

## IDEAL BEARING / Quality Control For IB09 Products

Working Step 1: Making Oil Pockets

Equipment: Rolling Mill Machine

Checking Tools: Depth Scale

Checking Points: Depth of Oil Pockets

Details: 1. Check the depth of oil pockets.

Working Step 2: Pressing to Requested Tolerance of Wall Thickness

Equipment: Rolling Mill Machine

Checking Tools: Micrometer

Checking Points: Wall Thickness.

Details: 1. Check the tolerance of wall thickness.

Working Step 3: 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.

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Working Step 4: 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 5: 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.

Working Step 6: Bending End

Equipment: End Bending Machine

Checking Tools: Ocular Estimate

Checking Points: Bending Radian

Details: 1. Control Bending Radian.

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### Working Step 7: 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 8: 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 9: 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.

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### Working Step 10: Polishing

Equipment: Centrifugal Concussive Machine

Checking Tools: Ocular Estimate

Checking Points: Out Looking

- Details: 1. Keep good appearance, no scratch on the outer surface.
2. Avoid the products being get rusted.

### Working Step 11: 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.