

# ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

## ISO RECOMMENDATION R 683 /V

HEAT-TREATED STEELS, ALLOY STEELS  
AND FREE-CUTTING STEELS

PART 5  
WROUGHT QUENCHED AND TEMPERED MANGANESE STEELS

1st EDITION

January 1970

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## BRIEF HISTORY

The ISO Recommendation R 683/V, *Heat-treated steels, alloy steels and free-cutting steels – Part V : Wrought quenched and tempered manganese steels*, was drawn up by Technical Committee ISO/TC 17, *Steel*, the Secretariat of which is held by the British Standards Institution (BSI).

Work on this question led to the adoption of a Draft ISO Recommendation.

In December 1967, this Draft ISO Recommendation (No. 1360) was circulated to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

|                |                       |                |
|----------------|-----------------------|----------------|
| Australia      | India                 | Spain          |
| Austria        | Israel                | Sweden         |
| Belgium        | Italy                 | Switzerland    |
| Canada         | Japan                 | Thailand       |
| Colombia       | Korea, Rep. of        | Turkey         |
| Czechoslovakia | Netherlands           | U.A.R.         |
| Denmark        | New Zealand           | United Kingdom |
| Finland        | Norway                | U.S.A.         |
| France         | Poland                | U.S.S.R.       |
| Germany        | Romania               |                |
| Hungary        | South Africa, Rep. of |                |

One Member Body opposed the approval of the Draft :

Brazil

This Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in January 1970, to accept it as an ISO RECOMMENDATION.

## HEAT-TREATED STEELS, ALLOY STEELS AND FREE-CUTTING STEELS

### PART 5

### WROUGHT QUENCHED AND TEMPERED MANGANESE STEELS

#### 1. SCOPE

- 1.1 This ISO Recommendation covers wrought manganese steels for mechanical purposes, and usually intended for use
- (a) in the quenched and tempered condition, or
  - (b) in the austempered condition,
- with or without subsequent cold reduction.
- 1.2 For the purpose of simplification, the steels covered by this ISO Recommendation in both conditions are called "quenched and tempered steels" and both conditions are summarized under the term "quenched and tempered".
- 1.3 The types of steel 1 a, 1 b, 2 a and 2 b are listed with special requirements for the sulphur content in order to improve machinability.

#### 2. REQUIREMENTS

##### 2.1 Production processes

Unless otherwise agreed in the order, the processes used in making the steel and the product are left to the discretion of the manufacturer, but the steel should be killed. When he so requests, the user should be informed what steelmaking process is being used.

##### 2.2 Chemical composition, mechanical properties and hardenability

- 2.2.1 The steels covered by this ISO Recommendation should be ordered and delivered in accordance with Table 1.

TABLE 1 - Types of condition of delivery

| Requirements                                                                  | Types of condition of delivery* |      |   |      |   |      |   |      |   |   |
|-------------------------------------------------------------------------------|---------------------------------|------|---|------|---|------|---|------|---|---|
|                                                                               | 1                               | 1(a) | 2 | 2(a) | 3 | 3(a) | 4 | 4(a) | 5 | 6 |
| Chemical composition                                                          | X                               | X    | X | X    | X | X    | X | X    | X | X |
| Hardenability                                                                 | —                               | —    | X | X    | — | —    | — | —    | — | — |
| Hardness in a condition of delivery other than quenched and tempered          | —                               | X    | — | X    | — | X    | — | X    | — | — |
| Mechanical properties of                                                      |                                 |      |   |      |   |      |   |      |   |   |
| — quenched and tempered test bars of 16 mm diameter                           | —                               | —    | — | —    | X | X    | — | —    | — | — |
| — quenched and tempered ruling sections                                       | —                               | —    | — | —    | — | —    | X | X    | — | — |
| — quenched and tempered product in final dimensions                           | —                               | —    | — | —    | — | —    | — | —    | X | — |
| — quenched and tempered product subsequently cold-reduced to final dimensions | —                               | —    | — | —    | — | —    | — | —    | — | X |

\* The numbers indicating the type of condition of delivery follow a co-ordinated series of numbers throughout all relevant ISO Recommendations.

