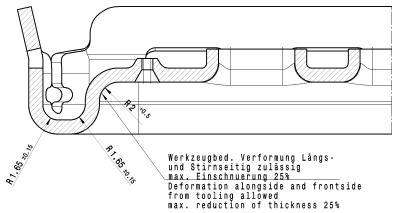
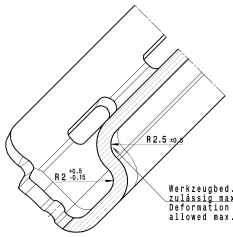
A-A 5:1



Werkzeugbed. Verformung Längs- und Stirnseitig zulässig max. Einschnuerung 25%
Deformation alongside and frontside from tooling allowed max. reduction of thickness 25%

B-B 5:1

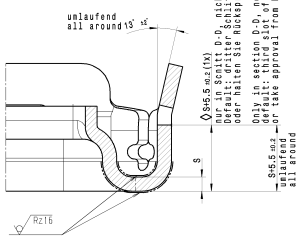


Werkzeugbed. Verformung im Eckbereich zulässig max. Einschnuerung 30%
Deformation at the corner from tooling allowed max. reduction of thickness 30%

Anzahl Wellschlitze Number of slots	
ungerade uneven	gerade even
b= 0 c= 0	b= -Y/2 c= -Z/2
Anzahl Durchzuege Number of ferrules	
ungerade uneven	gerade even
a= 0	a= -SQ/2
Beispiel s.Blatt2 Example see page 2	

D-D 5:1

(90° gedreht
90° Rotated)



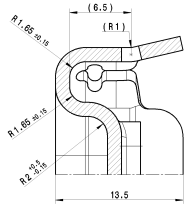
umlaufend
frei von Flux, Verunreinigung und Werkzeugmarkierungen

all around
free of flux, contamination and tool marks

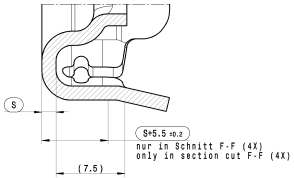
C-C 5:1

Biegekante umlaufend,
Biegung um neutrale Faser

Bending edge all around,
Bend around neutral fibre



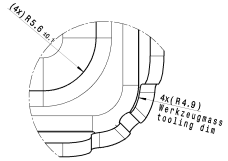
F-F 5:1



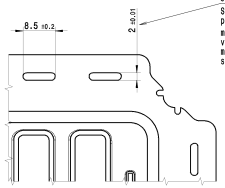
nur in Schnitt F-F (4X)
only in section cut F-F (4X)

(bei 0° Ausstellwinkel
at flare angle of 0 degrees)

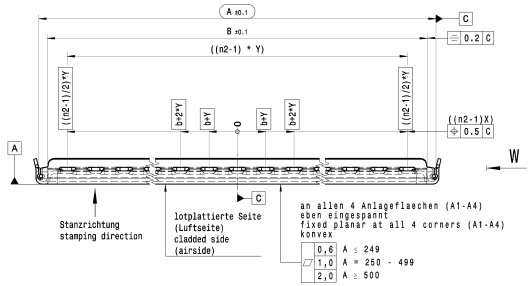
X 5:1

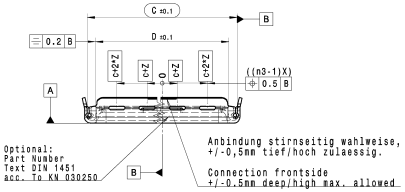


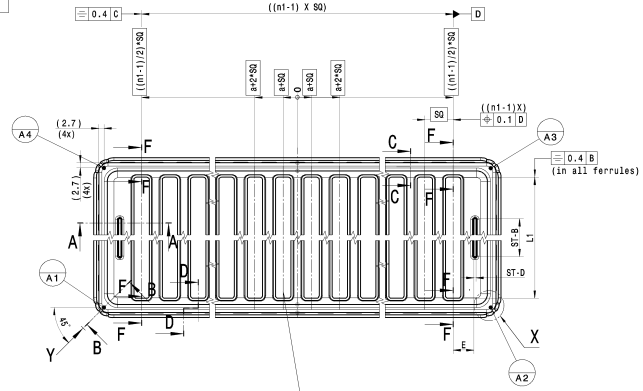
exempl.Darstellung der Platine
exempl. design of the plate



