

<b>DATOS DE LA PIEZA A CERTIFICAR:</b> PART DESCRIPTION	
Denominación: CAPÓ DELANTERO Name: Front bonnet	
Adaptable a: BMW SERIE 3 E-46 (98) Adaptable to	
Fabricado por: TALLERES ORAN Manufactured by	
Ref. fabricante: C1120030 Manufacturer reference	Ref. Constructor: 41618238461 O.E.M. reference
Nº Certificación: 06 012 06 05 Certification number	



Valorando lo resultados obtenidos en los ensayos y verificaciones a los que ha sido sometida la pieza de recambio, el dictamen final es:  
 Having analyzed the results of the test to which spare part has been subjected, the final decision is:

**RESULTADO DE LA PIEZA**  
Spare part result

**CERTIFICADA**  **NO CERTIFICADA**  
 Approved Fail

1. CONTROL DE MATERIAL MATERIAL CONTROL		
ENSAYO Test	RESULTADO Result	OBSERVACIONES OBSERVATION
Tipo de material Material	Acero Steel	Consultar informe Nº 0000689644 See report number 0000689644
Espesor de la pieza (mm) Part thickness	0,700	Consultar Anexo C01-01 (C1120030) See Appendix C01-01 (C1120030)
Espesor armazón (mm) Frame thickness	0,700	Consultar Anexo C01-01 (C1120030) See Appendix C01-01 (C1120030)
Espesor cierre (mm) Fastener thickness	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Masa de la pieza (Kg) Weight	18,000	Consultar Anexo C01-01 (C1120030) See Appendix C01-01 (C1120030)
Embutición (mm) Ball punch deformation test	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Prestaciones Mecánicas Impact resistance	NP	
Envejecimiento Acelerado Colour resistance	NP	
Resistencia al calor (%) Heat resistance	NP	
Resistencia combustible (%) Fuel resistance	NP	
CALIFICACIÓN DEL CONTROL DEL MATERIAL Test result		CONFORME APPROVED

<b>2. CONTROL DE LA PIEZA (ADAPTABILIDAD E INSPECCIÓN PREVIA)</b> PART CONTROL (ADAPTABILITY PREVIOUS INSPECTION)		
<b>ENSAYO</b> <small>Test</small>	<b>RESULTADO</b> <small>Result</small>	<b>OBSERVACIONES</b> <small>OBSERVATION</small>
<b>Inspección previa</b> <small>Previous inspection</small>	<b>Conforme</b> <small>Approved</small>	<b>Consultar informe 06012IP-AD01-HR01</b> <small>See report 06012IP-AD01-HR01</small>
<b>Tiempo de montaje (u.t)</b> <small>Assembly time</small>	<b>10,99</b>	<b>Consultar informe 06012TM01-HR01</b> <small>See report 06012TM01-HR01</small>
<b>Proceso de trabajo</b> <small>Assembly process</small>	<b>Similar a constructor</b> <small>Similar to O.E.M.</small>	<b>Consultar informe 06012IP-AD01-HR01</b> <small>See report 06012IP-AD01-HR01</small>
<b>Montaje de accesorios</b> <small>Adaptability of Accessories</small>	<b>Conforme</b> <small>Approved</small>	<b>Consultar informe 06012IP-AD01-HR01</b> <small>See report 06012IP-AD01-HR01</small>
<b>Holguras</b> <small>Gaps</small>	<b>Similar a constructor</b> <small>Similar to O.E.M.</small>	<b>Consultar informe 06012IP-AD01-HR01</b> <small>See report 06012IP-AD01-HR01</small>
<b>Paralelismos</b> <small>Parallelism</small>	<b>Similar a constructor</b> <small>Similar to O.E.M.</small>	<b>Consultar informe 06012IP-AD01-HR01</b> <small>See report 06012IP-AD01-HR01</small>
<b>Alineaciones</b> <small>Alignment</small>	<b>Similar a constructor</b> <small>Similar to O.E.M.</small>	<b>Consultar informe 06012IP-AD01-HR01</b> <small>See report 06012IP-AD01-HR01</small>
<b>Funcionalidad</b> <small>Functional features</small>	<b>Conforme</b> <small>Approved</small>	<b>Consultar informe 06012IP-AD01-HR01</b> <small>See report 06012IP-AD01-HR01</small>
<b>CALIFICACIÓN DEL CONTROL DE LA PIEZA</b> <small>Test result</small>		<b>CONFORME</b> <small>APPROVED</small>

3. CONTROL DE RECUBRIMENTOS COATING CONTROL		
ENSAYO Test	RESULTADO Result	OBSERVACIONES OBSERVATION
Espesor, $e_e$ ( $\mu\text{m}$ ) Thickness	15	Consultar Anexo C01-01 (C1120030) See Appendix C01-01 (C1120030)
Dureza Hardness	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Embutición (mm) Ball punch deformation test	5,6 a 7 5,6 to 7	Consultar Informe PPG N° WR09-5591 See Report PPG N° WR09-5591
Corrosión roja (n° horas) Corrosion resistance	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Adherencia Adhesion	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Resistencia al lavado alta presión High pressure resistance	NP	
Resistencia del recubrimiento a los disolventes Solvent resistance	NP	
CALIFICACIÓN DEL CONTROL DE RECUBRIMENTOS Test result		CONFORME APPROVED

4. CONTROLES ADICIONALES ADDITIONAL CONTROL		
ENSAYO Test	RESULTADO Result	OBSERVACIONES OBSERVATION
Material en sistemas de unión Material in joining parts	Conforme Approved	Puntos de soldadura, adhesivo y engatillado Spots weld, mastic and crimped
Materiales de subestructuras Reinforcement material	Acero y adhesivo Steel and mastic	Cumple requisitos CZ It is according to requirements of CZ
Cumple funcionalidad Functional features	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Área soldada (mm <sup>2</sup> ) Welded area	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Distancia (mm) entre puntos soldadura Distance between spots weld	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Puntos soldadura defectuosos Quality of sports weld	0	Cumple requisitos CZ It is according to requirements of CZ
Formas geométricas Geometrical shape	Conforme Approved	Sin partes puntiagudas, ni cortantes, ni susceptibles de enganches Without sharp and pointed parts
Orientación superficies laterales Lateral surface orientation	Conforme Approved	Vuelta al exterior Turn over to external side
CALIFICACIÓN DE LOS CONTROLES ADICIONALES Test result		CONFORME APPROVED

5. COMPORTAMIENTO MECÁNICO MECHANICAL BEHAVIOR		
ENSAYO Test	RESULTADO Result	OBSERVACIONES OBSERVATION
Diferencia de retroceso (cm) Diference in backward movement	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Forma de plegado Folded shape	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Adhesivo y sellante Mastic behavior	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Cierre Fastener behavior	Conforme Approved	Cumple requisitos CZ It is according to requirements of CZ
Crash-Test frontal Frontal crash-test	NP	
Crash-Test oblicuo Lateral crash-test	NP	
CALIFICACIÓN DEL COMPORTAMIENTO MECÁNICO Test result		CONFORME APPROVED

**ANEXO 1 – REPORTAJE FOTOGRÁFICO DE LA ADAPTABILIDAD**  
ANNEX 1 – ADAPTABILITY PHOTO DOCUMENTATION

**Muestra Constructor**  
O.E.M. Part

**Muestra Fabricante**  
Spare Part



