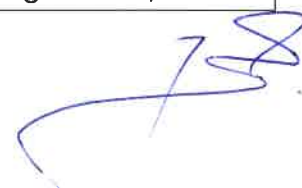


Table 1	<b>GENERAL TECHNICAL CONDITIONS OF CASTING ACCEPTANCE</b>	
Version: 1		
14-03-2016		

This Annex applies to all manufactured and newly started castings in company Teriel sp. z o.o. to the extent not precise separate, detailed terms and conditions of receipt or not specified in the drawing of rough casting also according to the current wording of the standard PN EN 1559-1: 2011.

Lp.	Characteristic	Description of requirements
1	Material	<p>Casting material verified in accordance with the: PN EN 1561 and PN EN 1563.</p> <p>While drawing of the cast or other arrangements not provide otherwise for the species ordered by criterion of "Tensile strength - Rm" – is measured on the separately cast test ingots.</p> <p>For species where the characteristic feature is the Brinell hardness - HB value is measured on the separately cast test ingots; hardness symbol: HBW 5/750 acc. PN-EN-ISO 6506-1: 2014</p>
2	Dimensional tolerances	Tolerances in accordance with approved by the Client drawing of casting. Dimensions not tolerated in accordance with ISO 8062 - class which is applicable must be determined in the drawing of casting or other related documents.
3	Surface roughness	3S1 PN EN 1370:2012
4	Machining allowance	Identification of the treatment surface and the machining allowance in accordance with the Client drawing of casting.
5	Transpositions	Permitted is switching on the mold split to 2,0 [mm], and on the core to 1 [mm] – if undefined by customer (for example a drawing or another arrangements).
6	Undimensioned casting draft	Max 5 °
7	Undimensioned casting radius	Max. R5 [mm]
8	External defects	On the surfaces identified as being under machining are allowed any concave casting defects, for the



		acceptance criterion taking depth. Permissible are defects to the depth of final machining and convex defects to a height of 1.5 [mm].
9	Internal defects	According to the wording of the standard PN EN 1559-1, all internal defects and methods of control has to be agreed before taking order into realization. Otherwise classification follows in accordance with the standard DIN 1690, Part 2.
10	Grinding	The residue after bringing the metal grind to "0", without prejudice to the casting shape.  On the split of the mold is allowed the trap up to 1 [mm].  At the interface between the mold and core is allow the trap to a height of 1.5 [mm].
11	Defects in the area mapped by the core	The holes identified as machined allow "fishing line" or other casting defects to a height of 2.5 [mm].  The unidentified as machined holes allow the above mentioned defects up to 1 [mm].

Kierownik Kontroli Jakości



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