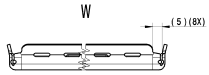
Ladeluftseite
Charge Air Side



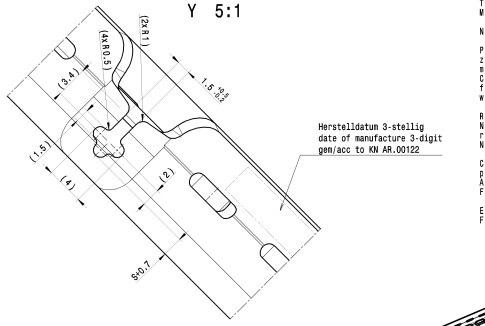




Durchzuege nach KN AR.01384 Pos., siehe Tabelle
Ferrule dimensions acc. to KN AR.01384 Pos.,see table



Y 5:1



Herstelldatum 3-stellig
date of manufacture 3-digit
gem/acc to KN AR.00122

Bemerkungen / Remarks:

Teile gemaess / parts according : PmL.00227
Messung nach / measurement acc.to : PN V AR.01379

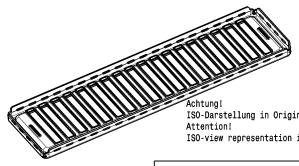
Nicht bem. Radien / not specified Radii : R0.5 - R1

Prüfung gem. BEHR Standard Kontrollplan als Minimalanforderung zur Qualitaetskontrolle. Weitere Festlegungen in Abstimmung mit BEHR Qualität
Checks acc. to BEHR standard control plan as minimum requirement for quality control. Additional requirements to be aligned with BEHR-Quality

Restoelmenge nach GN AR 01024 5.2 fuer NOCOLOC-Lötung/ Thermoentfettung zulässig
rest oil acc. to GN AR 01024 5.2 for NOCOLOC-brazing/ thermo-degreasing allowed

Changes to part design, materials or processing require prior approval from BEHR-engineering.
Aenderungen am Design,Material oder Prozess nur nach Freigabe durch Behr Entwicklung

Engineering department is responsible for dimensions
Fachabteilung ist verantwortlich für Masse



Achtung!
ISO-Darstellung in Originalgroesse
Attention!
ISO-view representation in original size

300,3	291,3	79,3	70,7	11,06	297*64	1,5	15	15	16	20	1,15	18	19	4	1260
A	B	C	D	E	Rohr Tube H*B	s	Teilung Pitch SQ	Y	Z	ST-B	ST-D	n1 Anzahl Rohre / Number of tubes	laengsseitig alongside(n2)	stirnseitig frontal(n3)	Pos.Nr.fuer Durchzugs-geom. nach / Pos.No.for ferrule dimensions acc.to KN AR.01384
													n2/n3 Anzahl Wellschlitze je Seite / n2/n3 No. of crimping slots per side		

Translation
No liability can be accepted for the correctness of the translation. It is in all instances the latest version of the document in its original language that is binding.
Original language: german

Qualitaetswichtiges Merkmal nach KN AR.00302
(1x) Significant Characteristic
Abnahmemass nach KN AR.00302
(4x) Acceptance dimension acc. to KN AR.00302

AR.00643/1997-11

Laengen-Toleranzen fuer Stanzteile (Umformteile)
Length Tolerances for Blanks (Formed Parts)
DIN 6930 - m

Nennmaßbereich Nominal Size Range	Dickenbereich Thickness Range bis / over / over / over			
		1 bis 3	3 bis 6	6 bis 10
von / over	0	± 0,2	± 0,3	± 0,4
über 6 bis	10	± 0,3	± 0,4	± 0,5
10 bis	25	± 0,4	± 0,5	± 0,6
25 bis	63	± 0,5	± 0,6	± 0,8
63 bis	160	± 0,6	± 0,8	± 1,0
160 bis	400	± 1,0	± 1,2	± 1,2
400 bis	1000	± 1,0	± 1,4	± 2,0

Toer Nennmass < 1: Abmass angeben
For Nominal Sizes < 1: Specify Allowance

1	Frei fuer Anfrage/Release for quotation				
Ind.	Field	Aenderung Text / Revision Text	Bearb. / Dept.	Kz. / Mk.	Datum / Date

Charakteristica according KN AR.00302 — Original at BHR — Variants — Behr-Spezifikation
Standard characteristics — No Symbol
Acceptance dimension
Significant characteristic
Critical characteristic
Revisting characteristic

Material: EN AW-3003 mod.-O GN AR.00126
Surface finish: Oxidiert/one side oxidized
GN AR.00126

Standard tolerances: DIN 6930-m

Date	Name	Part Name	Scale
Drawn by	[redacted]	Boden / Header	1:1
Checked by			Weight: kg
Approved by			Sheet 1 of 2
Drawing Number		21.29988	Format: A3
Replaces			CAD-System: Catia V5

Translation: Original language/German
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