

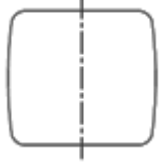


TECHNICAL SPECIFICATIONS

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

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

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						