



洛阳汇工轴承科技有限公司
LUOYANG HUIGONG BEARING TECHNOLOGY CO., LTD.

大型高端滚子
High-End Large Rollers



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公司简介

洛阳汇工轴承科技有限公司成立于1998年，位于洛阳市洛龙高新技术开发区，是一家专业从事轧机轴承，精密薄壁轴承、大型高端滚子设计、研发、生产、销售为一体的高新技术企业，产品广泛应于冶金、航空航天、医疗、风力发电等领域。

公司生产的高可靠性、长寿命大型高端圆柱滚子、圆锥滚子和球面滚子，精度可达到G1、G1A（I级）、G2、G2A（II级），产品重点为风力发电主轴轴承、偏航变桨轴承、增速箱轴承，轧机轴承等配套。

公司拥有当前热处理技术先进的全自动、智能化生产线，同时拥有多条大型滚子车、磨生产线，全自动探伤、分选、打字、涂油、包装生产线，生产实现全过程在线质量控制，确保产品品质。

历经二十多年的风雨洗礼，汇工人将继续秉承“汇精英，工精品”的企业经营理念，践行“感恩、精进、创新、拼搏”的核心价值观，走专业创新发展之路，竭诚为客户提供最优的产品与服务！

企业文化

核心价值观：

感恩、精进、创新、拼搏

愿 景：

成为轴承行业知名品牌

使 命：

为客户提供最佳轴承解决方案

- 荣誉证书
- 国家科技型中小企业
 - 河南省高新技术企业
 - 河南省专精特新中小企业
 - 河南省机器人精密特种薄壁轴承工程技术研究中心
 - 洛阳市高精密薄壁轴承工程技术研究中心
 - 公司通过了ISO9001:2015质量管理体系认证
 - 国军标GJB9001C-2017体系认证

About us

Luoyang Huigong Bearing Technology Co. Ltd., established in 1998, located in Luoyang City, Luolong High-tech Development Zone, is a high-tech enterprise specializing in the design, development, production and sales of rolling mill bearings, precision thin-wall bearings, and high-end large rollers, its products are widely applied in metallurgy, aerospace, medical care, wind power generation and other industries.

The high-end large cylindrical rollers, tapered rollers and spherical rollers of high-reliability, long-lifespan manufactured by the enterprise, accuracy can reach G1, G1A (Class I), G2, G2A (Class II), and are mainly applied in wind power spindle bearings, yaw pitch bearings, speed-increasing box bearings, rolling mill bearings and other bearings.

The company has an advanced, fully automatic and intelligent production line of heat treatment, also several turning & grinding production lines, automatic inspection and packaging lines including flaw detection, sorting, typing, oiling and packaging, which enables online quality control of the entire process and ensures stable quality of the products.

After more than twenty years of ups and downs, Huigong people will continue to uphold the business philosophy of "Gathering Elites & Producing Fine Products", practice the core values of "Gratitude, Refinement, Innovation, Hard work", adhere to the road of innovation and development, and be dedicated to providing customers with the best products and service!

Core values:

Gratitude, Progress, Innovation and hard work

Vision:

To be a great industry-leading brand

Mission:

To provide customers with the best solutions for bearings

Company Culture

- Certificates of honor
- "National Scientific and Technological SME"
 - Henan Province New High-Tech Enterprise"
 - Henan Province Professional, Unique and Superior SME"
 - Henan Province Robotic High-precision Special Thin-section Bearing Engineering Technology Research Center"
 - Luoyang High-precision Thin-section Bearing Engineering Technology Research Center"
 - Qualified with ISO9001:2015 quality control system"
 - Qualified with GJB9001C-2017 system"



大型高端滚子生产线

Introduction of High-End Large Roller Production Line

汇工轴承大型高端滚子生产线，可生产直径 $\phi 15\text{mm} \sim \phi 160\text{mm}$ 、长度 $20\text{mm} \sim 220\text{mm}$ 范围内的各类圆柱、圆锥高精度滚子，年产量300余万粒，产品精度可达G1、G1A(I级)标准。各类精密设备150余台，并配备各种完善的专用检测仪器，超声波探伤(UT)、磁粉探伤(MT)、涡流探伤(ET)仪器、光谱仪、碳硫分析仪、圆度仪、轮廓粗糙度仪等，热处理线能够自主保障产品质量，完全实现从原材料进厂到成品的全过程质量控制，生产工序车、热、磨有序衔接，探伤、分选、涂油、包装一站式完成。

Huigong bearing roller production line can produce all kinds of high-precision cylindrical and tapered rollers in the range of $\phi 15\text{mm}$ to $\phi 160\text{mm}$ in diameter and 20mm to 220mm in length, with an annual output of over 3 million pieces and product precision up to G1 and G1A (Grade I) standards. More than 150 sets of various precision equipment, and various perfect special testing instruments, ultrasonic flaw detection (UT), magnetic particle flaw detection (MT), eddy current flaw detection (ET) instruments, spectrometer, carbon and sulfur analyzer, roundness meter, contour roughness meter, etc. The heat treatment line can independently guarantee product quality, fully realize quality control adopted in the whole process from raw materials to finished products, the production process of turning, heating and grinding in an orderly manner and the flaw detection, sorting, oiling and packaging completed in one stop.



