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## Section 17: Product Part Numbering Index

## Common Metric–English Conversion Factors

## Metric/English Conversion Chart

Measurement	Multiply	by	to get:
Linear	millimeters (mm)	0.03937	inches
	inches	25.4	millimeters (mm)
	kilometers (km)	0.6214	miles
	miles	1.6093	kilometers (km)
Area	millimeters <sup>2</sup> (mm <sup>2</sup> )	0.00155	inches <sup>2</sup>
	inches <sup>2</sup>	645.16	millimeters <sup>2</sup> (mm <sup>2</sup> )
Volume	centimeters <sup>3</sup> (cm <sup>3</sup> )	0.06102	inches <sup>3</sup>
	inches <sup>3</sup>	16.387	centimeters <sup>3</sup> (cm <sup>3</sup> )
	1 cm <sup>3</sup> = 1 milliliter (mL)		
Acceleration	meter/second <sup>2</sup> (m/s <sup>2</sup> )	39.37	inch/second <sup>2</sup>
	inch/second <sup>2</sup>	0.0254	meter/second <sup>2</sup> (m/s <sup>2</sup> )
Velocity	meter/second (m/s)	3.281	feet/second
	feet/second	0.3048	meter/second (m/s)
Mass	kilogram (kg)	2.2046	pounds
	pounds	0.4536	kilogram (kg)
Force	kilograms-f (kgf)	9.807	Newtons (N)
	Newtons (N)	0.10194	kilograms-f (kgf)
	pounds-f	4.448	Newtons (N)
	Newtons (N)	0.2248	pounds-f
Pressure	bar	14.5	PSI
	PSI	0.069	bar
Torque	Newton-Meters (Nm)	8.851	pound-inches
	pound-inches	0.11298	Newton-Meters (Nm)
Moment of Inertia	centimeters <sup>4</sup> (cm <sup>4</sup> )	0.02403	inches <sup>4</sup>
	inches <sup>4</sup>	41.623	centimeters <sup>4</sup> (cm <sup>4</sup> )

## Metric Tap/Drill Specifications

Tap	Thread	Drill Size
M4	M4 x 0.7	3.3mm
M5	M5 x 0.8	4.2mm
M6	M6 x 1	5.0mm
M8	M8 x 1.25	6.8mm
M12	M12 x 1.75	10.2mm
M16	M16 x 2	14.0mm

## Common Tolerances Referenced in This Catalog

Tolerance	Max.	Min.
Ø10H8	+0.022	0
Ø19H7	+0.021	0
Ø28H7	+0.021	0
Ø38H7	+0.025	0
Ø6H8	+0.018	0
Ø8H8	+0.022	0
Ø6h6	0	-0.008
Ø12h6	0	-0.011
Ø19g6	-0.007	-0.020
Ø28g6	-0.007	-0.020
Ø38g6	-0.009	-0.025

## Quick Conversion Chart

Millimeters	Inches	Feet
20	0.79	0.07
30	1.18	0.10
45	1.77	0.15
60	2.36	0.20
90	3.54	0.30
180	7.09	0.59
1000	39.37	3.28
2000	78.74	6.56
5600	220.47	18.37
6000	236.22	19.68

## Section 17: Product Part Numbering Index

# Temperature Properties for Key Materials

## Metric Temperature Conversion

<b>Degrees Celsius</b>	$\frac{5 \times (\text{degrees F} - 32)}{9}$
<b>Degrees Fahrenheit</b>	$\frac{(9 \times \text{degrees C})}{5} + 32$

## Aluminum 6063-T6 Alloy Temperature Characteristics

Characteristic	Temperature Range	Observed Events
creep/elongation	less than 100° C	No observed increase in the amount of creep. Creep, or plastic elongation, is typically observed at prolonged exposure to temperatures in excess of 100° C.
ultimate and yield strength	up to 100° C	Metal retains approximately 95% of its original and ultimate yield strength.
	down to -100° C	Metal typically undergoes an approximately 10% increase in both ultimate and yield strength.

**NOTE:** Repeated cycling of metal through this type of thermal cycle can lead to eventual fatigue and subsequent failure.

