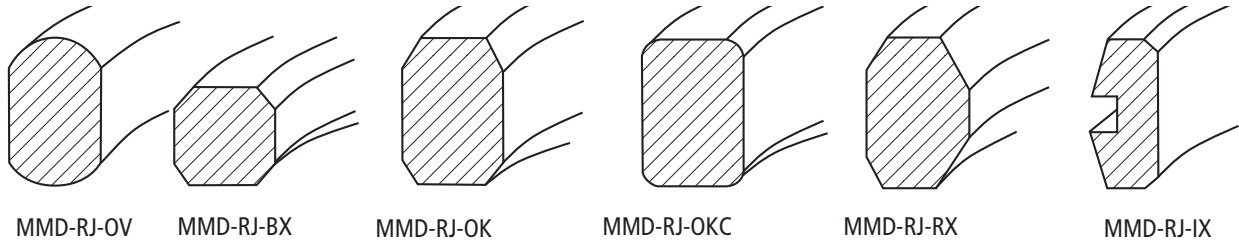


RJ Ring Joint Gaskets



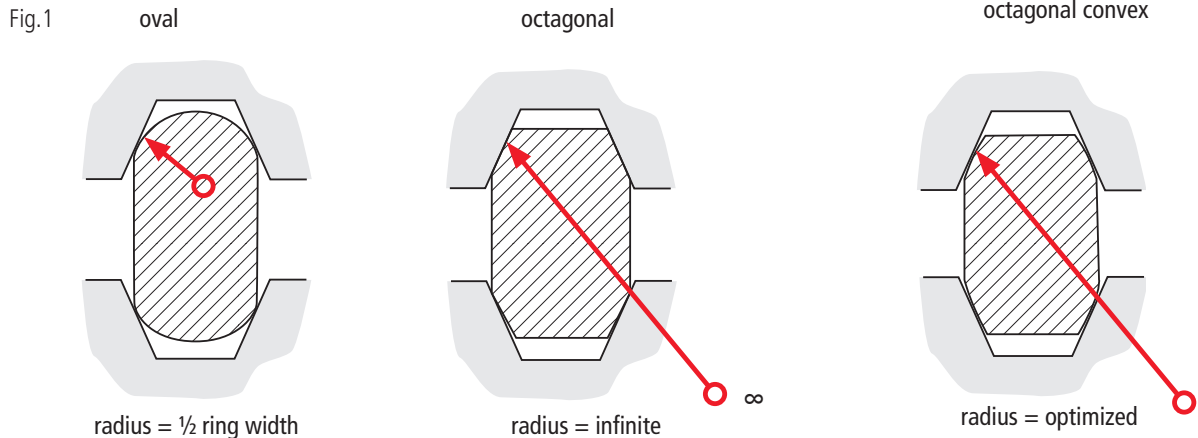
High-pressure gaskets from Germany produced with the highest precision

MMD-RJ Profile Overview



Ring-joints are increasingly used in the chemical and petrochemical industries. They are all-metal seals and therefore meet the requirements of all regulations. Usually the manufacturers have an approval of the American-Petroleum-Institute API. In Europe, especially in Germany, these rings were tested with a uniform gasket width of 1.6 mm. It can be noted, that the sealing width can vary depending on surface pressure due to the nested sealing surfaces.

At the beginning of the eighties, Dipl.-Ing. Hans-Joachim Tückmantel made a significant contribution to the improvement of a sealing system with ring joints. The shapes of the oval ring joint (MMD-RJ-OV) and the octagonal ring joints (MMD-RJ-OK) differ significantly in the radius of the nested surface. Oval ring-joints are very strongly deformed during assembly, their radii seem to be too small. Octagonal ring joints require precisely fitting sealing surfaces and very high bolt forces. While the radius of the oval ring corresponds to half the gasket width, the radius of the octagonal ring joint is infinitely large (Fig. 1). The solution is an octagonal-convex ring joint (MMD-RJ-OKC), with a conical surface as sealing



The MMD-BX and MMD-RX rings are designed for flanges with 2,000 to 10,000 lbs. The flanges of MMD-BX rings are precisely fitted to the surface.

Ring Joints Type MMD-RJ-IX are used in the compact flanges according to DIN EN ISO 27509.

