

## IDEAL BEARING / Quality Control For IB060, IB061 Products

### Working Step 1: Cutting Circumference

Equipment: Punch Press Machine

Checking Tools: Vernier Caliper

Checking Points: Circumference Size

- Details: 1. Keep good appearance, no scratch on the two surfaces.
2. Check the tolerance of wall thickness.
  3. Control the burrs.

### Working Step 2: Remove Burrs

Equipment: Belt Sander

Checking Tools: Ocular Estimate

Checking Points: Two Ends Burrs

- Details: 1. Keep good appearance, no scratch on the sliding layer.

### Working Step 3: Cutting Length

Equipment: Cutting Machine

Checking Tools: Vernier Caliper

Checking Points: Length Size

- Details: 1. Keep good appearance, no scratch on the sliding layer.
2. Control the burrs.

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### Working Step 4: Bending End

Equipment: End Bending Machine

Checking Tools: Ocular Estimate

Checking Points: Bending Radian

Details: 1. Control Bending Radian.

### Working Step 5: Rolling

Equipment: Rolling Machine

Checking Tools: Ocular Estimate

Checking Points: Roundness & Out Looking

Details: 1. Keep good appearance, no scratch on the sliding layer.

2. Control the small split.

### Working Step 6: Forming

Equipment: Hydraulic Press Machine

Checking Tools: Ring Gauge for Outer Diameter; Housing & Plug Gauge for Inner Diameter;

Micrometer for Wall Thickness

Checking Points: Outer Diameter, Inner Diameter and Wall Thickness

Details: 1. Keep good appearance, no scratch on the sliding layer.

2. Check the tolerance of outer diameter, inner diameter and wall thickness.

Working Step 7: Chamfering

Equipment: Chamfering Machine

Checking Tools: Vernier Caliper & Universal Angle Gauge

Checking Points: Inner Chamfering, Outer Chamfering and Length

- Details: 1. Keep good appearance, no scratch on the outer surfaces.  
2. Control the length.

Working Step 8: Hardening

Equipment: Hardening Stove

Checking Tools: Hardness Testing Instrument

Checking Points: Surface Hardness

- Details: 1. Control the surface hardness.

Working Step 9: Packing

Equipment: People

Checking Tools: Ocular Estimate

Checking Points: Appearance

- Details: 1. Reject the bad appearance products.  
2. Reject the bad sliding layer products.  
3. Reject the bad split products.  
4. Reject the bad chamfer products.