

Kayersdijk 131, 7332 AP Apeldoorn
P.O. Box 46, 7300 AA Apeldoorn
The Netherlands
Tel.: 055-5333717 fax.: 055-5423943
Email : mail@plaatijzerindustrie.com

postbank 826842
ABN /AMRO Bank nr. 43.70.66.606
B.T.W nr. nl. 8014.82.409B03
K.v.K.Handelsreg. nr. 08038788
www.plaatijzerindustrie.com

De Plaatijzerindustrie B.V.

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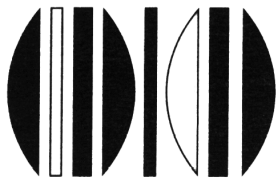
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1. General contract

1.1 general condition.

- 1.1.1 The general delivery and payment conditions are as approved through the “Metaalunie” (Dutch metal organisation for concerns) and like the “Metaalunie”, specifically the conditions as laid down by “Ter Griffie van de Arrondissement rechtbank te Rotterdam op 1 Januari 2001”. These delivery and payment conditions are available on request.
- 1.1.2 Unless otherwise agreed, our prices are Ex-works, i.e. excluding freight, packing and insurance (EXW. acc. Incoterms).
- 1.1.3 Packaging can be undertaken by us and passed on at a reasonable rate.
- 1.1.4 Unless otherwise agreed, payment terms are 30 days from receipt of invoice.

1.2 Costs for small orders and documentation.

- 1.2.1 For orders with a value of less than € 100,- there shall be an extra charge of € 15,-
- 1.2.2 For documentation such as cold press procedure, heat treatment diagrams or dimensional reports, there is a charge of € 15,- (per document).
There is no charge for material certification or heat treatment procedure statements.

1.3 Discounts for stock heads.

- 1.3.1 For decimal and korfbogen heads up to a dimension 324 mm, in the material S235JRG2 (St37) en P265GH (HII), we have discounts for the following quantities

0 t/m 20 pieces -	nett
21 t/m 50 pieces -	3%
51 pieces ore more -	5%

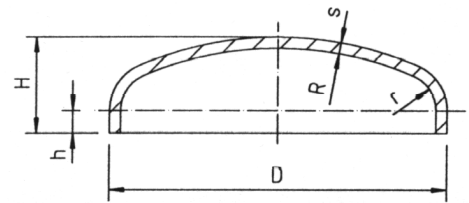
1.4 Certification :

- 1.4.1 Certificate of approval : **ISO 9001:2000**
- 1.4.2 Ec Certificate of conformity : **PED 97/23/EC Module H + H1**

2. Decimal (torispherical type) heads acc. DIN 28011

2.1 Profile

D	=	outside dimension
s	=	wall thickness before forming
r	=	inside knuckle radius (0,1D)
R	=	inside radius (R=D)
h	=	Straight flange height ($\geq 3,5 \times s$)
H	=	total height ($-0,192D + s + h$)



2.2 Tolerances

2.2.1 Diameter

Material	Diameter	Tolerance (on the circumference)
Unalloy steel and Low alloy steel	D < 100 mm	+3 /-3 mm
	100 ≤ D < 300 mm	+4 /-4 mm
	300 ≤ D < 1000 mm	+0.4/-0,4 %
	1000 ≤ D < 4000 mm	+0,3/-0,3 %
Stainless steel	D < 100 mm	+3 /-3 mm
	100 ≤ D < 300 mm	+5 /-5 mm
	300 ≤ D < 4000 mm	+0,5/-0,7 %

2.2.2 Height (H)

+10/-0 mm	of +0,015D/-0 mm (highest value)
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2.2.3 roundness

U = $\frac{2(D_{max} - D_{min.})}{(D_{max} + D_{min.})}$	X 100%	(max 1%)	NB : (D _{max.} -D _{min.} max. 30mm)
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2.3 Production possibilities :

2.3.1 Dimensions:

- Max. diameter 4000mm
- Max. wall thickness : R.V.S. 18 mm.
C.Steel 20 mm.

2.3.2 Material:

- Carbon steel : S235JRG2, P265GH, P355NL1/NL2, A516Gr60/70, etc.
- Stainless steel : 1.4301, 1.4404, 1.4541, 1.4571, etc.
- Nickel alloy : Monel, Inconel, Hastelloy, etc.
- Non Ferro : Aluminium, copper, Titan, etc.

2.3.3 Fabrication code:

- Stoomwezen rules, AD-2000, ASME (U-Stamp), PD5500, etc.

