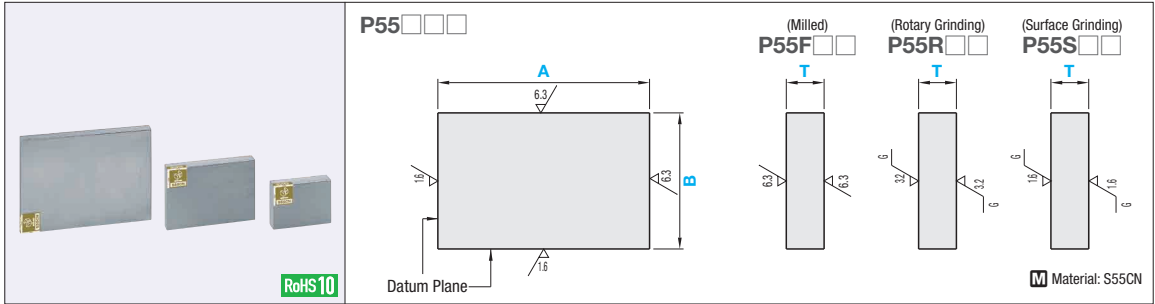


Configurable Plates - S55CN



Type	Upper-Lower Surface Finish	① Plate Thickness Tolerance	② A, B Dimension Tolerance	0.5mm Increment		
				A	B	T
P55	F (Milled) R (Rotary Grinding) S (Surface Grinding)	P Q N M	P Q N M	A ≥ B		8~30
				20~500	20~300	

① Plate Thickness Tolerance

Upper-Lower Surface Finish	P	Q	N	M
F (Milled)	+0.1~+0.3	0~+0.2	±0.1	-0.2~0
R (Rotary Grinding)	+0.1~+0.3	0~+0.2	±0.1	-0.2~0
S (Surface Grinding)	+0.1~+0.2	0~+0.1	±0.05	-0.1~0

② A, B Dimension Tolerance

Upper-Lower Surface Finish	A, B Dimension	P	Q	N	M
F (Milled) R (Rotary Grinding) S (Surface Grinding)	250mm or Less	+0.1~+0.3	0~+0.2	±0.1	-0.2~0
	250.5mm or More	+0.1~+0.6	0~+0.5	±0.25	-0.5~0

Precision Standards

(Max. Value)

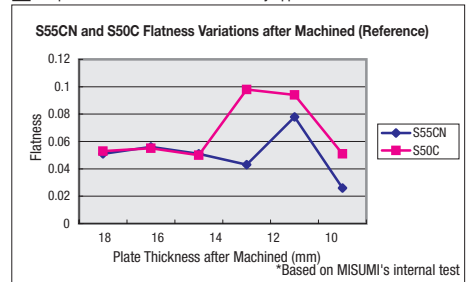
Item	Upper-Lower Surface Finish		
	F (Milled)	R (Rotary Grinding)	S (Surface Grinding)
Thickness Parallelism (per 100mm)	0.05	0.012	0.012
Flatness (per 100mm)	T8~15.5	0.07	0.03
	T16~25.5	0.05	0.015
	T26~30	0.05	0.012
Perpendicularity of Datum Plane	0.015 per 100mm		
Circumference Chamfering	C0.2~C0.5		



Alterations Part Number - A - B - T - (CSC, CBC, CCA...etc.)
P55RNM - 300 - 280 - 20 - CBC

Alterations	Circumference Chamfering		Corner Cut
Code	CSC	CBC	CCA, CCB, CCC, CCD
Spec.	Reduce the circumference chamfering dimension. Standard C0.2 ~ C0.5 → C0.1 or Less	Increase the circumference chamfering dimension. Standard C0.2 ~ C0.5 → C0.5~C1.0	Cuts any corners. 1 ≤ Corner Cut ≤ 50 1mm Increment 11~20 21~30 31~40 41~50 Ordering Code (Ex.)When the corners of A and D are cut by C5, → CCA5-CCD5

Comparison of Flatness Variation Caused by Upper-Lower Surface Milled Cutter



[Testing Method] S55CN and S50C (205x205x19mm) are placed on the same table, and machined with a milled path of 2mm at the same time. Each of the flatness is then measured with a three-dimensional measuring instrument.

Although it is assumed that S55C has higher internal stress than S50C, the test results show that normalized S55C or S55CN has as low internal stress as S50C.