

TECHNICAL SPECIFICATIONS AND TOLERANCES

TOLERANCES

OUTSIDE DIAMETER: tolerance f7 according to EN ISO 286-2, see following dimensional table. Upon request it is possible to supply chromed tubes with outside diameter according to tolerance h7 EN ISO 286-2.

INSIDE DIAMETER: according to EN 10305-1.

WALL THICKNESS: $\pm 10\%$ with a minimum of ± 0.1 mm.

ECCENTRICITY: $\frac{\text{W.T. max.} - \text{W.T. min.}}{\text{W.T. max.} + \text{W.T. min.}} \times 100 \leq 10\%$

STRAIGHTNESS: maximum deviation 0.3 mm/m on the total length of the tube.

TECHNICAL SPECIFICATION

THICKNESS OF THE CHROMIUM LAYER: for tubes with outside diameter from 8 to 18 mm, $20 \pm 5 \mu\text{m}$
for tubes with outside diameter from 20 to 120 mm, $25 \pm 5 \mu\text{m}$
The coating is always Hexavalent Chromium free (CrVI free).

SURFACE MICROHARDNESS: 1000 ± 100 Vickers

SURFACE ROUGHNESS: $Ra 0,15 \pm 0,05 \mu\text{m}$

RESISTANCE TO CORROSION: 96 h rating 9 according to ISO 9227 (tested by salt spray).

Nominal Value (mm)	Outside diameter		Wall thickness (mm)					
	Tolerance f7 (mm)	Tolerance h7 (mm)	3.0	4.0	5.0	7.5	10.0	
			Mass (Kg/m)					
18	-0.016 / -0.034	+0 / -0.018	1.11					
20	-0.020 / -0.041	+0 / -0.021	1.26	1.58				
22			1.40	1.78				
25			1.63	2.47				
30			2.00	2.56	3.08	4.16		
35	-0.025 / -0.050	+0 / -0.025	2.37	3.06	3.70	4.09		
40					4.32	6.01	7.40	
45					4.93	6.94	8.63	
50						5.55	7.86	9.86
55						6.16	8.79	11.10
60	-0.030 / -0.060	+0 / -0.030			6.78	9.71	12.33	
65					7.40	10.64	13.56	
70						8.01	11.56	14.80
75						8.50	12.48	16.03
80						9.25	13.41	17.26
85						9.86	14.33	18.50
90	-0.036 / -0.071	+0 / -0.036			10.48	15.26	19.73	
100					11.71	17.11	22.20	
110					12.95	18.96	24.66	
120					14.18	20.81	27.13	