The type of condition of delivery according to Table 1 should be stated at the time of enquiry and order.

2.2.2 The chemical composition expressed by the cast analysis should be in accordance with Table 2.

TABLE 2 – Types of steel and chemical composition guaranteed  
(applicable to cast analysis)\*

| Type of steel | C %          | Si %         | Mn %         | P %** max. | S %**          |
|---------------|--------------|--------------|--------------|------------|----------------|
| 1             | 0.25 to 0.32 | 0.15 to 0.40 | 1.30 to 1.65 | 0.035      | 0.035 max.     |
| 1 a           |              |              |              |            | 0.020 to 0.035 |
| 1 b           |              |              |              |            | 0.030 to 0.050 |
| 2             | 0.33 to 0.40 | 0.15 to 0.40 | 1.30 to 1.65 | 0.035      | 0.035 max.     |
| 2 a           |              |              |              |            | 0.020 to 0.035 |
| 2 b           |              |              |              |            | 0.030 to 0.050 |

\* Elements not quoted in Table 2 should not be intentionally added to the steel without the agreement of the purchaser, other than for the purpose of finishing the heat. All reasonable precautions should be taken to prevent the addition, from scrap or other materials used in manufacture, of such elements which affect the hardenability, mechanical properties and applicability.

\*\* If agreed between the purchaser and the manufacturer, the steel may be ordered with an upper limit of sulphur and phosphorus less than 0.035 %.

2.2.2.1 If ordered to conditions of delivery type 1 or 1(a) (see Table 1), the following permissible deviations between the values specified in Table 2 and the product analysis of products up to 160 mm (6.3 in) diameter should apply. Above 160 mm (6.3 in) diameter, the permissible deviations should be stated at the time of enquiry and order.

TABLE 3 – Permissible deviations between specified analysis and product analysis

| Type of steel | Permissible deviations* |        |        |         |         |
|---------------|-------------------------|--------|--------|---------|---------|
|               | C %                     | Si %   | Mn %   | P %     | S %     |
| 1             | ± 0.02                  | ± 0.03 | ± 0.06 | + 0.005 | + 0.005 |
| 1 a           |                         |        |        |         | ± 0.005 |
| 1 b           |                         |        |        |         | ± 0.005 |
| 2             |                         |        |        |         | + 0.005 |
| 2 a           |                         |        |        |         | ± 0.005 |
| 2 b           |                         |        |        |         | ± 0.005 |

\* ± means that in one cast the deviation may occur over the upper value or under the lower value of the specified range in Table 2 but not both at the same time.

2.2.2.2 If ordered to condition of delivery types 2, 2(a), 3, 3(a), 4, 4(a), 5 and 6, the mechanical properties or hardenability specified in Tables 4, 5 and 7 should be the governing criteria for acceptance. In such cases, the cast analysis may deviate slightly from the values shown in Table 2.

2.2.3 If specified, the mechanical properties should be those shown in Table 4 or Table 5.

2.2.3.1 The values apply to test pieces, taken on rounds in the direction of the metal fibre, the axis of the test piece corresponding to that shown in Figure 1.

2.2.3.2 For rectangular sections, the ranges for equivalent diameters are given in Figure 2.

2.2.3.3 For other sections, the equivalent diameter should be agreed at the time of enquiry and order.

2.2.4 The mechanical properties in the quenched and tempered condition as given in Table 4 are those which can be obtained for one of the conditions given below :

- (1) For a reference test bar of 16 mm diameter, taken from the product to be delivered either by machining from a location according to Figure 1 or by forging, and then quenched and tempered according to the temperatures listed in Table 8 (types of condition of delivery 3 and 3(a) of Table 1).
- (2) For a ruling section\*, to be specified at the time of enquiry and order, which is quenched and tempered according to the temperatures listed in Table 8 (types of condition of delivery 4 and 4(a) of Table 1).  
For location of the test bar, see clause 3.2.1.
- (3) For the product in the quenched and tempered condition of delivery (type of condition of delivery 5 of Table 1).  
For location of the test bar, see clause 3.2.1.

