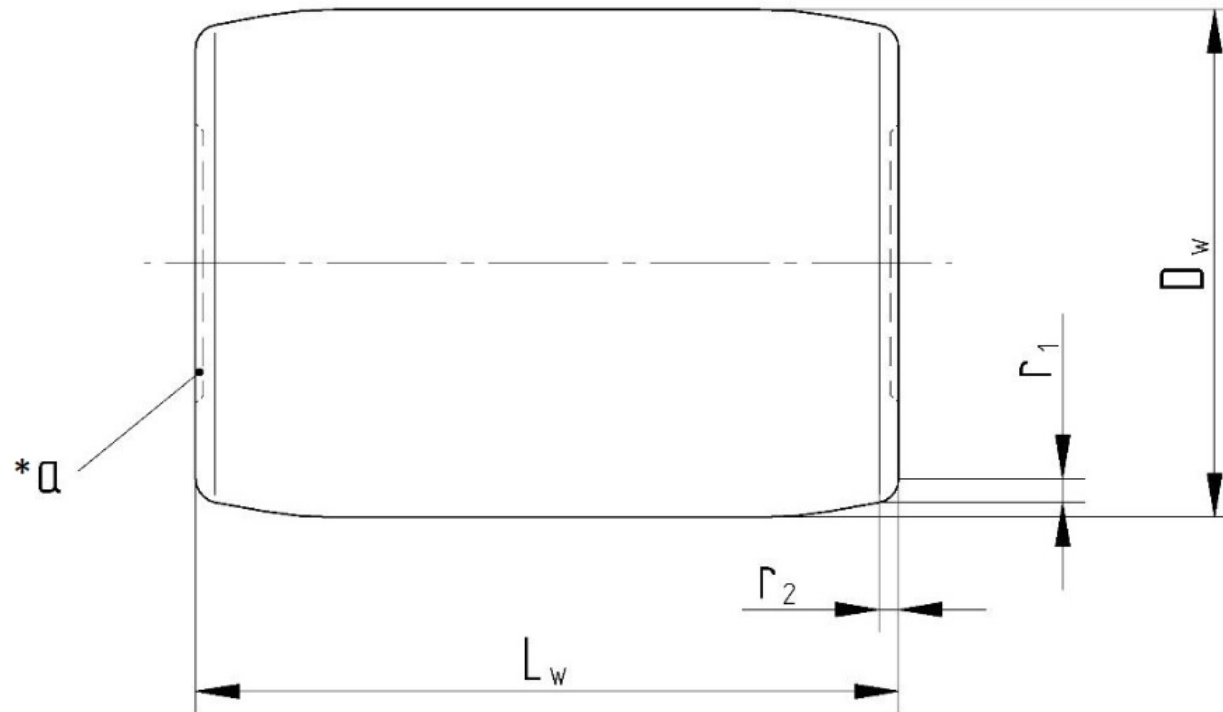


DESIGN: cylindrical- spherical profile (CS)



MATERIAL, HARDNESS:

Bearing steel acc. DIN EN ISO 683-17

Hardness acc. DIN 5402-1

Standard material: $\leq D_w 30 \text{ mm} = 100\text{Cr6 (1.3505)}$

58 - 65 HRC

$> D 30 \text{ mm} = 100\text{CrMnSi6-4 (1.3520)}$

***a** Exemption is optional



DIAMETER, LATERAL SURFACE - DIMENSION ACCURACY, VARIATION, ROUGHNESS:

Diameter D_w	Upper Tolerance	Lower Tolerance	Roundness	Diameter tolerance of a variation	Variation range middle tolerance			Roughness
[mm]	[μm]	[μm]	[μm]	[μm]	[μm]			[Ro]
- to 26	+7	-9	0,8	2	+6 to +1	0	-1 to -8	0,1
26 to 40	+7,5	-10,5	1,2	3	+6 to +1,5	0	-1,5 to -9	0,1
40 to 75	+7,5	-10,5	2	3	+6 to +1,5	0	-1,5 to -9	0,16
75 to 120	+12.5	-12.5	2.5	5	+10 to +2.5	0	-2.5 to -10	0.2

