

Honed Tube

**Product
Introduction**

WUXI EAST AI MACHINERY
TECHNOLOGY CO., LTD



HONED TUBE

HYDRAULIC CYLINDER TUBE

SIZE

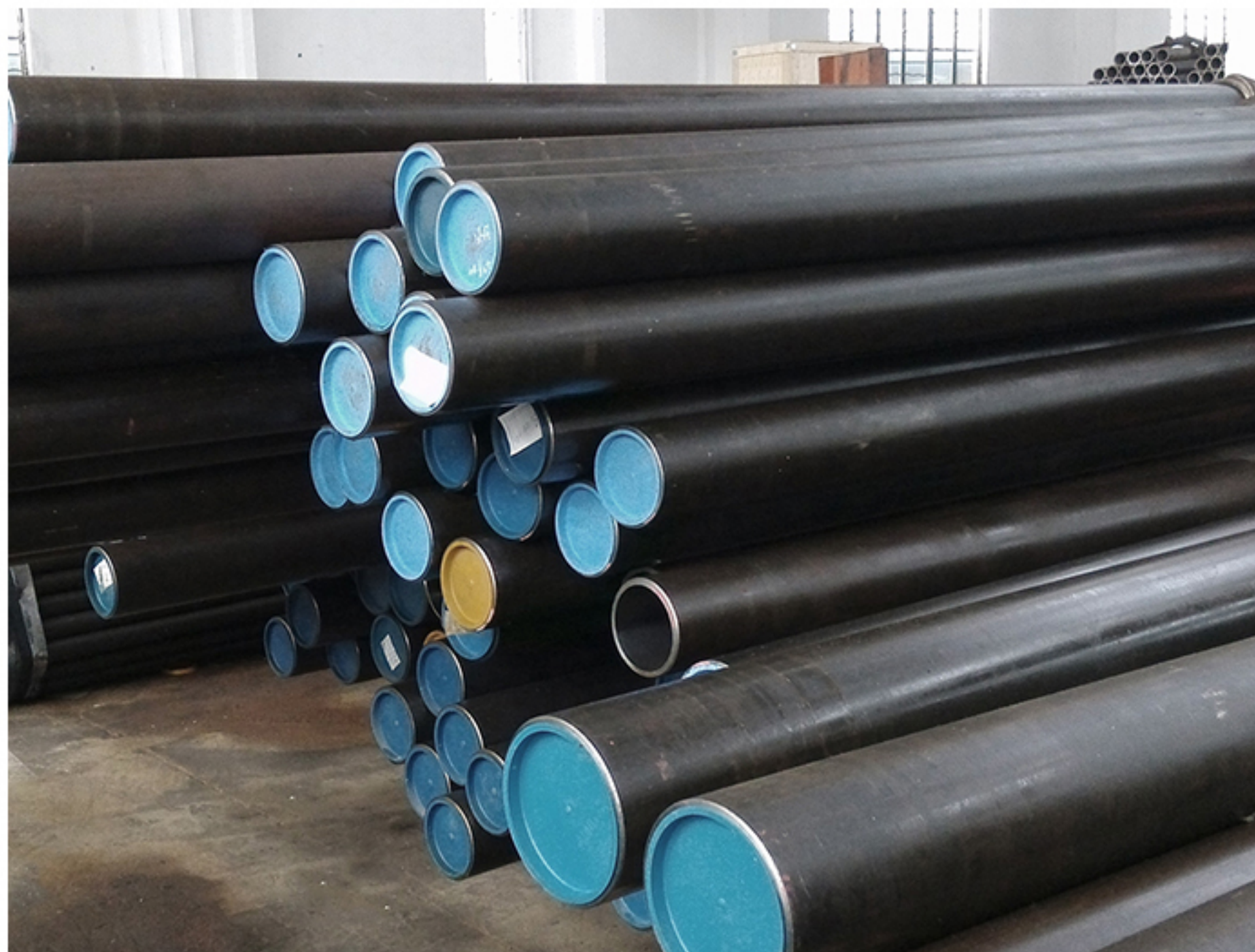
Cylinder tube ID: Φ 10-1500mm Thickness: $\geq$ 5mm

MATERIAL

ST52,E355,STKM13C,A106Gr.B, Q355B,Q355D
CK45,SAE1045,S45C,CK20,SAE1026,4140,25Mn
27SiMn,Stainless steel304/316/2205,etc.

