

# CUSTOM MODIFICATIONS



The modifications shown below are only those most frequently requested and do not represent the limit of our capabilities with regards to size ranges and tolerances. Also, please refer to the worksheet templates provided on pages 25-27.

Modification	Type	Description	Tolerances	How To Order: Examples
	<b>ML</b>	<b>REDUCED OVERALL LENGTH</b> Stock removal from front-end. Minimum length .500". Lengths under .500" per special quote only.	+ .015" - .000"	SQD .230 ML=1.063 HSS B-1 .030 ML=1.750 RQA .056 ML=1.500
	<b>CL</b>	<b>PRECISION OVERALL LENGTH</b> Same as above except closer tolerance held.	+/- .001"	RQB .175 CL=2.157 RCX-9 CL=5.312 PT-5-1/2 CL=4.093
	<b>MT</b>	<b>REDUCED HEAD THICKNESS</b> Shorter head than standard. Stock removal from back of head Shortens overall length	+ .010" - .000"	SQD .157 X2-1/2 TS, MT=.094 RC-17 L-3, MT=.156
	<b>CT</b>	<b>PRECISION HEAD THICKNESS</b> Same as above except closer tolerance held.	+/- .001"	SQD .204 X 2 1/2 HSS, CT=.118 RQB .090 X 2-1/2, CT=.090 RQA .130 X 6, CT=.083
	<b>MH</b>	<b>REDUCED HEAD DIAMETER</b> Head diameter smaller than standard. Minimum head diameter equals "D". Grinding head diameter on RQA does not change head thickness.	+/- .001"	RQB .240 X 4, MH=.280 SQD .370 X 2-1/2 HSS, MH=.437 PT-11 L-6, MH=.250
	<b>PS</b>	<b>PUNCH STEP</b> "B" = .750" Max. Specify "B" or "SBR" and "P" including tolerance	B +.06" -.00" SBR +.06" -.00"	RQB-PS .125 X 2-1/2, P=.093 +.0003/-0, B=.500 CPB-PS-12 X 2-1/2, P=.109+.0005/-0, B=.625 PPB-PS 37 X 3, P=.290 +.0002/-0, SBR=.437 AB-20-PS .312 X 3-1/2, P=.255 +.0003/-0, B=.500
	<b>CS</b>	<b>CORE PIN STEP - STRAIGHT</b> "B" = .750" Max. Should be ordered in conjunction with "CL" modification and "CT" if required. Specify "B", "P", "CL" and "CT" if required.	B +/- .001" CL +/- .001" CT +/- .001" P1 +.001"/-0 P - Specify	RQB-CS .067, CL=.940, B=.210, P=.050 RCX-13-CS, CL=2.590, B=.700, P=.157 PT-10-CS, CL=3.750, B=.730, P=.133
	<b>CSD</b>	<b>CORE PIN STEP - DRAFT</b> B=.750" max. Includes custom modifications "CL" and "CT" if required. Specify "B", "P1", "P2", "CL" and "CT" if required.	B +/- .001" CL +/- .001" CT +/- .001" P1 +.001"/-0 P2 +.001"/-0	RCX-19 -CSD, CL=2.187, B=.431, P1=.255, P2=.263 RQB-CSD .236, CL=.870, B=.575, P1=.197, P2=.207, CT = .125
	<b>PN</b>	<b>PILOT NOSE</b> Pilot nose is included in the overall length.	Standard	SQF-PN .250 X 2-1/2 HSS B-15-PN .238 X 3 RQA-PN .136 X 2-1/2
	<b>SR</b>	<b>SPHERICAL RADIUS</b> Radius is half the diameter. Also specify "ML" or "CL" AND "CT" if required.	Standard	RQB-SR .060 X 2-1/2 AB-7-SR .125 X 2 RCX-11-SR L-3
<b>Coatings</b>	<b>TiN</b>	<b>TITANIUM NITRIDE COATING</b> PVD wear resistant thin film coating. TiN is an excellent coating for wear part applications demanding resistance to abrasive and adhesive wear. Typical coating thickness is .00005" to 00010" per side.	Diameter tolerances are before coating only. We cannot guarantee tolerance after coating.	RQB .075 X 4 TiN
	<b>D I C R O N I T E</b>	<b>PERMANENT DRY-LUBE TREATMENT</b> A Tungsten Disulfide coating that provides a thin barrier between opposing metal surfaces and prevents metal to metal contact to improve lubricity. Applied at room temperature and unaffected by the heat of the molding process, it will extend the life of the pins while providing fail safe protection by eliminating galling and seizing. Diconite does not migrate to the molded surface. Typical coating thickness is .000020" per side.	Diameter tolerances are before coating only. We cannot guarantee tolerance after coating.	RX-25 L-10 DICRONITE PT-5-2 L - 6 DICRONITE