2.2.5 The mechanical properties in the quenched and tempered and subsequently cold-reduced condition as given in Table 5 may be agreed for the product to be delivered in this condition (type of condition of delivery 6 of Table 1).

For location of the test bar, see clause 3.2.1.

2.2.6 If the products are delivered in a condition other than quenched and tempered, with or without subsequent cold reduction, a maximum hardness in accordance with Table 6, measured after preparation of the surface in the conventional manner, may be agreed in addition to the other requirements (types of condition of delivery 1(a), 2(a), 3(a) and 4(a) of Table 1).

2.2.6.1 Mechanical properties for the normalized condition for the types of steel 1, 1 a and 1 b are given for information in Table 9.

2.2.7 When ordering on hardenability (types of condition of delivery 2 and 2(a) of Table 1), the Rockwell C hardness numbers given in Table 7 and the scatter bands in Figure 3 apply.

## 2.3 Tolerances on dimensions and mass

The tolerances allowable on dimensions and mass should be stated in the order, as long as there are no ISO Recommendations to cover them.

## 3. TESTING

### 3.1 Number of sample products

3.1.1 *Chemical composition.* The cast analysis is given by the manufacturer. If a product analysis is required by the purchaser, at least one sample product should be taken from each cast.

\* In the selection of a steel, one of the most important considerations is whether the mechanical properties required can be obtained from the steel in the size and shape at the time of heat treatment. That portion, which is most important from the point of view of the mechanical properties obtained by heat treatment, is referred to as the ruling section, and the ruling section should always be expressed in terms of the diameter of an equivalent round bar (see Fig. 1).

### 3.1.2 Mechanical properties and hardenability

- 3.1.2.1 For material not supplied in the finally heat-treated condition (types of condition of delivery 2, 2(a), 3, 3(a), 4 and 4(a) of Table 1), one sample product should be taken from each cast for testing in accordance with the requirements of Tables 4, 6 and 7.
- 3.1.2.2 For material supplied in the finally heat-treated condition (type of condition of delivery 5 of Table 1) or in the heat-treated and subsequently cold-reduced condition (type of condition of delivery 6 of Table 1), one sample product should be taken from each size grouping from each heat-treatment batch for testing in accordance with Tables 4 and 5. If the product is continuously heat-treated, one sample product for each 15 t or part thereof, but at least one sample product for each cast, should be taken.

### 3.2 Samples and test pieces

- 3.2.1 The test pieces for tensile test and impact test should be taken in the longitudinal direction of the products according to Figure 1.
- 3.2.2 The bar from which the test piece for the end-quench hardenability test is machined should be a forged or rolled round piece 32 or 30 mm in diameter representing the full cross-section of the product. Larger cross-sections should be rolled or forged to these dimensions. By special agreement a cast test piece may be used in lieu of a rolled or forged test piece. Further conditions to be observed when preparing the test pieces should be as in ISO Recommendation R 642, *Hardenability test by end quenching steel (Jominy test)*.
- 3.2.3 For product analyses, the selection of samples should be carried out in conformity with the requirements of ISO Recommendation R 377, *Selection and preparation of samples and test pieces for wrought steel*.
- 3.2.4 General conditions for selection and preparation of test samples and test pieces for steel should be in accordance with ISO Recommendation R 377.

