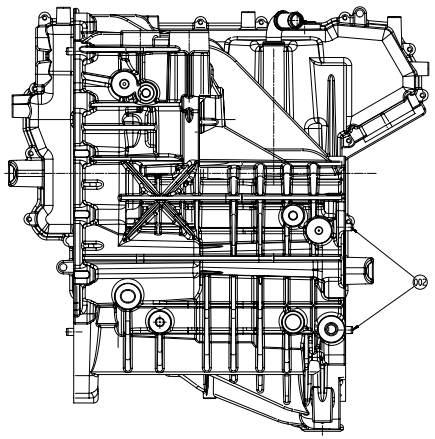
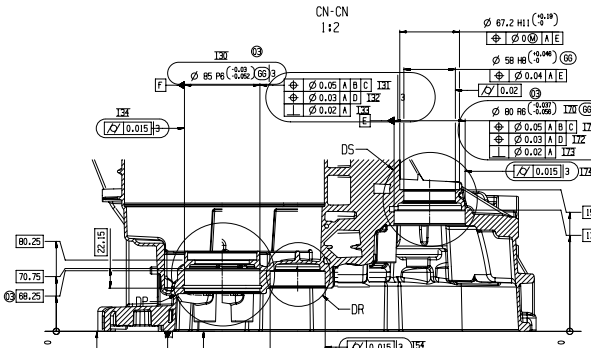
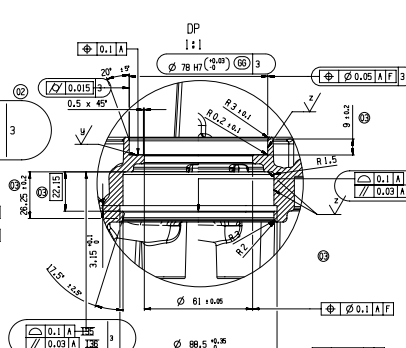
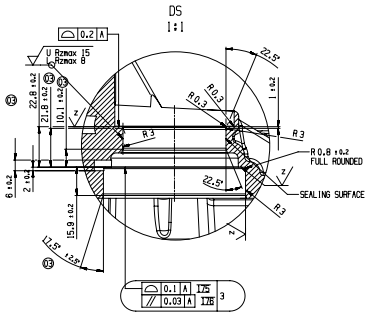
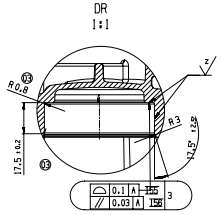










ENTIRE COMPONENT ACC. TO POS. 994.6 /

SEALING SURFACES:
Bosch N42AP605 - Ø L0.7 / U0.4 / A20
WET-SEALING SURFACE :
Bosch N42AP605 - Ø L1.5 / U0.7 / A20
FOR ALL THREADS UP TO DEPTH 2x NOMINAL SCREW DIAMETER /
Bosch N42AP605 - SX / Ø L1.5 / H0

INSPECTION AREA SHOULD BE AT LEAST
4 mm BIGGER THAN THE SURFACE ENVELOPE

ALL OTHER MACHINED SURFACES :
Bosch N42AP605 - Ø L3.0 / U1.0 / A8

THREAD FOR VEHICLE MOUNTING SHOULD BE PRECAST.
FOR THE FIRST 4WINDINGS OF THE THREAD ADDITIONAL
REQUIREMENT IS VALID:M42 AP6G5 X3,5 Ø 0,6/U0,3/H0

THREAD FOR VEHICLE MOUNTING MUST BE CHECKED ACC. POS. 989.0 /

CASTING FLASHES MAX HEIGHT 1.0 mm
CASTING FLASHES WHICH CAN FALL APART DURING TRANSPORT,
HANDLING, ASSEMBLY OR FUNCTIONING ARE NOT ALLOWED.
THOSE CASTING FLASHES WHICH IMPAIR FUNCTIONALITY ARE NOT
ALLOWED.
FL.1.0 ACC. TO BOM - ACC. TO DIN EN ISO 10135:2010-02