滚子自动车加工生产线
Roller auto-lathe production line



滚子磨加工连续生产线
Roller grinding continuous production line



技术研发

Technical Research and Development

公司有自己的技术研发中心，中、高级技术人员20余人，特聘技术专家4人，可为客户提供产品选型、设计计算、载荷分析等全寿命周期的技术服务。

The enterprise has its own technical R&D center with more than 20 middle and senior technicians and 4 specially-appointed technical experts, which can provide customers with technical service for the whole life cycle such as product selection, design calculation and load analysis.

质控体系

Standard Quality Control System

通过ISO9001及GJB9001C质量体系认证，严格按照体系要求，制定并实施产品从原材料到成品的质量控制计划。能够实现产品订单、原料采购、设计工艺、生产计划、质量检验、设备维护全流程规范化管理，使产品生产管理过程严谨有序，确保质量稳定。

The company has passed ISO9001 and GJB9001C quality system certification, and strictly follow the system requirements to develop and implement the quality control plan of products from raw materials to finished products. It is able to realize the standardized management of the whole process from product orders, raw material procurement, design process, production plan, quality inspection to equipment maintenance, so that the production management process is rigorous and organized, the product quality is stable and ensured.

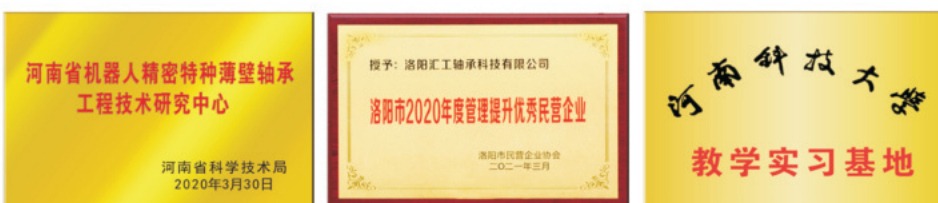
MES系统生产工艺

Processing Management

序号	生产工艺编号	生产工艺名称	生产工艺类型	负责人	创建时间	修改时间	禁用/启用
1	004	磨外圆	一级生产工艺	-	2021-11-03	2021-11-03	启用
2	00003	车外孔	二级生产工艺	-	2021-11-02	2021-11-02	启用
3	00202	圆火	二级生产工艺	-	2021-11-02	2021-11-02	启用
4	00201	淬火	二级生产工艺	-	2021-11-02	2021-11-02	启用
5	00302	车外圆	二级生产工艺	-	2021-11-02	2021-11-02	启用
6	00301	车端面	二级生产工艺	-	2021-11-02	2021-11-02	启用
7	002	热处理	一级生产工艺	-	2021-11-02	2021-11-02	启用
8	003	精车	一级生产工艺	-	2021-11-02	2021-11-02	启用

MES系统质量控制

Quality Management



技术研发中心
R & D Center

热处理线

Heat Treatment Line

引进世界一流的AICHELIN（爱协林）技术热处理生产线，推盘炉渗碳淬火&辊底炉二次淬火，整个生产过程工艺参数均为可视化显示。全过程自动监控、记录过程参数及质量数据。渗碳前预氧化工序，使产品渗碳层更加均匀。主要质量指标达到：根据需要渗碳层深度范围1~8mm；渗碳炉内碳势偏差 $\pm 0.05\%$ ，同一滚子渗层偏差 $\pm 0.1\text{mm}$ ；渗碳炉、保温炉、高低温回火炉、辊棒加热炉温控制精度 $\pm 1^\circ\text{C}$ ，炉温均匀性 $\leq \pm 5^\circ\text{C}$ ；高温回火采用氮气保护，辊底式加热炉采用气氛保护加热，实现了渗碳钢滚子无脱碳，高碳铬轴承钢滚子脱碳层深度 $\leq 0.03\text{mm}$ ；成品滚子残余奥氏体含量不大于8%。

