



轴承的装配 Bushing fixing

假如采用以上方法安装不合适或者不经济的话，可采用粘着剂、激光焊接或高温焊接。采用粘着剂安装时，可以不用固定销，但其效果较差。粘着剂以环氧树脂系的合成树脂较适合。当使用激光焊接或高温焊接时，不应该超过润滑层的最高承受温度。

If the above fixing methods are not appropriate or economic, you can adopt laser welding, adhesive fixing or high temperature welding. When using adhesive fixing, dowel is optional, but the fixing effect may not be good. Adhesives like oxidized rosin and synthetic rosin is more appropriate. When using laser welding or high temperature welding, the temperature shall not exceed the max temperature that the lubricating layer could bear.

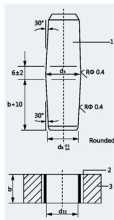
轴承安装后内径的校准 Inside diameter alignment after fixing

1) 卷制轴承内径的校准 Inside diameter alignment for common bushings

轴承安装后，通常可以直接使用。在配合间隙要求增大、或安装时由于配合过盈量太大而造成内孔变形时，可采用下图所示整形工具使轴承内孔达到所要求的尺寸，整形工具直径 d 不宜太大，否则会降低轴承寿命。见图。

Normally the bushing can be immediately put into use after it has been fixed. But if there's need to enlarge the matching clearance or due to too much surplus the inner bore of the bushing deformed, we can use the following showed molding tools to make the inner bore meet the required dimensions. Diameter of the molding tools shall not be too big; otherwise, life of the bushing may decrease. Please see the picture:

轴承内径 Dia of the axis d	要求内径 Required ID dE	整形工具直径 Diameter of the shaping tools dk
	d	d+0.03
d	d+0.02	d+0.06
	d+0.03	d+0.08
	d+0.04	d+0.10



2) 相配轴的校准 Alignment of the mating arbor

不论是径向还是轴向滑动轴承，为了避免负荷集中，安装时都要对其平行度进行校准，要求在整个宽度范围内，轴与轴承之间平行度不超过 0.02mm^2 。

In order to avoid load centralization, when fixing the bushing, radial or axial movement, parallelism between the bushing and the arbor must be aligned. It requires the parallelism not exceed 0.02mm^2 .

