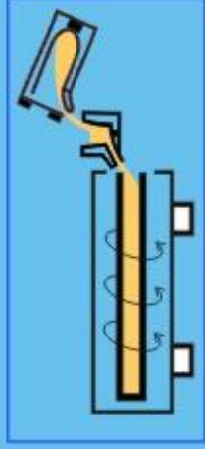


Centrifugal Cast Iron Hollow Bars Stock sizes & weights



PRINCIPLES OF CENTRIFUGAL CASTING
Molten metal is poured into a horizontal revolving mould. The centrifugal force generated by the revolving mould plus the friction created between the molten metal and the mould wall ensures even distribution of the metal. Then centrifugal force also separates the dissolved gases and impurities such as slag, where it collects in the base.

Inside Diameter (Nominal)

| MM | 45 | 50 | 55 | 65 | 70 | 80 | 95 | 105 | 120 | 130 | 145 | 155 | 165 | 180 | 190 | 205 | 215 | 245 | 270 | 295 | 320 | 345 | 370 | 395 | 420 | 445 | 470 | 495 | MM | |
|-----|-------|-------|-------|-------|------|-------|------|-------|------|-------|------|-------|-----|-------|-----|-------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-------|
| INS | 2 | 2 1/4 | 2 1/2 | 2 3/4 | 3 | 3 1/2 | 4 | 4 1/2 | 5 | 5 1/2 | 6 | 6 1/2 | 7 | 7 1/2 | 8 | 8 1/2 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | INS | |
| 80 | 3 | 8.3 | 7.3 | 6.1 | 4.8 | | | | | | | | | | | | | | | | | | | | | | | | | 3 |
| 95 | 3 1/2 | 12.2 | 11.2 | 10 | 8.7 | 7.2 | | | | | | | | | | | | | | | | | | | | | | | | 3 1/2 |
| 105 | 4 | 16.5 | 15.5 | 14.5 | 13 | 11.5 | 8.3 | | | | | | | | | | | | | | | | | | | | | | | 4 |
| 120 | 4 1/2 | 21.5 | 20.5 | 19.5 | 18 | 16.5 | 13.5 | 9.4 | | | | | | | | | | | | | | | | | | | | | | 4 1/2 |
| 130 | 5 | 27 | 26 | 25 | 23.5 | 22 | 19 | 15 | 10.5 | | | | | | | | | | | | | | | | | | | | | 5 |
| 145 | 5 1/2 | 33 | 32 | 31 | 30 | 28 | 25 | 21 | 16.5 | 11.5 | | | | | | | | | | | | | | | | | | | | 5 1/2 |
| 155 | 6 | 40 | 39 | 38 | 36 | 35 | 32 | 28 | 23 | 18 | 12.5 | | | | | | | | | | | | | | | | | | | 6 |
| 170 | 6 1/2 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 6 1/2 |
| 185 | 7 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 7 |
| 210 | 8 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 8 |
| 235 | 9 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 9 |
| 260 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 10 |
| 285 | 11 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 11 |
| 310 | 12 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 12 |
| 335 | 13 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 13 |
| 360 | 14 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 14 |
| 385 | 15 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 15 |
| 410 | 16 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 16 |
| 435 | 17 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 17 |
| 460 | 18 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 18 |
| 490 | 19 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 19 |
| 510 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 20 |
| 540 | 21 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 21 |
| 565 | 21 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 21 |
| INS | 2 | 2 1/4 | 2 1/2 | 2 3/4 | 3 | 3 1/2 | 4 | 4 1/2 | 5 | 5 1/2 | 6 | 6 1/2 | 7 | 7 1/2 | 8 | 8 1/2 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | INS | |
| MM | 45 | 50 | 55 | 65 | 70 | 80 | 95 | 105 | 120 | 130 | 145 | 155 | 165 | 180 | 190 | 205 | 215 | 245 | 270 | 295 | 320 | 345 | 370 | 395 | 420 | 445 | 470 | 495 | MM | |

KILOGRAMS PER FOOT (KG/FT) - Approximate only

Outside Diameter (Nominal)

- Machining Allowance:** 3-mm approx. diameter outside inside diameter, approx. 5-7mm to 205mm (OD) inside diameter, approx. 10-14mm over 205mm (OD)
- Normal finish:** Proof machined outside diameter, as cast inside diameter
- Standard length:** 1000mm (39'-40')
- Non-standard sizes:** by diameter and/or length by quotation only.

Denotes: Size supplied

Denotes: Nominal finished size

| Specifications | Type | Structure | Tensile Strength | Elongation | Hardness |
|----------------|--------------|------------|-------------------------------|------------|---------------|
| 2P | Grey Iron | *Pearlitic | 220-260 Mpa (32 - 37,000 psi) | Nil | 207 - 269 BHN |
| 3D | Ductile Iron | *Ferritic | 400 Mpa (50,000 psi) | 12% | 187 BHN max |

Similar Grades:

- 2P BS 1452 Grade 17 ASTM, A48 Class 35/40 AS 1830H 269
- 3D BS 2789 SNG 27/12 ASTM, A536 Class 60.45.12, AS 1831 400-250-12
- Other grades to order including ductile irons, ni-resist and ductile ni-resist.