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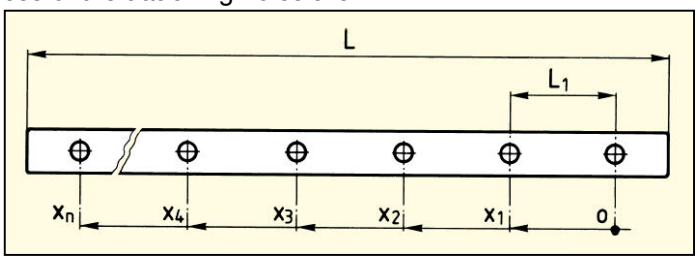
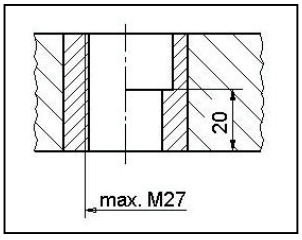
Special Components

Production specifications

material through-hardening inductive-hardening	 1.2842 (90MnCrV8) only on request
dimensions	• max. single-piece length: 1800mm • up to certain thickness resp. cross-section area: 2000mm ➔ if required please contact the product-line!
hardness through-hardening	 thickness ≤ 50mm: HRc 60±2
accuracy parallelism flatness rectangularity sides rectangularity front side	 2µm/m (Q2) 10µm/m 5µm/50mm 10µm/50mm
accuracy of butt-joint	2µm
grinding pattern peripheral cross hatch	surface quality R_a=0,3µm R_a=0,8µm
tolerance for attaching holes	due to the displacement of length caused by the through-hardening the position tolerances of the attaching holes are:  hole pitch L_1 ±0,3mm dimension $x_n \leq 350$ ±0,3mm dimension $x_n > 350$ ±0,8‰ of x_n
tolerance for rail lengths	length L ≤ 300 ±0,3mm length L > 300 ±1‰ of L Closer tolerances on request; as for single- and multi-piece rails.
locating hole	locating holes with closer position tolerance are possible; either predrilled in weak plugs or jig ground  threads up to M27 length of fitting max. 20mm
remark	in order to quote the correct and comparable product it is absolute necessary to specify the demands for surface quality, grinding pattern, runways, accuracy and application