Often ring joints are used several times. This is not permitted according to the technical rule for operational safety TRBS 2141-3 paragraph 4.2.2. Once used, sealing rings are considered damaged and must be replaced. If you reuse used ring joints, you will bear sole responsibility.

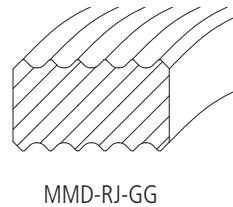
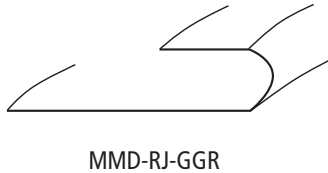
The mean ring diameter (P), the ring height (B for oval and H for octagonal rings) and the ring width (A) are defined and tolerated. It is different in EN 12560-5, where the radius (R) is exactly defined as $R = A/2$. It is our recommendation to include that EN 12560-5 in the order texts in order to close this gap.

Surfaces | Tolerances | Dimensions

Compensation caps are available for repeated use of ring joints or in case of slightly damaged sealing surfaces. Usually soft materials such as copper, nickel and silver are used.



In ring-joint connections, a radial gap is formed between the inner edge of the gasket and the flanges. This gap can be filled with gap guard rings in order to optimize the flow or to reduce flow noise. If corrosion protection for the gasket is desired, cam-profiles (grooved gaskets) made of PTFE are a good choice.



The sealing profile should correspond to the profile according to DIN 2697. The thickness can be calculated in accordance with API Standard 6A/ISO10423 (Table 1).

Table 1: Thickness of PTFE compensation rings according to API6A/ISO 10423, Table 63 for oval ring joints	
Ring number R	Thickness of the cam-profile gasket in mm
73,85	4.0
20, 47, 50, 54, 66, 86, 87, 91	4.8
23, 24, 26, 27, 31, 35, 37, 39, 41, 44, 45, 46, 49, 53, 57, 65, 69, 70, 74, 82, 84, 88, 89, 90, 99	5.5
63	6.3

Note

The gap between the gasket and the inner diameter is often filled in ring joint connections. According to API Standard 6A and ISO 10423 the gap (S) between the flanges defined in tables 63 and 64 is defined in the assembled state of the joint. Depending on the cross-section of the ring joint, the values are at 4.1 or 4.8 mm, deviations for ring sizes R63, R73 and R85. In fact the gaps are significantly wider. For this reason we recommend that the entire thickness of the PTFE-filling ring with cam-profile to be set to 8.5 mm at delivery. It should be noted that for RX rings the thicknesses are to be set much higher.

The surface of the ring joints must be as smooth as possible when using purely metallic gaskets. (Table 2).

Table 2: Surface condition of the sealing surfaces (roughness values according to ISO 4287)	
R_a μm	R_z μm
≤ 1.6	≤ 6.3

Tolerances | Hardness

Compliance with tolerances is very important for ring-joints. If the dimensions are not correct, the ring joints can tilt under pressure and become leaky. Manufacturing tolerances are defined in EN 12560-5, ASME B16.20 and API Standard 6A/ISO 10423 (Table 3).

Designation	Description	Tolerances
P	mean Ø of the ring	± 0.18 mm
A	ring width/width	± 0.20 mm
B und H	ring height	± 0.40 mm ¹⁾
C	edge length of the octagonal ring	± 0.20 mm
	angle of 23° (octagonal ring)	± 0.5°
R ₁	ring radius (octagonal ring)	± 0.40 mm

¹⁾ for the ring height a maximum height of +1.2 mm is allowed, the maximum height difference of a ring is 0.40 mm

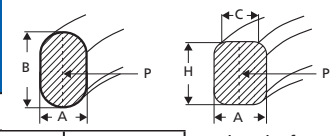
The hardness of the surface should be in the lower range of the usual materials, so that the ring joint is deformed and not the flange surface in the flanks of the ring groove (Table 4).

