

- Anodizing contact marks allowed in this area
- Contatti di anodizzazione ammessi in questa zona

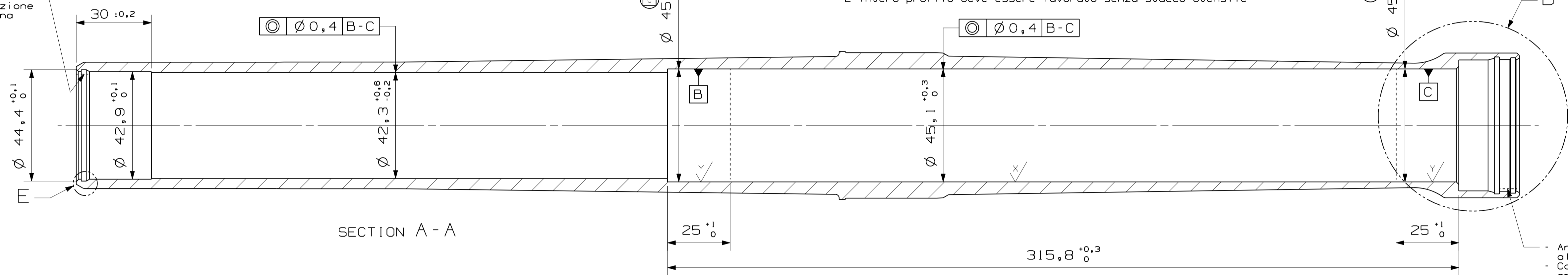


After superficial treatment
Dopo trattamento superficiale

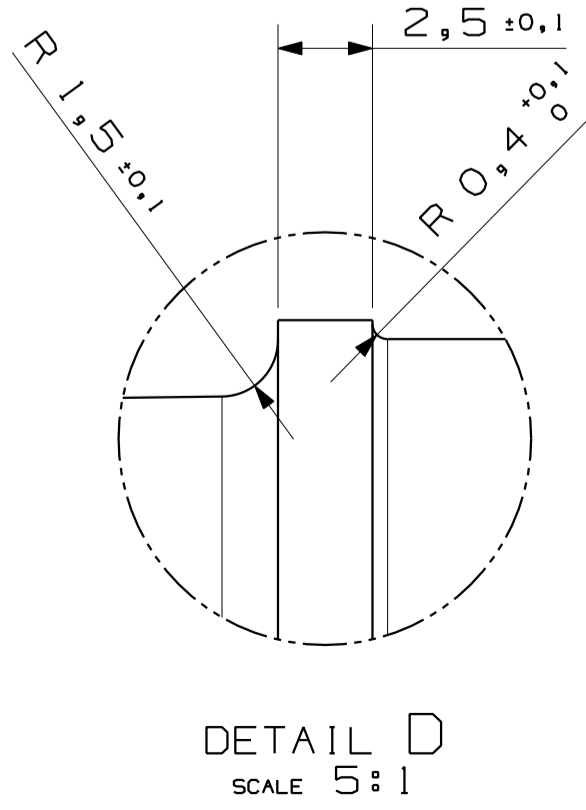
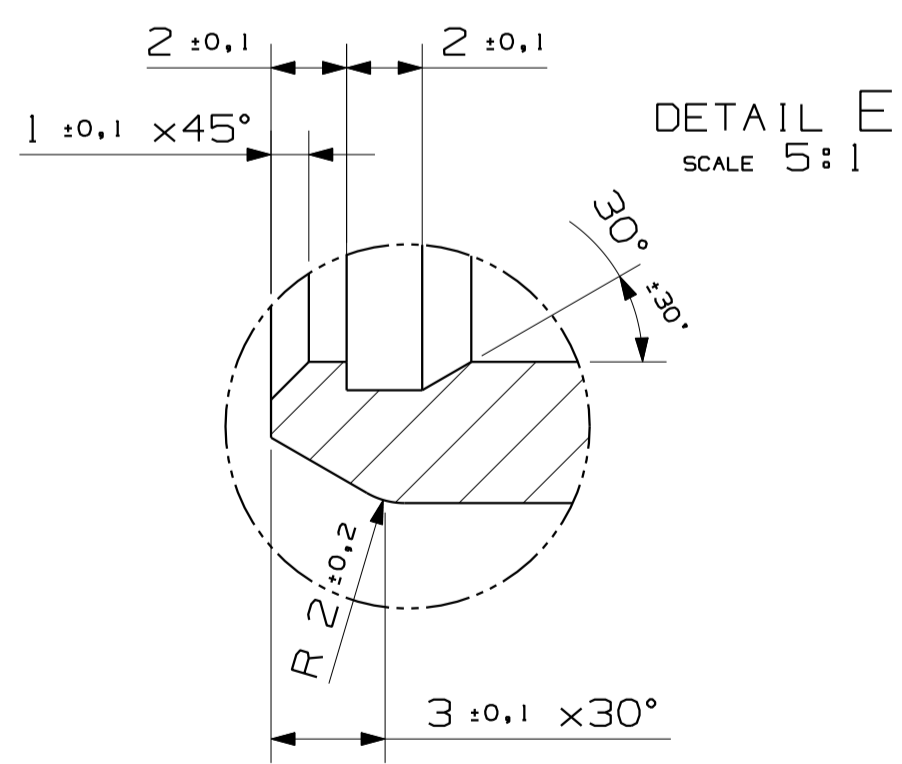
