



## 卷制轴承的检验方法

## Checking methods for wrapped bushes



DIN1494-2 測试 Testing A 检验模和芯棒 Verify mould and mandrel 试验力 Testing load

极限 Limit 4148 Outer diameter dch1=dch2= mm<sup>3</sup> Fch= A 2= n-

## 2) 环规检测法(根据 DIN 1494-2 检验方法 B) Measuring of gauge 检验采用调、止环规进行检测,用手(最大力 250N) 可将轴承推入并调过通环规; 相同力情况下,不能进入止环规。

- 注,在某些情况下,例如,希制轴承不圆或接缝太大、检验精度可能受到影响。 The checking is carried out by two ring gauges,a "GO" ring gauge and a "NO GO"
- ring gauge. It must be possible to press the bushing in "GO" ring gauge with hand pressure(max 250N). With the same force it must not be possible to press the bushing in "NO GO" ring gauge.

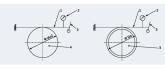
Note: In some cases, such as the bushing with roundness problem,or the butt joints not close tightly, the accuracy of the checking may be affected.



## 3) 带尺检测法(根据 ISO3547-2 检验方法 D) Measuring of rule

为了测量尺寸较大的轴承外径,可以用带尺来测量圆局长。用测量带尺在轴承宽度的中线上沿轴承360°,施加足够的拉力使用使开口闭合。 测量带尺绕外径等于轴承公称外径 Do 的定位芯轴进行标定。指示装置放置于测量带尺的自由端,并调至标定尺寸。在轴承检验完成后,周 长指示装置读数△ ZD 应为轴承测量值与定位芯轴标定值的差。由此,可计算轴承的外径 Do。

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A) 用定位芯轴校定 Verified by locating spindle

b) 轴承的检验 Measuring of bush

- 1- 精密的测量线; Precise measuring line
- 2- 干分表:
- Dial indicator
- 3-拉力板手:
- Pulling spanner
- 4- 定位芯轴:
- Locating spindle
- 5-卷制轴承 Wrapped bushing