### Features of Low Temperature Black Chrome Plating

- **Annealing required for wrench flats machining**
- **Circularity, Straightness, Perpendicularity and**
  - **Circularity and**
  - **Diameter tolerance may not meet**
- **Features**
  - **One End Threaded Hollow Shafts**
  - **With Wrench Flats**
  - **Both Ends Tapped Hollow Shafts**
  - **Tapped Hollow Shafts with Wrench Flats**

### One End Threaded Hollow Shaft Type

- **M (Cone Thread)**
  - **NC (Nose Cone Thread)**
- **Hollow Shafts**
  - **With Wrench Flats**
- **Shafts**
  - **One End Threaded**
  - **Both Ends Tapped**
  - **Hollow Shafts with Wrench Flats**

### One End Threaded Hollow Shafts / Both Ends Tapped Hollow Shafts with Wrench Flats

<table>
<thead>
<tr>
<th>Part Number</th>
<th>L</th>
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<tbody>
<tr>
<td>SPJN</td>
<td>6</td>
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### Alterations Details

- **Lateral hole diameters are shown in the table below.**
- **Values in ( ) are for Stainless Steel Shafts.**
- **Applicable to Both Ends Tapped Hollow Shafts only.**
- **Burrs might remain inside after alteration.**
- **Dimensions in relation to other features will be created.**
- **Not applicable to Both End Threaded Shafts.**
- **Not applicable to matching with other alterations.**
- **Details**
  - **On Machined Features**
  - **Minor Diameter**
  - **Maximum Outside Diameter**

### Alterations to L Dimension Tolerance

- **Wrench Flats**
  - **Dimensions**
  - **SC=1 mm Increment**

### Alterations Code Spec.

- **L**
  - **Changing Tolerances**
  - **Ordering Code**
  - **L<200**
  - **L±0.05**
  - **L±0.03**

### Application Example

- **Auto Tapping Shafts**
  - **in two directions**
  - **Ordering Code**
  - **DKC**
  - **Not applicable to Stainless Steel and**
  - **Low Temperature Chrome Plated Shafts.**

### About Hollow Shaft Wall Thickness Deviations

- **R19B**

### One End Threaded Hollow Shafts with Wrench Flats / Both Ends Tapped Hollow Shafts with Wrench Flats

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### About Hollow Shaft Wall Thickness Deviations

- **R19B**

### Part Number Example

1. **SPJN20**
   - **L = 20**
   - **M = 8**
   - **F = 10**
   - **B = 10**
   - **P = 2–F19B**
   - **SC = 0**

2. **SPJN30**
   - **L = 30**
   - **M = 8**
   - **F = 10**
   - **B = 10**
   - **P = 2–F19B**
   - **SC = 0**

### Alterations to L Dimension Tolerance

- **Wrench Flats**
  - **Dimensions**
  - **SC=1 mm Increment**

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- **R19B**

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