2.4 Stock :

see stocklist page 4.

Stock heads can be delivered in accordance with various codes including the documentation.

Decimale heads R=D r=0,1D – DIN 28011

General information					Material				General information					Material			
Outside	thickness	Outside	capacity	weight	S235Jrg2	P265GH	1.4301	1.4404	Outside	thickness	Outside	capacity	weight	S235JRG 2	P265GH	1.4301	1.4404
Diam.(D)	(S)	Height(H)	(litre)	(kg)					Diam.(D)	(S)	Height(H)	(litre)	(kg)				
34	3	↓17			X I			X I	306	3	85	4.1	2.8				X
38	3	↓16						X I	318	8	100	4.94	8.6	X I			
42	3	↓19			X I				324	4	85	4.71	4.2				X
44	3	↓15			X I				324	8	102	5.15	9.4		X		
57	3	↓23			X I		X I	X I	356	3	90	6.2	3.7				X
60	3	↓16			X I				356	4	91	6.1	5.1			X	X
60	3	↓25						X I	356	5	92	6	6.3	X			
70	3	↓26	0.11	0.21	X I			X I	385	3	96	7.7	4	X I			
76	3	31	0.16	0.29				X I	400	3	98	8.54	4.7			X	X
89	4	39	0.19	0.43	X			X	400	4	99	8.43	6.3				X
89	5	40	0.19	0.53		X			406	3	100	8.91	4.8			X	X
95	4	↓36	0.22	0.46	X I				450	3	108	11.85	5.8	X		X	X
102	3	41	0.27	0.38				X	450	4	109	11.7	7.8			X I	X
102	4	42	0.27	0.51	X				450	5	114	11.54	9.8	X			
108	4	43	0.31	0.61	X I				457	8	128	13.15	17.4		X		
114	4	44	0.35	0.66				X	500	3	117	15.9	7.2			X	X
114	5	45	0.35	0.82		X		X I	500	4	118	15.7	9.6			X I	X
129	2	40	0.48	0.4				X	508	5	121	16.2	12.2		X		X
133	4	48	0.51	0.84	X I				508	8	137	17.6	21.2	X!			
140	4	49	0.58	0.96				X	550	4	128	20.5	11.4				X
152	3	51	0.71	0.8				X	600	3	137	26.5	10.1			X	X
152	4	52	0.71	1.06	X				650	3	147	33.2	11.8			X	X
159	3	52	0.79	0.88	X I				650	10	167	35.9	41.5		X		
159	4	53	0.79	1.2	X I			X	700	3	157	41	13.6			X	X
159	5	54	0.79	1.4		X			800	3	176	59.9	17.6			X	X
164	1.5	45	0.85	0.5				X	800	4	177	59.3	23.4			X	X
168	3	54	0.83	1				X	800	5	178	58.8	29.3				X
206	2	60	1.46	1				X I	800	6	182	61.1	35.8		X		
206	3	61	1.43	1.5				X	950	3	205	98.1	24.5			X	X
219	4	62	1.64	2.1	X		X	X	1000	3	215	113.7	27.2			X	X
219	7	68	1.66	3.7		X			1000	4	216	113.1	36.3				X
250	2	65	2.43	1.3			X		1000	5	217	112.4	45.1	X			
250	3	70	2.38	1.95	X I			X	1100	3	234	149.7	32.8			X	X
250	4	71	2.33	2.6	X I				1200	3	253	192.6	38.7			X	X
273	4	75	2.96	3.1			X	X	1195	5	255	190.7	65		X		
273	6	79	3.1	4.8	X I	X			1200*	7	260	194.4	91		X		
273	7	80	3.05	5.6		X			1300	6	279	246.2	91		X		
300	2	79	3.96	1.8			X										
300	3	80	3.89	2.8	X		X	X									

* Heads with a centerhole 36mm.

