

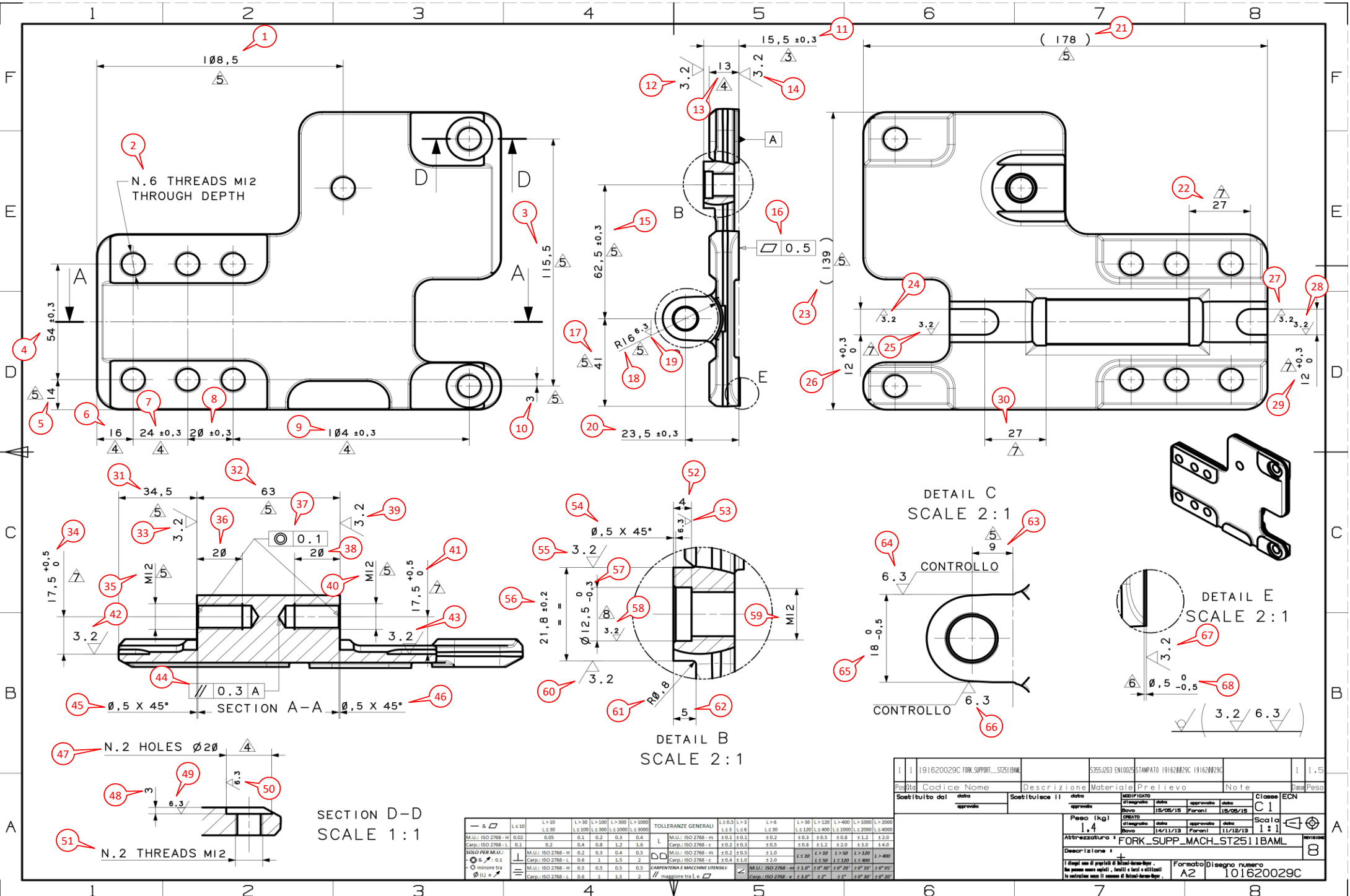
QUALITY CERTIFICATE according to EN10204 3.1

