

Архангельск (8182)63-90-72
Астана (7172)727-132
Астрахань (8512)99-46-04
Барнаул (3852)73-04-60
Белгород (4722)40-23-64
Брянск (4832)59-03-52
Владивосток (423)249-28-31
Волгоград (844)278-03-48
Вологда (8172)26-41-59
Воронеж (473)204-51-73
Екатеринбург (343)384-55-89
Иваново (4932)77-34-06

Ижевск (3412)26-03-58
Иркутск (395)279-98-46
Казань (843)206-01-48
Калининград (4012)72-03-81
Калуга (4842)92-23-67
Кемерово (3842)65-04-62
Киров (8332)68-02-04
Краснодар (861)203-40-90
Красноярск (391)204-63-61
Курск (4712)77-13-04
Липецк (4742)52-20-81
Киргизия (996)312-96-26-47

Магнитогорск (3519)55-03-13
Москва (495)268-04-70
Мурманск (8152)59-64-93
Набережные Челны (8552)20-53-41
Нижний Новгород (831)429-08-12
Новокузнецк (3843)20-46-81
Новосибирск (383)227-86-73
Омск (3812)21-46-40
Орел (4862)44-53-42
Оренбург (3532)37-68-04
Пенза (8412)22-31-16
Казахстан (772)734-952-31

Пермь (342)205-81-47
Ростов-на-Дону (863)308-18-15
Рязань (4912)46-61-64
Самара (846)206-03-16
Санкт-Петербург (812)309-46-40
Саратов (845)249-38-78
Севастополь (8692)22-31-93
Симферополь (3652)67-13-56
Смоленск (4812)29-41-54
Сочи (862)225-72-31
Ставрополь (8652)20-65-13
Таджикистан (992)427-82-92-69

Сургут (3462)77-98-35
Тверь (4822)63-31-35
Томск (3822)98-41-53
Тула (4872)74-02-29
Тюмень (3452)66-21-18
Ульяновск (8422)24-23-59
Уфа (347)229-48-12
Хабаровск (4212)92-98-04
Челябинск (351)202-03-61
Череповец (8202)49-02-64
Ярославль (4852)69-52-93

<https://sbm.nt-rt.ru/> || sfb@nt-rt.ru

piston rod



The guide column is the connecting part that supports hydraulic cylinder, most of which is used in the oil cylinder and cylinder movement execution part, and is a moving part with high movement frequency and high technical requirement. Taking hydraulic cylinder as an example, the cylinder, piston rod (oil cylinder rod), piston and end cover are made up of several parts. The quality of processing directly affects the life and reliability of the whole product. Piston rod processing requirements are high, and its surface roughness is required to be Ra0.4 ~ 0.8um, which is strict to coaxiality and abrasion resistance. The basic characteristic of oil cylinder rod is long and thin shaft processing, its processing difficulty is big, always perplexed processing personnel.

Therefore, it can improve the surface anti-corrosion ability and delay the production or expansion of fatigue cracks, thus improving the fatigue strength of oil cylinder. Roll forming, by forming a layer of cold work roll surface hardening layer, reducing the grinding pair of elastic and plastic deformation of the contact surface, thus improve the abrasion resistance on the surface of the cylinder rod, at the same time avoid the burn caused by grinding. After rolling, the surface roughness value decreases, which can improve the coordination property. At the same time, the friction damage to the sealing ring or seal is reduced when the piston motion of the oil cylinder is decreased, and the overall service life of the cylinder is improved. Rolling process is an efficient and high quality technological measure.

Piston rod technical standard
F7-F9
Guide column tolerance size
Ra 0.3-0.6
The surface roughness of the guide column
HRC58-64 : 1-3mm
The surface hardness of the guide column Piston rod surface depth
0.02-0.05
Precision of guide column machining
100m (5um)
Guide line straightness
0.025-0.035
guidepost