Material (US designation)	Material number	Hardness		Designation
		Brinell ¹⁾ HB max.	Rockwell ²⁾ HRB max	
Soft Iron (Soft-Iron)	1.0003	90	56	D
StW24 ³⁾ (Soft-Iron)	1.0335/DD13 mod.	90	56	D
Low-carbon steel (Low-Carbon)	1.0330	120	68	S
steel with 4 -6 % Cr/0,5 % Mo		130	72	F5 ⁴⁾
13CrMo44	1.7335	130	72	7335
12CrMo19-5 mod. (501)	1.7362 mod.	130	72	F5
X6Cr13	1.4000	160	83	S410
X12CrMo13 (410)	1.4006	170	86	S410
X5CrNi18-10 (304)	1.4301	160	83	S304
X5CrNiMo17-12-2 (316)	1.4401	160	83	316
X2CrNiMo17-12-2 (316L)	1.4404	160	83	S316
X6CrNiTi18-10 (321)	1.4541	160	83	S321
X6CrNiNb18-10 (347)	1.4550	160	83	S347
X6CrNiMoTi17-12-2	1.4571	160	83	S316Ti
17-4 PH	1.4548	300	-	S17400
SMO 254	1.4547	180	85	S32154
Duplex	1.4462	230	98	S31803
Duplex	1.4462	230	98	S32205
Superduplex	1.4410	230	98	S32750
Superduplex	1.4501	230	98	S32760
Alloy 600	2.4816	200	94	N06600
Alloy 625	2.4856	200	94	N06059
Alloy 718	2.4668	300	-	N07718
Alloy 800	1.4876	200	94	N08810
Alloy 825	2.4858	160	83	N08825
Alloy C276	2.4819	200	94	N10276
Nickel 200	2.4066	130	72	N02200
Titanium Grade 2	3.7035/34	160	83	R50400

¹⁾ measured Brinell hardness at 3,000 kg, soft iron at 500 kg - ²⁾ measured Rockwell hardness at 500 kg and ball Ø of 1.59 mm
³⁾ low-carbon steel modified to soft-iron, produced from sheet metal - ⁴⁾ F5 refers to the chemical composition of ASTM A182/ASTM A182M-87a

Dimensions and numbers for MMD-RJ

Table 5: Dimensions and numbers for ring joints according to EN 12560-5 (ASME B16.20) for flanges according to EN 1759-1 (ASME B16.5) Class 150 to 2500 with additions



Pressure level/Class					Number	Mean Ø of the ring flanks	Ring width	length of octagonal Ring		
150	300 600	900	1500	2500				oval	octagonal	
Nominal width DN (NPS)								P	A	B
-	15 (1/2)	-	-	-	R11	34.13	6.35	11.11	9.53	4.32
-	-	15	15	-	R12	39.69	7.94	14.29	12.70	5.23
-	20 (3/4)	-	-	15	R13	42.86	7.94	14.29	12.70	5.23
-	-	20	20	-	R14	44.45	7.94	14.29	12.70	5.23
25 (1)	-	-	-	-	R15	47.63	7.94	14.29	12.70	5.23
-	25	25	25	20	R16	50.80	7.94	14.29	12.70	5.23
32 (1 1/4)	-	-	-	-	R17	57.15	7.94	14.29	12.70	5.23
-	32	32	32	25	R18	60.33	7.94	14.29	12.70	5.23
40 (1 1/2)	-	-	-	-	R19	65.09	7.94	14.29	12.70	5.23
-	40	40	40	-	R20*	68.26	7.94	14.29	12.70	5.23
-	-	-	-	32	R21	72.23	11.11	17.46	15.88	7.75
50 (2)	-	-	-	-	R22	82.55	7.94	14.29	12.70	5.23
-	50	-	-	40	R23*	82.55	11.11	17.46	15.88	7.75
-	-	50	50	-	R24*	95.25	11.11	17.46	15.88	7.75
65 (2 1/2)	-	-	-	-	R25	101.60	7.94	14.29	12.70	5.23
-	65	-	-	50	R26*	101.60	11.11	17.46	15.88	7.75
-	-	65	65	-	R27*	107.95	11.11	17.46	15.88	7.75
-	-	-	-	65	R28	111.13	12.70	19.05	17.46	8.66
80 (3)	-	-	-	-	R29	114.3	7.94	14.29	12.70	5.23
-	80 ⁽¹⁾	-	-	-	R30*	117.48	11.11	17.46	15.88	7.75
-	80	80	-	-	R31*	123.83	11.11	17.46	15.88	7.75
-	-	-	-	80	R32	127.00	12.70	19.05	17.46	8.66
-	-	-	80	-	R35*	136.53	11.11	17.46	15.88	7.75
100 (4)	-	-	-	-	R36	149.23	7.94	14.29	12.70	5.23
-	100	100	-	-	R37*	149.23	11.11	17.46	15.88	7.75
-	-	-	-	100	R38	157.16	15.88	22.23	20.64	10.49
-	-	-	100	-	R39*	161.93	11.11	17.46	15.88	7.75
125 (5)	-	-	-	-	R40	171.45	7.94	14.29	12.70	5.23
-	125	125	-	-	R41*	180.98	11.11	17.46	15.88	7.75
-	-	-	-	125	R42	190.50	19.05	25.40	23.81	12.32
150 (6)	-	-	-	-	R43	193.68	7.94	14.29	12.70	5.23
-	-	-	125	-	R44*	193.68	11.11	17.46	15.88	7.75
-	150	150	-	-	R45*	211.14	11.11	17.46	15.88	7.75
-	-	-	150	-	R46*	211.14	12.70	19.05	17.46	8.66
-	-	-	-	150	R47*	228.60	19.05	25.40	23.81	12.32
200 (8)	-	-	-	-	R48	247.65	7.94	14.29	12.70	5.23
-	200	200	-	-	R49*	269.88	11.11	17.46	15.88	7.75
-	-	-	200	-	R50*	269.88	15.88	22.23	20.64	10.49
-	-	-	-	200	R51	279.40	22.23	28.58	26.99	14.81
250 (10)	-	-	-	-	R52	304.80	7.94	14.29	12.70	5.23