### 3.3 Test methods

- 3.3.1 The tensile test should be made in accordance with the following ISO Recommendations :
  - R 82, *Tensile testing of steel*;
  - R 86, *Tensile testing of steel sheet and strip less than 3 mm and not less than 0.5 mm thick*;
  - R 89, *Tensile testing of steel wire*.
- 3.3.2 The impact test should be made in accordance with ISO Recommendation R 83, *Charpy impact test (U-notch) for steel*. Unless otherwise specified at the time of enquiry and order, the impact value should be determined by the arithmetic average of the results obtained by the breaking of three test pieces next to one another in the test sample or test bar.
- 3.3.3 The end-quench hardenability test should be made in accordance with ISO Recommendation R 642, *Hardenability test by end quenching steel (Jominy test)*. The temperatures for quenching should be in accordance with Table 8.
- 3.3.4 The Brinell hardness test should be made in accordance with ISO Recommendation R 79\*, *Brinell hardness test for steel*. The Rockwell hardness test should be made in accordance with ISO Recommendation R 80\*, *Rockwell hardness test (B and C scales) for steel*.
- 3.3.5 In cases of dispute, the methods for the chemical analysis should be those established by the relevant ISO Recommendations. If no ISO Recommendations are available, the methods may be agreed upon and specified at the time of enquiry and order.

\* 2nd edition, 1968.

### 3.4 Retests

3.4.1 For retests for mechanical properties, clause 6.5 of ISO Recommendation R 404, *General technical delivery requirements for steel*, is valid.

3.4.2 For retests for the product analysis, clause 7.6 of ISO Recommendation R 404 is valid.

### 3.5 Certification of the tests

For certification of the tests, section 4 of ISO Recommendation R 404 is valid, acceptable documents being namely :

- statement of compliance with the order (see clause 4.1.1), or
- report based on quality control (see clause 4.1.2), or
- works certificate (see clause 4.1.3), or
- test certificate (see clause 4.2.1), or
- certificate of acceptance (see clause 4.2.2).

## 4. DEFECTS AND DIMENSIONAL TOLERANCES

The conditions given in section 8 of ISO Recommendation R 404 are valid for

- surface defects (see clause 8.1),
- rectification (see clause 8.2),
- internal defects (see clause 8.3),
- dimensional tolerances (see clause 8.4) and
- reclaiming (see clause 8.5).

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TABLE 4 — Mechanical properties for the quenched and tempered condition\*

| Type of steel | $\phi \leq 16 \text{ mm (0.63 in)}$            |                                                |                  |                       | $16 \text{ mm (0.63 in)} < \phi \leq 40 \text{ mm (1.58 in)}$ |                                                |                  |                       |
|---------------|------------------------------------------------|------------------------------------------------|------------------|-----------------------|---------------------------------------------------------------|------------------------------------------------|------------------|-----------------------|
|               | $R_e \text{ min.}$                             | $R_m$                                          | $A \text{ min.}$ | KCU min.              | $R_e \text{ min.}$                                            | $R_m$                                          | $A \text{ min.}$ | KCU min.              |
|               | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | %                | kgf·m/cm <sup>2</sup> | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> )                | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | %                | kgf·m/cm <sup>2</sup> |
| 1 and 1 a     | 60                                             | 80 to 95                                       | 13               | 5                     | 50<br>(31.7)                                                  | 70 to 85<br>(44.4 to 54.0)                     | 15               | 6                     |
| 1 b           | (38)                                           | (50.8 to 60.3)                                 |                  | —                     |                                                               |                                                |                  | —                     |
| 2 and 2 a     | 65                                             | 85 to 100                                      | 12               | 4                     | 55<br>(34.9)                                                  | 75 to 90<br>(47.6 to 57.1)                     | 14               | 5                     |
| 2 b           | (41.3)                                         | (54.0 to 63.5)                                 |                  | —                     |                                                               |                                                |                  | —                     |

