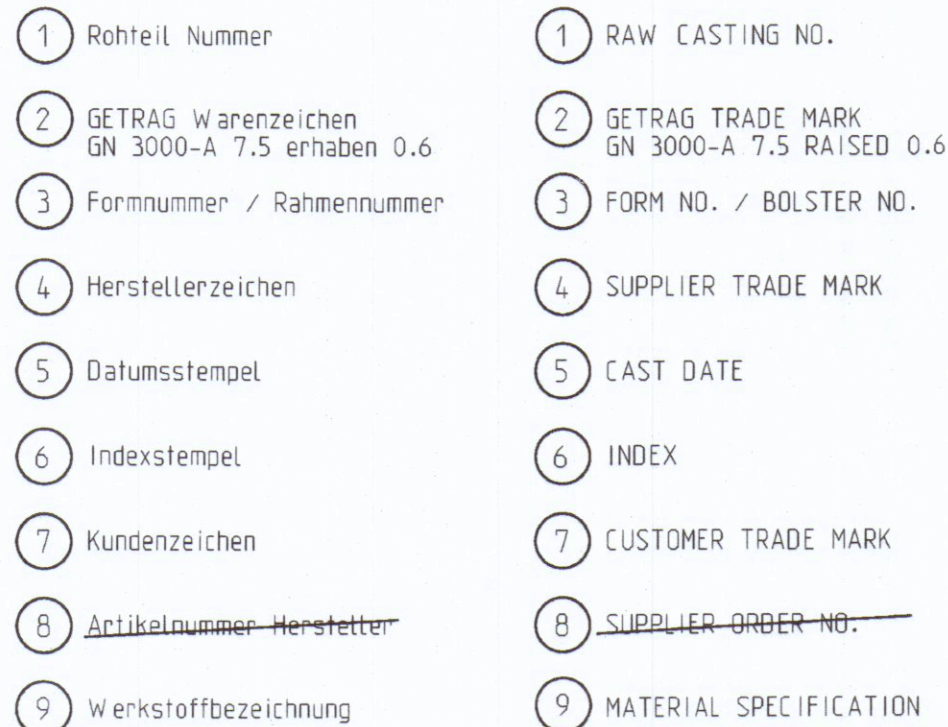


Document Status: approved



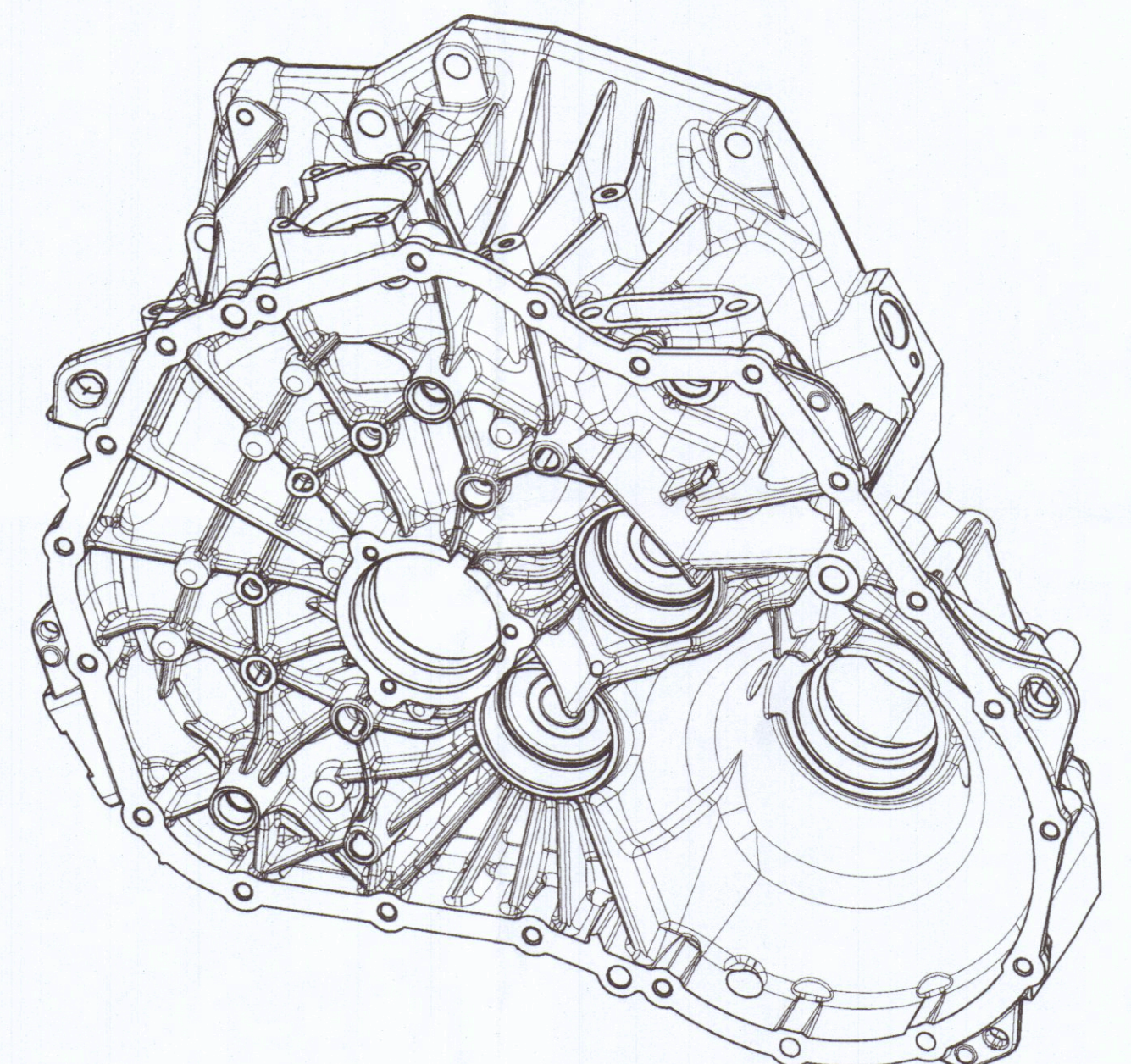
M22: $\varnothing 22.65 \pm 0.15 \times 45^\circ$

Strahlen / Flammstrahlbeschichtung ist

SHOT-BLASTING / SPARK COATING IS PERMISSIBLE

* 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

Rueckzugsriefen
zulaessig bis Rmax 25
RETRACTION MARKS
PERMISSIBLE UNTIL Rmax 25

$$\begin{aligned} \frac{r}{v} &= \sqrt{Rz 10 - R} \\ \frac{u}{v} &= \sqrt{Rz 6.3} \\ \frac{v}{v} &= \sqrt{Rz 10} \\ \frac{w}{v} &= \sqrt{Rz 16} \\ \frac{x}{v} &= \sqrt{Rz 25} \\ \frac{y}{v} &= \sqrt{Rz 40} \\ \frac{z}{v} &= \sqrt{Rz 63} \end{aligned}$$


Renault K9K Clio
MACHINING BARI

[illegible]

Revision: 20141203145628, printed at 2015-03-12 08:03:46 by D:\V...