

GENERAL TECHNICAL INFORMATION STRAIGHTENED ROLLERS / ROLLER LENGTHS

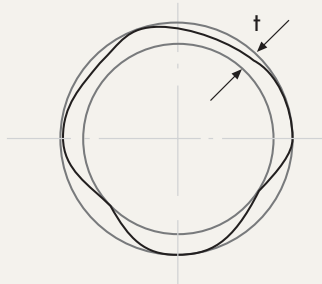
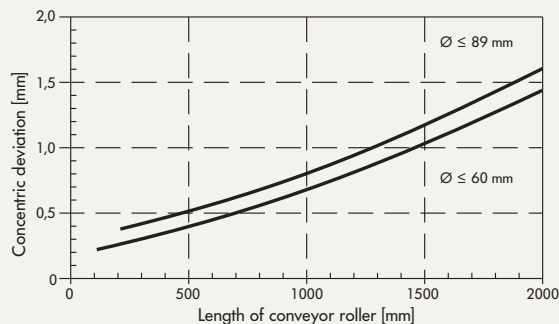


Fig.: Concentric deviation t

In principle, concentric deviation depends on the length and material of the tube. It is all the greater the longer a tube is, especially with polymer tubes.

The average concentric deviation of Uniking rollers can be found in the following diagrams.

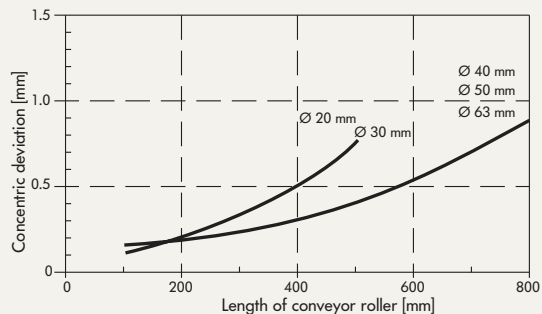
Steel tubes



Polymer tubes

With polymer tubes, the concentric deviation increases disproportionately to the length of the tube. The following lengths should not be exceeded:

$\varnothing$ Tube [mm]	Max. tube length [mm]
16	300
20	400
30	500
	600
63	800



For steel tubes $\leq 2 \text{ mm}$ wall thickness, Uniking offers a 100% check. In the process, the concentric precision of every roller ordered is checked and, if needed, the tube is straightened. Carbonitrided tubes cannot be straightened.

Please note that DIN-compliant tubes are permitted significantly higher concentric tolerances. For this reason, the empirically determined guide values represented in the diagrams can be exceeded in individual cases.

Straightened rollers / roller lengths

In principle, the rollers manufactured by Uniking have a high concentric precision. The concentric precision is sufficient for almost all applications. On top of that, Uniking offers a 100% inspection for rollers made out of steel.

During the inspection, the concentric precision of each roller is measured. If the concentric precision falls outside the specified tolerance (page 20), the tube is straightened. The concentric deviation is corrected only if it falls outside the tolerance.

When measuring the concentric precision and also for the straightening process, the tube is the reference point. The concentricity between shaft and tube is not checked.