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NATIONAL STANDARD OF THE

PEOPLE'S REPUBLIC OF CHINA

GB/T 12613.5-2011

Replacing GB/T 18331.1-2001

Plain bearings -- Wrapped bushes -- Part 5: Checking the outside diameter

滑动轴承 卷制轴套 第5部分：外径检验

(English Translation)

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Foreword

GB/T 12613 "Plain bearings - hub" consists of the following seven parts.

--- Part 1. Dimensions;

--- Part 2. outside and inside diameter of the test data;

--- Part 3. Lubrication holes, grooves and pockets;

--- Part 4. Materials;

--- Part 5. diameter test;

--- Part 6. inner diameter of the test;

--- Part 7. Measurement of wall thickness of thin-walled sleeve.

This part of GB/T 12613 Part 5.

This section drafted in accordance with GB/T 1.1-2009 given rules.

This Part replaces GB/T 18331.1-2001 "Plain bearings - Wrapped bushes outside diameter detection." And GB/T 18331.1-2001 Compared main changes are as follows.

--- Remove obsolete and incorrect references;

--- Symbol test mode and positioning plug symbol by the subscript "c" to "ch";

--- Increasing the outer diameter of the ring symbol "do", added between mold inspection length, width, and two mold halves from the symbol "x", "y", "z", increase foreign Diameter tolerance symbol "Do", increase the dial gauge reading "deltaz", increase the girth indicator reading "deltazD";

--- Remove the outer diameter of the elastic damping symbol "Ered", confidence symbol "Pzw", diameter tolerance symbol "T", the symbol of Measurement Uncertainty Uncertainty symbol "u", the measuring device "uE", the first and second measurement readings symbol value difference "deltax", "deltax" flat Mean symbol "deltax", the standard deviation of the symbol "sigma", the standard deviation of the symbol deltax "sigmadeltax";

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--- Test Method A test module added to the technical requirements and positioning plug (edition 8.2), an increase of test mold base hole length and width Degree requirements, the housing bore surface roughness test mode by the Ra1.6 to Ra0.2;

--- Test Method B ring size requirements change, the surface roughness Ra1 to Ra0.2;

--- Increased test method D (for GB/T 12613.2-2011 The test method D detailed provisions).

This section uses the translation method identical with the international standard ISO 3547-5:2007 "Plain bearings - Wrapped bushes - Part 5. OD inspection Experience. " and ISO 3547-5:2007 as compared to this section made the following editorial changes.

--- To increase the range. "Note 2. Except otherwise specified and the specified unit, GB/T 12613 in this section All dimensions in mm Meter. "Delete the text on the table," millimeters ";

--- Equivalents adoption of international standards in place of the standard corresponding to international standards.

This part is proposed by China Machinery Industry Federation.

Bearing this in part by the National Standardization Technical Committee (SAC/TC236) centralized.

This section is responsible for drafting unit. Productivity Promotion Center in the machine.

Participated in the drafting of this section. Zhejiang Changsheng Sliding Bearings Co., Ltd., Zhejiang Zhongda Bearing Co., Ltd., Zhejiang Flying free Oil Bearing Co., Ltd. Jiashan Feng into three complex Bearing Co., Ltd. Ningbo Bearing Factory.

This part of the standard replaces the previous editions are.

--- GB/T 18331.1-2001.

Plain bearings - Wrapped bushes Part 5. OD inspection

1 Scope

GB/T 12613 in this section according to GB/T 27939-2011, the provisions of the outer diameter of the sleeve rolling test (GB/T 12613.2 in the specimen Test method A, B, D) requirements, and provides the necessary testing methods and testing equipment.

Since the outer diameter of the sleeve in the free state is resilient, but after the installation due to differences in the outer diameter of the sleeve and the housing bore size, the pole sleeve Earth adaptation seat hole size. Therefore, the detection of the outer diameter of the sleeve should apply a constant load on the special equipment to carry out.

Note 1: Wrapped bushes - Dimensions and tolerances in GB/T 12613.1 given wall thickness

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inspection GB/T 12613.7 specified in.

Note 2: In addition to the marked and designated special units, GB/T 12613 in this section All dimensions are in millimeters.

2 Normative references

The following documents for the use of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

GB/T 12613.2-2011 Plain bearings - Wrapped bushes - Part 2. Dimensions (ISO 3547-2:2006, IDT) ISO 286-2. 1988 ISO system of limits and fits - Part 2. Standard hole and shaft tolerance level and limit deviations (ISO systemoflimitsandfits-Part 2. Tablesofstandardtolerancegradesandlimitdeviationsforholesand shafts) ISO/R1938. 1971 ISO system of limits and fits - Part 2. Inspection of plain workpiece (ISO systemoflimitsand fits-PartII. Inspectionofplainworkpieces)

3 Symbols and units

Table 1.

Table 1 Symbols and units

Symbol Parameter Description Unit B bush width mm bch, 1 mm width test mode bch, 2 mm width positioning plug do ring diameter mm Do sleeve diameter mm dch, 1 test module housing bore diameter (see GB/T 12613.2) mm dch, 2 positioning plug diameter (see GB/T 12613.2) mm dch, a, 1 test module housing bore diameter mm Found dch, a, 2 mm diameter locating plug Found

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