Survey No 22/1, Plot No 1,
Shapar Village Road, Opp. Best Agro Industries,
SHAPAR(Veraval)- 360 002. Tal:Kotadasanghani
Dist.: Rajkot, State: Gujarat, Country: India
Cell : Mr. Divyesh : (+91)-94262-19893
Cell : Mr.Vijay : (+91)-94262-02620

TECHNICAL SPECIFICATIONS

SPECIFICATION OF TAPER ROLLER

Sr. No.	PARAMETER	TOLERANCE
1	DIAMETER	(+/-) 2µm (Size Variation Within 3µm)
2	TAPER	(+/-) 2µm (Maximum)
3	OVALITY	1µm (Maximum)
4	LENGTH (Tolerance on Basic Size)	+50 To -200µm
5	FACE SQUARENESS	8µm (Maximum)
6	OD S/ROUGHNESS (Ra)	0.10µm (Maximum)
7	FACE S/ROUGHNESS (Ra)	0.20µm (Maximum)
8	ROUNDNESS (Filter : 1-15)	1µm (Maximum)
9	HARDNESS	60 To 64 HRC
10	VISUAL INSPECTION	FREE FROM RUST, DENT MARKS, SPIRAL LINES ON OD, OUT OF RADIUS
11	MATERIAL	SAE 52100
12	MICRO STRUCTURE	FINE TEMPERED MARTENSITE WITH UNDISOLVED CARBIDES
13	CROWNING (Pt)	DEPEND ON GROUND LENGTH

NOTE: > The Crowning value is to be consider only for 75 to 80% of centre Roller length.

Ground Length (MM)	CROWNING (Pt) µm
0 TO 15	1 TO 2
15 TO 25	1 TO 3
25 TO 30	1 TO 4
30 TO 35	1 TO 5
25 TO 45	2 TO 6
45 TO 50	2 TO 7
50 ABOVE	3 TO 8

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SPECIFICATION OF CYLINDRICAL ROLLER

Sr. No.	PARAMETER	TOLERANCE
1	DIAMETER	(+/-) 1.5µm (Size Variation Within 2µm)
2	OVALITY	1µm (Maximum)
3	LENGTH (Tolerance on Basic Size)	- 20µm (Maximum), Grouping within 6µm
4	FACE SQUARENESS	6µm (Maximum)
5	OD S/ROUGHNESS (Ra)	0.10µm (Maximum)
6	FACE S/ROUGHNESS (Ra)	0.20µm (Maximum)
7	ROUNDNESS (Filter : 1-15)	1µm (Maximum)
8	HARDNESS	60 To 64 HRC
9	VISUAL INSPECTION	FREE FROM RUST, DENT MARKS, SPIRAL LINES ON OD, OUT OF RADIUS
10	MATERIAL	SAE 52100
11	MICRO STRUCTURE	FINE TEMPERED MARTENSITE WITH UNDISOLVED CARBIDES
12	CROWNING (Pt)	DEPEND ON GROUND LENGTH

NOTE: > The Crowning value is to be consider only for 75 to 80% of centre Roller length.

Ground Length (MM)		CROWNING (Pt) µm	
MIN.	MAX.	MIN.	MAX.
6	7	1	3
8	10	1.5	5
11	14	2	7
15	17	3	9
18	19	5	10
20	22	7	14
23		7	15
24	25	8	16
26		8	17
27	28	8	18
29	30	9	18
31	32	9	19

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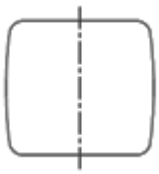
SPECIFICATION OF SPHERICAL ROLLER



Nominal Dia. Of Roller	Wobble of Face	Tol. On Length		Conicity	Ovality	Surface Roughness on OD.	Surface Roughness on Face.	Hardness	Material
		Max.	Min.						
0 - 10	8µm	-0	-15	12µm	1.5µm	0.15	0.30	60To 64 HRC	SAE 52100
10 - 20	10µm	-0	-20	15µm	2.0µm	0.20	0.40		
20 - 40	12µm	-0	-30	18µm	2.5µm	0.25	0.50		
40 -	20µm	-0	-40	25µm	3.0µm	0.25	0.60		
VISUAL INSPECTION		FREE FROM RUST, DENT MARKS, SPIRAL LINES ON OD, OUT OF RADIUS							
MICRO STRUCTURE		FINE TEMPERED MARTENSITE WITH UNDISOLVED CARBIDES							

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