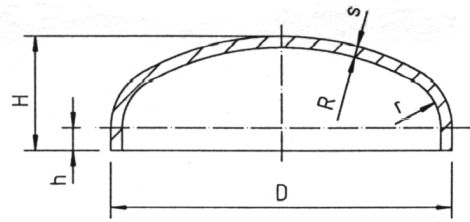
↓ Height not DIN 28011

X = standard X I = Non standard

3. Korbboegen(ellipsoidal type) heads acc. DIN 28013

3.1 Profile

D	=	outside dimension
s	=	wall thickness before forming
r	=	inside knuckle radius (0,154D)
R	=	inside radius (R=0,8D)
h	=	Straight flange height (≥ 3 x s)
H	=	total height (-0,251D + s + h)



3.2 Tolerances

3.2.1 Diameter

Material	Diameter	Tolerance (on the circumference)
Unalloy steel and Low alloy steel	D < 100 mm	+3 /-3 mm
	100 ≤ D < 300 mm	+4 /-4 mm
	300 ≤ D < 1000 mm	+0,4/-0,4 %
	1000 ≤ D < 4000 mm	+0,3/-0,3 %
Stainless steel	D < 100 mm	+3 /-3 mm
	100 ≤ D < 300 mm	+5 /-5 mm
	300 ≤ D < 4000 mm	+0,5/-0,7 %

3.2.2 Height (H)

+10/-0 mm	of +0,015D/-0 mm (highest value)
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3.2.3 roundness

U = $\frac{2(D_{max} - D_{min.})}{(D_{max} + D_{min.})}$	X 100% (max 1%)	NB : (D _{max.} -D _{min.} max. 30mm)
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3.3 Production possibilities :

3.3.1 Dimensions:

- Max. diameter 2600mm
- Max. wall thickness : R.V.S. 18 mm.
C.Steel 20 mm.

3.3.2 Material:

- Carbon steel : S235JRG2, P265GH, P355NL1/NL2, A516Gr60/70, etc.
- Stainless steel : 1.4301, 1.4404, 1.4541, 1.4571, etc.
- Nickel alloy : Monel, Inconel, Hastelloy, etc.
- Non Ferro : Aluminium, copper, Titan, etc.

3.3.3 Fabrication code:

- Stoomwezen rules, AD-2000, ASME (U-Stamp), PD5500, etc.

3.4 Stock :

see stocklist page 6.

Stock heads can be delivered with diverse codes including the documents.

Korbbogen head R=0,8D r=0,154D - DIN 28013

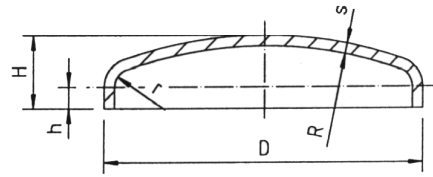
General information					Material					General information					Material			
Outside	thickness	Outside	capacity	weight	S235Jrg2	P265GH	1.4301	1.4404		Outside	thickness (S)	Outside	capacity	weight	S235JRG 2	P265GH	1.4301	1.4404
Diam.(D)	(S)	Height(H)	(litre)	(kg)						Diam.(D)	(S)	Height(H)	(litre)	(kg)				
168	3	64	1.03	1.1				X		600	4	175	32.5	14.7			X	X
168	5	65	0.9	1.8		X				600	5	176	32.2	18.4		X		
168	10	83	0.85	4		X				609	8	193	34	32.1		X		
244,5	7	89	2.62	5		X				609	10	195	34.7	39.4		X		
273	5	93	3.45	4.2				X		700	3	200	51	14.9			X	X
273	7	97	3.58	6.1		X				700	5	201	50.2	24.8		X		
273	10	110	3.62	9.2		X I				700	8	216	50.8	41.6		X		
298	7	103	4.56	7.1	X I					712	11	232	57.7	61		X		
300	4	98	4.58	4	X					750	3	212	62.2	17.1				X
324	5	106	5.57	5.7	X I			X		750	6	217	60.8	34.4		X		
324	10	123	5.83	12.4	X I					762	12	241	69.5	75		X		
350	3	110	7.15	3.9	X		X I	X		800	8	232	74.7	54		X		
350	5	112	6.92	6.6		X				800	11	255	80.2	76		X		
356	8	129	7.97	11.9		X				900	6	255	103	49		X		
356	12	142	8.22	18.7		X				950	6	268	121	54		X		
368	6	120	7.86	9		X				1000	6	280	141	61		X		
368	8	132	8.1	13		X												
400	4	123	10.2	6.8	X I													
406	5	127	10.5	8.7	X			X										
406	6	130	10.4	10.8		X												
406	10	144	10.9	18.8		X												
419	5	130	11.5	9	X													
450	5	138	14.1	10.6		X												
457	12	168	16.4	29.5		X												
500	5	150	19.1	13		X												
508	8	167	20.2	22.9		X												
508	11	180	22.3	32.7		X												
508	15	194	22.3	47.1	X I													
550	3	161	25.6	9.4				X										
560	12	189	29	42.4		X												

