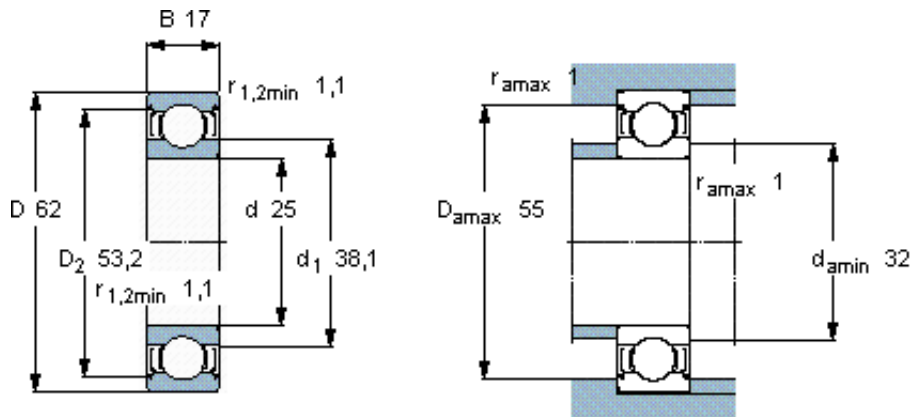




## 61808 FAG bearings offer size

d(mm)	40	da(min)	42
B(mm)	7	Db(min)	44
D(mm)	52	Da(max)	50
C0r	4200	Cur	178
Cr	4950	nG	16000 1/min
ra	0.3	nB	10000 1/min
New Model	FAG 61808	m	0.032kg



计算系数

 $k_r = 0,03$  $f_0 = 13$ 

### 3.M1432A type universal cylindrical grinder processing method

(1) cylindrical grinding as shown in figure 3-46, the processing required for the movement:

The wheel rotational motion of 61808 FAG bearings NT, it is the main movement of the outer circle grinding;

The workpiece rotation motion of NW, it is a circular workpiece feeding movement;

The workpiece longitudinal reciprocating motion of FA, it is grinding out the longitudinal feed movement necessary for the workpiece length;

The grinding wheel cross feed motion of 61808 FAG bearings FR, it is the breakthrough of intermittent movement.

(2) wear long conical surface as shown in figure 3-46 (b) shows, the desired motion and external grinding is the same, the difference is the angular position of the work table to a certain. At this time, the rotary center line of the workpiece and a workbench longitudinal feeding direction is not parallel, so the surface grinding out is a conical surface.