

PRECISION HARDENED ADHESIVE STRIPS **VARIODUCT**

Hardened and ground 'adhesive strips' are commonly used for both new machinery and equipment as well as in retrofit applications. VarioDuct is a standard program offering typical adhesive strip dimensions, with a thickness of 4 mm, freely selectable length, and optional chamfers on the longitudinal edges. Your desired length is quickly produced through cooled CBN cut-off grinding, and the desired chamfers can be ground up to $2 \times 45^\circ$ per edge. Chamfers are typically applied when the strips are to be glued into a milled groove in the machine bed. You can calculate your adhesive strip configuration online at:

www.varioduct.de.

Specifications:

Material: 1.2842 / 90 MnCrV 8

Hardness: 58 – 62 HRC

Thickness: 4 mm

VarioDuct is available in standard widths:

20, 25, 30, 35, 40, 45, 50, 55, 60, and 80 mm.

The length is freely selectable between 100 and 3,100 mm. Top side: Fine grinding, $R_a = 0.8 \mu\text{m}$

Bottom side: Cross grinding, $R_a = 6 \mu\text{m}$

(Rough for better adhesive bonding)

Tolerances:

Thickness: $+0.05 / -0$ mm

Width: $+0.20 / -0$ mm

Length: with cut-off grinding ± 1 mm,
upon request with angular end grinding $+0 / -0.2$ mm

Chamfers are possible up to $2 \times 45^\circ$ on the selected longitudinal edges.

Sample prices for 2 pieces, adhesive side down with 2 longitudinal chamfers, and end sides cut-off ground:

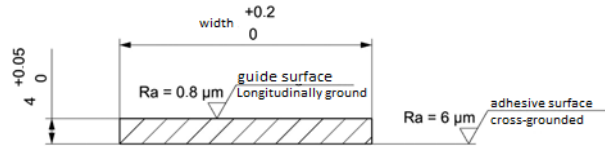
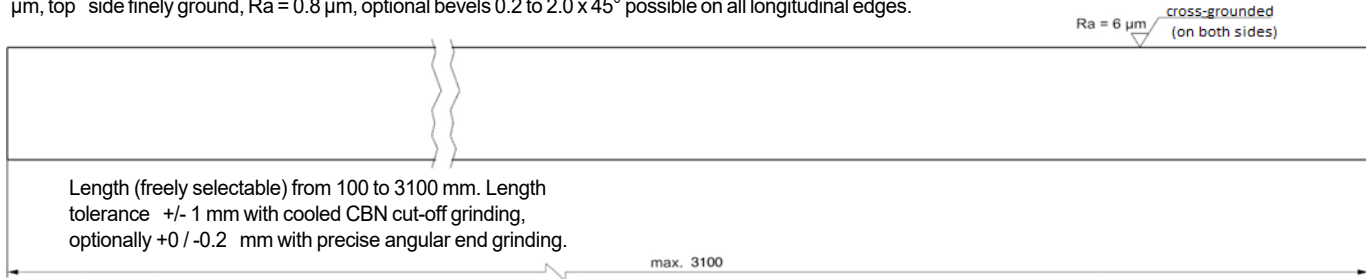
thickness 4mm

price per piece

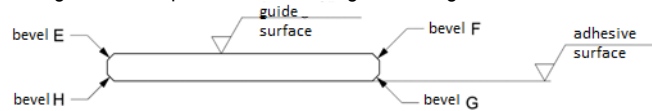
		width [mm]									
		20	25	30	35	40	45	50	55	60	80
length [mm]	1000	119	125	130	131	136	140	145	149	164	182
	2000	211	222	234	235	245	253	262	271	301	337
	3000	303	320	337	340	354	366	380	393	438	492



VarioDuct adhesive strip, thickness 4 mm, fully hardened, 58 - 62 HRC, adhesive side roughened (cross grinding), $Ra = 6 \mu\text{m}$, top side finely ground, $Ra = 0.8 \mu\text{m}$, optional bevels 0.2 to 2.0 x 45° possible on all longitudinal edges.

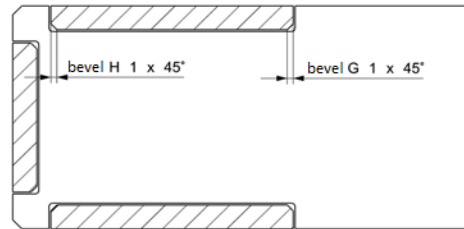


Designations for optional bevels on longitudinal edges:

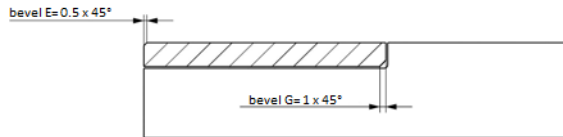


Installation example: Groove with side guide and undercut:

Bevel G and bevel H selected, longitudinal edges E and F sharp-edged.



Installation example: Step with bevel E and bevel G selected, longitudinal edges F and H sharp-edged.



Order example:

VarioDuct adhesive strip, 40 x 4 x 1,000 mm, bevel E = 0.5 mm, bevel G = 1.0 mm, end sides ground at a right angle.

Order example:

2 pieces of VarioDuct adhesive strip, 40 x 4 x 1,800 mm, bevel G = 1.0 mm, bevel H = 1.0 mm,
1 piece of VarioDuct adhesive strip, 25 x 4 x 1,800 mm, bevel G = 1.0 mm, bevel H = 1.0 mm.