Honed Tube

Product Introduction

WUXI EAST AI MACHINERY TECHNOLOGY CO., LTD

HONED TUBE

HYDRAULIC CYLINDER TUBE

SIZE

Cylinder tube ID: Φ10-1500mm Thickness:≥5mm

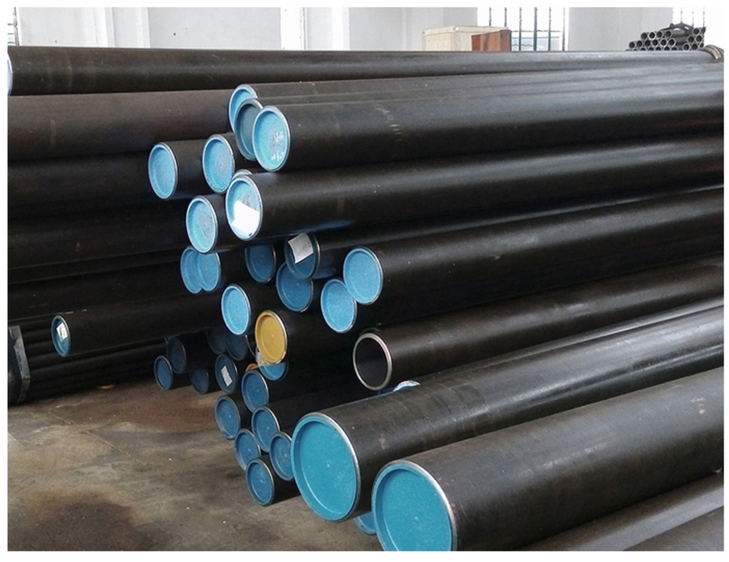
MATERIAL

ST52,E355,STKM13C,A106Gr.B, Q355B,Q355D
CK45,SAE1045,S45C,CK20,SAE1026,4140,25Mn
27SiMn,Stainless steel304/316/2205,etc.