CHG has brought in heat treatment line of the world-class Aichelin technology, pusher furnace carburizing quenching and roller hearth furnace secondary quenching, and can visually display its entire production, monitor and record automatically its processing parameters and quality data. Pre-oxidation before carburizing, can make the carburized layer of products more even. The main quality indexes need to meet: to be 1 ~ 8mm in the depth of carburizing layer in need; $\pm 0.05\%$ of the carbon potential deviation in the carburizing furnace, $\pm 0.1\text{mm}$ of the same roller carbon penetration deviation; carburizing furnace, thermal insulating furnace, high&low temperature tempering furnace, $\pm 1^\circ\text{C}$ temperature control accuracy of roller rod heating furnace, $\leq \pm 5^\circ\text{C}$ uniformity of furnace temperature. The nitrogen protection is adopted in high temperature tempering, while the atmosphere protection is adopted in roller hearth furnace, which makes sure that the carburized steel roller can avoid decarburization, the decarburizing layer depth of high-carbon chromium bearing steel rollers is $\leq 0.03\text{mm}$; Residual austenite content of the finished rollers is less than 8%.



热处理自动生产线

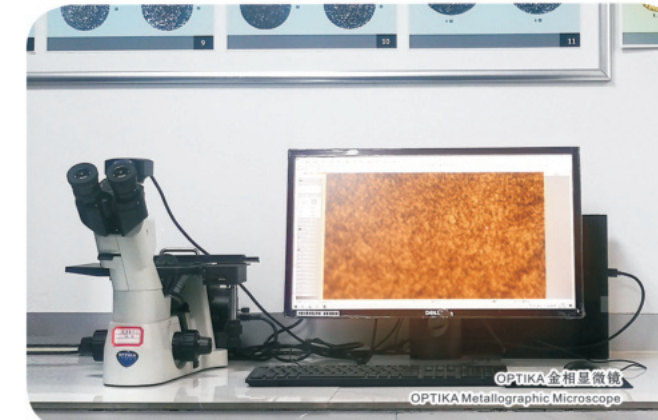
Automatic heat treatment production line

检测仪器

Testing Instrument

先进的三坐标测量仪、光谱仪、OPTIKA金相显微镜、碳硫分析仪、数显维氏硬度计、圆度仪、轮廓粗糙度仪等检测仪器，保证产品的各项检测指标符合质量控制体系的要求。

The three- Coordinate Measuring Machine (CMM), Spectrometer, OPTIKA Metallographic Microscope, Carbon and Sulfur Analyzer, Digital Vickers Hardness Tester, Roundness Meter, Contour Roughness Meter and other testing instruments, ensure that the testing indexes of the products meet the requirements of the Quality Control System.



分选包装

Sorting and Packaging

智能化自动分选检测、检验包装线，实现产品从涡流探伤、超声探伤、清洗、分选，到打字、涂油、包装一站式完成。直径分选测量精度 $0.5\mu\text{m}$ ，长度测量精度 $1\mu\text{m}$ ，清洗洁净度 $\leq 2.5\text{mg/kg}$ ，确保产品零缺陷、质量更可靠。

With automatic sorting and testing, inspection and packaging line, it can realize one-stop completion from Eddy Current Flaw Detection, Ultrasonic Flaw Detection, cleaning, sorting, typing, oiling to packaging. The accuracy of diameter sorting measurement reaches $0.5\mu\text{m}$, the accuracy of length measurement reaches $1\mu\text{m}$, the accuracy of cleanliness reaches $\leq 2.5\text{mg/kg}$, to ensure zero defects and more reliable quality.





CHG为您智能制造一粒精品！
With Smart Manufacturing(SM),
CHG will provide you with the best rollers!



CHG



质量管理体系认证证书

证书编号: 00120Q39432R4M/4100
兹证明
洛阳汇工轴承科技有限公司
统一社会信用代码: 91410300705564932B
中国河南省洛阳市洛龙区关林路 999 号
建立的质量管理体系符合标准:
GB/T 19001-2016 / ISO 9001:2015
通过认证范围如下:
滚动轴承的设计、生产和售后服务

首次发证日期: 2009年1月12日 本次发证日期: 2021年11月18日 有效期至: 2023年11月9日

在一个监督周期后, 本证书必须与CQC签发的监督审核合格通知书合并使用方可有效。查询证书有效状态请登陆www.cqc.com.cn。
本证书信息可在国家认证认可监督管理委员会官方网站 (www.cca.gov.cn) 上查询

IAF CNAS 中国质量认证中心

中国·北京



QUALITY MANAGEMENT SYSTEM
CERTIFICATE

Certificate No. 00120Q39432R4M/4100
We hereby certify that
Luoyang Huigong Bearing Technology Co., Ltd.
Unified Social Credit Code: 91410300705564932B
No.999, Guanlin Road, Luolong Zone, Luoyang City, Henan Province, P.R. China
has been awarded this certificate for compliance with the standard
GB/T 19001-2016 / ISO 9001:2015
The Quality Management System Applies in the following area:
Design Production and After-sale Service of Rolling Bearings

Certified since: January 12, 2009 Valid from: November 18, 2021 Valid until: November 9, 2023

After a surveillance cycle, the certificate is valid only when used together with an Acceptance Notice of Surveillance Audit issued by CQC.
Please access www.cqc.com.cn for checking validity of the certificate.
This certificate and its relevant information can query in the website of Certification and Accreditation Administration of the People's Republic of China (www.cca.gov.cn).