Flanges also according to API Standard 6A/ISO 10423 Table 63 • 1) only for rotatable flanges with attachment for welding neck flanges (Type 15) • 2) for flanges according to ASME B16.47 Series A

Dimensions and numbers for MMD-RJ

Table 5: Dimensions and numbers for ring joints according to EN 12560-5 (ASME B16.20) for flanges according to EN 1759-1 (ASME B16.5) Class 150 to 2500 with additions

Pressure level/Class					Number	Mean Ø of the ring flanks	Ring width	Ring height		Edge length of octagonal Ring
150	300 600	900	1500	2500				oval	octagonal	
Nominal width DN (NPS)								P	A	
-	250	250	-	-	R53*	323.85	11.11	17.46	15.88	7.75
-	-	-	250	-	R54*	323.85	15.88	22.23	20.64	10.49
-	-	-	-	250	R55	342.90	28.58	36.51	34.93	19.81
300 (12)	-	-	-	-	R56	381.00	7.94	14.29	12.70	5.23
-	300	300	-	-	R57*	381.00	11.11	17.46	15.88	7.75
-	-	-	300	-	R58	381.00	22.23	28.58	26.99	14.81
350 (14)	-	-	-	-	R59	396.88	7.94	14.29	12.70	5.23
-	-	-	-	300	R60	406.40	31.75	39.69	38.10	22.33
-	350	-	-	-	R61	419.10	11.11	14.46	15.88	7.75
-	-	350	-	-	R62	419.10	15.88	22.23	20.64	10.49
-	-	-	350	-	R63*	419.10	25.40	33.34	31.075	17.30
400 (16)	-	-	-	-	R64	454.3	7.94	14.29	12.70	5.23
-	400	-	-	-	R65*	469.90	11.11	17.46	15.88	7.75
-	-	400	-	-	R66*	469.90	15.88	22.23	20.64	10.49
-	-	-	400	-	R67	469.90	28.58	36.51	34.93	19.81
450 (18)	-	-	-	-	R68	517.53	7.94	14.29	12.70	5.23
-	450	-	-	-	R69*	533.40	11.11	17.46	15.88	7.75
-	-	450	-	-	R70*	533.40	19.05	25.40	23.81	12.32
-	-	-	450	-	R71	533.40	25.58	36.51	34.93	19.81
500 (20)	-	-	-	-	R72	558.80	7.94	14.29	12.70	5.23
-	500	-	-	-	R73*	584.20	12.70	19.05	17.46	8.66
-	-	500	-	-	R74*	584.20	19.05	25.40	23.81	12.32
-	-	-	500	-	R75	584.20	31.75	39.69	38.10	22.33
600 (24)	-	-	-	-	R76	673.10	7.94	14.29	12.70	5.23
-	600	-	-	-	R77	692.15	15.88	22.23	20.64	10.49
-	-	600	-	-	R78	692.15	25.40	33.34	31.75	17.30
-	-	-	600	-	R79	692.15	34.93	44.45	41.28	24.82
550 (22)	-	-	-	-	R80	615.95	7.93		12.70	5.23
-	550	-	-	-	R81	635.00	14.28		19.05	9.58
-	650 (26)	-	-	-	R93 ²⁾	749.30	19.05		23.81	12.32
-	700 (28)	-	-	-	R94 ²⁾	800.10	19.05		23.81	12.32
-	750 (30)	-	-	-	R95 ²⁾	857.25	19.05		23.81	12.32
-	800 (32)	-	-	-	R96 ²⁾	914.4	22.22		26.98	14.81
-	850 (34)	-	-	-	R97 ²⁾	965.20	22.22		26.98	14.81
-	900 (36)	-	-	-	R98 ²⁾	1022.35	22.22		26.98	14.81
-	-	650	-	-	R100 ²⁾	749.30	28.57		34.92	19.81
-	-	700	-	-	R101 ²⁾	800.10	31.75		38.10	22.33
-	-	750	-	-	R102 ²⁾	857.25	31.75		38.10	22.33
-	-	800	-	-	R103 ²⁾	914.40	31.75		38.10	22.33
-	-	850	-	-	R104 ²⁾	965.20	34.92		41.27	24.82
-	-	900	-	-	R105 ²⁾	1022.35	34.92		41.27	24.82

