



To determine the localization datum bearing sleeve and clamping means

(1) hole processing

The locating datum: hole processing when the outside circle positioning;

Fixture: three jaw self centering chuck, U-turn clamping processing, using a dial gauge for alignment, and the clamping part is wrapped with a layer of copper.

(2) the outer contour machining

The locating datum: determine the parts for the locating datum axis;

Fixture: three jaw self centering chuck, U-turn clamping processing, using a dial gauge for alignment, and the clamping part is wrapped with a layer of copper.