CERTIFICATE NO. : 100170 21004

Part Number:	101620029C	Revisions:	08	Part Name:	FORK_SUPP_MACH_ST2511BAML
Customer Code:	100170			PO No.:	1043007026
Supplier Name:	NINGBO SANJING IMPORT & EXPORT CO.,LTD			Shipment Qty.:	20 pcs

#	Submission items	Sample	
		Size	Freq.
1	Latest revision Drawing	n/a	every batch
2	Dimensional Inspection Report	5 pcs	every batch
3	Chemical Composition Analysis	n/a	every batch
4	Mechanical Properties-tensile strength	n/a	every batch
5	Mechanical Properties-yield strength	n/a	every batch
6	Mechanical Properties-elongation	n/a	every batch
7	Mechanical Properties-impact	n/a	every batch

Releaser & Date:  2021/12/13



N.6 THREADS M12 THROUGH DEPTH

DETAIL C SCALE 2:1

DETAIL E SCALE 2:1

DETAIL B SCALE 2:1

SECTION D-D SCALE 1:1

TOLLERANZE GENERALI				TOLLERANZE GENERALI			
L <= 10	L > 10	L >= 100	L > 1000	L <= 10	L > 10	L >= 100	L > 1000
±0.05	±0.10	±0.15	±0.30	±0.05	±0.10	±0.15	±0.30
±0.02	±0.05	±0.07	±0.15	±0.02	±0.05	±0.07	±0.15
±0.1	±0.2	±0.3	±0.6	±0.1	±0.2	±0.3	±0.6
±0.05	±0.1	±0.15	±0.3	±0.05	±0.1	±0.15	±0.3
±0.02	±0.05	±0.07	±0.15	±0.02	±0.05	±0.07	±0.15
±0.01	±0.02	±0.03	±0.06	±0.01	±0.02	±0.03	±0.06
±0.005	±0.01	±0.015	±0.03	±0.005	±0.01	±0.015	±0.03
±0.002	±0.005	±0.007	±0.015	±0.002	±0.005	±0.007	±0.015
±0.001	±0.002	±0.003	±0.006	±0.001	±0.002	±0.003	±0.006
±0.0005	±0.001	±0.0015	±0.003	±0.0005	±0.001	±0.0015	±0.003

Pos	Qta	Codice	Nome	Descrizione	Materiale	Prelievo	Note	Classe	Peso
1	1	191620029C	FORK SUPPORTI...ST251BAML	S355J2P3 EN10025 STAMPATO 191620029C 191620029C				I	1,5
Sostituito dal		data	Sostituito da II		data	MODIFICATO		Classe	ECN
approvato			approvato			data		C1	
Bozza		15/05/18	Paronci			15/05/18		Scala	1:1
CREATO		data	approvato		data	15/05/18		revisione	8
disegnato		14/11/18	Paronci			11/12/18			
Bozza									
Abbreviatura		FORK_SUPP_MACH_ST251BAML							
Descrizione									
Esempi uso di proprietà di IRI/Imme-SpA. In nessun caso agli utenti e terzi è consentito la ristampa senza il consenso di IRI/Imme-SpA.		Formato		Disegno numero					
		A2		101620029C					

Dimensional Inspection Report

Customer Code	Part Number	Part Name	Revisions	Shipment Qty	Inspected By
100170	101620029C	FORK_SUPP_MACH	08	20 pcs	YAN JIANJUN
Supplier Name			QA Manager		Date
NINGBO SANJING IMPORT & EXPORT CO.,LTD			ZHOUCHAO		2021.12.13
The Tolerance Standards					
TOLERANCES UNLESS OTHERWISE SPECIFIAL: ±0.7%					

- Standard Production Inspection
 First Part
 IQPC
 Last Part
 FQC
 Sample
 New Tooling/Fixture
 Design Change
 Maintain /Periodic Inspection