STANDARD

DIN2391 ST52 BK+S,EN10305 E355+SR,ASTM A519
JIS G3445,GB/T 3639



SIZE SPECIFICATIONS

Working Method	Tube ID(mm)	Length(m)	Straightness(mm/m)	Tolerance on ID	Tolerance on WT
cold-drawing	40-400	$\leq$ 12m	0.2-0.5		$\pm$ 5%
cold rolling	40-150	$\leq$ 12m	0.2-0.5		$\pm$ 5%
cold-drawing honing	40-400	$\leq$ 8m	0.2-0.3	H8-H9	$\pm$ 5%
cold-drawing SRB	50-300	$\leq$ 8m	0.2-0.3	H8-H9	$\pm$ 5%
Deep hole boring honing	250-400	$\leq$ 8m	0.2-0.3	H8-H9	$\pm$ 8%
Deep hole boring SRB	250-400	$\leq$ 8m	0.2-0.3	H8-H9	$\pm$ 8%

- Honed Tube
- Chrome Plated Honed Tube
- Internal Honed with External Hard Chrome Plated Tube
- Internal Honed and Hard Chrome Plated Tube
- Skived & Roller Burnished Tube

CHEMICAL COMPOSITION

STEEL GRADE	C	Si	Mn	P	S	Cr	Ni	Cu	V	Al
E355(ST52)	≤0.22	≤0.55	≤1.60	0.025	0.025	0.250	0.250	/	/	/
20	0.17-0.23	0.17-0.37	0.35-0.65	≤0.035	≤0.035	≤0.25	≤0.30	≤0.25	/	/
45	0.42-0.50	0.17-0.37	0.50-0.80	≤0.035	≤0.035	≤0.25	≤0.30	≤0.25	/	/
Q355B	≤0.2	≤0.5	≤1.7	≤0.035	≤0.035	≤0.30	≤0.50	≤0.30	/	/
Q355D	≤0.18	≤0.5	≤1.7	≤0.030	≤0.025	≤0.30	≤0.50	≤0.30	≤0.15	≥0.015
Q355E	0.12-0.18	0.2-0.5	1.2-1.7	≤0.025	≤0.025	≤0.30	≤0.50	≤0.20	0.04-0.15	≥0.02
25Mn	0.24-0.32	1.1-1.4	1.1-1.4	≤0.035	≤0.035	≤0.30	≤0.30	≤0.20	/	/
27SiMn	0.22-0.29	0.17-0.37	0.7-1	≤0.035	≤0.035	≤0.25	≤0.30	≤0.25	/	/
1026	0.22-0.28	0.15-0.36	0.6-0.9	≤0.040	≤0.050	≤0.20	≤0.30	≤0.35	/	/
4130	0.28-0.33	0.15-0.35	0.40-0.60	0.040	0.040	0.80-1.10	/	/	/	/
4140	0.36-0.43	0.15-0.35	0.75-1.00	0.040	0.040	0.80-1.10	/	/	/	/