| Type of steel | $40 \text{ mm (1.58 in)} < \phi \leq 100 \text{ mm (3.94 in)}$ |                                                |                  |                       | $100 \text{ mm (3.94 in)} < \phi \leq 160 \text{ mm (6.3 in)}$ |                                                |                  |                       |
|---------------|----------------------------------------------------------------|------------------------------------------------|------------------|-----------------------|----------------------------------------------------------------|------------------------------------------------|------------------|-----------------------|
|               | $R_e \text{ min.}$                                             | $R_m$                                          | $A \text{ min.}$ | KCU min.              | $R_e \text{ min.}$                                             | $R_m$                                          | $A \text{ min.}$ | KCU min.              |
|               | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> )                 | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | %                | kgf·m/cm <sup>2</sup> | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> )                 | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | %                | kgf·m/cm <sup>2</sup> |
| 1 and 1 a     | 45                                                             | 65 to 80                                       | 16               | 6                     | —                                                              | —                                              | —                | —                     |
| 1 b           | (28.6)                                                         | (41.3 to 50.8)                                 |                  | —                     |                                                                |                                                |                  | —                     |
| 2 and 2 a     | 47                                                             | 70 to 85                                       | 15               | 5                     | 42<br>(26.7)                                                   | 65 to 80<br>(41.3 to 50.8)                     | 16               | 4                     |
| 2 b           | (29.8)                                                         | (44.4 to 54.0)                                 |                  | —                     |                                                                |                                                |                  | —                     |

\*  $R_e$  = yield stress (0.2 % proof stress)  
 $R_m$  = tensile strength  
 $A$  = percentage elongation after fracture ( $L_0 = 5 d_0$ )  
KCU = impact strength with U-notch

TABLE 5 - Mechanical properties for the quenched and tempered and subsequently cold-reduced condition\*

| Type of steel | $\phi \leq 16 \text{ mm (0.63 in)}$            |                                                |          |                       | 16 mm (0.63 in) $< \phi \leq 40 \text{ mm (1.58 in)}$ |                                                |          |                       | 40 mm (1.58 in) $< \phi \leq 100 \text{ mm (3.94 in)}$ |                                                |          |                       |
|---------------|------------------------------------------------|------------------------------------------------|----------|-----------------------|-------------------------------------------------------|------------------------------------------------|----------|-----------------------|--------------------------------------------------------|------------------------------------------------|----------|-----------------------|
|               | $R_e$ min.                                     | $R_m$                                          | $A$ min. | KCU min.              | $R_e$ min.                                            | $R_m$                                          | $A$ min. | KCU min.              | $R_e$ min.                                             | $R_m$                                          | $A$ min. | KCU min.              |
|               | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | %        | kgf-m/cm <sup>2</sup> | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> )        | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | %        | kgf-m/cm <sup>2</sup> | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> )         | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | %        | kgf-m/cm <sup>2</sup> |
| 1 and 1 a     | 75<br>(47.6)                                   | 85 to 100<br>(54.0 to 63.5)                    | 11       | 3                     | 65<br>(41.3)                                          | 75 to 90<br>(47.6 to 57.1)                     | 11       | 3                     | 60<br>(38.1)                                           | 70 to 85<br>(44.4 to 54.0)                     | 12       | 3                     |
| 1 b           |                                                |                                                |          |                       |                                                       |                                                |          |                       |                                                        |                                                |          |                       |
| 2 and 2 a     | 80<br>(50.8)                                   | 90 to 110<br>(57.1 to 69.8)                    | 10       | 3                     | 70<br>(44.4)                                          | 80 to 95<br>(50.8 to 60.3)                     | 11       | 3                     | 65<br>(41.3)                                           | 75 to 90<br>(47.6 to 57.1)                     | 12       | 3                     |
| 2 b           |                                                |                                                |          |                       |                                                       |                                                |          |                       |                                                        |                                                |          |                       |

\*  $R_e$  = yield stress (0.2 % proof stress)  
 $R_m$  = tensile strength  
 $A$  = percentage elongation after fracture ( $L_o = 5 d_o$ )  
KCU = impact strength with U-notch

TABLE 6 – Maximum hardness for products delivered in a condition other than quenched and tempered

| Type of steel  | HB maximum in condition                                                                   |                                    |             |
|----------------|-------------------------------------------------------------------------------------------|------------------------------------|-------------|
|                | as rolled                                                                                 | treated for improved machinability | cold drawn* |
| 1, 1 a and 1 b | If required, to be agreed between purchaser and supplier at the time of enquiry and order | 223                                | 269         |
| 2, 2 a and 2 b |                                                                                           | 229                                | 285         |

\* All cold-drawn conditions except hardened and tempered and subsequently cold reduced.