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中国·北京



(后附目录)
Product Catalogue Attached

LUOYANG

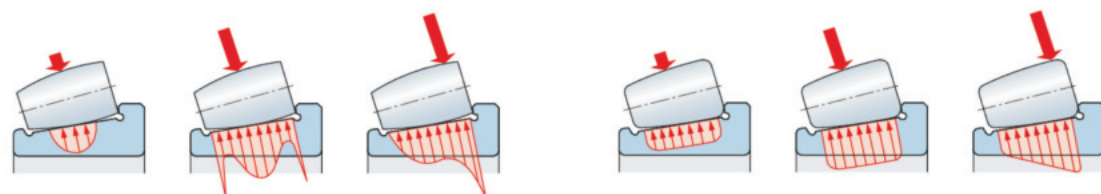
CHNOLGY CO.,LTD.

修型母线滚子、对数曲线滚子

Optimum Crowned Generatrix Roller and Logarithmic Crowned Roller

当滚子母线为直线时，工作中滚子母线表面发生弹性形变，会出现两端圆角处应力集中（如下图）；修型滚子中段为直线，两端采用圆弧过渡，缓解了偏载时的应力集中；对于一些可靠性要求很高的工况（风电主轴轴承），对数曲线滚子轮廓是最佳选择。既可避免两端圆角处应力集中，又使载荷分布更加均匀，极大地提高滚子可靠性及寿命。

When the roller generatrix is straight, the surface of the roller generatrix undergoes elastic deformation, and there will be stress concentration at the rounded corners of the two ends (as below); the middle part of the modified roller is straight, and the two ends adopt circular transition, which relieves the stress concentration at the unbalance load; for some working conditions with high reliability requirements (wind power spindle bearings), the logarithmic curve roller profile is the best choice, it not only can avoid the stress concentration at the rounded ends, but also make the load distribution more uniform, which greatly improves the roller's reliability and lifespan.