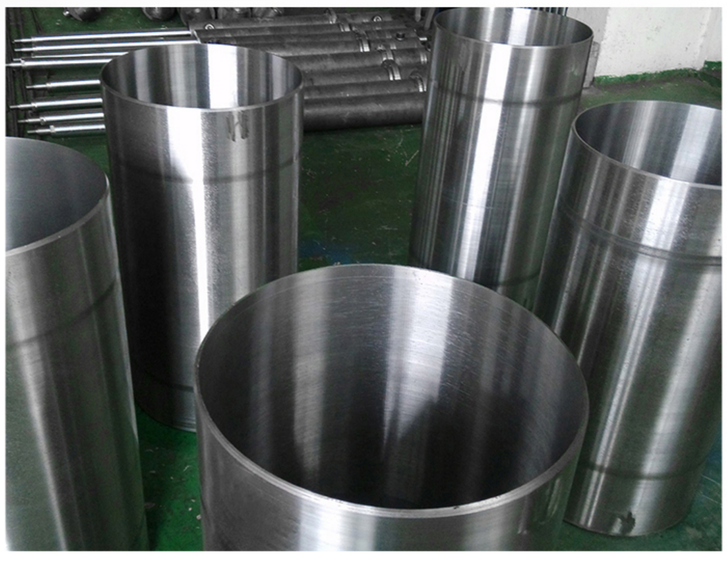
STANDARD

DIN2391 ST52 BK+S,EN10305 E355+SR,ASTM A519
JIS G3445,GB/T 3639



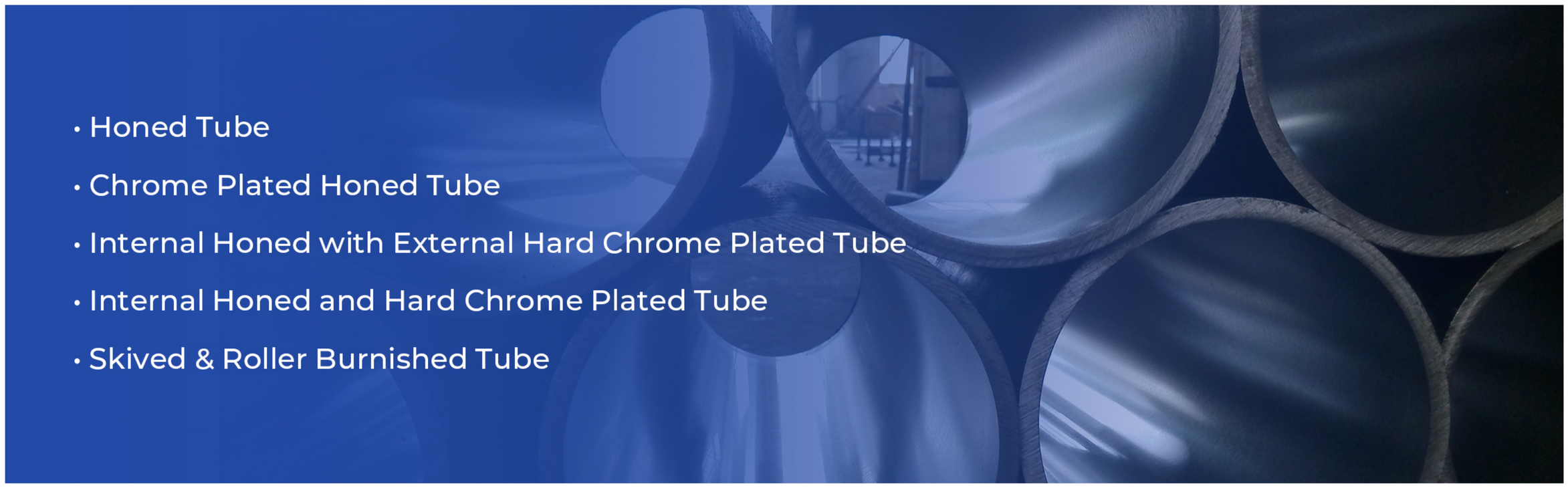






SIZE SPECIFICATIONS

Working Method	Tube ID(mm)	Length(m)	Straightness(mm/m)	Tolerance on ID	Tolerance on WT
cold-drawing	40-400	≤12m	0.2-0.5		±5%
cold rolling	40-150	≤12m	0.2-0.5		±5%
cold-drawing honing	40-400	≤8m	0.2-0.3	H8-H9	±5%
cold-drawing SRB	50-300	≤8m	0.2-0.3	H8-H9	±5%
Deep hole boring honing	250-400	≤8m	0.2-0.3	H8-H9	±8%
Deep hole boring SRB	250-400	≤8m	0.2-0.3	H8-H9	±8%



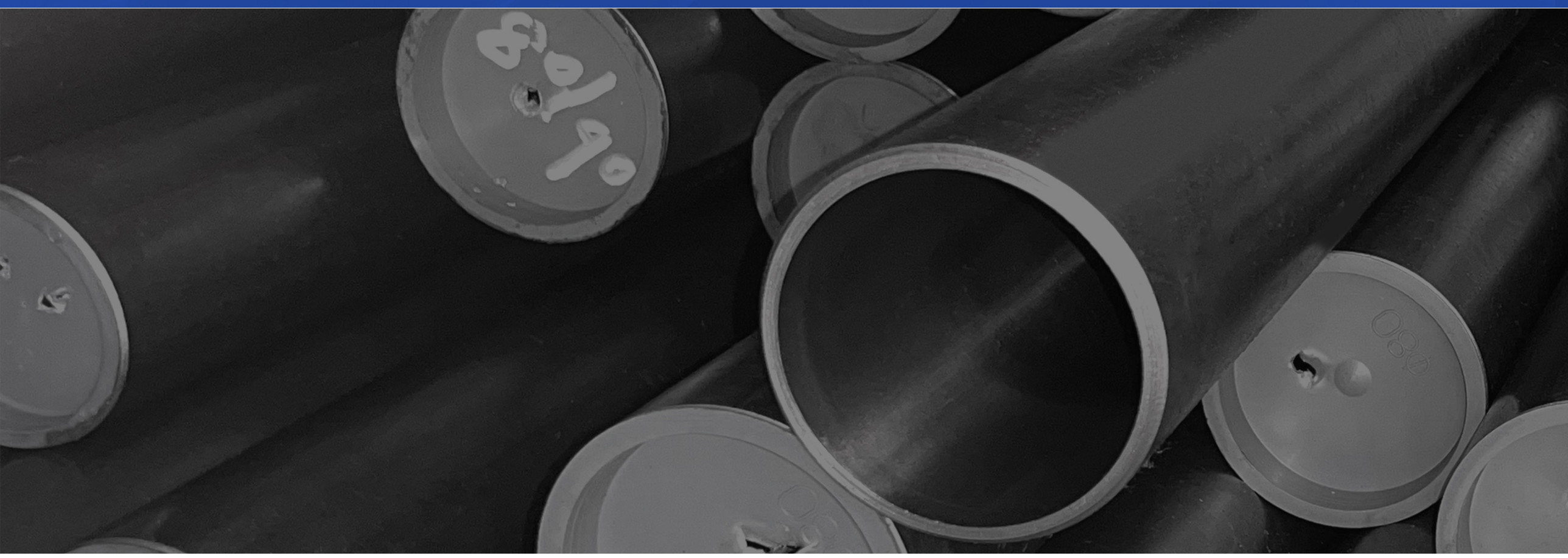
- Honed Tube
- Chrome Plated Honed Tube
- Internal Honed with External Hard Chrome Plated Tube
- Internal Honed and Hard Chrome Plated Tube
- Skived & Roller Burnished Tube