BURRS AND PROTRUSIONS ON CAST SURFACES WITH A MAXIMUM HEIGHT
OF 1.8 MM PERMISSIBLE. NOT ALLOWED IF IMPAIRS FUNCTIONALITY /

TRIMMING RIBS AND OVERFLOWS AFTER TRIMMING MAX. HEIGHT 1 mm
GATING RIBS AFTER TRIMMING MAX. HEIGHT 1 mm /

MECH. PROPERTIES AFTER T5 HEAT TREATMENT
ACC. TO. POS.: 994.9
MIN. YIELD STRENGTH: Rp0.2% = 193 MPa
MIN. ULTIMATE TENSILE STRENGTH: Rm = 256 MPa
MIN. ELONGATION: A = 1.6%

STATE OF DELIVERY: FREE OF CORROSION

EJECTOR PIN BOSSES ± 0.5 mm /

CLEANLINESS REQUIREMENT ACC. TO POS. 994.7 AND POS. 994.8

SPECIFICATION LEAKAGE OF WHOLE PART /
RELATIVE TEST PRESSURE ± 0.3 bar
LEAKAGE RATE MUST BE LOWER THAN 6.0 [Norm-ml/min]

SPECIFICATION LEAK TEST OF COOLANT PASSAGE

RELATIVE TEST PRESSURE: 2.5 bar
LEAKAGE RATE MUST BE LOWER THAN 0.8 [Norm-ml/min]

SPECIFICATION LEAKAGE OF OIL WETTED SURFACE /
RELATIVE TEST PRESSURE 2.5 bar
LEAKAGE RATE MUST BE LOWER THAN 3 [Norm-ml/min]
ACC. TO POS. 990.1 / nach Pos. 990.1

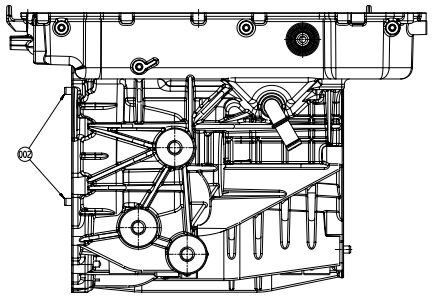
POSITION TOLERANCE AND PERPENDICULARITY
EVALUATED ACC. GAUSSIAN ACC. ISO 1101 /

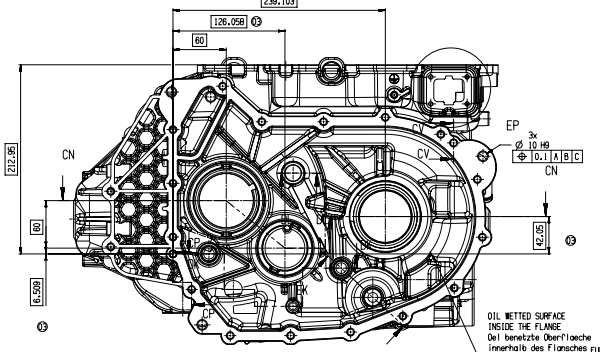
POSITION TOLERANCES OF THREADS CAN BE MEASURED
AT THE CONTOUR CREATED BY THE CORE HOLE TOOL /

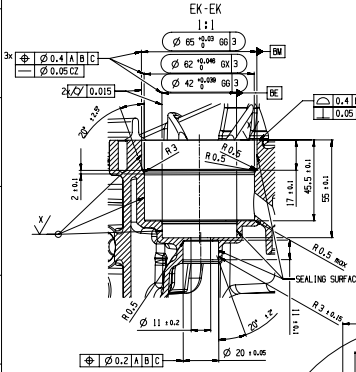
IMPREGNATION ONLY ONE TIME ACCEPTED /

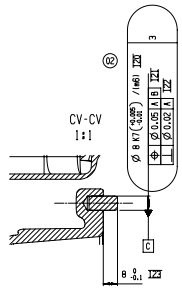
GENERAL INNER SURFACE TOLERANCE
(OIL WETTED SURFACE) /

