

TECHNICAL SHEET



GROUND BARS

Definition

Peeled and polished bars or rough ground bars are bright bars used for cold machining with a further mechanical polishing. All these mechanical workings guarantee the absence of surface defects.

Diameters and Size Tolerances

<i>Diameter</i>	<i>Tolerance *</i>	<i>Ovalization</i>
3 - 140	h 9	½ of tolerance
3 - 140	h 8 – h 7	½ of tolerance
6 – 101,60	h 6	½ of tolerance

* If required other tolerances, J and K in the field 6 – 9, are available

Lengths and Tolerances

<i>Diameter **</i>	<i>Length ***</i>	<i>Tolerance STD</i>	<i>Tolerance Extra STD</i>	<i>Short bars</i>
3 – 25,40	3 m	+50 - 0	+ 25 - 0	0
3 - 140	3-4-6 m	+200 -0	+ 50 - 0	0
68 - 140	3-4-6 m	+500 - 0	+ 100 - 0	0

** Progression diameter STD from 20 to 70, 1mm. From 71 to 100, 5 mm.
Diameter in inch STD

*** If required, other fixed lengths are possible.

Other characteristics

<i>Diameters</i>	<i>Tolerance</i>	<i>Roughness</i>	<i>Straightness</i>	<i>Bar's end *****</i>
3-140	h 9	1,2 Ra	0,5 ‰	1 cold heading 1 Chamfering 45°
3-140	h 7 – h 8	0,7 Ra	0,5 ‰	1 cold heading 1 Chamfering 45°
6-101,60	h 6	0,5 Ra	0,25 ‰	1 cold heading 1 Chamfering 45°

***** Possible 2 ends chamfered 45°e/o for diam. from 6 to 25,40 1 chamfer 45° + 1 chamfer 30°.

SAP Identification

01RETtondi – toll h 6/7/8/9 – stato sup.1

Packaging

Bundles weight: from Diam. 3 – 25,4 kg 250min; diam. 26 – 68 kg 500min; > kg 1000

Package. Bundle wrapped in plastified cardboard with plastic rings on bars + containing end caps , identification label. Cod. ES2

Other packages. 1° As above ES2 + wooden boxes. Cod. ES3

2° each bars protected by paper and placet in wooden boxes. Cod. ES5