

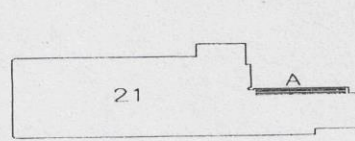
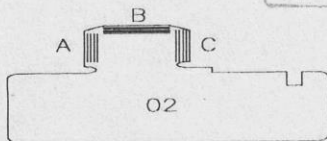
Bearing Parts Raceway Surface Hardness and Roughness Inspection Report

REFERENCE		PO: 47178717						110324-1-1	
PART NUMBER		2471605104903SB			REFERENCE			RW28/998	
Inspection status									
Part NO.	NO.	Raceway surface hardness (HRC)						Raceway roughness ($\leq Ra 1.0$)	Width of soft zone
		A		B		C			
01	H28011104	Max	60.5	Max	58.8	---	---	OK	36mm
		Min	55.6	Min	56.3	---	---		
	H28311105	Max	59.0	Max	59.0	---	---	OK	30mm
		Min	55.6	Min	55.9	---	---		
	H28011109	Max	60.8	Max	59.0	---	---	OK	32mm
		Min	55.5	Min	56.0	---	---		
21	H28211103	Max	59.0	---	---	---	---	OK	38mm
		Min	55.5	---	---	---	---		
	H28311101	Max	58.9	---	---	---	---	OK	35mm
		Min	55.6	---	---	---	---		
	H28211109	Max	60.0	---	---	---	---	OK	33mm
		Min	56.1	---	---	---	---		
02	H28021102	Max	60.1	Max	59.3	Max	60.5	OK	39mm
		Min	56.2	Min	55.8	Min	55.6		
	H28021101	Max	60.2	Max	59.6	Max	60.3	OK	37mm
		Min	57.0	Min	55.6	Min	55.5		
	H28021103	Max	59.1	Max	59.8	Max	60.1	OK	30mm
		Min	56.0	Min	55.6	Min	56.2		
Final status		Accepted <input checked="" type="checkbox"/>				Rejected <input type="checkbox"/>			
Head faces roughness ≤ 1.25		OK		ID,OD surface roughness ≤ 2.5		OK			
Other surfaces roughness ≤ 5.0		OK		-----		-----			

NDT OPERATOR NAME

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DATE 2011.3.24



LYCORES®

VISUAL AND DIMENSION REPORT FOR FINISHED PART

Type	RW 28/998 (2471605104903SB)		Quantity	3		Report No	110325-1		
Date	11-03-25	Standard	According to technical and inspection rules of GB307 and GB/T4604 Confirm drawing Rev 5 (Double row four point contact ball slewing bearing)						
Items	Technical Requirement			Product No					
				07#	09#	11#			
	Outer Ring	Φ1180	-0.1	-0.24	-0.23				
	Inner Ring	Φ800	+0.06	+0.10	+0.04				
	High	166±1	+0.70	+0.20	+0.40				
	Axial Clerance	0.05 - 0.15	0.11	0.09	0.10				
	Radial clearance	0.10 - 0.22	0.10	0.05	0.15				
	Radial runout of inner ring	0.20	0.18	0.10	0.20				
	Radial runout of outer ring	0.25	0.07	0.15	0.15				
	Axial runout of inner ring	0.14	0.02	0.01	0.02				
	Axial runout of outer ring	0.18	0.03	0.03	0.08				
	Central dimater of outer ring installing bore	Φ1114	-0.30 +0.40	-0.50 +0.20	-0.50 +0.40				
	Central dimater of inner ring installing bore	Φ866	-0.30 +0.10	-0.40 -0.10	-0.50 0				
	Surface Quality	Rusty	OK						
		Black	OK						
Crack		OK							
Mark		OK							

Material tempered and quenched hardness:HB229~269.Test result satisfie

Inspector: 代玉琴

Conctroller: 周莉莉

