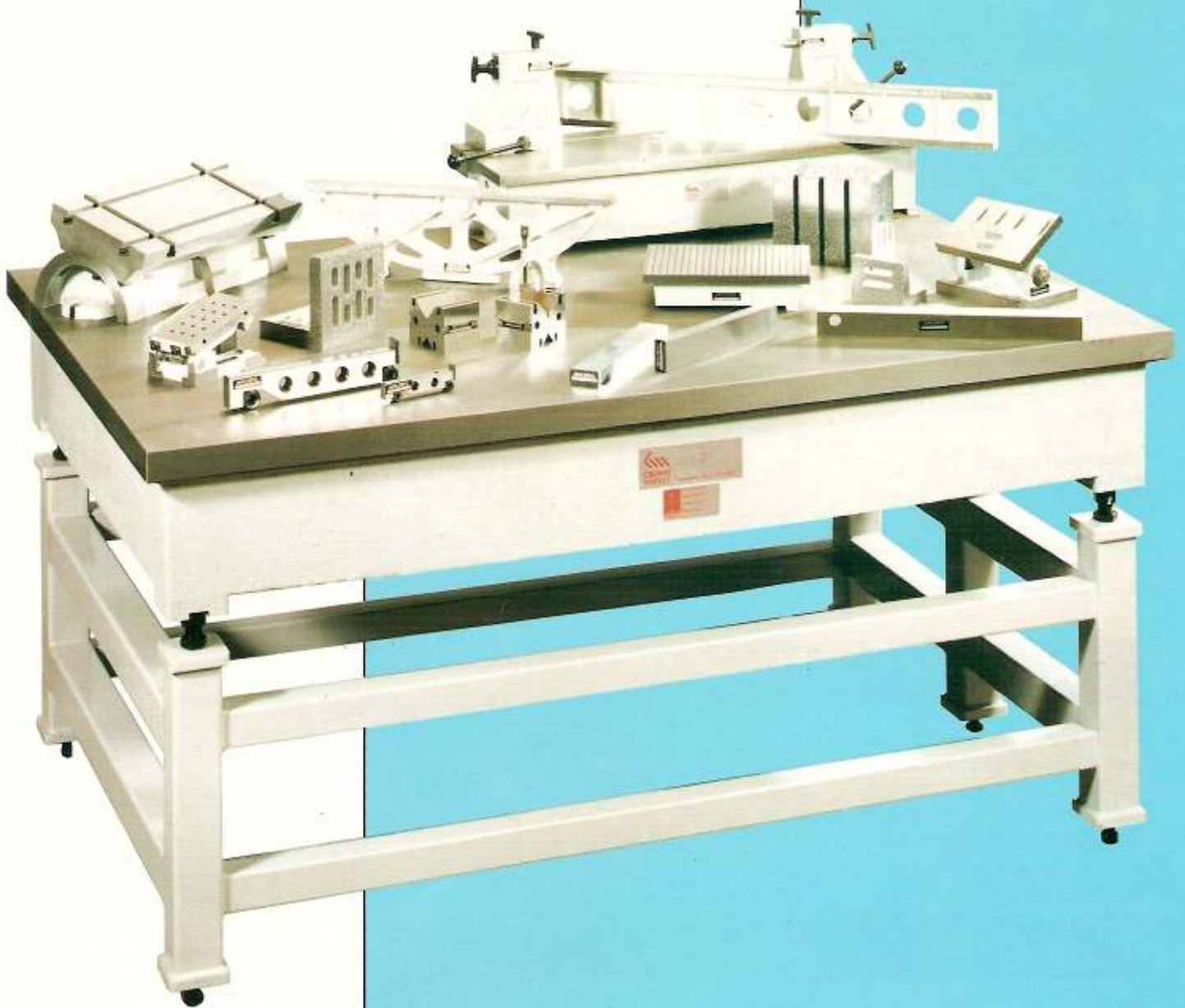


# CAST IRON



## METROLOGY STANDARDS



## CAST IRON SURFACE PLATES & TABLES

Crown Plates and Tables are manufactured from quality close grained Cast Iron. Hand scraped Grade 0 and 1 plates and tables are ideal for Laboratory or Toolroom use. Smooth planed Grades 2 and 3 plates and tables are recommended for use in Workshops.

All plates incorporate three support toes for bench mounting and are supplied with lifting handles. Generally of larger sizes than the Plates, Tables are supplied with their own stands. The nominal overall height of Tables is 865mm (34"). Special heights available on request. Lapping plates are also available in Grade 1 only. These are grooved on the top surface.