* Heads with a centerhole 36mm
X = standard X I = Non standard

4. Low pressure heads

4.1 Profile

D	=	outside dimension
s	=	wall thickness before forming
r	=	inside knuckle radius (10 till 60)
R	=	inside radius (1.2 till 1.4D)
h	=	Straight flange height
H	=	total height



4.2 Tolerances

4.2.1 Diameter

Material	Diameter	Tolerance (on the circumference)
Unalloy steel and Low alloy steel	D < 100 mm	+3 /-3 mm
	100 ≤ D < 300 mm	+4 /-4 mm
	300 ≤ D < 1000 mm	+0.4/-0,4 %
	1000 ≤ D < 4000 mm	+0,3/-0,3 %
Stainless steel	D < 100 mm	+3 /-3 mm
	100 ≤ D < 300 mm	+5 /-5 mm
	300 ≤ D < 4000 mm	+0,5/-0,7 %

4.2.2 Height (H)

+10/-0 mm	of +0,015D/-0 mm (highest value)
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4.2.3 roundness

U = $\frac{2(D_{max} - D_{min.})}{(D_{max} + D_{min.})}$ X 100% (max 1%)	NB : (D _{max} -D _{min.} max. 30mm)
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4.3 Production possibilities :

4.3.1 Dimensions:

- Max. diameter 4000mm
- Max. wallthickness : R.V.S. 18 mm.
C.Steel 20 mm.

4.3.2 Material:

- Carbon steel : S235JRG2, P265GH, P355NL1/NL2, A516Gr60/70, etc.
- Stainless steel : 1.4301, 1.4404, 1.4541, 1.4571, etc.
- Nickel alloy : Monel, Inconel, Hastelloy, etc.
- Non Ferro : Aluminium, copper, Titan, etc.

4.3.3 Fabrication code:

- On request.

4.4 Stock :

see stocklist page 8.

Stock heads can be delivered with diverse codes including the documents.

Low pressure heads R=1,2 till 1,4D

General information					Material				General information					Material			
Outside	thickness	Outside	capacity	weight	S235Jrg2	P265GH	1.4301	1.4404	Outside	thickness	Outside	capacity	weight	S235Jrg2	P265GH	1.4301	1.4404
Diam.(D)	(S)	Height(H)	(litre)	(kg)					Diam.(D)	(S)	Height(H)	(litre)	(kg)				
200	3	50	1	1.5	X I				900	5	160	46.6	31.1	X			
250	2	50	1.7	1.4	X I				1000	4	144	63.1	28.8	X			
250	3	51	1.7	2	X				1100	4	160	81.3	42.5	X			
300	2	60	2.6	1.8	X				1100	5	180	80.9	53	X			
300	3	65	2.6	2.6	X				1270	4	175	119.4	47.5	X			
350	3	65	3.8	3.2	X												
380	3	85	4.6	4.5	X												
400	2	70	5.3	3.1	X												
400	3	75	5.3	4.7	X												
400	5	85	5.1	7.7	X I												
450	3	83	7.1	5.7	X												
500	3	110	9.3	7.2	X												
500	5	110	9.1	12.4	X												
550	5	115	11.6	13.9	X												
600	3	115	14.8	10.3	X												
600	5	128	14.6	17.2	X												
650	3	123	10.8	16	X												
650	5	123	18	17.2	X												
700	4	105	24.9	14.5	X												
750	3	135	30	15.6	X												
750	5	130	29.6	21.6	X												
776	1.5	90	29.4	6.4	X I												
800	3	123	35.4	14.1	X												
800	5	157	35	24.8	X												
900	4	139	47.8	23.6	X												

Remark:

-Capacity en weight are based on

r=15mm en h=15mm (from 200mm till 650mm)

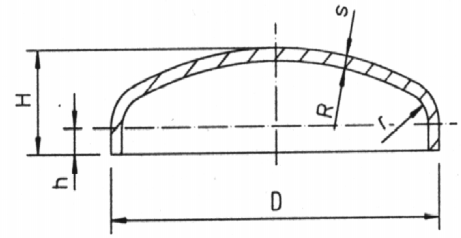
r=20mm en h=20mm.(from 700mm till 1270mm)

X = standard X I = Non standard

5. Standard heads

4.1 Profile

D	=	outside dimension
s	=	wall thickness before forming
r	=	inside knuckle radius (on request)
R	=	inside radius (on request)
h	=	Straight flange height
H	=	total height



