

# VG CLASSIC

## Frames & Parts

### Frame material & production specifications

VG Frame number: **100-36-011**  
Frame type: **Rigid Frame Knucklehead '36 25°**  
Approx maximum engine power: **65 HP**  
Approx maximum total weight: **480 kg**

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#### Material Specification

##### Tubing:

Material specification: **Seamless precision steel tubes E355 / 1.0580 ; oiled; DIN EN 10305-1:08.2016**

##### Tube diameters / wall thickness:

- Backbone: **1.5 inch / 3.2 mm**
- Down tubes: **1 inch / 3.2 mm**
- Seat post: **1.5 inch / 3.2 mm**
- Rear frame: **1 inch / 3.2 mm**

##### Material properties:

	1 inch	1.5 inch
Yield strength ReH (ISO 6892-1) MPa:	330 328	380/381
Tensile strength Rm (ISO 6892-1) MPa:	478/479	566/568
Elongation A (ISO 6892-1) %:	37.5/39.4	32/33

##### Castings:

Material Specification: **G16MnCr5**  
Casting method: **Investment casting**

Material Specification: **Ductile iron GG40**  
Casting method: **Sand casting**

##### Cast parts:

- Axle mounts
- Saddle cross member
- Lower front engine mount
- Engine Transmission mount
- Floorboard mounts
- Oil tank mount
- Sidecar mount (if applicable)

##### Cast parts:

- Steering head

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#### Production Specification

##### Welding method:

- Tubing / Investment cast iron parts: **TIG (filler used) / MIG (filler used) ISO14341-A**  
**Hard soldering (copper filler used) ISO17672-CU471**
- Ductile cast iron parts: **TIG (Nickel Filler Metal 61) ISO1071 SC NIFE 2**

Producer/welder: **VG Classic Frames & Parts**

Use of frame jig: **Yes**

Checked tolerances: **All sizes within +/- 1mm and +/- 0,2°**

Final check: **Herman Hulzebosch**

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#### Manufacturer

Producer: **VG Classic Frames & Parts**  
Address: **Transformatorhof 38-1, 7556 RA, Hengelo, The Netherlands**  
Contact: **Herman Hulzebosch**  
VAT number: **NL863414989B01**



### Dimensions

Length	1350 mm
Width	240 mm
Height	750 mm
Weight	34 kg

**Frame number is located at bottom of steering head**

### **WARNING!**

ANY CHANGES MADE TO THE FRAME WILL  
VOID THE WARRANTY!

**VG CLASSIC FRAMES & PARTS**

Underlying document for this certificate is TWS-5121.RAP d.d. May 1995