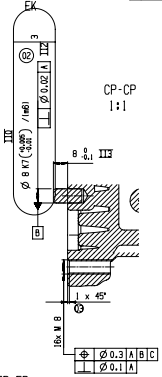
GENERAL OUTER SURFACE TOLERANCE

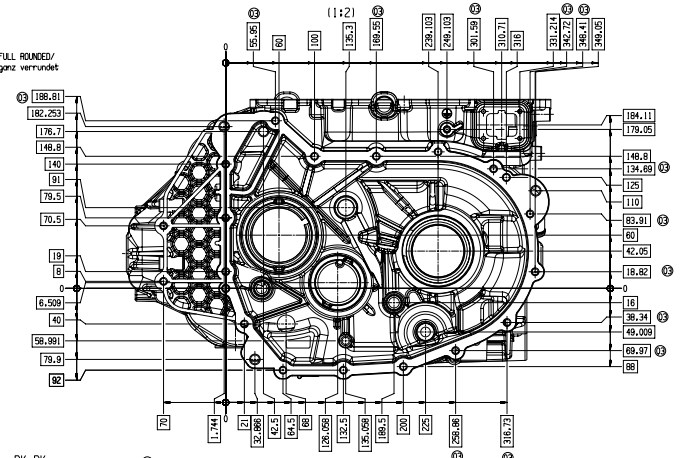


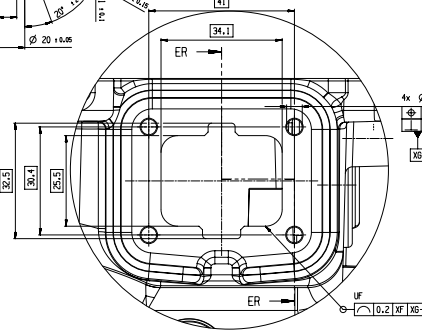


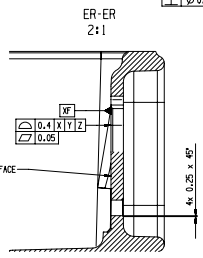


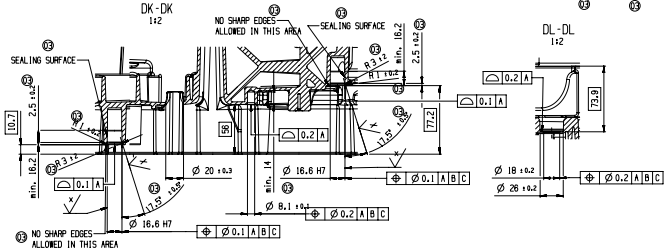


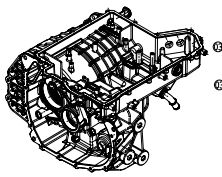












PK4 : Bosch N42AP605- Ø L3.0 / U1.0 / A8

PK3: Bosch N42AP605- Ø L0.7 / U0.4 / A20

PK4 (PK3)

CLASSIFICATION OF POROSITIES
ACC. PRODUCT MEMO: POS. 994.6

X : Rzmax 6.3
Y : Rzmax 25
Z : Rzmax 10

01	F202101649P01	20260826	stefsiu	cristo			210.1	DK-DK/DL-DL/EK-EK/EP
00	F202101650P01	20260526	stefsiu	cristo			210.1	DK-DK/DL-DL/EK-EK/EP
00	F202101650P01	20260513	cristo	tvasil	sigbal		210.1	DK-DK/DL-DL/EK-EK/EP
Ind.	Change Memo	Prepared	Checked	Released	Approved	Date	Pos.	Area/Description

Treatment: SEE BOM
Behandlung

Material: SEE BOM
Werkstoff

Surface: SEE BOM
Oberfläche

Process: Sand/Permanent Mould Gravity Die Casting
Prozess: Sand/Kokillenguss

Machine: SEE BOM
Maschine

Mass: SEE BOM
Masse

Drawing Status: Released
Zeichnungsstatus

Drawing Type: Product
Zeichnungsart

Replaces: 157
Ersetzt

Replaced by:
Ersetzt durch

Projection: 1.2
Projektion

Tolerances: ISO 8062-3:2023-02
Toleranzen

Dimensional Inspection: ISO 1101
Maßkontrolle

Weld Thickness/Weld Size: ISO 2553
Schweißnahtdicke/Schweißnahtgröße

Weld Indication/Weld Seam Length: ISO 2553
Schweißnahtkennzeichnung/Schweißnahtlänge

