

# 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](http://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

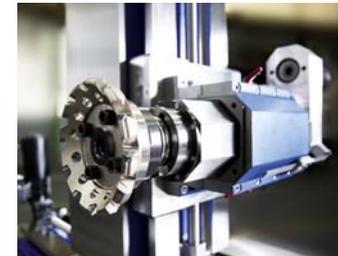
Width:  $+0.20 / -0$  mm

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

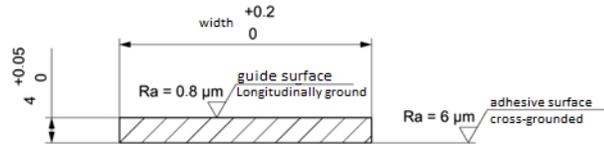
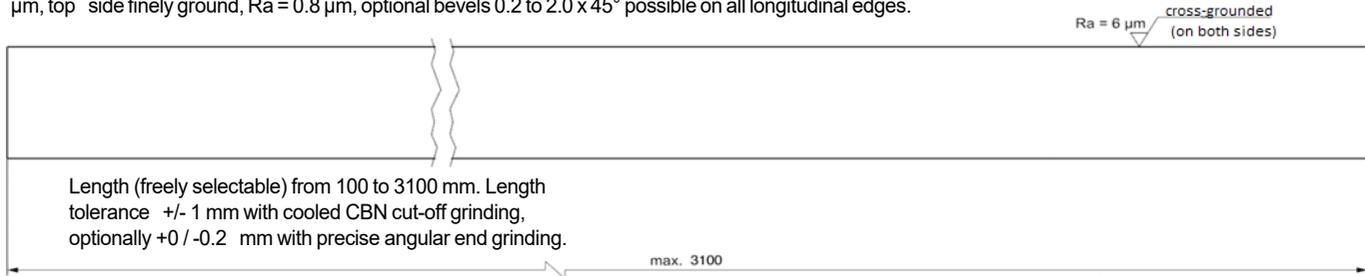
Chamfers are possible up to  $2 \times 45^\circ$  on the selected longitudinal edges.

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

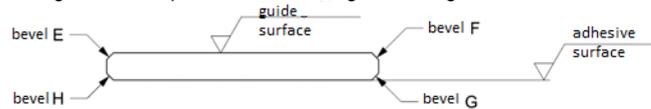
|             |      | price per piece |     |     |     |     |     |     |     |     |     |
|-------------|------|-----------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|
|             |      | thickness 4mm   |     |     |     |     |     |     |     |     |     |
|             |      | 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.

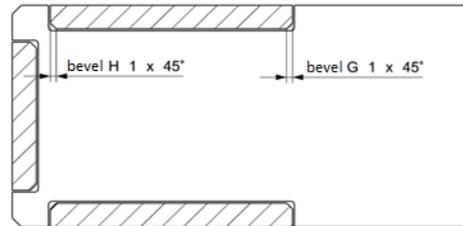


Designations for optional bevels on longitudinal edges:

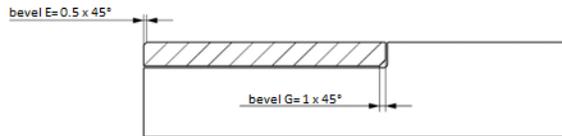


Installation example: Groove with side guide and undercut:

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.