CHEMICAL COMPOSITION

STEEL GRADE	C	Si	Mn	P	S	Cr	Ni	Cu	V	Al
E355(ST52)	≤0.22	≤0.55	≤1.60	0.025	0.025	0.250	0.250	/	/	/
20	0.17-0.23	0.17-0.37	0.35-0.65	≤0.035	≤0.035	≤0.25	≤0.30	≤0.25	/	/
45	0.42-0.50	0.17-0.37	0.50-0.80	≤0.035	≤0.035	≤0.25	≤0.30	≤0.25	/	/
Q355B	≤0.2	≤0.5	≤1.7	≤0.035	≤0.035	≤0.30	≤0.50	≤0.30	/	/
Q355D	≤0.18	≤0.5	≤1.7	≤0.030	≤0.025	≤0.30	≤0.50	≤0.30	≤0.15	≥0.015
Q355E	0.12-0.18	0.2-0.5	1.2-1.7	≤0.025	≤0.025	≤0.30	≤0.50	≤0.20	0.04-0.15	≥0.02
25Mn	0.24-0.32	1.1-1.4	1.1-1.4	≤0.035	≤0.035	≤0.30	≤0.30	≤0.20	/	/
27SiMn	0.22-0.29	0.17-0.37	0.7-1	≤0.035	≤0.035	≤0.25	≤0.30	≤0.25	/	/
1026	0.22-0.28	0.15-0.36	0.6-0.9	≤0.040	≤0.050	≤0.20	≤0.30	≤0.35	/	/
4130	0.28-0.33	0.15-0.35	0.40-0.60	0.040	0.040	0.80-1.10	/	/	/	/
4140	0.36-0.43	0.15-0.35	0.75-1.00	0.040	0.040	0.80-1.10	/	/	/	/