Weld Inspection: ISO 17637
Schweißnahtprüfung

Surface Inspection: ISO 3452-1
Oberflächenprüfung

Material Properties: ISO 6892-1
Materialeigenschaften

Hardness: DIN 276/2023-04 table 3
Härte

Sharp-edged Requirement: ISO 13715:2017-03
Kantenbeschaffenheit

Surface Texture Profile: ISO 1302:2002-02
Oberflächenprofil

Surface Texture Symbol: ISO 1640-1:2010-12
Oberflächensymbol

Edge Tolerance: Edge tolerance has to be interpreted on general tolerance ISO 2768-1 (m) if not otherwise mentioned.
Kantentoleranz: Kantentoleranz ist nach der allgemeinen Toleranz ISO 2768-1 (m) zu interpretieren wenn nicht anders angegeben.

Rzmax 100

Weight: SEE BOM
Gewicht

Scale: 1:2
Maßstab

Drawing Number: F 03Z 400 5BF-02
Zeichnungsnummer

Sheet: 000 03
Blatt

Index: 01
Index

SYSTEM HOUSING ASSY
SYSTEMGEHAEUSE Z50

BOSCH

Proprietary Clause: N 2580-1
Schutzvermerk

Drawn by: BRW
Gezeichnet

Checked by: NA
Geprüft

Released by:
Freigegeben

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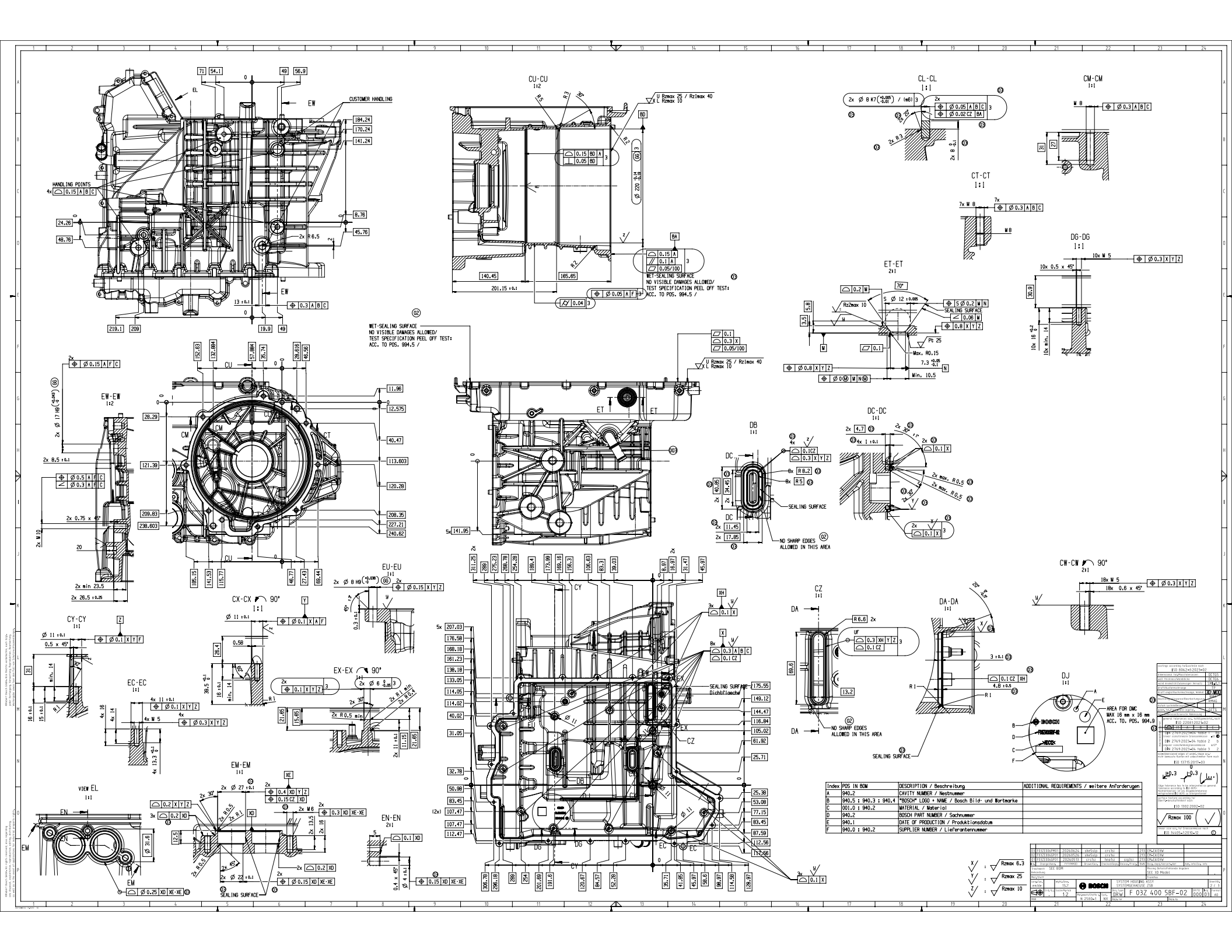