Flanges also according to API Standard 6A/ISO 10423 Table 63 • 1) only for rotatable flanges with attachment for welding neck flanges (Type 15) • 2) for flanges according to ASME B16.47 Series A

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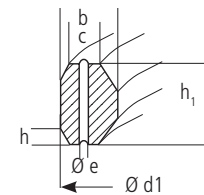
Table 6: Dimensions for ring joints according to Class 2.000-3.000 and 10.000

Class				Number	Mean Ø of the ring flanks P	Ring width A	Ring height		Edge length of octagonal Ring C
Nominal width		2.000 3.000	10.000				oval	octagonal	
DN	NPS						B	H	
25	1	-	x	*R82	57.15	11.11		15.87	7.75
40	1 1/2	-	x	*R84	63.50	11.11		15.87	7.75
50	2	-	x	*R85	79.37	12.70		17.46	8.66
65	2 1/2	-	x	*R86	90.49	15.87		20.63	10.49
80	3	-	x	*R87	100.10	15.87		20.63	10.49
100	4	-	x	*R88	123.83	19.05		23.81	12.32
	3 1/2	-	x	*R89	114.30	19.05		23.81	12.32
125		-	x	*R90	155.58	22.22		26.98	14.81
250	10	-	x	*R91	260.35	31.75		38.10	22.33
				R92	228.60	11.11	17.46	15.87	7.75
200	8	x	-	*R99	234.95	11.11		15.87	7.75

* Flanges also according to API Standard 6A/ISO 10423

Class 2.000 - 10.000 | Type MMD-RX

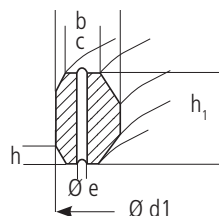
Table 7: Dimensions for Ring Joints Type RX according to ASME B16.20 and API Standard 6A/ISO 10423 for flanges according to API Standard 6B *



