Chrome

Product Introduction Rod

WUXI EAST AI MACHINERY TECHNOLOGY CO., LTD

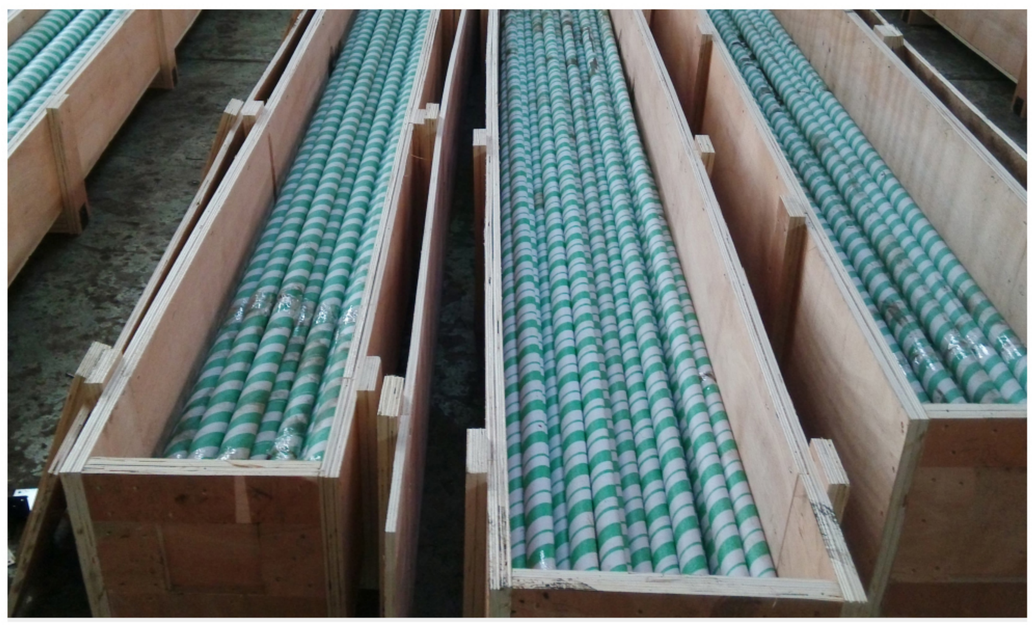
Diameter		Kg/m
mm	inch	
6		0.22
6.35	1/4"	0.25
8		0.39
9.525	3/8"	0.56
10		0.62
12		0.89
12.7	1/2"	1
13		1.04
14		1.21
15		1.39
15.88	5/8"	1.56
16		1.58
18		2
19.05	3/4"	2.24
20		2.47
22		2.99
22.225	7/8"	3.05
24		3.55
25		3.86
25.4	1"	3.98
28		4.84
28.575	1.1/8"	5.04
30		5.55
31.75	1.1/4"	6.22

Diameter		Kg/m
mm	inch	
32		6.32
34.525	1.3/8"	7.35
35		7.56
36		8
38		8.91
38.1	1.1/2"	8.96
40		9.87
42		10.88
44.45	1.3/4"	12.19
45		12.49
50		15.43
50.8	2"	15.92
55		18.66
56		19.35
57.15	2.1/4"	20.15
60		22.21
63		24.49
63.5	2.1/2"	24.88
65		26.07
69.85	2.3/4"	30.1
70		30.23
75		34.71
76.2	3"	35.83
80		39.49

Diameter		Kg/m
mm	inch	
82.55	3.1/4"	42.05
85		44.58
88.9	3.1/2"	48.76
90		49.98
95		55.68
100		61.70
101.6	4"	63.69
105		68.02
110		74.66
115		81.60
120		88.85
125		96.41
127	5"	99.52
130		104.27
140		120.93
150		138.83
152.4	6"	143.3
160		157.95
170		178.31
177.8	7"	195.05
180		199.91
190		222.74
200		246.8
203.2	8"	254.76

Product Introduction





Piston Rod Dimensions

Rod Specification

1.Material:CK45,SAE1045,JIC45C,ST52,4140,4340,42CrMo,40Cr,20MnV6, SS430,SS431,Stainless Steel304/316/2205,etc.
2.Diameter: Φ 6-500mm
3.Length: max 15m
4.Chrome thickness: 20-100μm
5.Hardness of the chrome layer: 850HV
6.Roughness: Ra ≤0.2u
7.Straightness:≤ 0.2/1000 mm
8.Diameter Tolerance: f7/f8/g6,etc
9.Surface plating:chrome plating/nickel plating/ceramic plating
10.Roundness: the deviation of roundness is 50% of the diameter tolerance at the most
11.Packing: Anti rust oil to be spread on rod surface and each rod to be packed in paper roll and then in wooden case,can be customised according to customer requirements

ISO f7			
OD(mm)		Tolerance(mm)	
<	≤	≤	≤
6	10	-0.013	-0.028
10	18	-0.016	-0.034
18	30	-0.02	-0.041
30	50	-0.025	-0.05
50	80	-0.03	-0.06
80	120	-0.036	-0.071

CHEMICAL COMPOSITION

MATERIAL	C%	Mn%	Si%	S%	P%	V%	Ni	Cr%	Mo	Cu
CK45	0.42-0.5	0.5-0.8	0.17-0.37	≤0.035	≤0.035		≤0.25	≤0.25		≤0.25
ST52	≤0.22	≤1.6	≤0.55	≤0.04	≤0.04	0.02-0.15				
20MnV6	0.17-0.24	1.3-1.7	0.1-0.5	≤0.035	≤0.035	0.1-0.2	≤0.30	≤0.30		≤0.30
42CrMo	0.38-0.45	0.5-0.8	0.17-0.37	≤0.035	≤0.035	0.07-0.12	≤0.03	0.9-1.2	0.15-0.25	≤0.03
40Cr	0.37-0.45	0.5-0.8	0.17-0.37	≤0.035	≤0.035		≤0.3	0.8-1.1		≤0.03

MECHANICAL PROPERTIES

MATERIAL	T.S(Mpa)	Y.S(Mpa)	A%	CHARPY	CONDITION
CK45	610	355	15	>41J	NORMALIZED(HRC 15-22)
CK45	610	355	15	>41J	Induction and Hardened (HRC 50-62)
CK45	800	540	20	>41J	Quenched and Tempered (HRC 25-32)
ST52	500	355	22		NORMALIZED
20MnV6	750	590	12	>40J	NORMALIZED
42CrMo4	980	850	14	>47J	Q+T
40Cr	1000	800	10		Q+T



Hydraulic Piston Rod





Cr-plating Piston Rod





Hollow-Rod

specification lenght

Φ6~Φ20mm 1000mm~6000mm

Φ20~Φ300mm 6000mm~7500mm

Pipe Rod(Hollow Pistion Rod)

Pemarx

External Diameter Accuracy:f7

Surface Roughness:≤0.2μm

Surface Hardness:850HV

Standard Length:1m~8m

Hard Chrome Thickness:20-100 micron