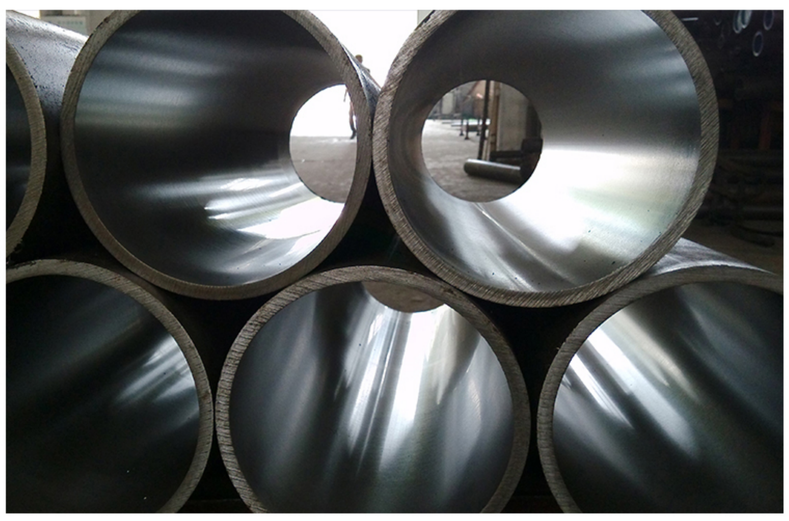
MECHANCIAL PROPERTY

STEEL GRAD	COLD FINISHED(HRAD)(BK)		COLD DRAWN AND STRESS-RELIEVED(BK+S)				
	T.S bN/mm2	Elongation 5%	T.S bN/mm2	Y.S bN/mm2	Elongation 5%	Hardness HB	impact value (-20 C)J
E355(ST52)	≥640	≥5	≥600	≥520	≥14	/	/
20	≥550	≥8	≥520	≥400	≥15	170	/
45	≥680	≥5	≥630	≥520	≥12	190	/
Q355B	≥660	≥8	≥620	≥520	≥15	190	/
Q355D	≥660	≥8	≥620	≥520	≥15	190	≥27
Q355E	≥660	≥8	≥620	≥520	≥15	≥190	≥27
25Mn	≥640	≥8	≥620	≥510	≥15	190	/
27SiMn	≥780	≥5	≥700	≥580	≥10	220	/
1026	≥640	≥8	≥620	≥510	≥15	≥190	/



We are reliable.

Raw material is mainly from some famous refinery steel mills, such as BAO STEEL,Tianjin,and Chengdu etc, which are the best and largest raw material manufacturers in China.
We have experienced technicians and skilled workers and provide you with high quality and efficient products.
We have advanced equipments: cold drawing machine,honing machine, skiving & roller burnishing machine, centerless grinding machine,straightening machine, polishing machine,etc. Delivery on time and best after-sale service.



TOLERANCE

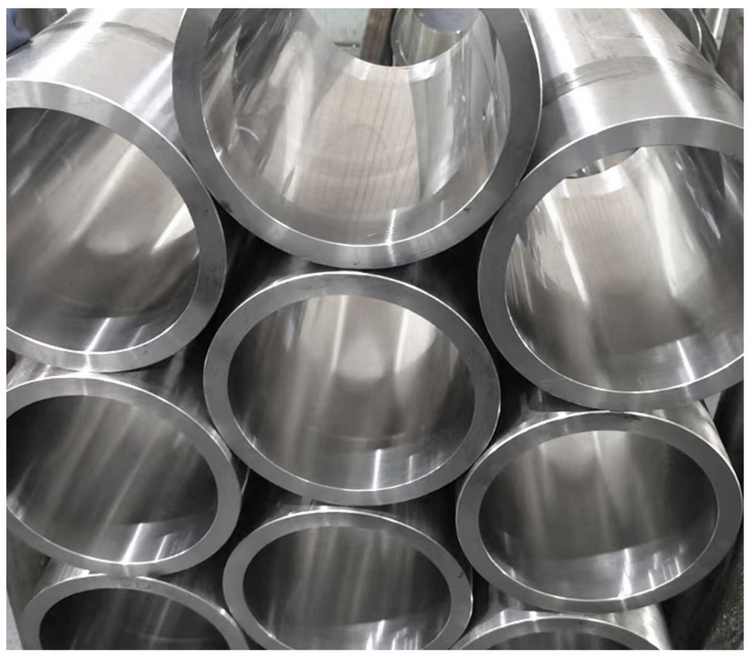
Tolerance	I.D Tolerance			Tolerance of wall thickness	
Size of I.D	H8	H9	H10		
30	0.033	0.052	0.084		
>30-50	0.039	0.062	0.1		
>50-80	0.046	0.074	0.12		
>80-120	0.054	0.087	0.14	<120mm(O.D)	±5%
>120-180	0.063	0.1	0.16	≥120mm up to 210mm	±7.5%
>180-250	0.072	0.115	0.185	>210mm	±10%
>250-315	0.081	0.13	0.21		
>315-400	0.089	0.14	0.23		

