Scrape how sliding bearing KOYO

Scraping in front, should carefully check the shaft neck is smooth, if there is rust, scratches and other defects, if you should try to eliminate; then, contact, check the shaft neck and the shaft of the inspection method, the diameter of shaft coated with a thin layer of display agent (such as red lead powder, red beauty oil), then the shaft neck is installed on the KOYO bearing, hand rotating two or three turned to positive and negative direction, the shaft removed, check the KOYO bearing colored point distribution, if the colored point distribution is not normal or simply not to move, to start scraping.

Scraping, should be based on the situation, adopts the principle of light, light weight, large left scraping scraping the small after the first. The first few times, hands can be heavier, more scrape some metal, quickly reach good contact. When the contact area reached 50%, you should blow gently. Each finished once, the tile surface wipe, and then displays the agent on the axle neck Colonel nuclear inspection, according to the contact condition of scraping, until it meets the technical requirements so far. Scraping check can be used to display the agent, KOYO precision bearings but high demands on the point of contact, the final stage not scraping use display agent.

Because the display, coating agent, KOYO bearing coloring on a bit too big, not easy to judge the actual contact. At this time, the shaft neck can be wiped clean, directly put check in the KOYO bearing, and the shaft is removed, we can see that the KOYO bearing bright spot, is the point of contact. Then on the window scraping, until it meets the technical requirements so far.

Scraping, not only to make the contact point to meet the technical requirements, but also to make the side clearance and contact angle to meet the technical requirements. The first general research point of contact, but also take care of contact angle, then scrape side clearance. However, the contact part and the non contact part should not have clear boundaries, wiping KOYO bearing surface rub with your fingers, should be perceptible marks.

Open the oil groove to rely on the experience, but mainly to grasp the principle:

1, the lubricating oil from the oil film pressure at the smallest input KOYO bearing;

2, the oil groove on the bearing area in non, otherwise it will reduce the carrying capacity of the oil film;

3, the oil groove axial cannot be opened, so as to avoid the oil from the oil tank end large loss;

4, the level of the installation of the KOYO bearing oil groove on the half of the week, not extending to the bearing area, the entire week oil tank should be opened in the near KOYO bearing end.

In addition, into the oil hole in the top of the oil groove bearing, around the oil inlet hole as the center, the oil groove on the width and equal aperture, shape can take "a" shape, "X" font, "Wang" shape.