**Manufactured in grades to BS817(1988).**

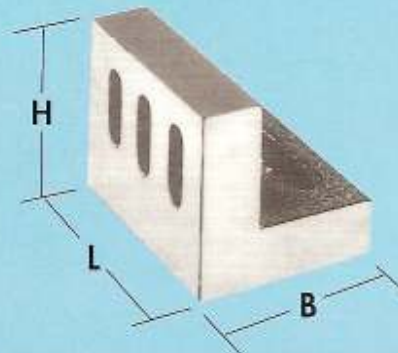


| Sizes in Inches | Accuracies in Microns |    |    |     |
|-----------------|-----------------------|----|----|-----|
|                 | Grade                 |    |    |     |
|                 | 0                     | 1  | 2  | 3   |
| 12" x 8"        | 3,5                   | 7  | 14 | 28  |
| 12" x 12"       | 4,0                   | 8  | 16 | 32  |
| 18" x 12"       | 4,0                   | 8  | 16 | 32  |
| 18" x 18"       | 4,5                   | 9  | 18 | 36  |
| 24" x 18"       | 4,5                   | 9  | 18 | 36  |
| 24" x 24"       | 5,0                   | 10 | 20 | 40  |
| 36" x 24"       | 5,5                   | 11 | 22 | 44  |
| 36" x 36"       | ---                   | 12 | 24 | 48  |
| 48" x 36"       | ---                   | 13 | 26 | 52  |
| 60" x 36"       | ---                   | 14 | 28 | 56  |
| 72" x 36"       | ---                   | 16 | 32 | 64  |
| 72" x 48"       | ---                   | 16 | 32 | 64  |
| 96" x 48"       | ---                   | 19 | 38 | 76  |
| 96" x 72"       | ---                   | 21 | 42 | 84  |
| 120" x 72"      | ---                   | 23 | 46 | 92  |
| 144" x 72"      | ---                   | 26 | 52 | 104 |

## CAST IRON ANGLE PLATES

Cast Iron Angle Plates are available either webbed or non-webbed with cast-in slots.

**Manufactured in 2 Grades to BS5535(1978).**

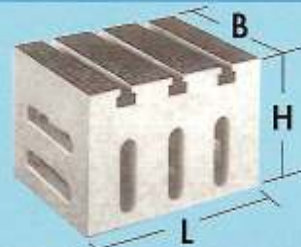


| Sizes in Inches | Accuracies in microns |    | Secondary Squareness |     |
|-----------------|-----------------------|----|----------------------|-----|
|                 | Squareness            |    | Grade                |     |
|                 | A                     | B  | A                    | B   |
| L x B x H       | A                     | B  | A                    | B   |
| 4" x 3" x 3"    | 8                     | 40 | 8                    | 45  |
| 7" x 5" x 4"    | 10                    | 50 | 13                   | 65  |
| 6" x 6" x 6"    | 10                    | 50 | 13                   | 65  |
| 9" x 9" x 9"    | 15                    | 75 | 17                   | 85  |
| 10" x 8" x 6"   | 12                    | 60 | 15                   | 75  |
| 12" x 9" x 9"   | 15                    | 75 | 17                   | 85  |
| 12" x 12" x 12" | 17                    | 85 | 20                   | 100 |
| 18" x 12" x 9"  | 17                    | 85 | 20                   | 100 |

## CAST IRON BOX ANGLE PLATES

Crown Box Angle Plates have tee-slots machined from solid in the top face. The four sides are supplied with cast-in slots and the base is open to provide access.

**Manufactured in 2 Grades to BS5535(1978).**



| Sizes in Inches  | Accuracies in microns |    | Secondary Squareness |     |
|------------------|-----------------------|----|----------------------|-----|
|                  | Squareness            |    | Grade                |     |
|                  | A                     | B  | A                    | B   |
| L x B x H        | A                     | B  | A                    | B   |
| 6" x 5" x 4,5"   | 10                    | 50 | 13                   | 65  |
| 9" x 7" x 4,6"   | 12                    | 60 | 15                   | 75  |
| 12" x 10" x 4,9" | 17                    | 85 | 20                   | 100 |
| 18" x 12" x 4,9" | 17                    | 85 | 20                   | 100 |
| 24" x 18" x 15"  | ---                   | 85 | ---                  | 100 |
| 30" x 24" x 18"  | ---                   | 85 | ---                  | 100 |

## CAST IRON BENCH CENTRES

Centres are ground to a 60° taper. Each centre stock can be locked in position anywhere along the tee-slot. Stands to suit Bench Centre Plates are available.

**Note! Stocks can be supplied to fit our standard range of Cast Iron and Granite Tables, with the tee-slot positioned to customer requirement.**



| Plate size in inches                          | Plate flatness in microns |    |    |    | Centre stock sizes |                   |
|---|---------------------------|----|----|----|--------------------|-------------------|
|   | Grade                     |    |    |    | Centre Height      | Capacity Diameter |
|   | 0                         | 1  | 2  | 3  |                    |                   |
| 24" x 12"                                     | 4,5                       | 9  | 18 | 36 | 4"                 | 8"                |
| 36" x 12"                                     | 5                         | 10 | 20 | 40 | 8"                 | 16"               |
| 48" x 12"                                     | 6                         | 12 | 24 | 48 | 12"                | 24"               |
| 60" x 12"                                     | 6,5                       | 13 | 26 | 52 | 14"                | 28"               |
| 72" x 24"                                     | 7,5                       | 15 | 30 | 60 | 16"                | 32"               |
| Vertical accuracy of centres per 12" of plate |                           |    |    |    |                    |                   |
|   | 2,5                       | 5  | 10 | 20 |                    |                   |

Lost capacity on plate due to length of pair of centre stocks is 14"