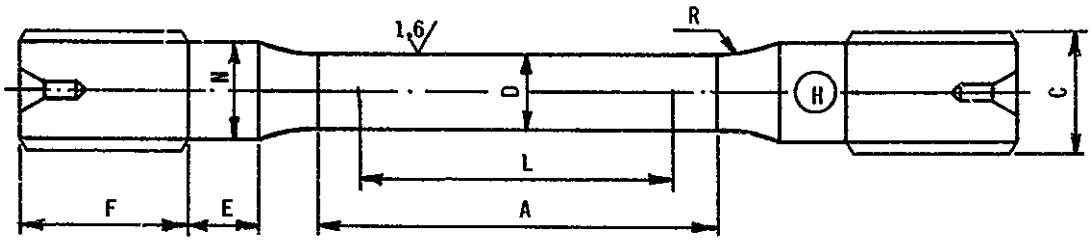
Nuovo Pignone INTERNAL STANDARDIZATION	CYLINDRIC TEST-TUBES FOR TENSILE TEST ACCORDING TO ASTM A 370 AND E 8	ITN 06014.01/A

Mechanical machining according to ITN 06023.



Dimensions in mm.

Reference		Type 1	Type 2	Type 3	Type 3 A*	Type 4	Type 5
D	nominal	12.5	8.75	6.25	5.5	4	2.5
	toll.	±0.25	±0.18	±0.12	±0.12	±0.08	±0.05
A		60	45	32	32	20	16
L	nominal	50	35	25	22	16	10
	toll.	±0.1					
C		3/8 GAS	M 14x1.5	M 10x1	M 10x1	M 8	M 5
E		8	8	7	7	7	7
F		20	15	12	12	10	10
R		10	6	5	5	4	2
N		14	12	9	9	7	4
Concentricity and parallelism		±0.06	±0.04	±0.03	±0.03	±0.02	±0.01
Total length (aprox.)		126	106	75	75	58	52

NOTES: The identification of the test-tube must be executed with indelible writting using the zone marked with the letter H on the drawing.

* Test-tube type 3A is to be applied limitedly in the case of bars melted in superalloy, for which it´s not possible, for dimensional reasons, obtain the type 3 test-tube.

Buttafuoco L.

Sheet	1																							
Rev.	5																							

Origin	Rev. ITN 5 Date 08/2010	Descript. Rev. CONFIRMED 1st Sheet	Prepared OFS	Checked Iozzelli F.	Approved Giannozzi M.	Standardization Committee	1st Issue 9/84	Sheet 1/1

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Electronically approved draw. GE NuovoPignone Internal DT-IN