Dim. No.	Dimension Type	Nominal	Tol. +	Tol. -	USL	LSL	Sample 1	Sample 2	Sample 3	Sample 4	Sample 5	Measuring Device	Comments	OK	NOT OK
1	Linear	108.500	0.500	0.500	109.000	108.000	108.662	108.715	108.521	108.651	108.548	CMM		X	
2	Thread	M12x1.75-6H					OK	OK	OK	OK	OK	Thread Gauge		X	
3	Linear	115.500	0.300	0.300	115.800	115.200	115.551	115.527	115.580	115.533	115.542	CMM		X	
4	Linear	54.000	0.300	0.300	54.300	53.700	54.003	53.998	54.007	54.028	53.979	CMM		X	
5	Linear	14.000	0.500	0.500	14.500	13.500	14.256	14.352	14.317	14.348	14.266	CMM		X	
6	Linear	16.000	0.500	0.600	16.500	15.400	15.925	15.744	15.951	15.834	15.837	CMM		X	
7	Linear	24.000	0.300	0.300	24.300	23.700	24.073	24.013	23.955	24.075	24.095	CMM		X	
8	Linear	20.000	0.300	0.300	20.300	19.700	19.990	20.054	19.992	20.021	19.945	CMM		X	
9	Linear	104.000	0.300	0.300	104.300	103.700	104.002	103.987	103.940	103.992	104.006	CMM		X	
10	Linear	3.000	0.100	0.100	3.100	2.900	3.001	2.906	3.080	2.911	2.935	CMM		X	
11	Linear	15.500	0.300	0.300	15.800	15.200	15.239	15.367	15.570	15.290	15.429	CMM		X	
12	Roughness	3.200	0.000	3.200	3.200	0.000	1.510	1.294	1.472	1.493	1.552	Roughmeter		X	
13	Linear	13.000	0.500	0.500	13.500	12.500	13.24	13.10	13.12	13.06	13.14	Caliper		X	
14	Roughness	3.200	0.000	3.200	3.200	0.000	1.611	1.379	1.402	1.286	1.354	Roughmeter		X	
15	Linear	62.500	0.300	0.300	62.800	62.200	62.441	62.398	62.435	62.426	62.490	CMM		X	
16	Planeness	0.500	0.000	0.500	0.500	0.000	0.249	0.214	0.198	0.216	0.204	CMM		X	
17	Linear	41.000	0.500	0.500	41.500	40.500	41.252	41.350	41.258	41.300	41.336	CMM		X	
18	R	16.000	0.200	0.200	16.200	15.800	16.126	16.187	16.099	16.125	16.094	CMM		X	
19	Roughness	6.300	0.000	6.300	6.300	0.000	1.237	1.209	1.411	1.370	1.218	Roughmeter		X	
20	Linear	23.500	0.300	0.300	23.800	23.200	23.445	23.484	23.365	23.413	23.482	CMM		X	
21	Linear	178.000	0.500	0.500	178.500	177.500	178.18	178.20	178.30	178.10	178.20	Caliper		X	
22	Linear	27.000	0.200	0.200	27.200	26.800	27.095	26.864	27.121	26.901	26.892	CMM		X	
23	Linear	139.000	0.500	0.500	139.500	138.500	139.40	139.20	139.10	139.30	139.20	Caliper		X	
24	Roughness	3.200	0.000	3.200	3.200	0.000	1.366	1.521	1.356	1.197	1.484	Roughmeter		X	
25	Roughness	3.200	0.000	3.200	3.200	0.000	1.273	1.408	1.355	1.218	1.450	Roughmeter		X	
26	Linear	12.000	0.300	0.000	12.300	12.000	12.30	12.29	12.28	12.30	12.30	Caliper		X	
27	Roughness	3.200	0.000	3.200	3.200	0.000	1.263	1.414	1.572	1.305	1.511	Roughmeter		X	
28	Roughness	3.200	0.000	3.200	3.200	0.000	1.311	1.405	1.387	1.294	1.364	Roughmeter		X	
29	Linear	12.000	0.300	0.000	12.300	12.000	12.28	12.26	12.26	12.26	12.20	Caliper		X	
30	Linear	27.000	0.200	0.200	27.200	26.800	26.981	26.979	26.886	27.110	26.820	CMM		X	
31	Linear	34.500	0.500	0.500	35.000	34.000	34.466	34.544	34.481	34.662	34.535	CMM		X	
32	Linear	63.000	0.300	0.300	63.300	62.700	63.039	63.071	63.074	63.041	63.051	CMM		X	
33	Roughness	3.200	0.000	3.200	3.200	0.000	1.504	1.426	1.387	1.297	1.306	Roughmeter		X	
34	Linear	17.500	0.500	0.000	18.000	17.500	17.741	17.692	17.624	17.600	17.776	CMM		X	
35	Thread	M12x1.75-6H					OK	OK	OK	OK	OK	Thread Gauge		X	
36	Linear	20.000	3.500	0.000	23.500	20.000	21.92	21.80	21.90	22.00	21.90	Caliper		X	
37	Concentric	0.100	0.000	0.100	0.100	0.000	0.097	0.095	0.094	0.096	0.098	CMM		X	
38	Linear	20.000	3.500	0.000	23.500	20.000	21.80	21.94	21.80	21.77	21.96	Caliper		X	
39	Roughness	3.200	0.000	3.200	3.200	0.000	1.281	1.315	1.152	1.029	1.410	Roughmeter		X	
40	Thread	M12x1.75-6H					OK	OK	OK	OK	OK	Thread Gauge		X	
41	Linear	17.500	0.500	0.000	18.000	17.500	17.714	17.673	17.810	17.765	17.596	CMM		X	
42	Roughness	3.200	0.000	3.200	3.200	0.000	1.571	1.483	1.277	1.416	1.392	Roughmeter		X	
43	Roughness	3.200	0.000	3.200	3.200	0.000	1.433	1.391	1.216	1.309	1.277	Roughmeter		X	
44	Parallel	0.300	0.000	0.300	0.300	0.000	0.054	0.037	0.061	0.016	0.002	CMM		X	
45	Chamfer	0.500	0.200	0.200	0.700	0.300	0.52	0.48	0.54	0.60	0.58	Chamfer Gauge		X	
46	Chamfer	0.500	0.200	0.200	0.700	0.300	0.60	0.58	0.55	0.62	0.56	Chamfer Gauge		X	
47	Chamfer	0.500	0.200	0.200	0.700	0.300	0.60	0.58	0.55	0.62	0.56	Chamfer Gauge		X	
48	Diameter	20.000	0.200	0.200	20.200	19.800	19.96	19.97	19.96	19.98	20.00	Caliper		X	
49	Linear	3.000	0.100	0.100	3.100	2.900	3.04	3.00	3.04	3.02	3.00	Caliper		X	
50	Roughness	3.200	0.000	3.200	3.200	0.000	1.507	1.440	1.329	1.433	1.500	Roughmeter		X	
51	Roughness	3.200	0.000	3.200	3.200	0.000	1.984	2.014	2.112	1.951	1.893	Roughmeter		X	

