

TOOLING APPLICATION GEOMETRICAL TOLERANCES - Part 1

STANDARD FORECREU BAR DIAMETER TOLERANCES

DECARBURIZATION

• Ground products are decarb-free. Black finish products tolerance and max decarburisation are indicated below :

Supply	Dimensions and tolerances		Max decarb.		Machining oversize on OD	
condition	mm in		mm in		mm in	
Ground OD	Ø2.2 to Ø30 ISO k9*	Ø0.0866 to Ø1.181 ISO k9*	none	none	-	-
	Ø4.4 / Ø17.5 -0.10 / +0.30	Ø0.173 / Ø0.689 -0.004 / +0.012	0.30	0.012	0.7	0.028
Black finish	Ø18 / Ø23.5 -0.15/+0.30	Ø0.551 / Ø0.925 -0.006 / +0.02	0.40	0.016	1.0	0.039
OD	Ø24 /Ø30 -0.20 / +0.60	Ø0.945 / Ø1.181 -0.008 / +0.024	0.40	0.016	1.5	0.059
	Ø31 / Ø60 -0.30 / +0.70	Ø1.26 / Ø2.52 -0.012 / +0.028	0.65	0.0256	2.0	0.079

* Central hole bars are supplied ground to ISO h9.

POSSIBLE SURFACE DEFECTS, CRACKS, ROPING EFFECT

Supply condition		OD	ID
	Ground condition	none	- no penetrative defects.
Black finish		≤ OD tolerance	(each batch is individually tested)

OVALIZATION : This defect is included in the OD tolerance

·Bar length :

1.8 to 3.9m5.9 to 12.8 ft

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