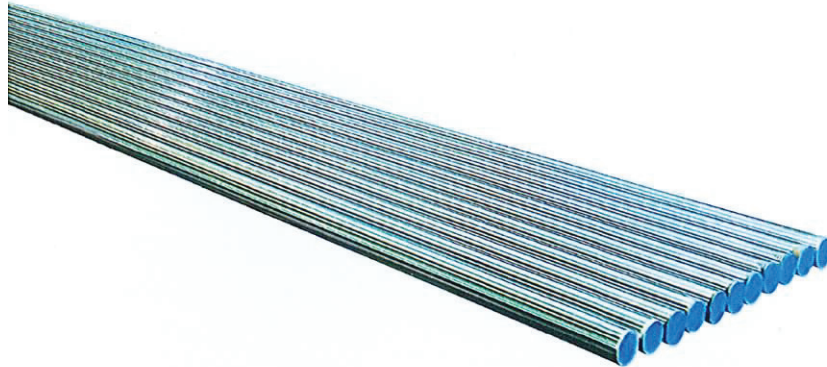


Hard Chromium Piston Rods



REMARK

- External Diameter Accuracy :** f8
- Surface Roughness :** Ra0.2 μ m ~ Ra0.4 μ m
- Hard Chrome Thickness :** 20Micron \pm 10%
- Surface Hardness :** HV 850 (Minimum) up
- Straightness :** 0.15-0.2/1000mm
- Roundness :** Tolerance x1/3
- Standard Length :** 3M ~ 6Mup
- Standard Size :** 6 Φ ~ 255 Φ
- Material :** JIS S45C, SAE1045, DIN CK45,
(As :SCM440,SAE4140,DIN 17204)
- special specifications & materials can be made customer request and the surface do the Quenched & Tempered or do the Induction.

Dia mm Φ						
6	19	32	50.8	76.2	112	160
8	19.05	35	55	80	114.3	165.1
10	20	35.5	56	82.55	115	170
12	22	36	57.15	85	120	177.8
12.5	22.4	38	60	88.9	125	180
12.7	25	38.1	63	90	127	190
14	25.4	40	63.5	95	130	200
15	28	42	65	100	135	210
15.87	28.56	44.45	67	101.6	140	220
16	30	47.62	70	105	145	230
17	31.5	45	71	107.95	150	240
18	31.75	50	75	110	152.4	250
						255

Chemical Composition & Mechanical Property

Spec.		CHEMICAL ANALYSIS%						FORGING TEMPERATURE	INDUCTION				MACHINE FUNCTION					Application
JIS	DIN	C	Si	Mn	P	S	$^{\circ}$ C	Normalizing $^{\circ}$ C	Annealing $^{\circ}$ C	Quenching $^{\circ}$ C	Tempering $^{\circ}$ C	(Y.P) Kg/mm 2	(T.S) Kg/mm 2	(EL) %	Twist %	Hardness HB		
S45C	CK45	0.42 0.48	0.15 0.35	0.60 0.90	<0.030	<0.035	0.30 0.90 Slow Cooling	820-870 Water Cooling	—	—	—	>35	>58	>20	—	167-229	Bend axle	
								—	810 Furnace Cooling	—	—	—	—	—	—	137-170		
								—	—	820-870 Water Cooling	550-650 Quenching	>50	>70	>17	>45	204-269	Axles	

Spec.	Chemical Composition(%)								Equivalent
	C	Si	Mn	P	S	Ni	Cr	Mo	AISI No.
SCM440	0.38-0.43	0.15-0.35	0.60-0.85	\leq 0.030	\leq 0.030	—	0.90-1.20	0.15-0.30	4140