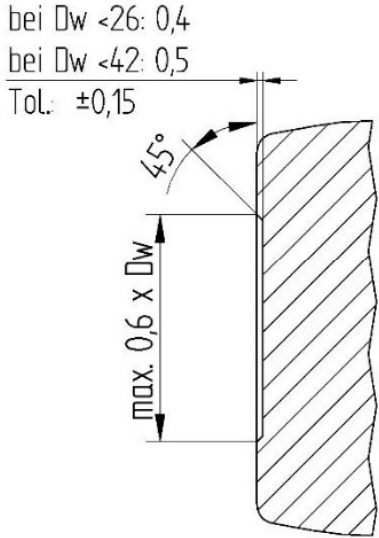
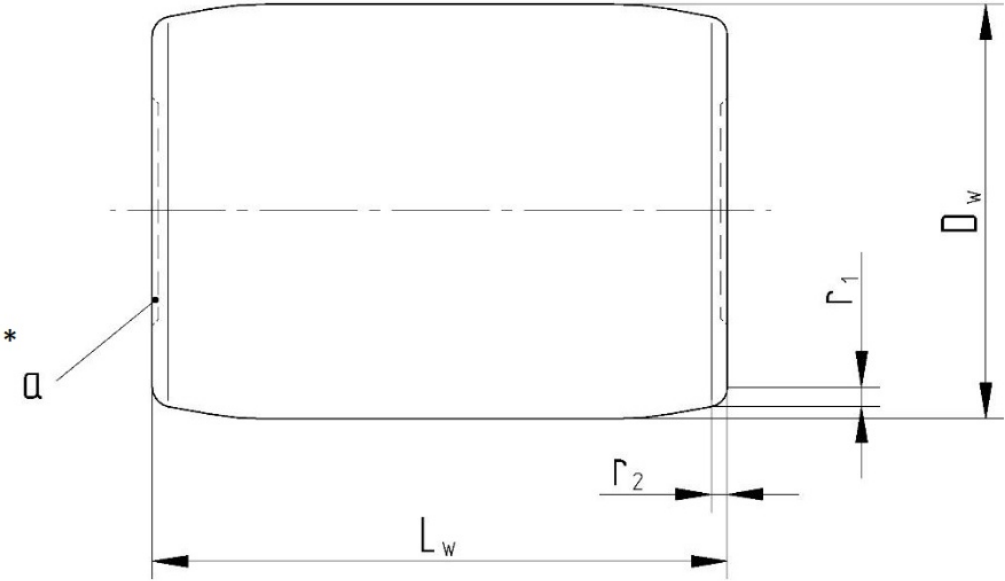
LENGTH, FRONT FACE - DIMENSION ACCURACY, VARIATION, ROUGHNESS:

Length L_w	Upper tolerance	Lower tolerance	Roller length tolerance of a variation	Length tolerance a variation [μm]	Variation range middle tolerance [μm]			Roughness
[mm]	[μm]	[μm]	[μm]	[μm]	[μm]			[Ro]
- to 48	+3	-15	8	6	0	-6	-12	0,25
48 to 120	+5	-35	10	10	0	-10	-20 -30	0,4



CYLINDER ROLLER – according DIN 5402-1

DESIGN: cylindrical- spherical profile (CS)



*a Exemption is optional

MARKING EXAMPLE: ZRO 12x18 ZB +3/-12

Marking of a cylinder roller with $D_w= 12$ mm roller diameter, $L_w= 18$ mm roller length, cylindrical- spherical profile, diameter variation +3 μm (+4 μm bis +2 μm), length variation -12 μm (-9 μm to -15 μm)



Diameter D _w [mm]	r1 min [mm]	r1 max [mm]	r2 min [mm]	r2 max [mm]
- to 4	0,2	0,4	0,2	0,7
4 to 8	0,2	0,6	0,2	0,7
8 to 12	0,3	0,7	0,3	1,0
12 to 16	0,4	0,8	0,4	1,2
16 to 20	0,4	1,0	0,4	1,2
20 to 26	0,5	1,1	0,5	1,3
26 to 34	0,6	1,4	0,6	1,4
34 to 42	0,7	1,7	0,7	1,7
42 to 56	0,9	2,1	0,9	2,1
56 to 64	1,2	2,4	1,2	2,4
64 to 75	1,4	2,6	1,4	2,6
75 to 95	1,8	3,2	1,8	3,2
95 to 115	2,2	3,8	2,2	3,8
115 to 120	2,7	4,3	2,7	4,3

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