



# DEBURRING, CHAMFERING, ROUNDING

RON 102  
edition 2002962  
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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														
<table><thead><tr><th>nominal dimensions</th><th>over 0.5-3</th><th>over 3-6</th><th>over 6-30</th></tr></thead><tbody><tr><td>0.3-0.5</td><td></td><td></td><td></td></tr><tr><td>deviations</td><td>±0.1</td><td>±0.2</td><td>±0.5</td></tr></tbody></table>			nominal dimensions	over 0.5-3	over 3-6	over 6-30	0.3-0.5				deviations	±0.1	±0.2	±0.5
nominal dimensions	over 0.5-3	over 3-6	over 6-30											
0.3-0.5														
deviations	±0.1	±0.2	±0.5											
Angular dimensions														
nominal dimensions of facet width		till 2												
deviations		±/-5°												
		2 till 5												
		±/-3°												
		over 10												
		±/-1°												

2002962	Addition of angle tolerances for chamfer		
9537	conversion to DP document; no change in content		
edition	description of change		
prepared/date Kan/Fh 1994 09 06	checked/date 2007 07 13 QP/BUN	approved/date 2007 07 16 AK/Ai	replaces: RON 102 edition: 9537
Modified: 2007 06 29 AK/AI			



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name	entry on drawing	explanation
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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