Index	POS IN BOM	DESCRIPTION / Beschreibung	ADDITIONAL REQUIREMENTS / weitere Anforderungen
A	940.2	CAVITY NUMBER / Nestnummer	
B	940.5 ; 940.3 ; 940.4	"BOSCH" LOGO + NAME / Bosch Bild- und Wortmarke	
C	001.0 ; 940.2	MATERIAL / Material	
D	940.2	BOSCH PART NUMBER / Sachnummer	
E	940.1	DATE OF PRODUCTION / Produktionsdatum	
F	940.0 ; 940.2	SUPPLIER NUMBER / Lieferantennummer	

00	F 03Z 400 584-P01	2020-08-24	stwf-stin	cristo		210 EN-EXTERN	
01	F 03Z 400 584-P01	2020-09-24	stwf-stin	cristo		210 EN-EXTERN	
02	F 03Z 400 584-P01	2020-10-13	cristo	tmatti	stgiai	210 EN-EXTERN	

Treatment: SEE BOM

Rzmax 6.3 / Rzmax 25 / Rzmax 10

Rzmax 100

Drawing-Nr.	Rev.-Index	BOSCH	SYSTEM HOUSING ASSY			Sheet-No.	Sheets
1 3 7 6 0 4 0 0 5 8 4	02		SYSTEMGEHÄUSE Z10			1 / 1	
Format	Scale	Replaces	Replaced by	Projection method	Dimensioning	Drawing-No.	Rev.
A3	1:2					F 03Z 400 584-02	02
Mat. No.	Material-No.	Mat. Info.	Mat. Status	Mat. Grade	Mat. Color	Mat. Weight	Mat. Volume
	N 2586-1	NA					

