Intentions, perfect. It began in customer needs, and finally customer satisfaction!

Quality - is to get the trust of weight is the key to winning the competition, is the starting point for endless most demand, value and dignity.

Related Design

Checking methods

Rolled products in the manufacturing process determine the existence of open joints, making products in the free state not habe a good whole circle shape, while sleeve diameter and the seat for the interference fit between the holes, sleeve adapted to maximize Block hole shape can not be directly measured in the free state the inner/outside diameter of the product only can be by a special measuring instrument; In ISO3547 standards measured Part 2 of the rolled products made clear tolerance test requirements, including :
Test Method A: Huff regulatory test outside diameter;
Test method B: use stop-pass gauge to test the outside diameter;
Test method C: use stop-pass gauge to test the inside diameter;
Test method D: Measure the outer diameter of large scale product and use wall-thickness test to replace test method C. (Wall-thickness test and test method C can not be used at the same time.)

External diameter test methods

Test A of ISO 3547 Part 2

Check the outside diameter of a wrapped bush using measuring equipment as shown to the right, with a checking block consisting of upper and lower halves and setting plugs, at a determined checking load of Fch, during the test the outside diameter of the bush is made smaller by the elastic reduction, however it is not a permanent deformation. The bushes outside diameter can be calculated from the difference in the value of z (⊿Z)

Test B of ISO 3547 Part 2

The test is carried out with two ring gauggs, a Go gauge and a No Go gauge whose diameter Shall be chosen empirically from with Table 6 of ISO3547-1:1999 and agreed upon. It shall be possible to press the bushes into the GO gauge and then push them through with hand pressure (maximum force 250N). On the other hand with the same force, it shall not be possible for them to go into and through the NO GO gauge (See ISO 12307-1)

Test D (ISO 3547-2)

The test is carried out by means of a precision measuring tape.

Internal diameter test methods

Test C (ISO3547-2: Test C)

To check the inside diameter, the bush is to be pressed into a ring gauge, whose nominal diameter corresponds to the dimension specified in ISO3547-1:1999.The inside diameter shall be measured with a 3-point measuring instrument or checked with a GO and NO GO plug gauge. The GO plug gauge shall be inserted by a minimum effort; the NO GO plug gauge shall not be inserted by manual pressure(maximum force 250N). In order to enable the manufacturer and the customer to compare results of this test it should be agreed whether results should be obtained by measuring or by gauging.

Thrust washer test method

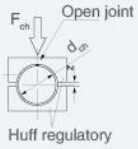
Beside the thickness, the flatness of washer is also important for washer and grinding parts' usage age. We use very helpful test in which the washer falls through the gap between two plain parallel plates of a gauge under its dead weight. The plates must be big enough to cover the whole washer.

壁厚检测方法 Wall Thickness test method

The wall thickness is measured at once,two or three positions axially according to the bearing dimensions.The wall thickness and the inside diameter shall not be specified together on the same drawing.

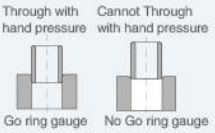
B[mm²]	X[mm²]	measurement position
B≤15	B/2	1
15 < B≤50	4	2
50 < B≤90	6 and B/2	3
B > 90	8 and B/2	3

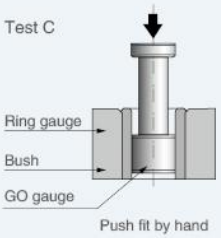
A Test A of ISO

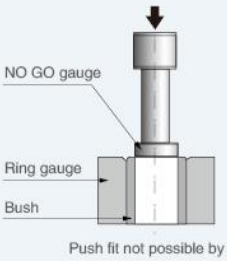


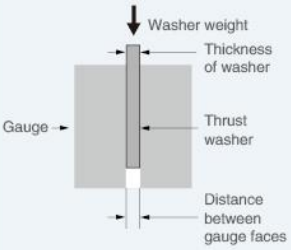
Checking block and setting mandrel d_{ch}=____mm
Torce test F_{ch}=____N
Limiting value Δ_z=___and___mm
OD tolerance D_e=___to___mm

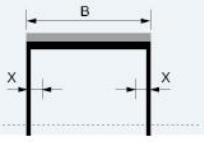
Test B of ISO











Measurement position