



SLOVENSKI STANDARD

SIST EN 604-2:1998

01-april-1998

Aluminij in aluminijeve zlitine - Predulitki za kovanje - 2. del: Tolerance mer in oblike

Aluminium and aluminium alloys - Cast forging stock - Part 2: Tolerances on dimensions and form

Aluminium und Aluminiumlegierungen - Gegossenes Schmiedevormaterial - Teil 2: Grenzabmaße und Formtoleranzen

Aluminium et alliages d'aluminium - Produits coulés et destinés a la forge - Partie 2: Tolérances sur dimensions et forme

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Ta slovenski standard je istoveten z: EN 604-2:1997

ICS:

77.150.10

Aluminijski izdelki

Aluminium products

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en

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EUROPEAN STANDARD

EN 604-2

NORME EUROPÉENNE

EUROPÄISCHE NORM

January 1997

ICS 77.120.10; 77.140.90

Descriptors: aluminium products, aluminium alloys, forgings, dimensional tolerances, form tolerances

English version

**Aluminium and aluminium alloys - Cast forging
stock - Part 2: Tolerances on dimensions and form**

Aluminium et alliages d'aluminium - Produits
coulés et destinés à la forge - Partie 2:
Tolérances sur dimensions et forme

Aluminium und Aluminiumlegierungen - Gegossenes
Schmiedevormaterial - Teil 2: Grenzabmaße und
Formtoleranzen

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This European Standard was approved by CEN on 1996-12-19. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

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Foreword

This European Standard has been prepared by Technical Committee CEN/TC 132 "Aluminium and aluminium alloys", the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by July 1997, and conflicting national standards shall be withdrawn at the latest by July 1997.

This standard is part of a set of two standards. The other standard deals with :

EN 604-1 Aluminium and aluminium alloys - Cast forging stock - Part 1 : Technical conditions for inspection and delivery

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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1 Scope

This part of this standard specifies the tolerances on dimensions and form of cast aluminium and aluminium alloy forging stock for general engineering applications.

The chemical compositions for these alloys are specified in EN 573-3. The technical conditions for inspection and delivery of these products are specified in EN 604-1.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 573-3 Aluminium and aluminium alloys - Chemical composition and form of wrought products - Part 3 : Chemical composition

EN 604-1 Aluminium and aluminium alloys - Cast forging stock - Part 1 : Technical conditions for inspection and delivery

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3 Tolerances on dimensions and form

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3.1 **General** <https://standards.iteh.ai/catalog/standards/sist/174b218e-18fa-4f31-9d8e-954ca8ce6e0f/sist-en-604-2-1998>

The tolerances specified below shall apply to round ingots, as cast or scalped on diameter and sawn to length and to rectangular ingots, scalped on faces and sawn to length and width.

3.2 Tolerances on dimensions

3.2.1 Round ingots (as cast or scalped)

3.2.1.1 Diameter

The measurements shall be taken at the two sawn ends on two diameters 90° apart. The limit deviations on the nominal diameter shall be :

a) as cast :

- $-\frac{0}{2}$ mm for ingot diameter not greater than 200 mm ;
- $-\frac{0}{3}$ mm for ingot diameters greater than 200 mm and not greater than 400 mm ;
- $-\frac{0}{4}$ mm for ingot diameter greater than 400 mm ;

b) scalped :

- $-\frac{0}{2}$ mm for all ingot diameters.

3.2.1.2 Length

The measurement shall be taken overall. The limit deviations on the nominal length shall be :

- ± 3 mm for ingot lengths not greater than 1200 mm ;
- ± 15 mm for ingot lengths greater than 1200 mm.

3.2.2 Rectangular ingots (scalped)

3.2.2.1 Width

The measurement shall be taken overall. The limit deviations on the nominal width shall be :

- $+\frac{10}{0}$ mm for all ingot widths.

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3.2.2.2 Thickness

The measurement shall be taken at the two sawn ends on both sides of the ingot. The limit deviations on the nominal thickness shall be :

- ± 5 mm for all ingot thicknesses.

3.2.2.3 Length

The measurement shall be taken overall. The limit deviations on nominal length shall be :

- ± 25 mm for all ingot lengths.

3.3 Tolerances on form

3.3.1 Round ingots (as cast or scalped)

3.3.1.1 Perpendicularity

Sawn ends of ingots shall be perpendicular to the longitudinal axis to $(90 \pm 1)^\circ$.

3.3.1.2 Straightness (as cast ingot only)

The deflection measured on any generating line of the ingot shall be less than 3 mm per metre. The total deviation over the full length of the ingot shall not exceed 15 mm.

3.3.2 Rectangular ingots (scalped)

3.3.2.1 Perpendicularity

Sawn faces of ingots shall be perpendicular to the longitudinal or transverse axis, as applicable, to $(90 \pm 1)^\circ$.

3.3.2.2 Flatness

The deflection measured in any direction on any face of the ingot shall be less than 2 mm per metre.

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