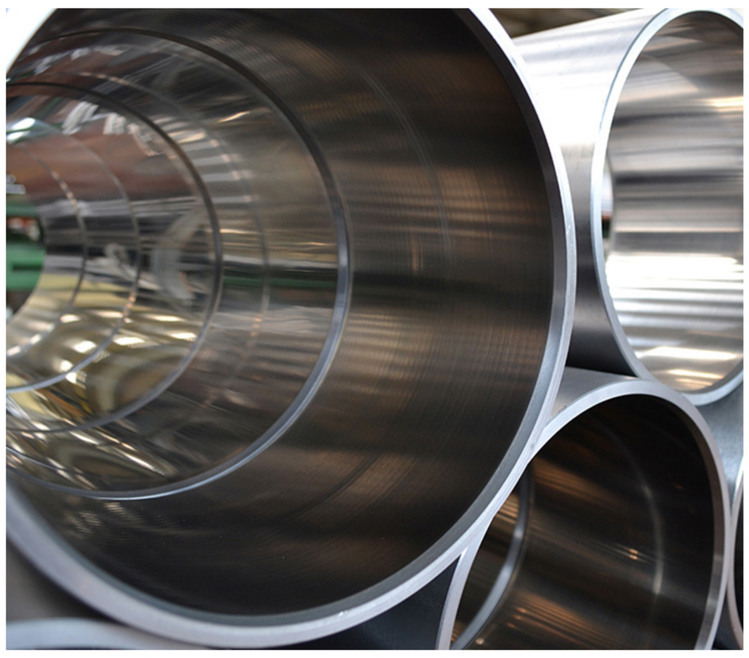
PROCESSING FORM

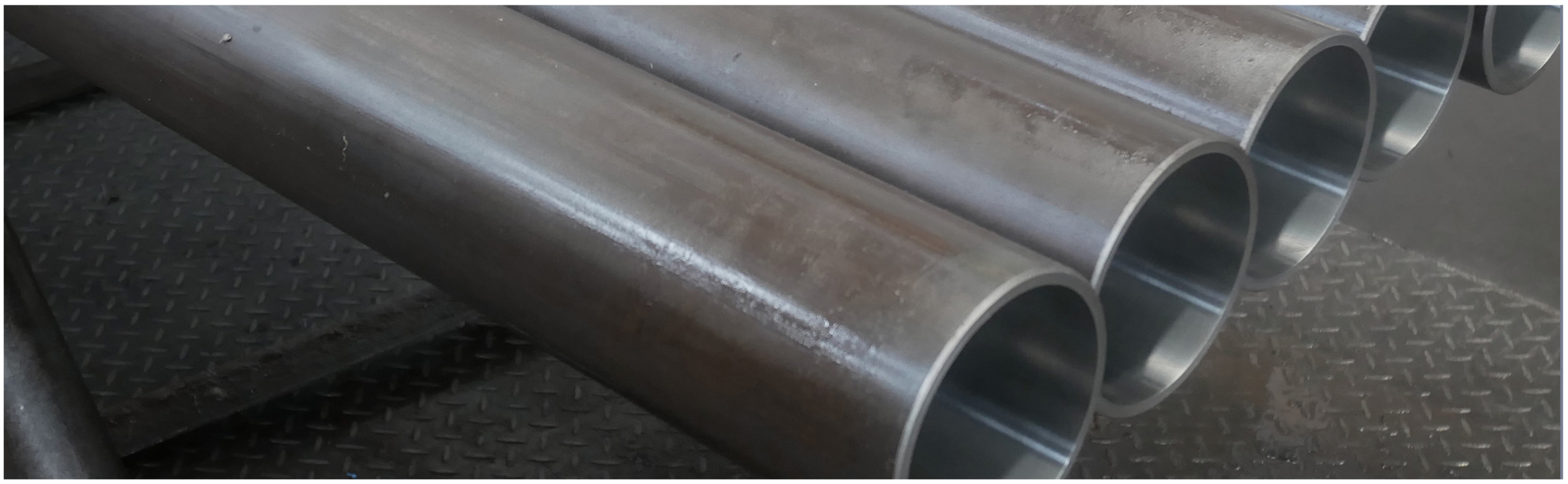
Processing form	I.D mm	length	Straightness	I.D tolerance	I.D Roughness (RA)
Honed	40-500	≤12M	0.5-1/1000	H8-H9	0.4-0.8μm
SRB	50-250	≤13M		H8	0.1-0.4μm





