

CUSTOM MODIFICATIONS



The modifications shown below are only those most frequently requested and do not represent the limit of our capabilities with regards to size ranges and tolerances. Also, please refer to the worksheet templates provided on pages 25-27.

Modification	Type	Description	Tolerances	How To Order: Examples
	ML	REDUCED OVERALL LENGTH Stock removal from front-end. Minimum length .500". Lengths under .500" per special quote only.	$+ .015"/- .000"$ [+0.5/-0.0]	SQD .230 ML=1.063 HSS B-1 .030 ML=1.750 RQA .056 ML=1.500
	CL	PRECISION OVERALL LENGTH Same as above except closer tolerance held.	$\pm .001"$ [+/-0.03]	RQB .175 CL=2.157 RCX-9 CL=5.312 PT-5-1/2 CL=4.093
	MT	REDUCED HEAD THICKNESS Shorter head than standard. Stock removal from back of head Shortens overall length	$+ .010"/- .000"$ [+0.3/-0.0]	SQD .157 X2-1/2 TS, MT=.094 RC-17 L-3, MT=.156
	CT	PRECISION HEAD THICKNESS Same as above except closer tolerance held.	$\pm .001"$ [+/-0.03]	SQD .204 X 2 1/2 HSS, CT=.118 RQB .090 X 2-1/2, CT=.090 RQA .130 X 6, CT=.083
	MH	REDUCED HEAD DIAMETER Head diameter smaller than standard. Minimum head diameter equals "D". Grinding head diameter on RQA does not change head thickness.	$+ .000"/- .010"$ [+0.0/-0.3]	RQB .240 X 4, MH=.280 SQD .370 X 2-1/2 HSS, MH=.437
	PH	PRECISION HEAD DIAMETER Same as above except closer tolerance held.	$\pm .001"$ [+/-0.03]	PT-11 L-6, PH=.250
	PS	PUNCH STEP "B" = .750" Max. Specify "B" or "SBR" and "P" including tolerance	B $+ .06"$ $- .00"$ SBR $+ .06"$ $- .00"$	RQB-PS .125 X 2-1/2, P=.093 +.0003/-0, B=.500 CPB-PS-12 X 2-1/2, P=.109+.0005/-0, B=.625 PPB-PS 37 X 3, P=.290 +.0002/-0, SBR=.437 AB-20-PS .312 X 3-1/2, P=.255 +.0003/-0, B=.500
	CS	CORE PIN STEP - STRAIGHT "B" = .750" Max. Should be ordered in conjunction with "CL" modification and "CT" if required. Specify "B", "P", "CL" and "CT" if required.	B $\pm .001"$ CL $\pm .001"$ CT $\pm .001"$ P1 $+ .001"/- 0$ P - Specify	RQB-CS .067, CL=.940, B=.210, P=.050 RCX-13-CS, CL=2.590, B=.700, P=.157 PT-10-CS, CL=3.750, B=.730, P=.133
	CSD	CORE PIN STEP - DRAFT B=.750" max. Includes custom modifications "CL" and "CT" if required. Specify "B", "P1", "P2", "CL" and "CT" if required.	B $\pm .001"$ CL $\pm .001"$ CT $\pm .001"$ P1 $+ .001"/- 0$ P2 $+ .001"/- 0$	RCX-19 -CSD, CL=2.187, B=.431, P1=.255, P2=.263 RQB-CSD .236, CL=.870, B=.575, P1=.197, P2=.207, CT = .125
	PN	PILOT NOSE Pilot nose is included in the overall length. Pilot is manufactured with .119 radius.	Standard	SQF-PN .250 X 2-1/2 HSS B-15-PN .238 X 3 RQA-PN .136 X 2-1/2
	SR	SPHERICAL RADIUS Radius is half the diameter. Also specify "ML" or "CL" AND "CT" If required.	Standard	RQB-SR .060 X 2-1/2 AB-7-SR .125 X 2 RCX-11-SR L-3
Special Hardness	HD	ANNEALED HEADS Induction annealing of heads to a lower Rockwell hardness for improved strength.		RQB-HD .125 x 2-1/2
		SPECIAL HARDNESS When a hardness other than catalog standard is required.	Specify hardness range required.	SQD .187 x 2-1/2 TS, Rc 45-50
Coatings	TiN	TITANIUM NITRIDE COATING PVD wear resistant thin film coating. TiN is an excellent coating for wear part applications demanding resistance to abrasive and adhesive wear. Typical coating thickness is .00005" to .00010" per side.	Diameter tolerances are before coating only. We cannot guarantee tolerance after coating.	RQB .075 X 4 TiN
	WS2	PERMANENT DRY-LUBE TREATMENT A Tungsten Disulfide coating that provides a thin barrier between opposing metal surfaces and prevents metal to metal contact to improve lubricity. Applied at room temperature and unaffected by the heat of the molding process, it will extend the life of the pins while providing fail safe protection by eliminating galling and seizing. Tungsten disulfide does not migrate to the molded surface. Typical coating thickness is .000020" per side.	Diameter tolerances are before coating only. We cannot guarantee tolerance after coating.	RX-25 L-10 (WS2) PT-5-2 L-6 (WS2)

[] DENOTES TOLERANCES HELD ON METRIC PARTS