

Series	Description
NI-WV <i>metric sizes</i>	Induction hardened and hard chrome plated linear shafts steel grade: Cf53, C55E, C45E / Ø4 - 100 mm

Steel grades correspondents

EN	Werkstoff	DIN	B.S.	UNI	JIS	GOST	AISI SAE ASTM
C53	1.1213	Cf53 (C53G)	070M55	C53	S50C	50	1050
C55E	1.1203	Ck55	060A57, 070M55	C55	S55C, S55CM	55	1055
C45E	1.1191	Ck45	080M46	C45	S45C	45	1045
C60E	1.1221	Ck60	060A62, 070M60	C60	S58C	60, 60G, 60GA	1060

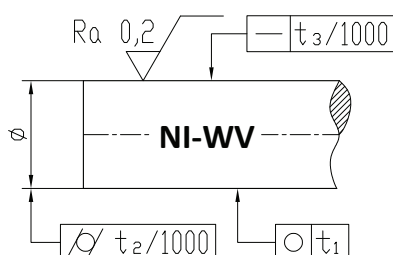
Chemical composition - % by weight

Steel grade	Norm	C	Si	Mn	P	S	Cr	Ni.	Mo	V
Cf53	DIN 17212	0.50 ÷ 0.57	0.15 ÷ 0.35	0.40 ÷ 0.70	max. 0.025	max. 0.035	-	-	-	-
C55E	EN 10083-2	0.52 ÷ 0.60	max. 0.4	0.60 ÷ 0.90	max. 0.030	max. 0.035	max. 0.4	max. 0.4	max. 0.1	-
C45E	EN 10083-2	0.42 ÷ 0.50	max. 0.4	0.50 ÷ 0.80	max. 0.030	max. 0.035	max. 0.4	max. 0.4	max. 0.1	-
C60E	EN 10083-2	0.57 ÷ 0.65	max. 0.4	0.60 ÷ 0.90	max. 0.030	max. 0.035	max. 0.4	max. 0.4	max. 0.1	-

Mechanical properties for steel bars

Steel grade	Diameter Ø mm	Tensile strength R _m N/mm ²	Yield strength R _{p0.2} N/mm ²	Elongation A ₅ %	Hardness Brinell HB
C45E+N	Ø ≤ 16	min. 620	min. 340	min. 14	min. 190
	16 < Ø ≤ 100	min. 580	min. 305	min. 16	min. 172
Cf53+N	Ø ≤ 16	610 - 760	min. 340	min. 16	min. 183
	16 < Ø ≤ 100	610 - 760	min. 340	min. 16	-
C55E+N	Ø ≤ 16	min. 680	min. 370	min. 11	min. 208
	16 < Ø ≤ 100	min. 640	min. 330	min. 12	min. 198
C60E+N	Ø ≤ 16	min. 710	min. 380	min. 10	min. 218
	16 < Ø ≤ 100	min. 670	min. 340	min. 11	min. 203

N=normalized



Shaft Diameter Ø	Weight kg/m	Series	Standard length mm	Surface hardening depth SHD mm	Roundness (circularity)		Parallelism (cylindricity)		Straightness t3 max. mm/m	Standard tolerance ISO h7 µm
					t1 max. µm	t2 max. µm	t3 max. mm/m			
4	0.10	NI-WV 4	4000	0.4 + 0.4	5	10	0.30	0 / -12		
5	0.15	NI-WV 5	4000	0.4 + 0.4	5	10	0.25	0 / -12		
6	0.22	NI-WV 6	6000	0.4 + 0.4	5	10	0.25	0 / -12		
8	0.39	NI-WV 8	6000	0.4 + 0.4	6	10	0.20	0 / -15		
10	0.62	NI-WV 10	6000	0.4 + 0.4	6	10	0.20	0 / -15		
12	0.89	NI-WV 12	6000	0.6 + 0.6	8	12	0.20	0 / -18		
14	1.21	NI-WV 14	6000	0.6 + 0.6	8	12	0.20	0 / -18		
15	1.39	NI-WV 15	6000	0.6 + 0.6	8	12	0.20	0 / -18		
16	1.58	NI-WV 16	6000	0.6 + 0.6	8	12	0.20	0 / -18		
20	2.46	NI-WV 20	6000	0.9 + 0.8	9	12	0.20	0 / -21		
25	3.85	NI-WV 25	6000	0.9 + 0.8	9	12	0.15	0 / -21		
30	5.55	NI-WV 30	6000	0.9 + 0.8	9	12	0.15	0 / -21		
35	7.55	NI-WV 35	6000	1.5 + 1.3	11	15	0.15	0 / -25		
40	9.86	NI-WV 40	6000	1.5 + 1.3	11	15	0.15	0 / -25		
45	12.48	NI-WV 45	6000	1.5 + 1.3	11	15	0.15	0 / -25		
50	15.41	NI-WV 50	6000	1.5 + 1.3	11	15	0.15	0 / -25		
60	22.20	NI-WV 60	6000	2.2 + 1.6	13	15	0.15	0 / -30		
70	30.20	NI-WV 70	6000	2.2 + 1.6	13	15	0.15	0 / -30		
80	39.44	NI-WV 80	6000	2.2 + 1.6	13	15	0.15	0 / -30		
90	49.92	NI-WV 90	6000	2.2 + 1.6	15	18	0.15	0 / -35		
100	61.62	NI-WV 100	6000	3.2 + 2.0	15	18	0.15	0 / -35		

- ✓ Surface hardness: 62±2 HRC
- ✓ Chrome layer thickness: 12±5 µm
- ✓ Chrome layer microhardness: 900-1100HV0.1
- ✓ Surface roughness: Ra: max. 0.20 µm
- ✓ Length tolerance: ±200 mm
- ✓ Steel grades: Cf53, C55E, alternative C45E, C60E
- ✓ Surface hardening depth, SHD: according to EN ISO 15787
- ✓ On request: special lengths, tolerances and dimensions

✓ The hardening depth (SHD according to EN ISO 15787 or Rht according to DIN 6773) is defined as the distance from the steel surface up to the point where the hardness value is 80% of the minimum guaranteed value of the surface hardness and it is established in accordance with ISO 13012, depending on the shaft's size.

✓ The minimum guaranteed value of the surface hardness varies between the steel grade.