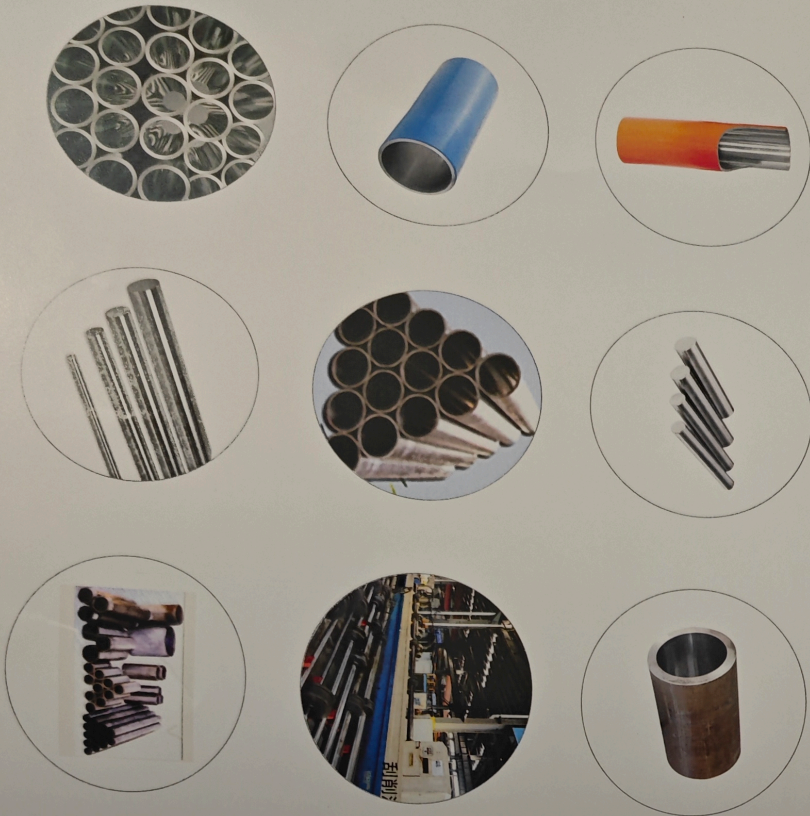


COLD-DRAWING TUBE
HONING TUBE
SKIVING TUBE
冷拔管 / 珩磨管 / 刮滚管



技术参数 Technical Parameters

工艺 Type	内径(mm) ID (mm)		长度(mm) Length (mm)		直线度 Straightness		公差 Tolerance		壁厚差 Wall margin		粗糙度 Roughness (um)	
	冷拔 Cold-drawn	30-250	≤10.5M	≤10.5M	0.3-1/1000mm	±5%	±5%	±5%	±5%	±5%	±5%	0.8-1.6
珩磨 Honed	30-250	≤6M	≤6M	0.3-1/1000mm	H8-H9	±5%	±5%	±5%	±5%	±5%	0.4-0.8	
刮滚 skiving	60-200	≤8M	≤8M	0.3-1/1000mm	H8	±5%	±5%	±5%	±5%	±5%	0.2	

冷拔力学性能 Mechanical Property

交货状态 Supply state Material	冷拔 Cold-drawn			冷拔+去应力退火 Cold-drawn and anneal				
	抗拉强度 (σ _b /N/mm ²) T. S _b (N/mm ²)	伸长率 (δ5%) Elongation (δ5%)	屈服强度 (σ _s /N/mm ²) Y. S _s (N/mm ²)	抗拉强度 (σ _b /N/mm ²) T. S _b (N/mm ²)	屈服强度 (σ _s /N/mm ²) Y. S _s (N/mm ²)	伸长率 (δ5%) Elongation (δ5%)	硬度 (HB) Hardness (HB)	
20#	≥550	≥5	≥510	≥510	≥470	≥12	≥175	
45#	≥650	≥4	≥600	≥600	≥520	≥12	≥207	
16Mn	≥640	≥10	≥600	≥600	≥520	≥15	≥190	
25Mn	≥640	≥10	≥600	≥600	≥510	≥15	≥195	
27SiMn	≥840	≥7.5	≥800	≥800	≥720	≥10	≥195	

珩磨/刮滚技术参数 Technical Parameters

内径尺寸 Inner diameter dimension	内径偏差 Inner diameter deviation				
	H7	H8	H9	H10	H11
30	+0.0210	+0.0330	+0.0520	+0.0840	+0.1300
>30-50	+0.0250	+0.0390	+0.0620	+0.1000	+0.1600
>50-80	+0.030	+0.0460	+0.0740	+0.1200	+0.1900
>80-120	+0.0350	+0.0540	+0.1000	+0.1400	+0.2200
>120-180	+0.040	+0.0630	+0.1150	+0.1600	+0.2500
>180-250	+0.0460	+0.0720	+0.1300	+0.1850	+0.2900
>250-315	+0.0250	+0.0810	+0.1400	+0.2100	+0.3200
>315-400	+0.0570	+0.0890	+0.1400	+0.2300	+0.3600