修型母线滚子

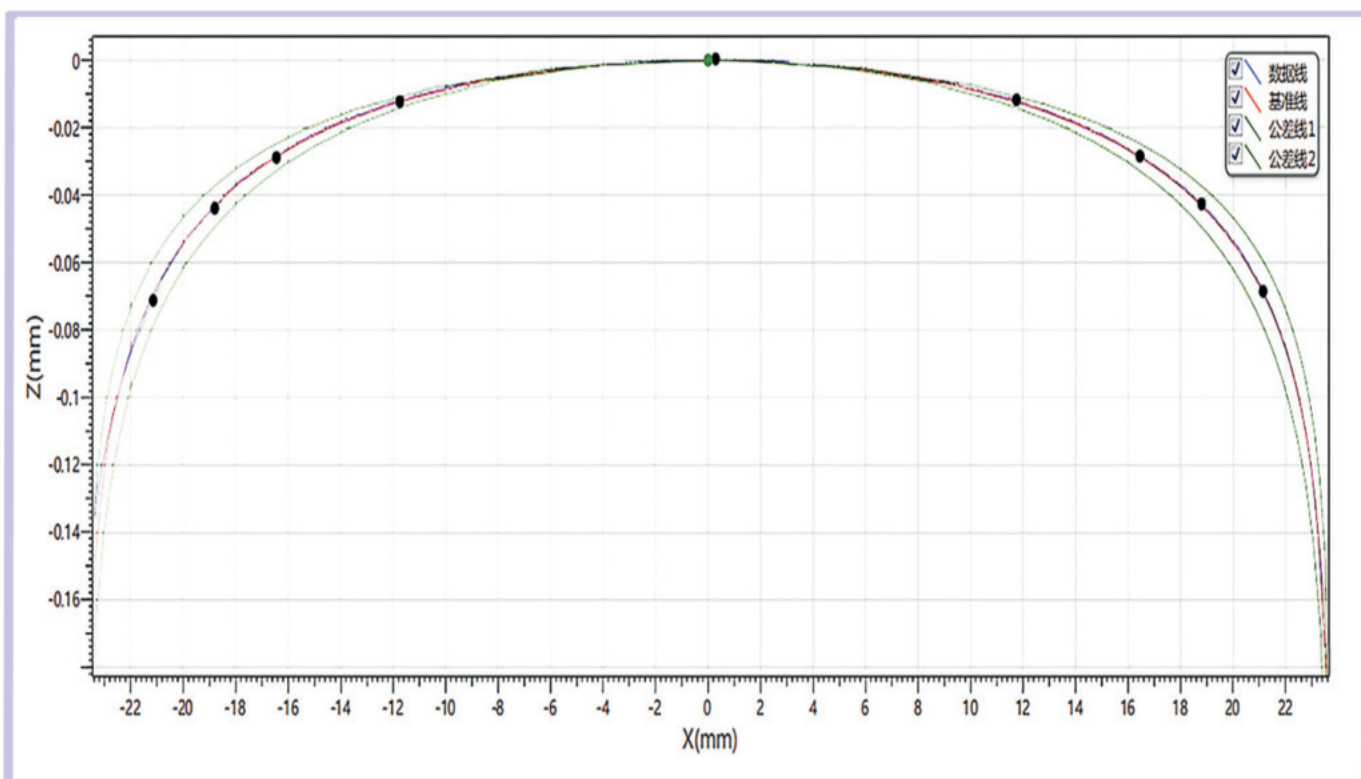
Optimum Crowned Generatrix Roller

对数曲线滚子

Logarithmic Crowned Roller

对数曲线滚子轮廓示例图

Example of logarithmic curve measurement

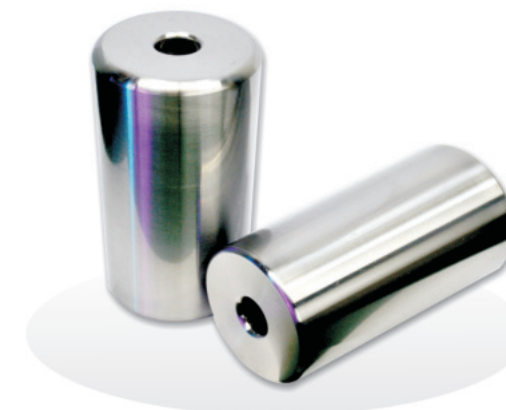


球基面圆锥滚子

Spherical Substrate Tapered roller

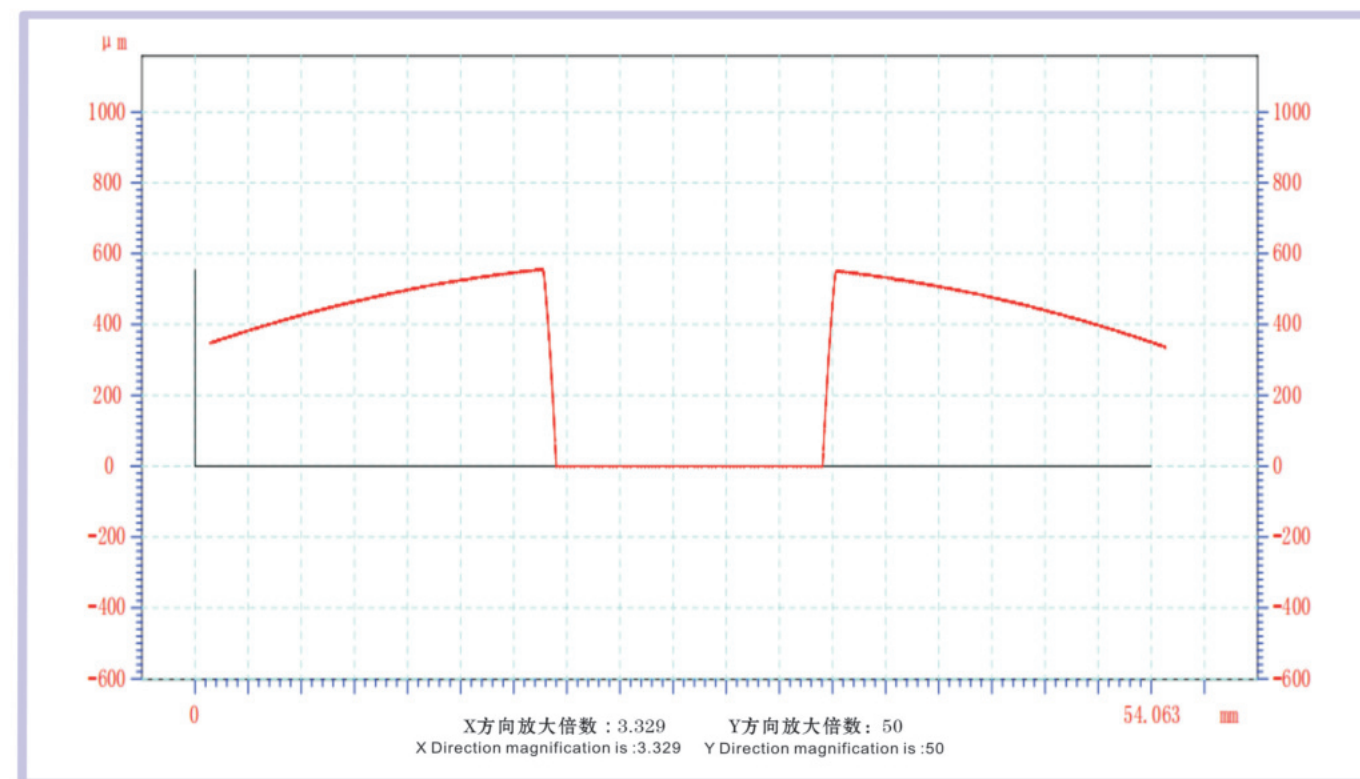
圆锥滚子球基面半径偏差可控制在2%之内，稳定的球基面可改善滚子与挡边的接触形式和接触位置，降低运行时的摩擦和噪声水平。

