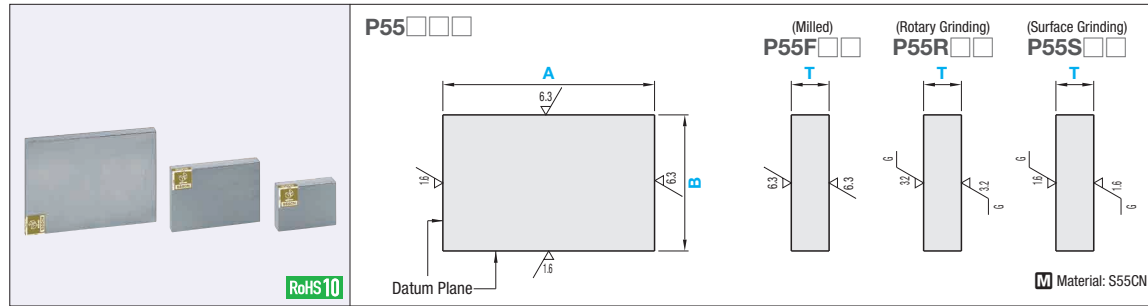
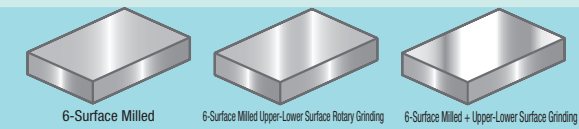


# Configurable Plates - S55CN

**Features of S55CN**  
 Normalized S55C, which relieves its internal stress.  
 Added free-cutting elements enhance its machinability.  
 It has higher mechanical strength than S50C.



| Type | Upper-Lower Surface Finish                                | ① Plate Thickness Tolerance | ② A, B Dimension Tolerance | 0.5mm Increment |        | T    |
|------|---|-----------------------------|----------------------------|-----------------|--------|------|
|      |   |                             |                            | A               | B      |      |
| P55  | F (Milled)<br>R (Rotary Grinding)<br>S (Surface Grinding) | P<br>Q<br>N<br>M            | P<br>Q<br>N<br>M           | 20~500          | 20~300 | 8~30 |

### ① Plate Thickness Tolerance

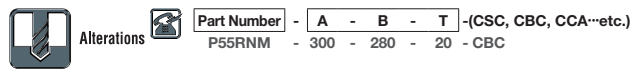
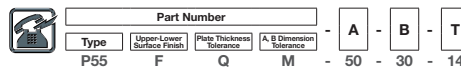
| Upper-Lower Surface Finish | P         | Q      | N     | M      |
|----------------------------|-----------|--------|-------|--------|
| F (Milled)                 | +0.1~+0.3 | 0~+0.2 | ±0.1  | -0.2~0 |
| R (Rotary Grinding)        | +0.1~+0.3 | 0~+0.2 | ±0.1  | -0.2~0 |
| S (Surface Grinding)       | +0.1~+0.2 | 0~+0.1 | ±0.05 | -0.1~0 |

### ② A, B Dimension Tolerance

| Upper-Lower Surface Finish | A, B Dimension  | P   | Q             | N         | M      |
|----------------------------|-----------------|---|---------------|-----------|--------|
|                            |                 | F (Milled)<br>R (Rotary Grinding)<br>S (Surface Grinding) | 250mm or Less | +0.1~+0.3 | 0~+0.2 |
|                            | 250.5mm or More | +0.1~+0.6   | 0~+0.5        | ±0.25     | -0.5~0 |

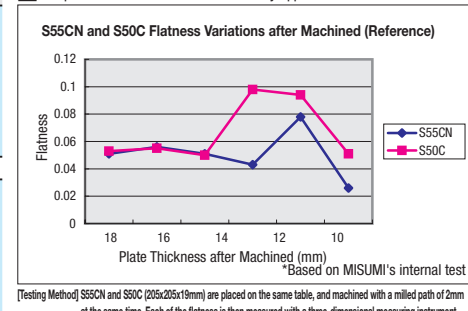
### Precision Standards

| Item                              | Upper-Lower Surface Finish (Max. Value) |                     |                      |
|-----------------------------------|---|---------------------|----------------------|
|                                   | F (Milled)                              | R (Rotary Grinding) | S (Surface Grinding) |
| Thickness Parallelism (per 100mm) | 0.05                                    | 0.012               | 0.012                |
| Flatness (per 100mm)              | T8~15.5                                 | 0.07                | 0.03                 |
|                                   | T16~25.5                                | 0.05                | 0.015                |
|                                   | T26~30                                  | 0.05                | 0.012                |
| Perpendicularity of Datum Plane   | 0.015 per 100mm                         |                     |                      |
| Circumference Chamfering          | C0.2~C0.5                               |                     |                      |



| Alterations | Circumference Chamfering  |  | Corner Cut  |
|-------------|---|--|---|
|             | CSC   | CBC  | CCA, CGB, CCC, CCD  |
| Code        | CSC   | CBC  | CCA, CGB, CCC, CCD  |
| Spec.       | Reduce the circumference chamfering dimension. Standard C0.2 ~ C0.5<br>→ C0.1 or Less | Increase the circumference chamfering dimension. Standard C0.2 ~ C0.5<br>→ C0.5~C1.0 | Cuts any corners. 1mm Increment<br>1 ≤ Corner Cut ≤ 50<br>1mm Increment<br>11~20<br>21~30<br>31~40<br>41~50<br>(Ex.) When the corners of A and D are cut by C5, → CCA5-CCD5 |

### Comparison of Flatness Variation Caused by Upper-Lower Surface Milled Cutter



Although it is assumed that S55C has higher internal stress than S50C, the test results show that normalized S55C or S55CN has as low internal stress as S50C.

