

## Appendix 36\_INT

### Sheet Metal Parts and Stampings

General tolerances

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If there are no tolerances specified in drawings for the dimensions of sheet metal parts and stampings, the general tolerances in table 1 must be selected; these tolerances are determined by the process and the technology.

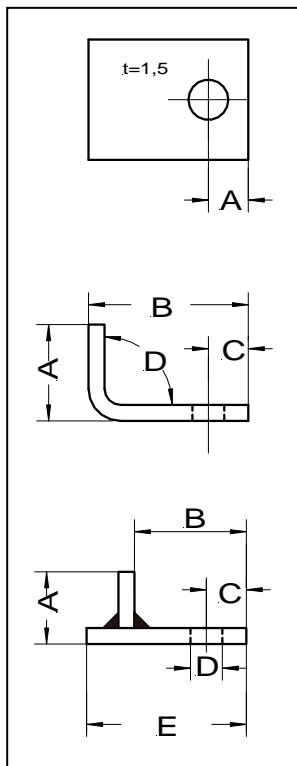
Table:

Process	General tolerance
Stamping / Forming	DIN 6930
Thermal cutting (e.g. flame cutting, laser cutting, plasma cutting)	DIN ISO 9013
Bending	SN 6935
Welding *	EN ISO 13920 (with restrictions)

**\* Note / Restriction:**

According to EN ISO 13920, the tolerances specified in this standard apply to welded constructions in general. The limit dimensions listed in tables 1 – 3 of this standard are only used by Heidelberg if the reference dimensions are generated or directly affected by welding.

**Additional explanations:**



All dimensional tolerances according to DIN 6930, part 1 "flat stampings".

All dimensional tolerances except the bending angle according to DIN 6930, part 3 „stampings manufactured through forming“. Tolerance of the bending angle "D" according to SN 6935.

Tolerances of dimensions A and B according to EN ISO 13920. Tolerances of dimensions C, D, E according to the respective manufacturing method.