5.2 Tolerances

5.2.1 Diameter

Material	Diameter	Tolerance (on the circumference)
Unalloy steel and Low alloy steel	D < 100 mm	+3 /-3 mm
	100 ≤ D < 300 mm	+4 /-4 mm
	300 ≤ D < 1000 mm	+0.4/-0,4 %
	1000 ≤ D < 4000 mm	+0,3/-0,3 %
Stainless steel	D < 100 mm	+3 /-3 mm
	100 ≤ D < 300 mm	+5 /-5 mm
	300 ≤ D < 4000 mm	+0,5/-0,7 %

5.2.2 Height (H)

+10/-0 mm	of +0,015D/-0 mm (highest value)
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5.2.3 roundness

$U = \frac{2(D_{max} - D_{min.})}{(D_{max} + D_{min.})} \times 100\%$	(max 1%)	NB : (D _{max.} -D _{min.} max. 30mm)
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5.3 Production possibilities :

5.3.1 Dimensions:

- Max. diameter 4000mm
- Max. wallthickness : R.V.S. 18 mm.
C.Steel 20 mm.

5.3.2 Material:

- Carbon steel : S235JRG2, P265GH, P355NL1/NL2, A516Gr60/70, etc.
- Stainless steel : 1.4301, 1.4404, 1.4541, 1.4571, etc.
- Nickel alloy : Monel, Inconel, Hastelloy, etc.
- Non Ferro : Aluminium, copper, Titan, etc.

5.3.3 Fabrication code:

- On request.

5.4 Stock :

see stocklist page 10.

Stock heads can be delivered with diverse codes including the documents..

Standard heads

[illegible]

remark:

Radius $R=D$.

Knuckle radius $r=50\text{mm}$ for diam. 1400mm t/m 1800mm and 2200mm;

$r=70\text{mm}$ for diam. 1900mm;

r=80mm for diam. 2500.

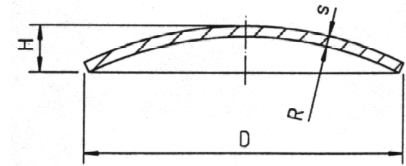
X = standard X I = Non standard

6. Various Heads

6.1 Heads types

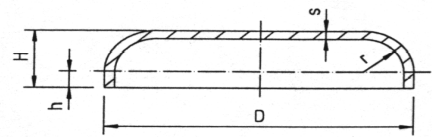
6.1.1 Spherical caps

D	=	outside dimension
s	=	wall thickness before forming
R	=	inside radius
H	=	total height



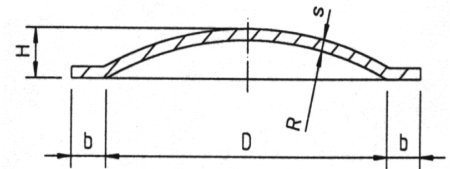
6.1.2 Flat heads

D	=	outside dimension
s	=	wall thickness before forming
r	=	inside knuckle radius
h	=	Straight flange height
H	=	total height



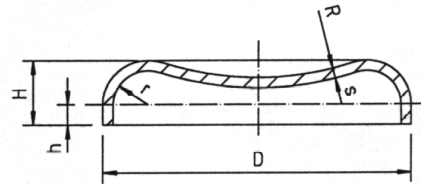
6.1.3 Spherical covers

D	=	outside dimension
s	=	wall thickness before forming
R	=	inside radius
b	=	flange
H	=	total height



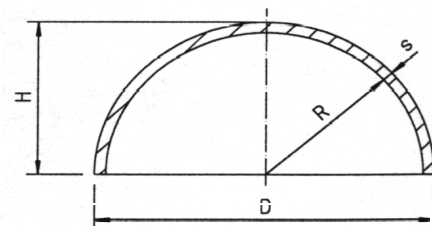
6.1.4 Diffusion heads

D	=	outside dimension
s	=	wall thickness before forming
r	=	inside knuckle radius
R	=	inside radius
h	=	Straight flange height
H	=	total height



6.1.5 Hemispherical

D	=	outside dimension
s	=	wall thickness before forming
R	=	inside radius
H	=	total height



6.2 Tolerances:

Tolerances on request.

6.3 Production possibilities:

On request. (depends on the tools).

7. Heat and surface treatment

7.1 Heat treatment

-Normalised , stress relieving	Carbon-Steel.
-Annealing	stainless steel
-according to your specification .	
-Capacity furnace	electric power 400kVA.
	max .temperature 1150gr.C.
	Dimension (length x deep x height) 4000x4000x1400mm.