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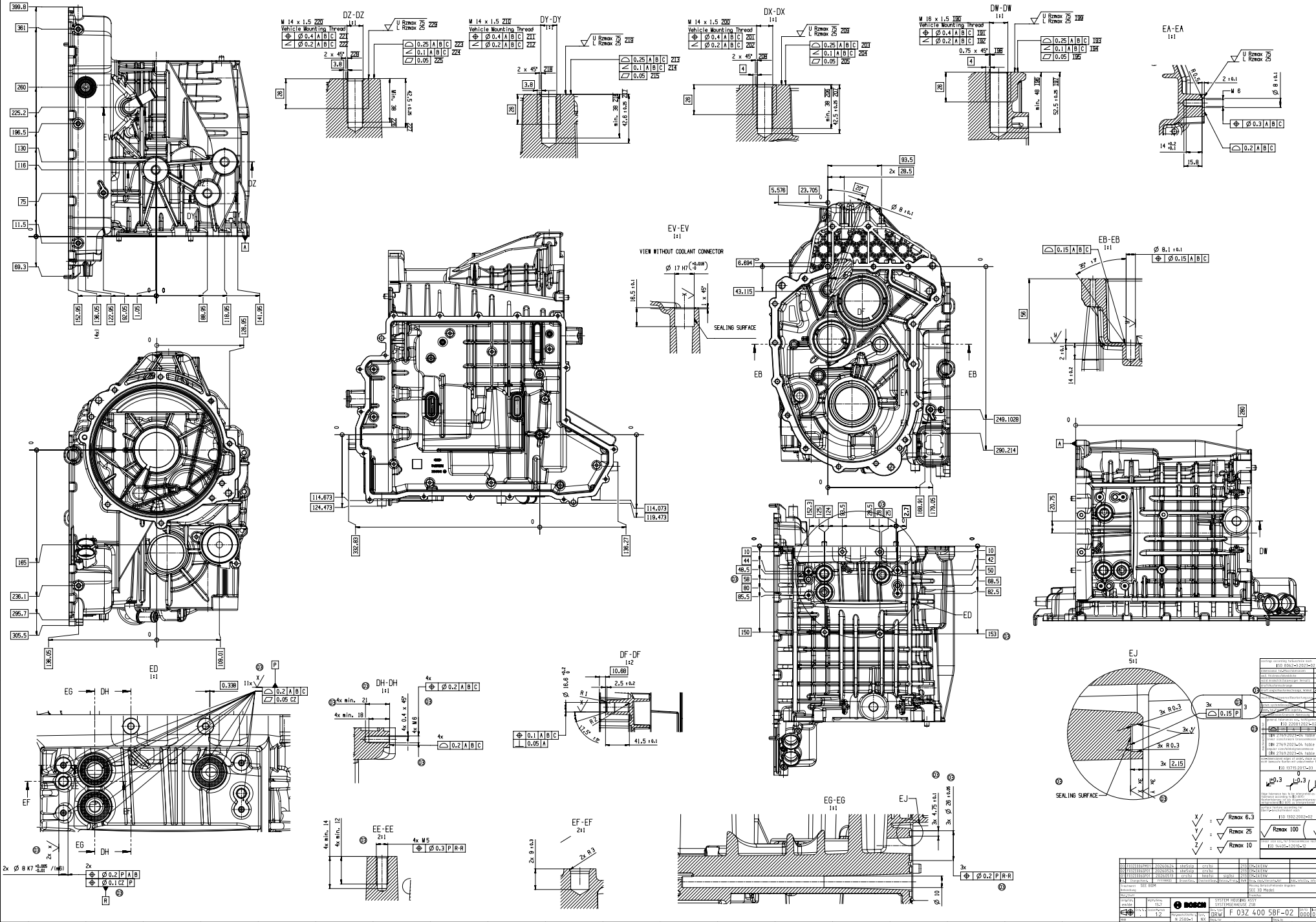
VEHICLE MOUNTING POINTS



Original working technical sheet ISO 8062-3:2023-02
Dimensional tolerancing acc. ISO 1101
Dimensional and geometrical tolerancing acc. ISO 8015
Edge tolerance acc. ISO 13715:2017-03
Surface texture acc. ISO 1302:2002-02
Rzmax 6.3
Rzmax 25
Rzmax 10
Rzmax 100
Surface texture acc. ISO 14638-1:2015-12

01	F03Z016349P01	20260826	stwSUN	cristo		210	EN-EHW
00	F03Z016349P01	20260526	stwSUN	cristo		210	EN-EHW
01	F03Z016349P01	20260513	cristo	tvaisi	sigisi	210	EN-EHW
Index	Change Mark.	F/I/W/P/S	Drawn/Dsg.	Technol/Dsn.	Verific./Val.	Appr.	Mod. reason, info

Treatment: SEE BOM
Remarks: SEE 3D Model
Material: SEE 3D Model

Replaces	Replaced by				
	1577				
Scale	Sheet				
	1:2				

BOSCH

SYSTEM HOUSING ASSY
SYSTEMGEHÄUSE Z10

Doc. type	Doc. no.	Index
DRW	F 03Z 400 5BF-02	01

Replaces: 0000 03 AA
Replaced by:

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