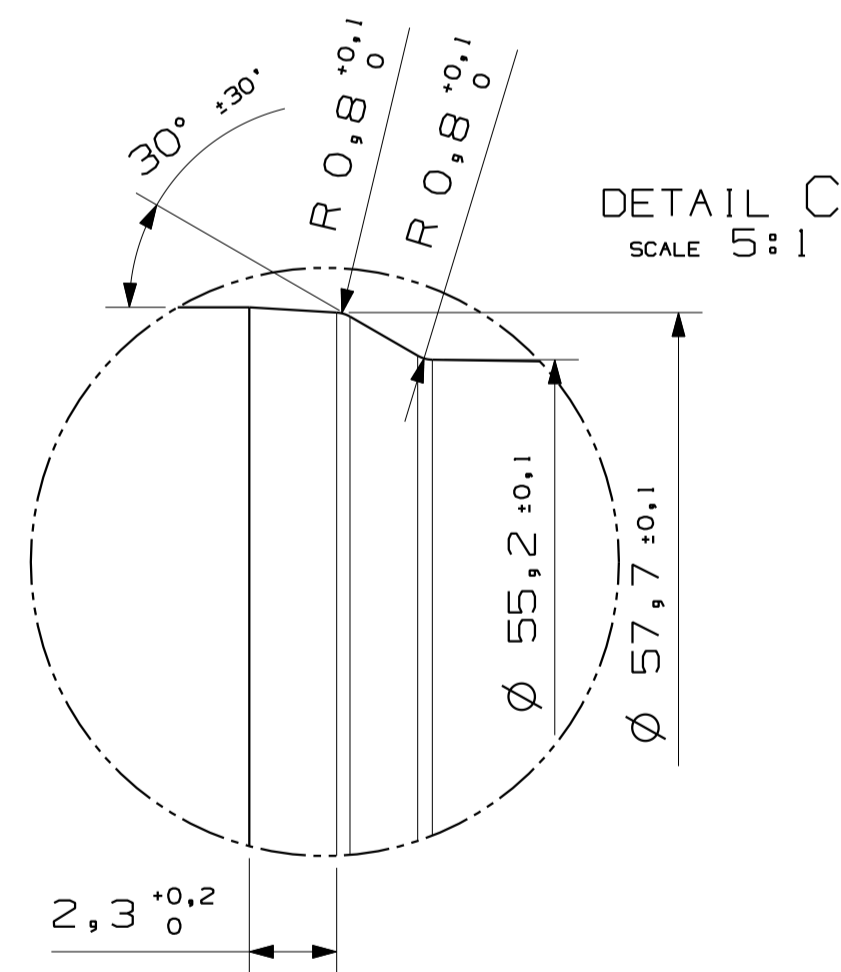
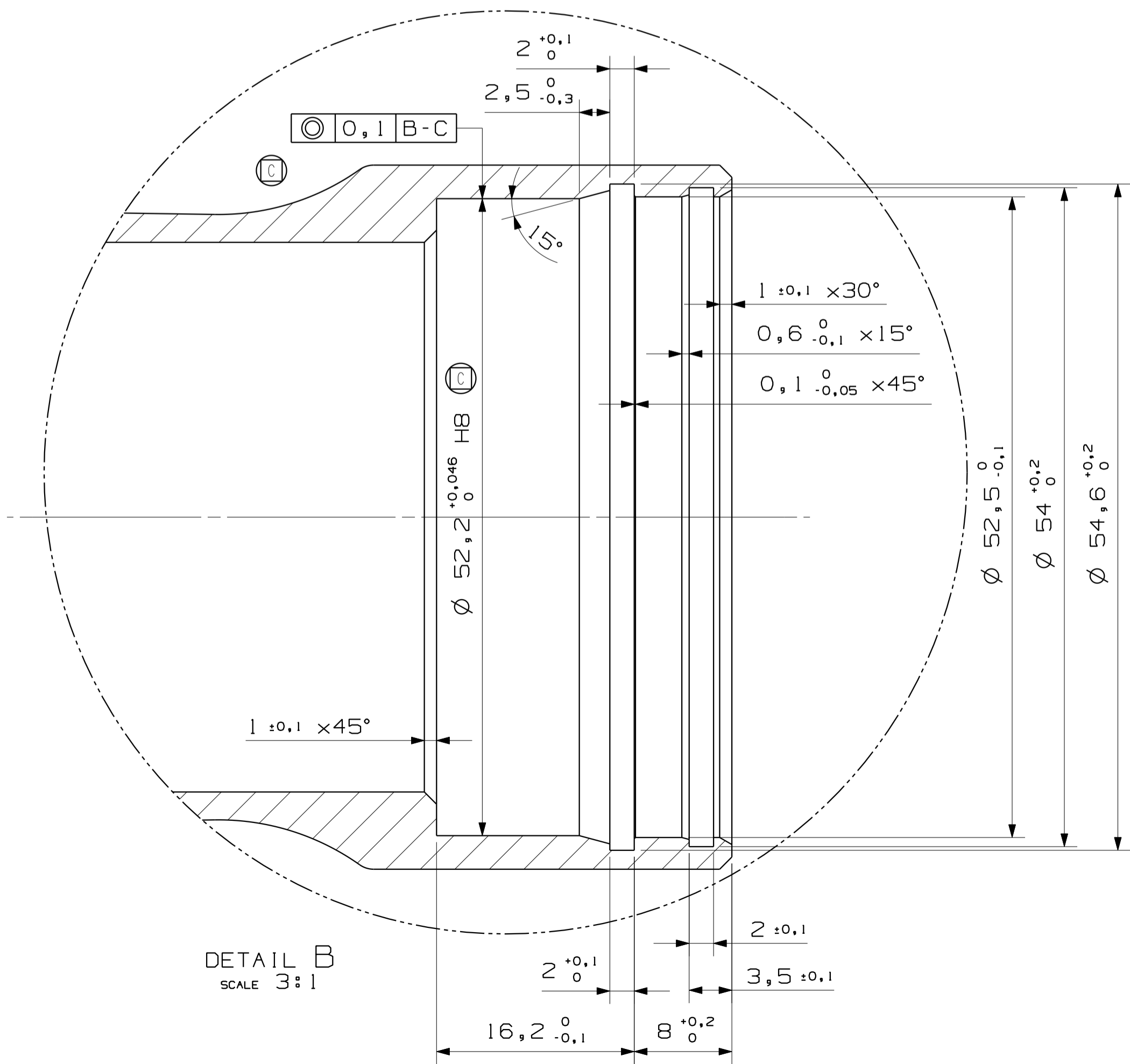
TURNING OF EXTERNAL PROFILE:
- Tool radius 0,8mm
- Advancement 0,3mm/Turn
- This areas must have Rz between 12 and 16 microns
- The whole profile must be machined without any discontinuance

