SPECIFICATION SHEET

WIND TURBINE COMPONENTS

Plates, bushings, pins and brackets, machined and coated to OEM drawings, with bolts and nuts sourced to your specification. Forged close to shape where your specification allows, with forging and machining in one plant.

Parts
Plates, bushings, pins, brackets
custom parts to drawing; bolts and nuts to your specification

Material
The grade you specify
e.g. S355J2, S460NL, 42CrMo4

Process
CNC machined from bar and plate
or forged from bar where your specification allows

Heat treatment
Normalised or quenched and tempered
by grade and drawing

General tolerances
ISO 2768-m
unless your drawing specifies

Coating allowance
Left on fits and threads
before coating

Measuring
CMM and contour measuring instrument

Standard values apply unless your drawing specifies otherwise.

Coating

to the system and class on your drawing, or to your OEM coating specification

System	Standard	Thickness	Corrosion class
Hot-dip galvanized	ISO 1461	Typically 85 µm, thicker on request	C4 routinely, C5 on request
Electroplated zinc	ISO 2081	12 µm or more, passivated or sealed	C3 and C4 routinely
Zinc flake	ISO 10683	To your drawing	C5 on request

Corrosion classes per ISO 12944-2. All coatings applied by qualified coating partners. Coating thickness measured and recorded on every order.

Process route

in production order

Process	Stage	Result
Material	Bar or plate in the grade you specify	Traced to the heat
Closed-die forging	Where your specification allows	Close to shape, less machining
Heat treatment	By grade and drawing	Normalised or quenched and tempered
CNC machining	Turning, milling, drilling, tapping	To your drawing, allowance left for coating
Dimensional inspection	Every part	Against your drawing
Coating	Hot-dip, electroplated or zinc flake	Thickness measured and recorded
Packing	For sea freight	Packed to protect the coating

Inspection and documents

WITH EVERY ORDER

Check or document	Scope	Standard
Material certificate	Every order, traced to the heat	EN 10204 3.1. Chemistry of the heat, plus mill mechanical properties, or hardness where we heat treat
Dimensional report	100% of parts, against your drawing	Gauges and CMM
Coating thickness report	Every order	—
Salt spray test report	Every order, to your coating specification	ISO 9227, NSS or CASS

ON REQUEST

Ultrasonic and magnetic particle test	Forged parts	—
Tensile and impact test	External laboratory	Same heat and heat treatment batch
Third-party inspection	Agency appointed by you	Before the parts ship
Additional documents	As your OEM requires	—

New parts: first article approved by you before series production. The manufacturing plant is certified to ISO 9001, ISO 14001 and ISO 45001. Customer plant audits are welcome. We sign an NDA before you share drawings.

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ENQUIRIES
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