

## Marking-off tables, Typ ARP

Stolle marking-off tables are distinguished by their highly dense and plain surface structure. Exceptional strength and durability of the surface are guaranteed by a special cast iron / steel alloy. Our special casting process and the rib design with T-form reinforcements ensure high stiffness against bending and twisting of the plate.

Provided the plates are stored and supported correctly subsequent distortion of the plate surface is eliminated due to the various finishing stages.

The plate surface can be machined to DIN 876/III, II or I. The edges are machined square to the surface. The measuring plates can be marked with a precise grid pattern lines or T slots according to DIN 650. Special machining of the sides for fitting measuring machines is also possible. The plates are mounted on supports type VS/VSK.

Plate size approx. mm	Plate thickness approx. mm	Rib height approx. mm	Plate height approx. mm	Weight approx. kg	Number of required supports
1500 x 1000	40	175	215	820	5
2000 x 1000	40	205	245	1120	5
2000 x 1250	50	200	250	1600	6
2000 x 1500	50	200	250	2040	5
2000 x 2000	50	200	250	2530	5
2500 x 1000	50	200	250	1730	6
2500 x 1250	50	200	250	2020	6
2500 x 1500	50	200	250	2470	8
2500 x 2000	50	200	250	3050	8
3000 x 1000	50	200	250	2100	6
3000 x 1500	50	200	250	2980	8
3000 x 2000	50	250	300	3940	8
3000 x 2500	50	250	300	5100	9
3000 x 3000	50	300	350	6190	13
3500 x 1000	50	200	250	2460	8
3500 x 1500	50	200	250	3500	11
3500 x 2000	50	250	300	4630	11
3500 x 2500	50	250	300	5970	12
4000 x 1000	50	200	250	2820	8
4000 x 1500	50	200	250	4000	11
4000 x 2000	50	250	300	5300	11
4000 x 2500	50	250	300	6850	12
4000 x 3000	50	300	350	8320	18
4500 x 1500	50	200	250	4450	11
4500 x 2000	50	250	300	5850	11
4500 x 2500	50	250	300	7600	12
4500 x 3000	50	300	350	9200	18
5000 x 1000	50	250	300	3780	10
5000 x 1500	50	250	300	5330	14
5000 x 2000	50	250	300	6540	14
5000 x 2500	50	250	300	8500	15
5000 x 3000	50	300	350	10230	23

Prices for other sizes and surface accuracies on request!



## Surface accuracy and tolerances

The surfaces of clamping, marking, and surface plates are machined according to DIN 876.

A minimum of 3 points are used for measuring the surface accuracy of the plates. The ribbing designed for the specific application transmits the forces occurring during use to the supporting points, providing a correspondingly small level of deformation in the surface to be measured and a high level of surface accuracy.

## Surface characteristics:

- DIN 876 /III planed / milled
- DIN 876 /II fine planed / milled
- DIN 876 /I fine milled
- DIN 876 /0 fine scraped with bluing

## Flatness tolerances:

The flatness tolerances specify the permissible deviation in  $\mu\text{m}$  of the measured surface over the entire length L of the longest edge of the plate. Reference temperature 20 °C

- DIN 876 /III =  $40 + L : 25 = \mu\text{m}$
- DIN 876 /II =  $20 + L : 50 = \mu\text{m}$
- DIN 876 /I =  $10 + L : 100 = \mu\text{m}$
- DIN 876 /0 =  $4 + L : 250 = \mu\text{m}$

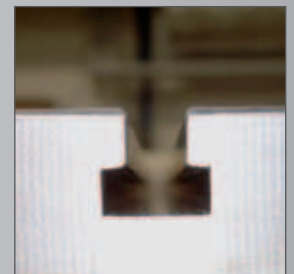
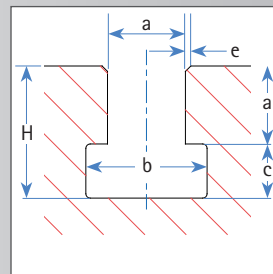
## Tolerance tables

L mm	200	300	500	800	1000	1200	1500	2000	2500
DIN 876 / III	48	52	60	72	80	88	100	120	140
DIN 876 / II	24	26	30	36	40	44	50	60	70
DIN 876 / I	12	13	15	18	20	22	25	30	35
DIN 876 / 0	4,8	5,2	6	7,2	8	8,8	10	12	14

L mm	3000	3500	4000	4500	5000	5500	6000	6500	7000
DIN 876 / III	160	180	200	220	240	260	280	300	320
DIN 876 / II	80	90	100	110	120	130	140	150	160
DIN 876 / I	40	45	50	55	60	65	70	75	80
DIN 876 / 0	16	18	20	22	24	26	28	30	32

## T-slots

The T-slots are machined to DIN 650 H12 as standard. Machining to higher levels of accuracy in the tolerance zones H7 or H8 is also possible! Special T-slot dimensions available on request!



Nominal size: a	for bolts	b	c	H	e
10 mm	M8	17,5 - 18 mm	8 mm	18 mm	1,0 mm
12 mm	M10	20,5 - 21 mm	9 mm	21 mm	1,0 mm
14 mm	M12	1/2"	23,5 - 24 mm	10 mm	1,0 mm
16 mm	M14		26,5 - 27 mm	11 mm	1,0 mm
18 mm	M16	5/8"	29,5 - 30 mm	12 mm	1,5 mm
20 mm	M18		33,5 - 34 mm	14 mm	1,5 mm
22 mm	M20	3/4"	37,5 - 38 mm	16 mm	1,5 mm
24 mm	M22	7/8"	41,0 - 42 mm	18 mm	1,5 mm
28 mm	M24	1"	47,0 - 48 mm	20 mm	1,5 mm
32 mm	M27	1 1/8"	54 mm	22 mm	1,5 mm
36 mm	M30	1 1/4"	60 mm	25 mm	2,0 mm
42 mm	M36	1 1/2"	70 mm	29 mm	2,0 mm

## Machined T-slots according to DIN 650

in tolerance zone H 12, keyways in tolerance zones of H7 or H8 available at extra cost