Nominal width		Pressure level/Class	Number	Outer Ø of the ring Ø d1					Bore
DN	NPS				b	c	h1	h	Ø e
40	1 1/2	2000 3000 5000	RX20	76.20	8.73	4.62	19.05	3.18	
50	2	2000	RX23	93.27	11.91	6.45	25.40	4.24	
50	2	3000 5000	RX24	105.97	11.91	6.45	25.40	4.24	
	3 1/8	5000	RX25	109.54	8.73	4.62	19.05	3.18	
65	2 1/2	2000	RX26	111.92	11.91	6.45	25.40	3.78	
65	2 1/2	3000 5000	RX27	118.27	11.91	6.45	25.40	4.24	
80	3	2000 3000	RX31	134.54	11.91	6.45	25.40	4.24	
80	3	5000	RX35	147.24	11.91	6.45	25.40	4.24	
100	4	2000 3000	RX37	159.94	11.91	6.45	25.40	4.24	
100	4	5000	RX39	172.64	11.91	6.45	25.40	4.24	
125	5	2000 3000	RX41	191.69	11.91	6.45	25.40	4.24	
125	5	5000	RX44	204.39	11.91	6.45	25.40	4.24	
150	6	2000 3000	RX45	221.85	11.91	6.45	25.40	4.24	
150	6	5000	RX46	222.25	13.49	6.68	28.58	4.78	
200	8	crossover flange	RX47	245.30	19.84	10.34	41.28	6.88	
200	8	2000 3000	RX49	280.59	11.91	6.45	25.40	4.24	
200	8	5000	RX50	283.37	16.67	8.51	31.75	5.28	
250	10	2000 3000	RX53	334.57	11.91	6.45	25.40	4.24	
250	10	5000	RX54	337.34	16.67	8.51	31.75	5.28	
300	12	2000 3000	RX57	391.72	11.91	6.45	25.40	4.24	
350	14	5000	RX63	441.72	26.99	14.78	50.80	8.46	
400	16	2000	RX65	480.62	11.91	6.45	25.40	4.24	

Dimensions MMD-RJ-RX

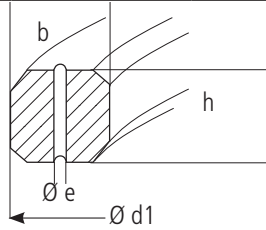
Table 7: Dimensions for Ring Joints Type RX according to ASME B16.20 and API Standard 6A/ISO 10423 for flanges according to API Standard 6B *.



Nominal width		Pressure level/Class	Number	Outer Ø of the ring					Bore
DN	NPS			Ø d1	b	c	h1	h	Ø e
400	16	3000	RX66	483.39	16.67	8.51	31.75	5.28	
450	18	2000	RX69	544.10	11.91	6.45	25.40	4.24	
450	18	3000	RX70	550.10	19.84	10.34	41.28	6.88	
500	20	2000	RX73	596.10	13.49	6.68	31.75	5.28	
500	20	3000	RX74	600.87	19.84	10.34	41.28	6.88	
25	1	10000	RX82	67.87	11.91	6.45	25.40	4.24	1.6
40	1 1/2	10000	RX84	74.22	11.91	6.45	25.40	4.24	1.6
50	2	10000	RX85	90.09	13.49	6.68	25.40	4.24	1.6
65	2 1/2	10000	RX86	103.58	15.08	8.51	28.58	4.78	2.4
80	3	10000	RX87	113.10	15.08	8.51	28.58	4.78	2.4
100	4	10000	RX88	139.3	17.46	10.34	31.75	5.28	3.2
	3 1/2	10000	RX89	129.78	18.26	10.34	31.75	5.28	3.2
125	5	10000	RX90	174.62	19.84	12.17	44.45	7.42	3.2
250	10	10000	RX91	286.94	30.16	19.81	45.24	7.54	3.2
200	8	2000 3000	RX99	245.67	11.91	6.45	25.40	4.24	
32	1 1/4	5000	RX201	51.46	5.74	3.20	11.30	1.45	
	1 3/4	5000	RX205	62.31	5.56	3.05	11.10	1.83	
65	2 1/2	5000	RX210	97.63	9.53	5.41	19.05	3.18	
100	4	5000	RX215	140.89	11.91	5.33	25.40	4.24	
	4 x 4 1/4	5000	RX215	140.89	11.91	5.33	24.40	4.24	

Dimensions TYP MMD-BX

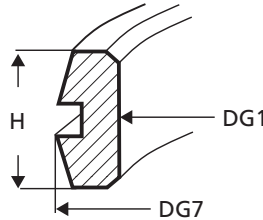
Table 8: Dimensions for ring joints type BX according to ASME B16.20 and API Standard 6A/ISO 10423 for flanges according to API Standard 6A for BX flanges *