(Ex.) For P55FQM-50-30-14

A Dimension x Area Unit Price = Price

| Part Number | A         | B        | T    | 8-9 | 9.5-11 | 11.5-13 | 13.5-16 | 16.5-20 | 20.5-22 | 22.5-25 | 25.5-28 | 28.5-30 |  |
|-------------|-----------|----------|------|-----|--------|---------|---------|---------|---------|---------|---------|---------|--|
|             |           |          |      |     |        |         |         |         |         |         |         |         |  |
| P55F        | 20 ~ 50   | 20-25    | 8-30 |     |        |         |         |         |         |         |         |         |  |
|             | 50.5-75   |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-250 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 25.5-50   | 25.5-40  |      |     |        |         |         |         |         |         |         |         |  |
|             | 50.5-75   |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 200.5-500 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 40.5-50   | 40.5-60  |      |     |        |         |         |         |         |         |         |         |  |
|             | 50.5-75   |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 200.5-500 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 60.5-75   | 60.5-80  |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 200.5-500 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 80.5-100  | 80.5-100 |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 100.5-125   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 125.5-200   | 125.5-150 |          |      |     |        |         |         |         |         |         |         |         |  |
| 125.5-200   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 150.5-200   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   | 150.5-160 |          |      |     |        |         |         |         |         |         |         |         |  |
| 160.5-200   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   | 200.5-250 |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 250.5-300   |           |          |      |     |        |         |         |         |         |         |         |         |  |

| Part Number | A         | B        | T    | 8-9 | 9.5-11 | 11.5-13 | 13.5-16 | 16.5-20 | 20.5-22 | 22.5-25 | 25.5-28 | 28.5-30 |  |
|-------------|-----------|----------|------|-----|--------|---------|---------|---------|---------|---------|---------|---------|--|
|             |           |          |      |     |        |         |         |         |         |         |         |         |  |
| P55R        | 20 ~ 50   | 20-25    | 8-30 |     |        |         |         |         |         |         |         |         |  |
|             | 50.5-75   |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-250 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 25.5-50   | 25.5-40  |      |     |        |         |         |         |         |         |         |         |  |
|             | 50.5-75   |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 200.5-500 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 40.5-50   | 40.5-60  |      |     |        |         |         |         |         |         |         |         |  |
|             | 50.5-75   |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 200.5-500 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 60.5-75   | 60.5-80  |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 200.5-500 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 80.5-100  | 80.5-100 |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 100.5-125   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 125.5-200   | 125.5-150 |          |      |     |        |         |         |         |         |         |         |         |  |
| 125.5-200   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 150.5-200   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   | 150.5-160 |          |      |     |        |         |         |         |         |         |         |         |  |
| 160.5-200   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   | 200.5-250 |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 250.5-300   |           |          |      |     |        |         |         |         |         |         |         |         |  |

| Part Number | A         | B        | T    | 8-9 | 9.5-11 | 11.5-13 | 13.5-16 | 16.5-20 | 20.5-22 | 22.5-25 | 25.5-28 | 28.5-30 |  |
|-------------|-----------|----------|------|-----|--------|---------|---------|---------|---------|---------|---------|---------|--|
|             |           |          |      |     |        |         |         |         |         |         |         |         |  |
| P55S        | 20 ~ 50   | 20-25    | 8-30 |     |        |         |         |         |         |         |         |         |  |
|             | 50.5-75   |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-250 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 25.5-50   | 25.5-40  |      |     |        |         |         |         |         |         |         |         |  |
|             | 50.5-75   |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 200.5-500 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 40.5-50   | 40.5-60  |      |     |        |         |         |         |         |         |         |         |  |
|             | 50.5-75   |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 200.5-500 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 60.5-75   | 60.5-80  |      |     |        |         |         |         |         |         |         |         |  |
|             | 75.5-100  |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 200.5-500 |          |      |     |        |         |         |         |         |         |         |         |  |
|             | 80.5-100  | 80.5-100 |      |     |        |         |         |         |         |         |         |         |  |
|             | 100.5-200 |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 100.5-125   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 125.5-200   | 125.5-150 |          |      |     |        |         |         |         |         |         |         |         |  |
| 125.5-200   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 150.5-200   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   | 150.5-160 |          |      |     |        |         |         |         |         |         |         |         |  |
| 160.5-200   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   | 200.5-250 |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 200.5-500   |           |          |      |     |        |         |         |         |         |         |         |         |  |
| 250.5-300   |           |          |      |     |        |         |         |         |         |         |         |         |  |