

**Metallvalu. Tehnilised tarnetingimused.
Osa 4: Lisanõuded alumiiniumisulamist
valandite kohta**

Founding - Technical conditions of delivery - Part 4:
Additional requirements for aluminium alloy castings

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 1559-4:2000 sisaldab Euroopa standardi EN 1559-4:1999 ingliskeelset teksti. Käesolev dokument on jõustatud 11.01.2000 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes. Standard on kättesaadav Eesti standardiorganisatsioonist.	This Estonian standard EVS-EN 1559-4:2000 consists of the English text of the European standard EN 1559-4:1999. This document is endorsed on 11.01.2000 with the notification being published in the official publication of the Estonian national standardisation organisation. The standard is available from Estonian standardisation organisation.
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Käsitlusala: This part of EN 1559 specifies the technical conditions for delivery of aluminium alloy castings unless other technical delivery conditions have been agreed at the time of acceptance of the order.	Scope: This part of EN 1559 specifies the technical conditions for delivery of aluminium alloy castings unless other technical delivery conditions have been agreed at the time of acceptance of the order.
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ICS 77.150.10

Võtmesõnad:

English version

Founding – Technical conditions of delivery

Part 4: Additional requirements for aluminium alloy castings

Fonderie – Conditions techniques de
fourniture – Partie 4: Spécifications
complémentaires pour les pièces
moulées en alliages d'aluminium

Gießereiwesen – Technische Liefer-
bedingungen – Teil 4: Zusätzliche
Anforderungen an Gußstücke aus
Aluminiumlegierungen

This European Standard was approved by CEN on 1999-04-16.

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.

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CEN

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

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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 November 1999, and conflicting national standards shall be withdrawn at the latest by November 1999.

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

Within its programme of work, Technical Committee CEN/TC 132 requested CEN/TC 132/WG10 "Aluminium and aluminium alloys - Castings" to prepare the following standard :

prEN 1559-4, *Founding - Technical conditions of delivery - Part 4 : Additional requirements for aluminium alloy castings.*

This is one of several which specify European Standard technical delivery conditions for castings. The other standards in this series are :

EN 1559-1, *Founding - Technical conditions of delivery - Part 1 : General.*

prEN 1559-2, *Founding - Technical conditions of delivery - Part 2 : Additional requirements for steel castings.*

EN 1559-3, *Founding - Technical conditions of delivery - Part 3 : Additional requirements for iron castings.*

EN 1559-5, *Founding - Technical conditions of delivery - Part 5 : Additional requirements for magnesium alloy castings.*

EN 1559-6, *Founding - Technical conditions of delivery - Part 6 : Additional requirements for zinc alloy castings.*

Introduction

CEN/TC 132 "Aluminium and aluminium alloys" has prepared a material standard covering aluminium alloy castings. In order to assist manufacturers and purchasers to prepare proper contractual arrangements and prevent misunderstandings, CEN/TC 190 "Foundry Technology" approved the preparation of a series of standards covering technical delivery conditions for various metals.

The European Standard cannot be used alone for compiling a specification for ordering and supplying aluminium alloy castings, but as a complement to EN 1559-1.

This European Standard covers the additional technical delivery conditions for aluminium alloy castings.

The following symbols used in this standard for clauses and subclauses are identified as follows :

- ✦ completely replace those in EN 1559-1 ;
- are identical to those in EN 1559-1 ;
- ◆ are supplementary to those in EN 1559-1 ;
- are requirements to be agreed upon at the time of ordering ;
- are requirements which are optional and may be agreed between the manufacturer and the purchaser at the time of ordering.

Clauses and subclauses without a symbol are mandatory.

1 Scope

This part of EN 1559 specifies the additional technical conditions for delivery of aluminium alloy castings unless other technical delivery conditions have been agreed at the time of acceptance of the order.

This standard denotes clauses specific to aluminium alloy castings under existing or new headings and retains the same structure and numbering system as used in EN 1559-1. It repeats the numbering of clauses and subclauses even if nothing extra or different has been added.

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 1371-1, *Founding - Liquid penetrant inspection - Part 1 : Sand, gravity die and low pressure die castings.*

EN 1559-1, *Founding - Technical conditions of delivery - Part 1 : General.*

prEN 12681, *Founding - Radiographic inspection.*

ISO 10049, *Aluminium alloy castings - Visual method for assessing the porosity.*

NOTE Informative references to documents used in the preparation of this standard and cited at the appropriate places in the text, are listed in a bibliography, see annex B.

3 Terms and definitions

For the purposes of this European Standard, the following definition apply:

3.1

◆excavation cavity

cavity produced by the removal of material from a casting in the area of a defect prior to repair by production welding or other methods