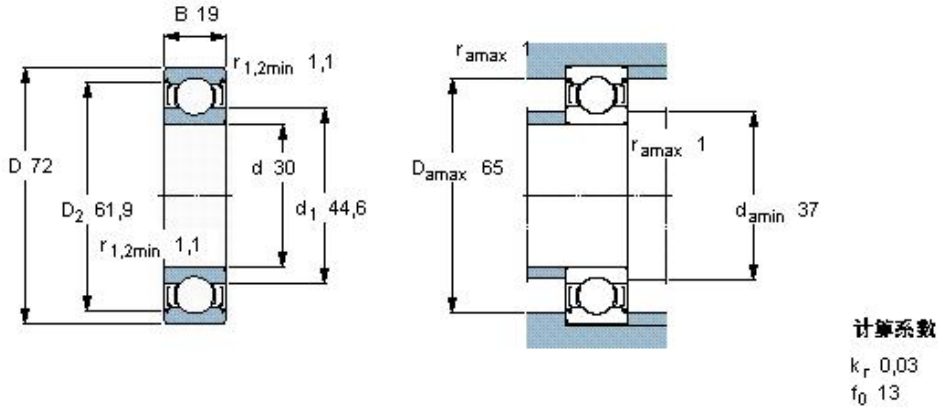
N228-E-M1 of Cylindrical roller Bearings



New Model	FAG N228-E-M1	m	9.3kg
d(mm)	140	da(min)	154
B(mm)	42	Db(min)	227
D(mm)	250	Da(max)	236
C0r	510000	Cur	77000
Cr	460000	nG	4800 1/min
ra	2.5mm	nB	2600 1/min

1 transmission principle
Turning the screw thread, in order to obtain accurate thread, must use the screw rod drives the rest feed, make work per revolution of the tool movement, distance equal to the pitch.
The 2 threaded tool and installation
Tooth type angle assurance, depends on the thread cutter grinding and installation.
Thread cutting edge grinding requirements:
1) tool tool angle is equal to the tooth type screw axial profile angle;
2) the rake angle of 0=0 degrees, coarse thread in order to improve the cutting conditions, tool is available with front angle (gamma 0=
5 degrees to 15 degrees).

$D_{a\ max}$	236	mm	
$D_{b\ min}$	227	mm	
$D_{c\ max}$	223	mm	
d_1	179,4	mm	
$d_{a\ min}$	154	mm	
E	225	mm	
F	169	mm	
$r_{1\ min}$	3	mm	
$r_{a\ max}$	2,5	mm	
$r_{a1\ max}$	2,5	mm	
r_{min}	3	mm	
s	2	mm	距离中心位置的轴向偏移

m	9,3	kg	质量
C_r	460000	N	基本额定动载荷，径向
C_{0r}	510000	N	基本额定静载荷，径向
n_G	4800	1/min	极限转速
n_B	2600	1/min	参考速度
C_{ur}	77000	N	疲劳极限载荷，径向

Thread cutting tool installation requirements:
1) the tip must be with the workpiece rotation center high.
2) tool angle bisector line must be vertical with the axis of workpiece. Therefore, to use the knife template cutter.
3 machine tool adjustment and installation
Tools are installed, the machine tools were adjusted according to N228-E-M1 of Cylindrical roller Bearings the size of look-up lathe workpiece pitch, signs, selected feed box handle position, the removal of N228-E-M1 of Cylindrical roller Bearings the polish rod feeding mechanism, by the screw drive. Select the spindle speed is low, so that the cutting smoothly, and have sufficient time to retreat knife. In order to make the tool moving even and smooth, need to be adjusted in the cross slide rail gap and the knife frame wire rod and nut.
In the turning process, the workpiece with tiny loose on the spindle like, that will lead to thread shape or pitch is not accurate, so the firm clamping of the workpiece must be.