TORNITURA DEL PROFILO ESTERNO:
- Raggio utensile 0,8mm
- Avanzamento 0,3mm/Giro
- in queste zone Rz deve essere compreso tra 12 e 16 microns
- L'intero profilo deve essere lavorato senza stacco utensile

After superficial treatment
Dopo trattamento superficiale



- Anodizing contact marks allowed in this area
- Contatti di anodizzazione ammessi in questa zona

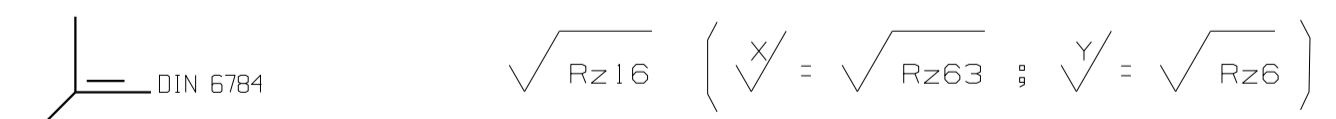


NOTE A
MATERIAL - Al 6xxx series
- Tensile Strength: Rm min 310 N/mm²
- Yield Strength: Rp_{0.2} min 260 N/mm²
- Elongation: min 8%
- Hardness: HB 90-135

NOTE B
SUPERFICIAL TREATMENT - Anodizing according to GS90010
- Color: NATURAL (according to master sample)
- Quality specifications according to "surface C" of BMW norm GS97010

NOTE A
MATERIALE - Alluminio serie 6xxx
- Carico di rottura: Rm min 310 N/mm²
- Carico di snervamento: Rp_{0.2} min 260 N/mm²
- Allungamento: min 8%
- Durezza: HB 90-135

NOTE B
TRATTAMENTO SUPERFICIALE - Anodizzazione secondo norma GS90010
- Colore: naturale "FN" (come da master)
- Le specifiche qualitative devono rispettare le specifiche "superficie C" della norma BMW GS97010



- No burrs are allowed
Non sono ammesse bave

- If not differently specified dimensions and tolerances are referred to machining before superficial treatment
Se non diversamente specificato dimensioni e tolleranze sono riferite alle lavorazioni prima del trattamento superficiale

- Anodizing contact marks are allowed only where specified
Contatti di anodizzazione ammessi solo nelle zone indicate

N. Change	Index	Change description	Date	Signature	Approval
References to customer's special rules: THIS IS A CAD DRAWING - NO MANUAL ALTERATION					
Material: See NOTE A		Raw code:			
Thermal treatment:		Part weight: 0,950 Kg			
Superficial treatment: See NOTE B		Original characteristic			
References for superficial treatment: See NOTE B					
Drawn	Date	Scale	Size	Signature	Approval
29/08/11	1:1	A2	L.F.		
Denomination: Outer tube BMW K25			Drawing n.: X5182303		Index: 00

