1. Materiał:
   - wykonanie podstawowe  
     C 45, St 52.3, 20 MnV6
   - hartowane indukcyjnie  
     C 45, 42 CrMo4
   - ulepszane cieplnie  
     42 CrMo4V
   - ze stali nierdzewnych  
     1,4301

2. Wykonanie:
   - powłoka chromu twardego:
     do Ø 20 - 15 μ
     powyżej Ø 20 - 20 μ
   - powłoka niklowa + chrom twardy:
     Ni = 30 μ
     Cr = 20 μ

3. Tolerancja wykonania - f 7
4. Klasa chropowatości - Rt max 2 μ
5. Długości produkcyjne - 1,5 — 8,0 m.
6. Tolerancja dla długości ciętych na wymiar:
   ⇒ L = do 500 mm - +2 / -0 mm
   ⇒ L = 500 do 3000 mm - +5 / -0 mm
   ⇒ L = 3000 i powyżej - +10 / -0 mm
7. Wykonanie wg indywidualnych rysunków: na zapytanie

Wykonanie podstawowe w gatunkach:
C 45 , St 52.3 , 20 MnV6

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Inne wymiary na zapytanie
Tłoczyska ulepszane cieplnie w gat. 42 CrMo4V

Rm = 750 ÷ 1300 N/mm²
HRc = 20,3 ÷ 40,8

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Inne wymiary na zapytanie
Tłoczyska ze stali szlachetnej w gat. 1.4301

Rm = 500 ÷ 700 N/mm²
HRB = 71,2 ÷ 89,5

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Inne wymiary na zapytanie
Tłoczyska indukcyjnie hartowane

w gat. **42 CrMo4**

Hartowane indukcyjnie na głębokość:

- Ø 16÷30 mm = 1,5 +/- 0,5 mm
- Ø 32÷60 mm = 1,7 +/- 0,5 mm
- Ø 65÷120 mm = 2,0 +/- 0,5 mm
- **HRC = 56÷60**

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Inne wymiary na zapytanie

Tłoczyska indukcyjnie hartowane

w gat. C45

Hartowane indukcyjnie na głębokość:

Ø 16÷30 mm = 1,5 +/- 0,5 mm
Ø 32÷60 mm = 1,7 +/- 0,5 mm
Ø 65÷120 mm = 2,0 +/- 0,5 mm

HRC = 56÷60

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Inne wymiary na zapytanie

Tłoczyska niklowane i chromowane
w gat. 20 MNV6

groźność warstwy niklowej = 30 μ  
groźność warstwy chromowej = 20 μ

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Inne wymiary na zapytanie
**RURY TŁOCZYSKOWE**

7. Materiał:
   - wykonanie podstawowe St 52.3

8. Wykonanie:
   - powłoka chromu twardego:
     - do Ø 20 - 15 μ
     - powyżej Ø 20 - 20 μ
   - otwór rury nieobrabiany wg DIN – 2391

9. Tolerancja wykonania - f 7
10. Klasa chropowatości - Rt max 2 μ
11. Długości produkcyjne - 1,5 — 8,0 m.
12. Tolerancja dla długości ciętych na wymiar:
   - L = do 500 mm - +2 / -0 mm
   - L = 500 do 3000 mm - +5 / -0 mm
   - L = 3000 i powyżej - +10 / -0 mm

7. Wykonanie wg indywidualnych rysunków: na zapytanie

**St 52**

**DIN 2391**

**tolerancja f 7**

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Inne wymiary na zapytanie