ACCIAI INOSSIDABILI STAINLESS STEELS

TECHNICAL SHEET

COLD DRAWN BARS

Definition

The cold drawn bars are a cold worked product without metal remouval, therefore it can show some surface defect. Cold drawn bars always shows some residual hard work, so it cannot be used for applications where maximum softening is required.

Diameters and Size Tolerances

Diameter	*Tolerance **	*Ovalization*
3 ÷ 25.4	H9 – H10	1/3 of the tolerance

* Other tolerance J e K available on request

Lengths and Tolerances

*Diameter ***	*Length*	*Tolerance STD ****	*Tolerance Extra STD*	*Short bars*
3÷5.99	3-4.2 m	+50 – 0	+25 – 0	5%
6÷25.4	3-6.2 m	+50 – 0	+25 – 0	5%

** Progression diameter 0,5 mm STD e 0,01 Extra STD

*** Possible ± 25 mm

Other characteristics

	Roughness	*Straightness*	*End bars*
STD	1.25 Ra	0.8 ‰	1 Chamfer 45° 1 Square sheared
Extra STD	0.8 Ra	0.5 ‰	1 Chamfer 45° 1 Chamfer 30°

Surface defects

Diameter	*Depth of the defect*	*Minimum removal for zero defect*
≤ 10	0.08 mm	0.10 mm
>10 ≤ 25	0.8 % on diameter max 0.15 mm	0.10 % on diameter max 0,18 mm

Defects such us pittings and drawing scratchings are not included. As extra STD it can be required "0 defect ". In this case the material in dimension range 6-10 will be previously bark peeled and the dimensions above 10 will be grinded after drawing.

Packaging

Bundle Kg 500 min.
Wooden box diameter 3 ÷ 5,99
Plastic cardboard diameter ≥ 6