The radius deviation of tapered roller's spherical substrate can be controlled within 2%, and the stable spherical substrate can improve the contact form and contact position of roller and rib, and reduce the friction and noise level during operation.



球基面测量示例图

Example of spherical substrate measurement



滚子精度标准

Roller Accuracy Standard

圆柱滚子精度等级

Cylindrical Roller Accuracy Grade

单位Unit：μm

公差等级 Roller Grade	D _w /mm		圆度 Δ _{Rw} (Roundness)	端跳 S _{Dw} (End face run-out)	批直径变动量 V _{DwL} (Variation of lot diameter)	批长度变动量 V _{LwL} (Variation of Lot Length)	滚子平均值变动量 V _{Dwmp} (Variation of mean diameter)	表面粗糙度 Ra Surface Roughness/Ra		
	>	≤						外径 Outer Diameter	端面 End Face	倒角 Chamfer
G1	3	18	0.5	6	1.5	5	0.8	0.1	0.125	1.25
G1A	3	30	0.8	6	2	7	1.2	0.125	0.16	1.25
G2	3	50	1	6	2	10	1.5	0.125	0.2	1.25
G2A	10	160	1.3	6	3	13	2	0.16	0.25	2.5

圆锥滚子精度等级

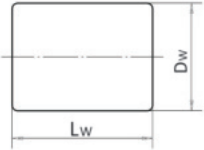
Tapered Roller Accuracy Classes

单位Unit：μm

公差等级 Roller Grade	D _w /mm		形位公差 Geometrical tolerance			圆锥角偏差 Deviation of Angle of taper		规值批尺寸变动量 Deviation of roller gauge lot diameter		表面粗糙度Ra Surface Roughness /Ra		
			V _{Dwsp}	Δ _{Rw}	S _{Dw}	Δ2φ		V _{DwL}	Δ2φ _L	圆锥面 Cone surface	球基面 Spherical substrate	其余表面 Other surfaces
	超过 Over	到 To	max			上偏差 High	下偏差 Low	max		max		
I	10	18	0.5		2.5	+1.0	-1.0	1.5	1.0	0.08	0.125	1.25
	18	30	0.8		3.0	+1.5	-1.5	2.0	1.5			
	30	50	1.2		4.0	+2.0	-2.0	2.5	2.0	0.125	0.16	
II	10	18	1.2		4.0	+2.0	-2.0	2.5	2.0	0.125	0.16	2.5
	18	30	1.5		5.0	+2.5	-2.5	3.0	2.5			
	30	160	2.0		6.0	+3.0	-3.0	3.5	3.0	0.16	0.20	

