



name	entry on drawing	explanation
edge deburred		Deburring up to a facet width of max. 0.4 / rounding with max. 0.4 edge distance. Usually left out on drawings.
edge sharp		Sharp edges on pieces must always be without burr and have no gradual change. Must be specified on drawing.
facet rounding chamfer		Desired edge-making or rounding normally begins with 0.3 as the smallest facet or smallest rounding radius and the dimension must be entered on the drawing. The deviations on the following table apply to the machining of metals.
permissible deviations for rounding radii and facets		
nominal dimensions 0.3-0.5		over 0.5-3 over 3-6 over 6-30
deviations ± 0.1		± 0.2 ± 0.5 ± 1
Angular dimensions		
nominal dimensions of facet width		till 2 2 till 5 over 10
deviations		$+\text{-}5^\circ$ $+\text{-}3^\circ$ $+\text{-}1^\circ$

2002962	Addition of angle tolerances for chamfer			RON 102_en_200296 2.doc
9537	conversion to DP document; no change in content			RON102 .DOC
edition	description of change			Document
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DEBURRING, CHAMFERING, ROUNDING

RON 102
edition 2002962
page 2 of 2

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cylinder bore ports		<p>Cylinder bore ports are deburred with 0.3-0.8x15-45°. This does not include narrow spaces, e.g. between support and transfer ports. A facet width of 0.1-0.3 is valid for these.</p> <p>Facet width at the center of the port shall be bigger than in the corners!</p> <p>Does not apply to Nikasil and Chromal cylinders!</p>

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DEBURRING, CHAMFERING, ROUNDING

RON 102
edition2002962
page 2 of 2