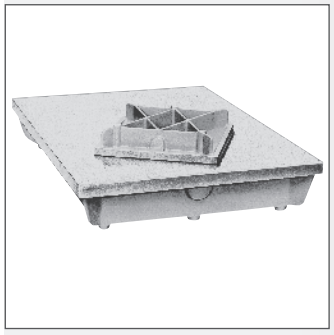
Blueing plates



Blueing plates, Type TLN

Plate size approx. mm	Plate height approx. mm	Weight approx. kg
200 x 200	65	7
300 x 200	65	10
300 x 300	85	19
400 x 300	85	25
400 x 400	85	27
500 x 400	95	37
500 x 500	100	50
600 x 400	100	55
600 x 500	100	59
600 x 600	125	81
700 x 500	125	88
800 x 500	125	100
800 x 600	145	127
800 x 800	150	176
1000 x 600	150	164
1000 x 800	175	236
1000 x 1000	175	290
1200 x 800	175	287

Stolle blueing plates are made from a special cast iron / steel alloy. The plate surface is machined to different levels of accuracy according to DIN 876 and the edges are machined angular.

DIN 876/III planed / milled
DIN 876/II, I, 0 milled / scraped

The plates can be equipped with protective covers, handles, or table bearings if required.
The plates are delivered standard in RAL 6011 (green) paint. Other RAL colours are available on request.

The blueing plates are mounted on support frames UU with adjustment bolts or cabinets. Supports type VS/VSK can be used for larger dimensions.

Accessories for blueing plates

	up to plate size mm
Handles for TLN	400 x 400 700 x 500
Table bearing	Consisting of a supporting bolt with a ball head, that is mounted in a lower part and is adjustable in height, locked with a nut. Adjustable from approx. 95 to 120 mm. We recommend 3, 4, or 5 pieces per plate.

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

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

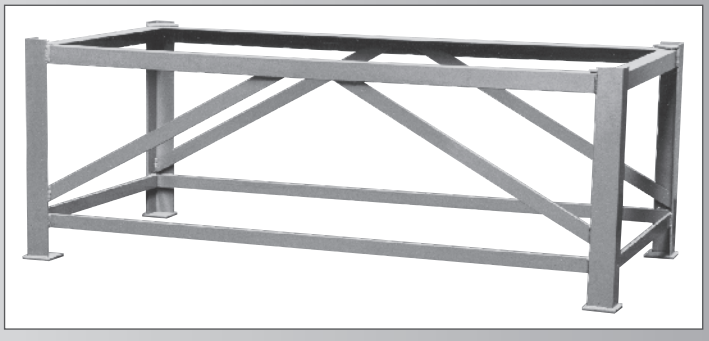
Support frame / Cabinets

Universal support frame, Type UU

Plate size approx. mm	Number of legs	Weight approx. kg
400 x 400	4	16
500 x 500	4	27
600 x 600	4	29
700 x 700	4	42
800 x 800	4	46
1000 x 800	4	50
1000 x 1000	4	54
1200 x 800	4	54
1200 x 1000	4	65
1500 x 1000	4	72
2000 x 1000	4	86
2000 x 1500	6	105

Other dimensions on request.

Sturdy welded iron-support frame for supporting straightening plates, blueing plates and marking-off plates with a working height of approx. 800 mm. Other working heights are available on request.
For larger straightening plates we recommend supporting using the VS/ VSK supports. For blueing plates we recommend supporting on a frame with adjustment bolts.



Cabinets

The cabinets are made of sheet metal, with lockable doors and internal shelves available on request.

Adjustable height supports, Type VS

These cast supports are suitable for the installation of marking-off and measuring tables as well as larger straightening and welding plates.

An adjustable M 30 supporting bolt (M 20 for small plates) allows exact alignment of the plate.
Please find the correct number of supports required for marking-off tables in the appropriate table. The number of supports must be increased for extremely heavy loads. The supports can also be supplied with a machined base. Additional cost 30,- €.

No.	Support height h approx. mm	Weight approx. kg
0	220 - 270	15
1	270 - 320	24
2	340 - 390	29
3	425 - 475	32
4	530 - 580	38
5	575 - 625	43
6	630 - 680	47
7	695 - 745	49

Support with ball-bearings for precise adjustment of measuring and marking-off plates to high levels of accuracy.
Additional cost 35,- €.

Support - Type VSK

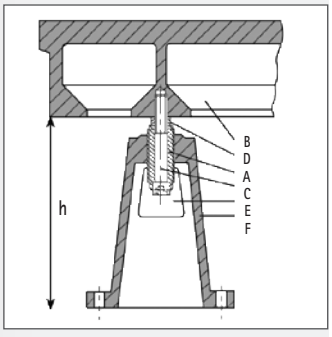
Levelling units, Type BE

The BE provides a solid connection between marking-off or clamping plates and the foundation.

It is used for (e.g.) measuring plates with side-oriented measuring machines with horizontal arm to prevent the plate from tipping over. The plate surface can be aligned to the desired tolerance by pulling and pushing. The alignment support is anchored to the foundation and the surface alignment occurs at the underside of the plate.

Levelling utilizing the forcing screw A. The fastening bolt C is used to secure the plate and counter pressure is applied using the forcing screw at the same time.

No.	Support height h approx. mm	Weight approx. kg
1	320	45
2	420	52
3	520	60



A: Forcing screw
B: Plate
C: Fastening bolt
D: Hardened ball socket joint
E: Access opening
F: Support
h: Block height including screw