圆柱滚子

Cylindrical Roller



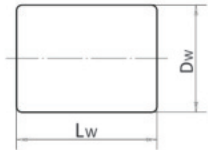
圆柱滚子外形尺寸

Cylindrical Roller Overall Dimension

单位Unit：μm

直径×长度 D _w ×L _w	直径×长度 D _w ×L _w	直径×长度 D _w ×L _w	直径×长度 D _w ×L _w	直径×长度 D _w ×L _w
15×20	26×40	30×56	35×35	38×63
15×22	26×41	30×58	35×45	38×65
20×20	26×42	30×59	35×52	38×68
21×30	26×44	32×32	35×55	38×70
24×24	26×45	32×34	35×58	38×88
24×27	26×48	32×36	35×60	38×103
24×28	27×27	32×40	35×66	39×52
24×30	28×28	32×42	36×36	39×75
24×36	28×32	32×44	36×38	39×82
24×38	28×40	32×45	36×40	40×40
24×40	28×42	32×46	36×48	40×43
24×43	28×44	32×47	36×52	40×45
25×25	28×46	32×48	36×56	40×46
25×27	28×48	32×50	36×58	40×50
25×28	28×49	32×52	36×60	40×52
25×32	28×52	32×55	36×65	40×55
25×34	29×40	32×56	37×53	40×58
25×35	29×42	32×58	37×56	40×60
25×36	29×44	32×65	37×75	40×64
25×38	30×30	33×48	38×38	40×65
25×39	30×34	33×64	38×42	40×68
25×40	30×36	34×34	38×46	40×69
25×48	30×40	34×38	38×48	40×70
25×50	30×42	34×40	38×50	40×71
26×26	30×44	34×55	38×55	40×72
26×29	30×46	34×56	38×56	40×75
26×31	30×48	34×58	38×58	40×85
26×34	30×49	34×60	38×60	41×39
26×38	30×52	34×68	38×62	42×42

圆柱滚子
Cylindrical Roller



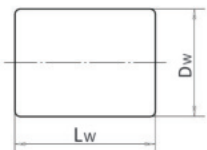
圆柱滚子外形尺寸

Cylindrical Roller Overall Dimension

单位Unit: μm

直径×长度 $D_w \times L_w$	直径×长度 $D_w \times L_w$	直径×长度 $D_w \times L_w$	直径×长度 $D_w \times L_w$	直径×长度 $D_w \times L_w$
42×54	45×73	50×50	55×68.5	60×90
42×58	45×74	50×52	55×73	60×92
42×60	45×75	50×55	55×75	60×95
42×65	45×78	50×62	55×86	60×100
42×66	45×80	50×65	55×98	60×115
42×70	45×82	50×70	55×110	62×62
42×73	45×84	50×72	55×140	62×78
42×85	46×30	50×74	56×56	62×96
42×88	46×80	50×75	56×85	62×100
42×108	46×85	50×80	56×100	62×110
43×43	46×97	50×85	57×57	63×63
43×45	47×68	50×90	58×60	63×66
43×52	47×82	50×100	58×62	63×110
43×66	47×85	51×60	58×65	64×63
43×72	47.5×60	51×92	58×72	64×72
43×75	48×48	52×52	58×75	64×95
43×80	48×52	52×76	58×90	64×128
43×90	48×56	52×88	58×100	65×65
43×95	48×65	52×95	58×104	65×70
44×60	48×74	52×98	58×106	65×72
44×62	48×75	52×100	58×120	65×80
45×45	48×78	52×120	58×124	65×85
45×46	48×82	53×76	60×60	65×95
45×50	48×85	54×54	60×63	65×100
45×52	48×86	54×65	60×65	65×110
45×62	48×90	54×72	60×70	66×78
45×65	48×96	54×75	60×72	66×90
45×68	48×97	55×55	60×75	66×100
45×72	49×95	55×60	60×85	66×115

圆柱滚子
Cylindrical Roller



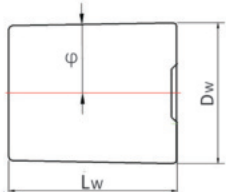
圆柱滚子外形尺寸

Cylindrical Roller Overall Dimension

单位Unit: μm

直径×长度 $D_w \times L_w$	直径×长度 $D_w \times L_w$	直径×长度 $D_w \times L_w$	直径×长度 $D_w \times L_w$	直径×长度 $D_w \times L_w$
66×120	75×85	90×170		
67×70	75×96	93×165		
67×102	75×120	95×100		
67×127	75×135.5	95×120		
68×100	75×136	98×150		
68×106	75×142.5	98×196		
68×110	75×150	98×200		
68×120	76×165	100×100		
68×125	78×70	120×120		
68×130	78×76			
68.5×103	78×80			
69×105	78×96			
70×75	78×140			
70×85	78×150			
70×90	80×80			
70×100	80×120			
70×104	80×150			
70×105	80×155			
70×112	80×160			
70×123	80×165			
70×125	82×130			
70×128	85×85			
70×140	85×125			
72×120	85×130			
72×122	85×155			
72×136	86×125			
72×142	90×90			
74×76	90×95			
75×75	90×130			