TABLE 7 – Tentative hardness limits for specified hardenability\*

| Distance from quenched end of test piece | Hardness HRC          |      |                       |      |
|------------------------------------------|-----------------------|------|-----------------------|------|
|                                          | steels 1, 1 a and 1 b |      | steels 2, 2 a and 2 b |      |
| mm                                       | min.                  | max. | min.                  | max. |
| 1.5                                      | 46                    | 55   | 51                    | 59   |
| 3                                        | 43                    | 54   | 48                    | 58   |
| 5                                        | 37                    | 51   | 42                    | 57   |
| 7                                        | 31                    | 48   | 37                    | 54   |
| 9                                        | 27                    | 45   | 27                    | 49   |
| 11                                       | 23                    | 42   | 23                    | 45   |
| 13                                       | 20                    | 39   | 20                    | 41   |
| 15                                       | —                     | 37   | —                     | 38   |
| 20                                       | —                     | 33   | —                     | 35   |
| 25                                       | —                     | 31   | —                     | 33   |
| 30                                       | —                     | 29   | —                     | 31   |
| 35                                       | —                     | 28   | —                     | 30   |
| 40                                       | —                     | 27   | —                     | 30   |
| 45                                       | —                     | 27   | —                     | 30   |
| 50                                       | —                     | 26   | —                     | 30   |

\* The hardness values are tentative and may be adjusted as more information becomes available. The hardness values are based primarily on steels having a grain size of 5 and finer as defined in ISO Recommendation R 643, *Micrographic determination of the austenitic grain size of steels*.

TABLE 8 – Conditions for heat-treatment

The temperatures given below are for guidance, but the actual temperatures chosen should be those that will give the properties required. However, the temperatures specified for the end-quench test are mandatory.

| Type of steel  | Quenching*<br>°C | Quenching agent | Tempering**<br>°C | Normalizing<br>°C | End-quench test<br>°C |
|----------------|------------------|-----------------|-------------------|-------------------|-----------------------|
| 1, 1 a and 1 b | 830 to 870       | Water or oil    | 540 to 680        | 840 to 890        | 850 ± 5               |
| 2, 2 a and 2 b | 820 to 860       | Oil or water    | 540 to 680        | —                 | 840 ± 5               |

\* Time for austenitizing as a guide : 0.5 hour minimum.

\*\* Time for tempering as a guide : 1 hour minimum.

NOTE. — Temperatures at the lower end of the range should be used for water, and those at the upper end for oil.

TABLE 9 – Mechanical properties of types of steel 1, 1 a and 1 b for the normalized condition or the normalized and tempered condition\*

| $\phi \leq 40$ mm (1.58 in)                    |                                                |          | 40 mm (1.58 in) < $\phi \leq 100$ mm (3.94 in) |                                                |          | 100 mm (3.94 in) < $\phi \leq 160$ mm (6.30 in) |                                                |          |
|------------------------------------------------|------------------------------------------------|----------|------------------------------------------------|------------------------------------------------|----------|-------------------------------------------------|------------------------------------------------|----------|
| $R_e$ min.                                     | $R_m$                                          | $A$ min. | $R_e$ min.                                     | $R_m$                                          | $A$ min. | $R_e$ min.                                      | $R_m$                                          | $A$ min. |
| kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | %        | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | %        | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> )  | kgf/mm <sup>2</sup><br>(tonf/in <sup>2</sup> ) | %        |
| 36<br>(22.9)                                   | 65 to 85<br>(41.3 to 54.0)                     | 13       | 34<br>(21.5)                                   | 60 to 80<br>(38.1 to 50.8)                     | 14       | 31<br>(19.7)                                    | 55 to 75<br>(34.9 to 47.6)                     | 16       |

\*  $R_e$  = yield stress (0.2 % proof stress)

$R_m$  = tensile strength

$A$  = percentage elongation after fracture ( $L_0 = 5 d_0$ )