## Temperature Ranges for Plastics

Material	Abrv.	Temperature Range in °C	
		Low	High
Polycarbonate	PC	-40C	115C
Polyethylene	PE		100C
Polyvinyl Chloride	PVC	-5C	60C
Polyoxymethylene	POM	-40C	100C
Polypropylene	PP		100C
Buna N Nitrile	NBR	-40C	120C*
Polyurethane	PU		92C
Polyurethane Elastomer	PUR	-25C	80C
Delrin® 100	Delrin 100	NA	90C
Polyamide 6	PA6	-40C	80C
Polyamide 12	PA12	-40C	80C
Polyamide 66	PA66	-40C	90C
Thermoplastic Elastomer	TPE		60C
ABS	ABS	-40C	70C

\* Dry air only

## Section 17: Product Part Numbering Index

# Technical Specifications for Key Materials

## Delrin® 100 Technical Specifications

Characteristic	Units	Specifications
Specific Gravity	g/cm	1.41 - 1.42
Rockwell Hardness		R119 - 112
Water Absorption	%	0.25
Shear Strength	psi	9,500
Compressive Strength	psi	18,000
Tensile Strength	psi	10,000
Dielectric Strength	v/mm	380 - 500
Flexural Modulus of Elasticity		375,000
Flexural Yield Strength	psi	14,300
Elongation	%	12 - 75
Max. Continuous Temp.	C (F)	90° (195°)
Melting Point	C (F)	175° (347°)
Density		88.6
Coefficient of Friction	%	0.12
Effect of Weak Acids		Resistant to Some
Effect of Strong Acids		Attacked
Effect of Weak Alkalies		Resistant to Some
Effect of Strong Alkalies		Attacked
Effect of Organic Solvents		Excellent Resistance
Key Words		Impact Resistant
Machinability		Excellent
Compliances		FDA and USDA



## Section 17: Product Part Numbering Index

# Making Basic Connections

## Using T-bolts and T-nuts

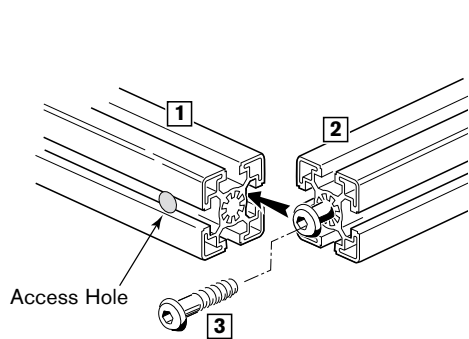
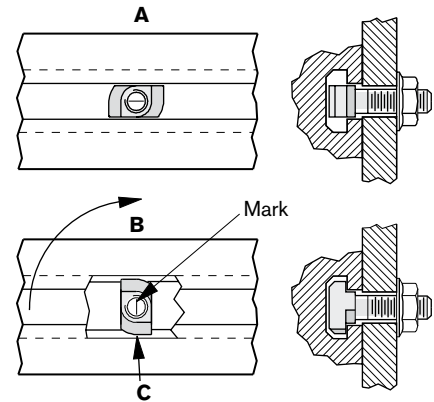
Bosch Rexroth Aluminum Structural Framing components attach to a profile's T-slot using T-bolts or T-nuts.

The drawing to the right illustrates the procedure for using T-bolts and T-nuts. First insert the T-bolt into slot (A), and tighten down the flange nut. As the nut tightens, it will turn the T-bolt 90° in the slot (B), creating a friction lock (C).

The same principle applies to T-nuts. Refer to the appropriate catalog page or Section 17 for torque specifications.

### ASSEMBLY HINT:

T-bolts have a mark on the end of the threaded shaft that is in line with the T-bolt head. The T-bolt is correctly positioned when this mark is perpendicular to the T-slot.



## Using Connection Screws

When using a connection screw to make a 90° connection, an access hole must first be drilled into the end of profile (1) as shown at left. Dimensions vary depending on the profile size and can be found on the appropriate profile page in this catalog.

After drilling the access hole in the end of profile (1), thread a connection screw (3) into the end of profile (2). Tighten the screw until the threads are all the way

into the profile end, leaving enough of the screw exposed to slide freely along the T-slot.

Now slide the profile with connection screw (2) into the T-slot of profile (1), adjacent to the access hole.

Tighten the connection screw through the access hole in profile (1) with the appropriate size Allen wrench. Refer to the appropriate catalog page or Section 17 for torque specifications.

## Installing Gussets

Insert T-bolts with flange nuts threaded onto the ends through the gusset mounting holes. Line the gusset up in the profile's T-slot using the alignment tabs on the gusset. Insert the T-bolt into the profile's T-slot, then tighten the flange nut to turn and lock the T-bolt.

Refer to the appropriate catalog page or Section 17 for torque specifications.