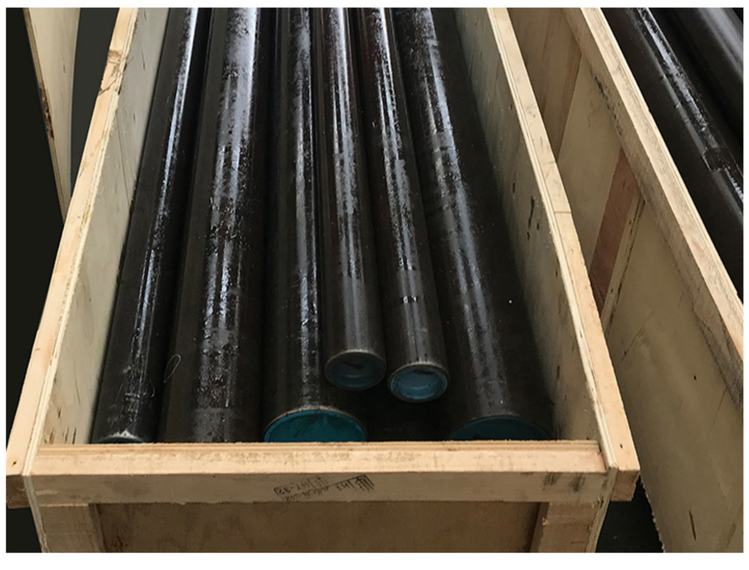












SIZE RANGE

ID(mm)	OD(mm)	WT(mm)	ID(mm)	OD(mm)	WT(mm)	ID(mm)	OD(mm)	WT(mm)
40	50	5	90	100	5	140	156	8
40	52	6	90	105	7.5	140	160	10
40	55	7.5	90	110	10	140	165	12.5
40	58	9	90	114	12	140	168	14
50	60	5	95	105	5	140	170	15
50	65	7.5	95	110	7.5	140	180	20
50	70	10	100	110	5	150	170	10
60	70	5	100	115	7.5	150	175	12.5
60	72	6	100	120	10	150	180	15
60	75	7.5	100	125	12.5	160	180	10
60	80	10	100	127	13.5	160	185	12.5
63	73	5	100	130	15	160	190	15
63	75	6	110	125	7.5	160	200	20
63	76	6.5	110	130	10	170	190	10
63	78	7.5	110	140	15	170	195	12.5
63	80	8.5	115	130	7.5	170	200	15
63	83	10	115	135	10	180	200	10
70	80	5	120	135	7.5	180	205	12.5
70	82	6	120	140	10	180	210	15
70	85	7.5	120	145	12.5	180	220	20
70	90	10	120	150	15	200	220	10
75	85	5	125	140	7.5	200	225	12.5
75	90	7.5	125	145	10	200	230	15
75	95	10	125	150	12.5	200	235	17.5
80	90	5	125	152	13.5	200	245	22.5
80	92	6	125	155	15	220	250	15
80	95	7.5	125	160	17.5	220	270	25
80	100	10	130	145	7.5	220	273	26.5
80	102	11	130	150	10	240	270	15
80	105	12.5	130	160	15	250	290	20
80	110	15	135	160	12.5	250	299	24.5

IMPERIAL SIZE HONED TUBE
(OTHER SIZES UPON REQUEST)

ID(mm)	OD(mm)	WT(mm)	ID(mm)	OD(mm)	WT(mm)	ID(mm)	OD(mm)	WT(mm)
63.5	76.2	6.35	88.9	101.6	6.35	114.3	127	6.35
63.5	82.55	9.525	88.9	107.95	9.525	114.3	139.7	12.7
76.2	88.9	6.35	101.6	114.3	6.35	127	139.7	6.35
76.2	95.25	9.525	101.6	120.65	9.525	127	152.4	12.7