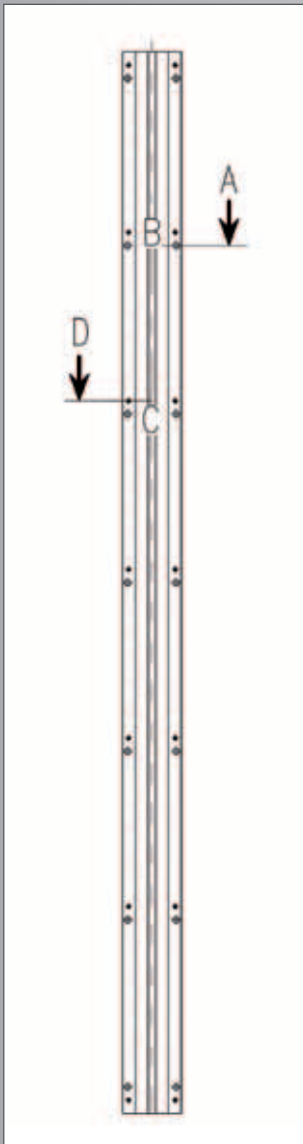
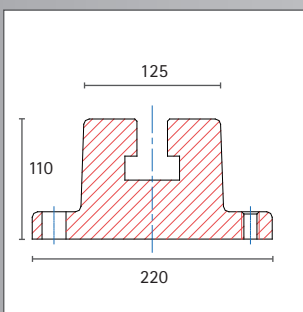


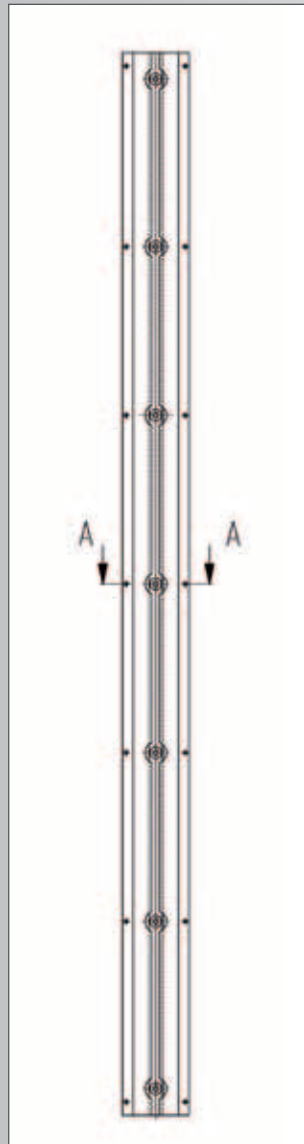
Type A floor clamping rail



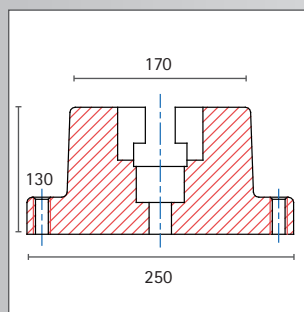
Section A-D



Type B floor clamping rail



Section A-A



Floor with clamping rails

Stolle floor clamping rails have a wide range of use. Large installation sites can be equipped with versatile clamping possibilities by laying the rails end to end. The floor clamping rails are mounted to the floor using anchor bolts and level screws, then exactly aligned and grouted in place. This provides a surface with the required clamping possibilities. Stolle floor clamping rails have an excellent surface finish. Each rail comes with a T-slot according to DIN 650 and T-slot removal pockets. Floor clamping rails Type A are mounted to the floor using anchor bolts located at both sides of the rail.

Floor clamping rails type B have anchor holes located in the center of the T-slot. The abutting surfaces are machined square to the working surface to allow exact positioning of multiple single rails.

## 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 =  $4 + L : 250 = \mu\text{m}$

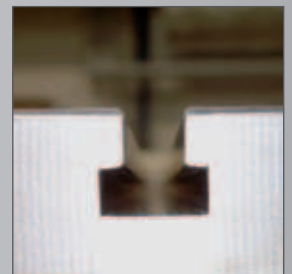
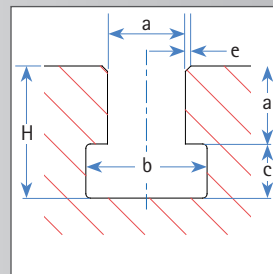
## Tolerance tables

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	24 mm	1,0 mm
16 mm	M14		26,5 - 27 mm	27 mm	1,0 mm
18 mm	M16	5/8"	29,5 - 30 mm	30 mm	1,5 mm
20 mm	M18		33,5 - 34 mm	34 mm	1,5 mm
22 mm	M20	3/4"	37,5 - 38 mm	38 mm	1,5 mm
24 mm	M22	7/8"	41,0 - 42 mm	42 mm	1,5 mm
28 mm	M24	1"	47,0 - 48 mm	48 mm	1,5 mm
32 mm	M27	1 1/8"	54 mm	54 mm	1,5 mm
36 mm	M30	1 1/4"	60 mm	61 mm	2,0 mm
42 mm	M36	1 1/2"	70 mm	74 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