7.2 surface treatment

7.2.1 pickling C-steel

-Composition	on request.
-Dimension	max. 5000x1800x1900mm. (length x depth x height)

7.2.2 pickling and passivating stainless steel

- Composition	on request
- Dimension	max. 3500x1200mm. (diameter x depth)

7.3 Grinding

7.3.1 Grinding C-staal

-Weight	max. 12 ton.
-Material	high carbon steelgrit (Composition on request).
-Dimension	12000x4800x4250mm. (length x width x height)

7.3.2 Grinding stainless steel

- Weight	max. 12 ton.
- Material	speed blast (Composition on request).
- Dimensions	max. 12000x4800x4250mm. (length x width x height)

7.4 Painting

on request

7.5 Polishing

on request

8. Other Non standard heads

General information					General information				
Quantity	Outside	thickness		Remarks	Quantity	Outside	thickness		Remarks
	Diam.(D)	(S)				Diam.(D)	(S)		
Non standard Decimal head 1.4301					Non standard Korbbogen heads in 1.4301				
25 st.	114	3			58 st.	89	4		1.4306
7 st.	102	5			3 st.	357	6		
1 st.	133	3							
4 st.	155	3							
6 st.	219	3			Non standard Korbbogen heads in 1.4404				
5 st.	241	3			138 st.	48	4		
6 st.	250	5			1 st.	60	3		
9 st.	253	6			14 st.	60	6		
6 st.	253	6		With centerhole 10mm	2 st.	89	3		
5 st.	273	6			11 st.	114	8		
16 st.	102	5			39 st.	140	3		
10 st.	244,5	3			3 st.	368	6		
7 st.	250	2		With an flat spot in the middle	1 st.	508	6		A240-316L
9 st.	1000	3							
Non standard Decimal head 1.4404									
15 st.	171	5			Non standard Korbbogen heads HII DIN 17155				
1 st.	114	3			70 st.	168	10		
4 st.	219	4			5 st.	219	6		A516Gr60
7 st.	273	4		without certification	136 st.	324	5		
2 st.	102	5			11 st.	368	6		Heavy rust
2 st.	461	5			29 st.	368	8		Heavy rust pitting
5 st.	600	3		With an little bulge length 40mm	2 st.	500	6		A516Gr60
2 st.	800	2			11 st.	508	15		
1 st.	900	3		made by spinning+centerhole36mm	2 st.	680	5		
1 st.	1500	10		A240-316L	10 st.	762	13/14		P275Ni1 / SA 516Gr60
Non standard Decimal head 1.4571 1.4541					7 st.	762	13/14		SA 516Gr60
5 st.	34	3		1.4571	5 st.	850	6		
64 st.	57	4		1.4571	3 st.	1300	10	516gr60	ASME with a centerhole 36mm
42 st.	60	4		1.4541					
1 st.	159	4		1.4571					
1 st.	450	3		1.4571	Non standard Korbbogen heads St.37 DIN 17100				
2 st.	800	4		1.4571 hotrolled with bulge	17 st.	762	13/14		without certification
Non standard Decimal head HII DIN 17155									
17 st.	508	8							
5 st.	820	7							
11 st.	1300	5							
8 st.	1400	5		None fabrication code heavy rust	Non standard other heads / discs in various materials				
1 st.	1400	7		None fabrication code heavy rust	1 st.	306	3	1.4404	Flat head
Non standard Decimal head St.37 DIN 17100					5 st.	300	10	A516gr60	Flat head r=50
104 st.	60	3		Height 16mm (not acc. DIN 28011)					With pres edge
40 st.	194	6			3 st.	89	12	16Mo3	Dutch boiler rules
					3 st.	760	12	1.4301	Flat head Centerhole 36mm
					2 st.	835	4	1.4301	Round discs
					2 st.	3230	4	1.4404	Round discs with welding acc
									Dutch rules
Non standard Low pressure head St.37 DIN 17100					Non standard Low pressure head 1.4404				
19	750	4		Fold in straight flange height	1 st.	3200	4	1.4404	Fold in radius

The quantity of the heads are variable, it depends on if they are sold ore not.

9. News

9.1 protection foil for stainless steel heads

9.1.1 deep drawn heads with foil

-dimensions	up to 1200mm max.
-two sides	up to ca. 800mm (on request)
-one side	up to 1200mm max.
-type foil	laserfoil
-marks	low stress stamped through the foil
Note : After deep drawing, the foil may not cover the complete straight flange area.	