

GENERAL GUIDELINES FOR PARTS PRODUCED ACCORDING TO DRAWINGS



Spritzgiessautomaten

1. When receiving CAD exchange-files (for example stp-files) the latest pdf-file is the governing version. It must be checked if the drawing index is up-to-date.
2. All work piece edges and bores must be cleanly deburred. Edges which must remain sharp for functional reasons are identified accordingly in the drawing.
3. Bores and holes must be free of chips and other impurities (castings without sand residues). There must not be any shrink holes in the honed cylinder bores in cast parts. Groove widths and depths must be produced true to register, without chatter marks and in accordance with the surface roughness specified in the drawing.
4. Tolerance fields 6H for nut threads and 6g for bolt threads apply for all intolerance threads in the drawing. Threaded bores are generally sunk to the nominal diameter at 90°. Threaded connections must be mirrored in accordance with the thread size and drawing (sealing surface). The specified thread depth constitutes a minimum depth and must be met without fail.
5. Machining data, fits and surface finishes refer to the final condition, even in the case of heat treated or electroplated work pieces.
6. Only the materials specified in the drawing or order may be used. Alternative materials may only be used with the written approval of the Quality Management of Dr. Boy GmbH & Co KG.
7. If not specified in the drawing, hardened parts must be tempered in accordance with the treatment specifications of the material used.
8. Any cantering bores required for production reasons may remain in the finished part. Faces in which a cantering bore is not permitted for functional reasons are identified accordingly in the drawing. If not specified, centering bores must be produced in accordance with DIN 332 form A. The remaining centering bores must be no larger than required for machining.
9. The parts must be identified with the supplier's mark as specified in the drawing. Castings must bear the manufacturer's mark and casting date and if required a sequential number.
10. Control blocks must be washed after machining and all bores examined to ensure they are clean. Stoppers must be sealed oil-tight in accordance with the installation instructions of the expander manufacturer. The blocks must be corrosion-proofed after the final inspection.
11. Quality inspections must be carried out during the production process. A documented outgoing inspection must be carried out and proofed on request.
12. The final painting of the parts must be done with powder coating. An additional priming will not be necessary. Both shade of colour and colour structure are subject to approval and release of a colour reference specimen by Dr. Boy GmbH & Co KG.

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12.1 Parts to be primed may be coated with colour code:

Colour code = M	9717160	(52087610)	Textured paint powder, tele grey RDS 000 7500
Colour code = N	9717161	(52087710)	Textured paint powder, anthracite grey RAL 7016
Colour code = B	9717162	(52035810)	Textured paint powder, blue RDS 210 4035
Colour code = G	9717163	(52035610)	Textured paint powder, yellow RDS 095 8070
Colour code = A (Alternative colour code = M)		(52070410)	Textured powder coating RAL 7001 silver grey

Others primers may only be used with the written approval of the Quality Management of Dr. Boy GmbH & Co KG.

12.2 The powder coating has to be provided by company:

KANSAI HELIOS Germany GmbH

Industriepark Nord 74, D-53567 Buchholz

T.: +49 (0) 2683 509 08 0

<https://www.kansai-helios.de>

12.3 Grinding marks caused by the removal of welding residue are not permitted.

12.4 Prior to powder coating or priming, all substances adhering to the metal surfaces, which originate from the manufacturing process and subsequent machining and conservation processes, should be removed. This can be achieved using organic solvents, aqueous alkaline detergents or acid/alkali pickling agents. It may be necessary to carry out mechanical pretreatment by abrasive blasting or grinding. In case of doubt, the effectiveness of this pretreatment should be checked by means of the water break test.

This test is described as follows:

Trough wetting the metal surface a water drop should spread quickly to give a thin film, without forming any islands.

The coated and primed parts must not be stacked or laid on cardboard until the primer has cured completely a hardened through.

13. Uncoated and bare metal parts must be cleaned, corrosion- proofed and protected before delivery.

14. Castings must be stored in a dry place protected from moisture (rust-free)

15. Suitable aids and packagings must be used to prevent damage to the parts during transport.

16. We should like to point out that verbal collateral agreements will not be binding upon Dr. Boy GmbH & Co KG, and that faulty parts possibly resulting from such verbal collateral agreements may be rejected.

Note:

All parts in contact with hydraulic fluids must be delivered without dirt particles (i.e. clean).

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