Material Inspection Report

Customer Code: 100170
Part Number: 101620029C
Part Name: FORK_SUPP_MACH_ST2511BAML
Inspected By: JIAZHAOYU
Material Name: S355J2G3

1. Chemical Composition Analysis

Test Method: GB/T 4336 Standard test method for spark discharge atomic emission spectrometric analysis of carbon and low-Alloy steel (routine method)

Casting Date	Shift No.	Element	C[%]	Si[%]	Mn[%]	P[%]	S[%]
		Standards	0.23max	0.60max	1.70max	0.045 max	0.045 max
2021/11/24	C20	Result	0.186	0.358	1.469	0.021	0.006
Judge			OK	OK	OK	OK	OK

Note: The results comply with the requirement of material standard

2. Tensile Test

Test Method: GB/T 228(ISO 6892) Metallic materials-Tensile testing at ambient temperature

Casting Date	Shift No.	Test Item	Tensile Strength [Mpa]	Yield Strength [Mpa]	Elongation [%]
		Standards	490-630	355min.	20min.
2021/11/24	C20	Result	568	392	24.2
Judge			OK	OK	OK

Note: The results comply with the requirement of material standard

3. Impact Test

Test Method: GB/T 229(ISO 148-1) Metallic materials-Charpy pendulum impact test method

Casting Date	Shift No.	Test Item	Impact (-20°C)		
		Standards	27 J MIN. (KV)		
2021/11/24	C20	Result	47	48	45
Judge			OK	OK	OK

Note: The results comply with the requirement of material standard