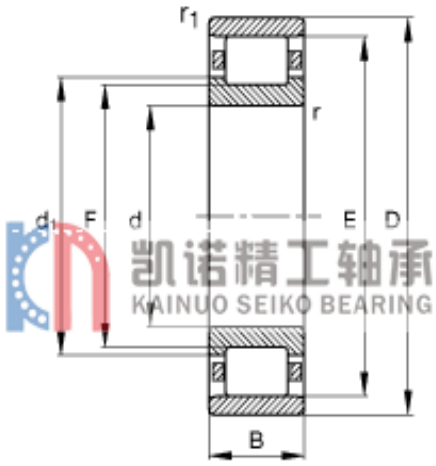
FAG N1938 - K - M1 - SP bearing sample figure



New Model	FAG N1938-K-M1-SP	Pda(min)	43.5
d(mm)	190	db(max)	199
B(mm)	33	Db(min)	245
D(mm)	260	Da(min)	251
C0r	208000	Cur	46000
Cr	340000	nG	3000 1/min
s	3	nB	5300 1/min

In large mould processing, there are a number of large size and complex shape parts, large distortion of these parts after heat treatment, grinding with difficulty, therefore, ceramic tool can be used on nc machine tools to turning of hardened after parts, car for grinding, improve processing efficiency.

(2) process

(1) analysis of the drawings

To analyze parts of material, shape, size, precision and blank shape and heat treatment requirements, etc, in order to determine the suitability of the parts on the nc machine tool processing, or which kind of numerical control machine is suitable for processing.Sometimes determine on a digit-controlled lathe processing which process or which a few surface of the parts.

(2) process is determined

Determine the parts processing methods (such as clamping apparatus, the clamping positioning methods, etc.) and processing route (such as the cutting point, feed line), and determined the processing quantity of process parameters (such as cutting feed speed and spindle speed, cutting width and depth, etc.).

(3) the numerical

According to drawings and determine the processing route, calculate the numerical control machine tools required for the input data, such as adjacent intersections of geometric elements and a contour tangent point, a straight line or arc approximation contour adjacent intersection of geometric elements and point of tangency calculation.

(4) write parts program list

Calculated according to the processing route of the processing of data and has determined dosage, combined with

the numerical control system of procedures section format write parts processing program list.In addition, still should fill in the relevant process documents, such as the nc machining process card, nc cutter card, workpiece installation and zero setting card, etc.