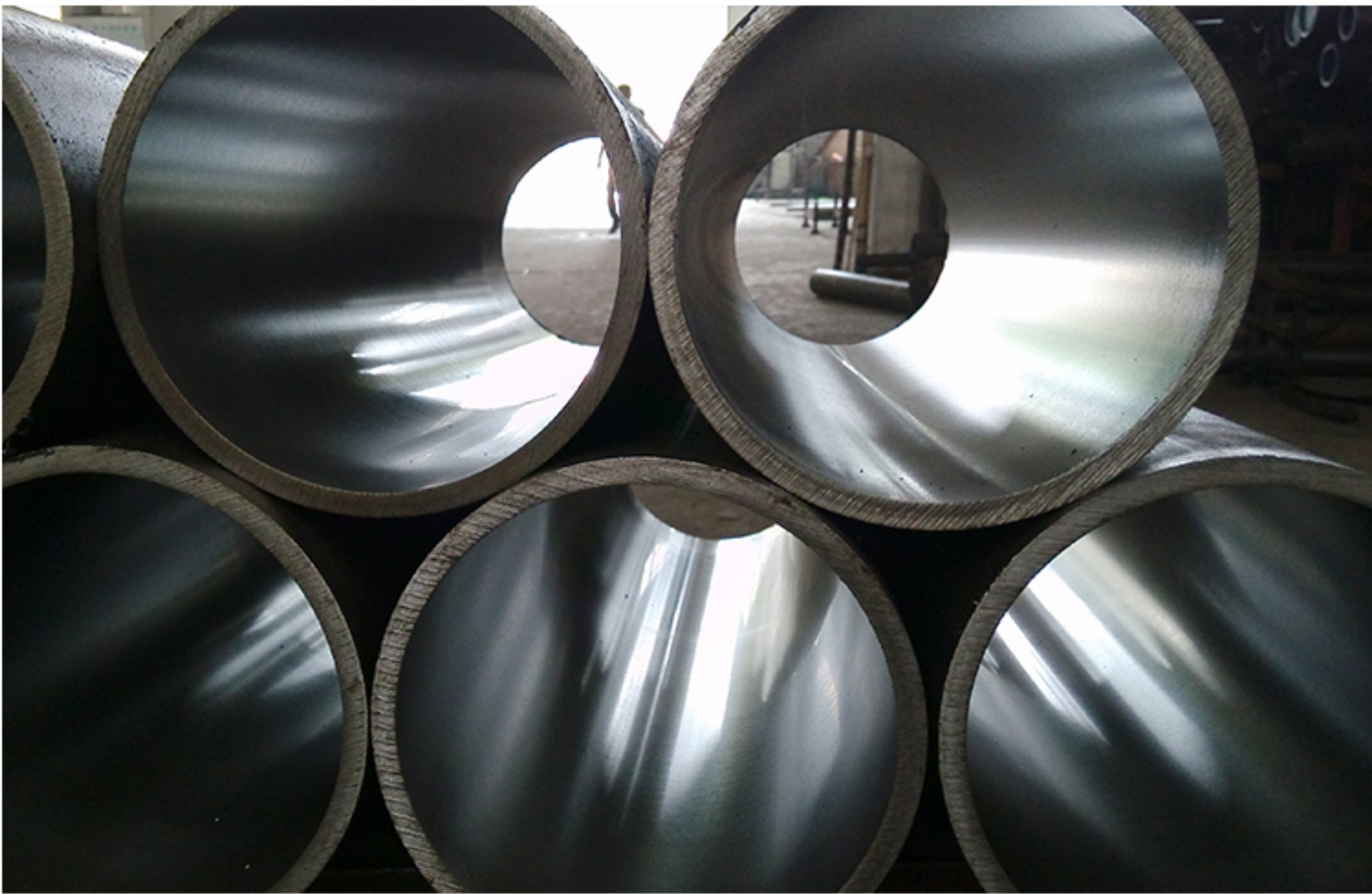
MECHANICAL PROPERTY

STEEL GRAD	COLD FINISHED(HRAD)(BK)		COLD DRAWN AND STRESS-RELIEVED(BK+S)				
	T.S bN/mm2	Elongation 5%	T.S bN/mm2	Y.S bN/mm2	Elongation 5%	Hardness HB	impact value (-20 C)J
E355(ST52)	≥640	≥5	≥600	≥520	≥14	/	/
20	≥550	≥8	≥520	≥400	≥15	170	/
45	≥680	≥5	≥630	≥520	≥12	190	/
Q355B	≥660	≥8	≥620	≥520	≥15	190	/
Q355D	≥660	≥8	≥620	≥520	≥15	190	≥27
Q355E	≥660	≥8	≥620	≥520	≥15	≥190	≥27
25Mn	≥640	≥8	≥620	≥510	≥15	190	/
27SiMn	≥780	≥5	≥700	≥580	≥10	220	/
1026	≥640	≥8	≥620	≥510	≥15	≥190	/



► We are reliable.

Raw material is mainly from some famous refinery steel mills, such as BAO STEEL,Tianjin,and Chengdu etc, which are the best and largest raw material manufacturers in China.
We have experienced technicians and skilled workers and provide you with high quality and efficient products.
We have advanced equipments: cold drawing machine,honing machine, skiving & roller burnishing machine, centerless grinding machine,straightening machine, polishing machine,etc. Delivery on time and best after-sale service.



TOLERANCE

Tolerance	I.D Tolerance			Tolerance of wall thickness
Size of I.D	H8	H9	H10	
30	0.033	0.052	0.084	<120mm(O.D) ≥120mm up to 210mm >210mm ±5% ±7.5% ±10%
>30-50	0.039	0.062	0.1	
>50-80	0.046	0.074	0.12	
>80-120	0.054	0.087	0.14	
>120-180	0.063	0.1	0.16	
>180-250	0.072	0.115	0.185	
>250-315	0.081	0.13	0.21	
>315-400	0.089	0.14	0.23	

PROCESSING FORM

Processing form	I.D mm	length	Straightness	I.D tolerance	I.D Roughness (RA)
Honed	40-500	≤12M	0.5-1/1000	H8-H9	0.4-0.8μm
SRB	50-250	≤13M		H8	0.1-0.4μm