Nominal width NPS	Pressure stage Classe	Number	Ø d1	b	h	Bore Ø e
1 1/16	10000 15000	BX150	72.19	9.30	9.30	1.6
1 13/16	10000 15000 20000	BX151	76.40	9.63	9.63	1.6
2 1/16	10000 15000 20000	BX152	84.68	10.24	10.25	1.6
2 9/16	10000 15000 20000	BX153	100.94	11.38	11.38	1.6
3 1/16	10000 15000 20000	BX154	116.84	12.40	12.40	1.6
4 1/16	10000 15000 20000	BX155	147.96	14.22	14.22	1.6
7 1/16	10000 15000 20000	BX156	237.92	18.62	18.62	3.2
9	10000 15000	BX157	294.46	20.98	20.98	3.2
11	10000 15000	BX158	352.04	23.14	23.14	3.2
13 5/8	10000	BX159	426.72	25.70	25.70	3.2
13 5/8	5000	BX160	402.59	13.74	23.83	3.2
16 3/4		BX161	491.41	16.20	28.07	3.2
16 3/4	5000 10000	BX162	475.49	14.22	14.22	1.6
18 3/4	5000	BX163	556.16	17.37	30.10	3.2
18 3/4	10000	BX164	570.56	24.59	30.10	3.2
21 1/4	5000	BX165	624.71	18.49	32.03	3.2
21 1/4	10000	BX166	640.03	26.14	32.03	3.2
26 3/4	2000	BX167	759.36	13.11	35.86	1.6
26 3/4	3000	BX168	765.25	16.05	35.86	1.6
5 1/8	10000	BX169	173.52	12.93	15.84	1.6
9		BX170	218.03	14.22	14.22	1.6
11		BX171	267.44	14.22	14.22	1.6
13 5/8		BX172	333.07	14.22	14.22	1.6
30	2000 3000	BX303	852.75	16.97	37.95	1.6

Dimensions and numbers for MMD-IX

Table 9: Dimensions for Ring Joints Type IX according to DIN EN ISO 27509 for compact flanges according to DIN EN ISO 27509



Nominal width		Pressure stage Class	Number	Outer Ø	Inner Ø	Height
DN	NPS			Ø DG7	Ø DG1	H (HG5)
15	1/2	150 - 2500	IX15	30.19	22.2	10.00
20	3/4	150 - 2500	IX20	35.20	27.7	10.00
25	1	150 - 2500	IX25	42.22	34.2	10.00
40	1 1/2	150 - 2500	IX40	58.21	49.3	10.56
50	2	150 - 2500	IX50	71.13	61.3	11.78
65	2 1/2	150 - 2500	IX65	85.05	74.4	12.96
80	3	150 - 2500	IX80	100.96	89.5	14.24
100	4	150 - 2500	IX100	128.85	115.7	16.19
125	5	150 - 2500	IX125	156.75	142.0	17.94
150	6	150 - 2500	IX150	186.66	170.2	19.64
200	8	150 - 2500	IX200	238.54	220.5	22.36
250	10	150 - 2500	IX250	298.42	274.9	25.20
300	12	150 - 2500	IX300	347.36	325.0	27.15
350	14	150 - 2500	IX350	380.32	357.1	28.46
400	16	150 - 2500	IX400	434.27	409.3	30.47
450	18	150 - 2500	IX450	486.23	459.4	32.28
500	20	150 - 2500	IX500	539.20	511.6	34.06
550	22	150 - 2500	IX550	591.18	561.7	35.69
600	24	150 - 2500	IX600	642.16	611.9	37.25
650	26	150 - 2500	IX650	695.16	664.0	38.81
700	28	150 - 2500	IX700	747.16	714.1	40.25
750	30	150 - 2500	IX750	800.16	766.3	41.69
800	32	150 - 2500	IX800	851.16	816.4	43.03
850	34	150 - 2500	IX850	902.18	866.6	44.34
900	36	150 - 2500	IX900	956.19	918.7	45.65
950	38	150 - 2500	IX950	1007.21	968.8	46.88
1000	40	150 - 2500	IX1000	1060.23	1021.0	48.12
1050	42	150 - 2500	IC1050	1111.26	1071.1	49.29
1100	44	150 - 2500	IX1100	1162.28	1121.3	50.43
1150	46	150 - 2500	IX1150	1215.31	1173.4	51.59
1200	48	150 - 2500	IX1200	1266.35	1223.6	52.68

Surface quality according to Table 31 and tolerances according to Table 32 of DIN EN ISO 27509



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