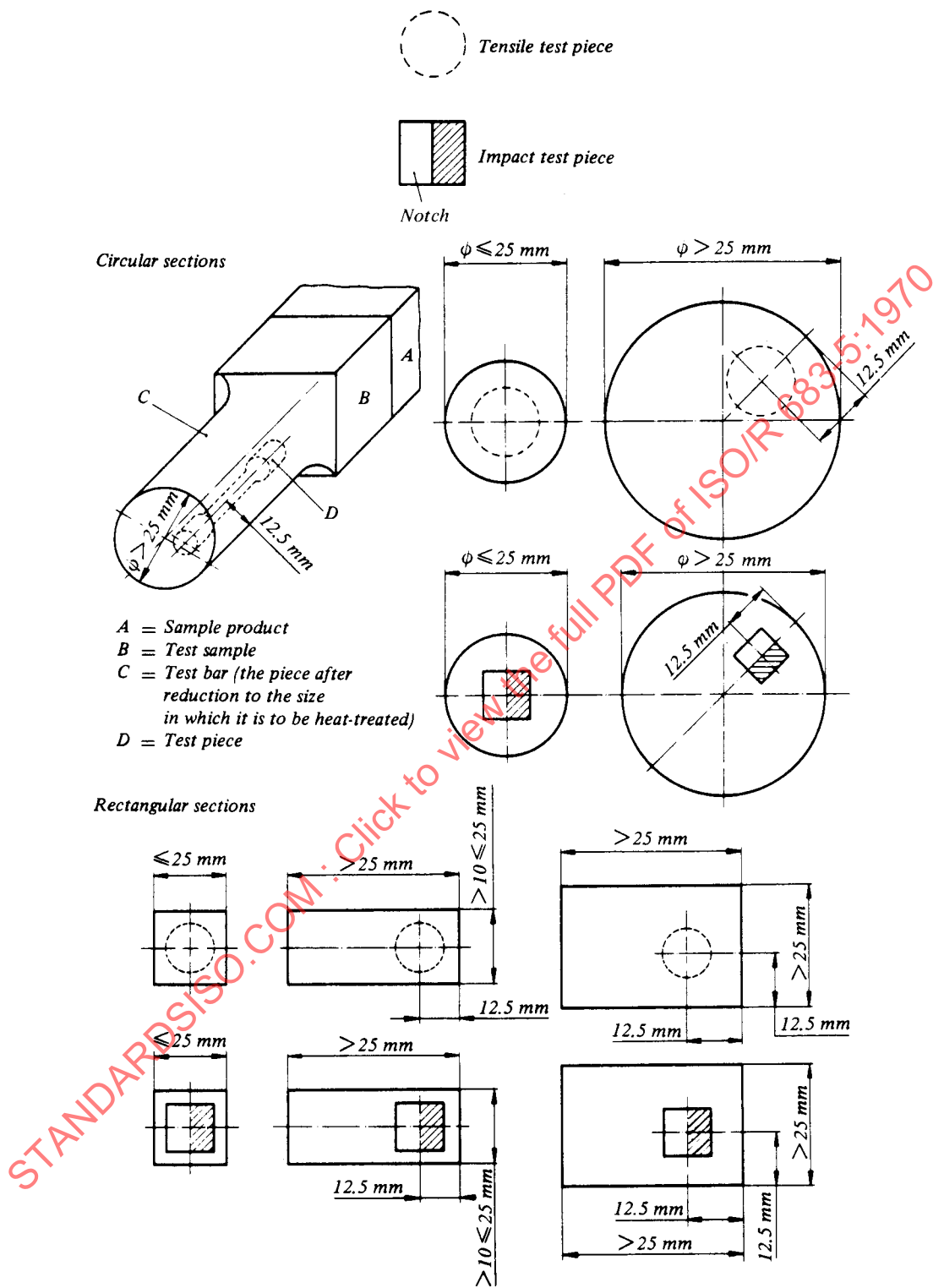


FIG. 1 – Location of the test pieces in the products