圆锥滚子
Tapered Roller



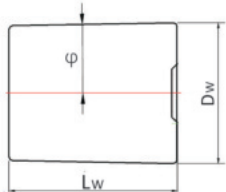
圆锥滚子外形尺寸

Tapered Roller Overall Dimension

单位 Unit: μm

直径 D _w	长度 L _w	角度 φ	直径 D _w	长度 L _w	角度 φ	直径 D _w	长度 L _w	角度 φ
11.4	16	45'	17.22	31.08	1°5'	20.15	25	56'
11.66	21.76	1°16'	17.5	31	1°10'	20.4	33	48'
12.07	16	1°21'	17.5	40	53'	20.5	21	3°52'
12.39	26.3	1°45'	17.65	35	1°5'	20.52	35	1°
13.436	23.5	45'	17.7	35	1°5'	20.55	46.08	51'
13.5	25	1°	17.72	36.5	55'	20.65	35	50'
13.7	16.27	1°12'	17.9	30.5	45'	20.67	32	1°
13.8	28	55'	18	31	1°6'	20.7	35	1°15'
14	24.07	1°13'	18.1	31	42'	20.8	35	1°25'
14.35	27.06	56'	18.1	41	0°50'	21.1	48	1°15'
14.46	28	1°	18.2	30	1°15'	21.22	35	50'
14.5	28	1°30'	18.2	38	56'30"	21.34	26.1	1°14'40"
14.53	25.2	45'	18.3	32	1°15'	21.45	24	1°45'
14.88	30	50'	18.36	42	30'	21.8	43	35'
14.9	24	1°10'	18.4	30	1°10'	22	33.9	0°50'
14.9	30	50'	18.45	38	50'	22.05	50	55'
15.2	25	1°	18.6	36.09	1°5'	22.157	42.5	55'10"
15.3	32	55'	19.03	36	1°6'	22.202	44.21	55'
15.368	21	1°10'	19.1	41	45'	22.24	30.5	30'
15.5	32.07	1°	19.18	19	2°10'	22.25	28.13	1°20'
15.547	32.9	1°8'	19.4	26	1°26'	22.35	41.08	51'
15.7	32.5	1°	19.5	46.5	1°15'	22.4	26.7	30'20"
15.8	33	1°5'	19.65	41.77	47'	22.45	41	52'30"
16	34	1°5'	20	32	1°9'	22.54	43.1	58'
16.15	35	1°5'	20	41.06	0°44'	22.6	32	2°47'
16.67	16.8	3°30'	20.05	36	1°5'	22.8	42	55'
17	31.09	1°10'	20.1	24.61	1°17'	22.9	36	3°30'
17	32.5	55'	20.1	35.1	1°10'	23	40	1°54'
17.08	28	55'	20.11	20	3°30'	23	53	1°

圆锥滚子
Tapered Roller



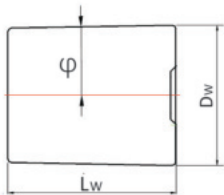
圆锥滚子外形尺寸

Tapered Roller Overall Dimension

单位 Unit: μm

直径 D _w	长度 L _w	角度 φ	直径 D _w	长度 L _w	角度 φ	直径 D _w	长度 L _w	角度 φ
23.37	45	1°	25.6	48	55'	28	50	1°30'
23.579	53.2	1°10'	25.62	42.87	1°30'	28.05	38	1°18'
23.92	32.14	1°20'	25.7	50.1	56'	28.35	54.13	1°5'
23.96	27.5	53'40"	25.8	45.12	1°2'	28.5	30	4°18'
24	38.18	1°41'	25.8	70	1°	28.5	34	5°24'
24.05	40	1°7'	26	50	1°6'	28.6	62.1	46'
24.08	53	1°5'	26	52	56'	28.68	65.1	46'
24.1	34	1°10'	26	52.11	0°56'	28.7	60	50'
24.1	36.5	45'	26	56	46'20"	28.885	31	2°
24.1	42.5	1°	26.024	52	51'	28.91	30.25	2°
24.24	51.02	50'	26.08	54.1	0°51'	29	32	1°10'
24.25	54	52'	26.1	49	46'	29.1	44.7	1°33'
24.5	44	1°5'	26.347	52.5	55'	29.2	54	1°
24.74	47.5	1°10'	26.35	45	1°5'	29.3	39	1°15'
24.8	46	50'	26.4	33	1°50'	29.4	50	1°
24.96	46	1°35'	26.56	45	55'	29.5	30	1°27'
25	31.11	1°3'	26.7	46	47'	29.6	45	1°10'
25	41.5	1°2'	26.8	34.59	0°48'	29.7	48	1°6'
25	42	1°	27	39	1°20'	29.8	52.5	1°32'
25	42.5	1°	27.1	49	49'	29.9	48	1°
25	43.2	45'	27.2	49.13	1°4'	30.1	35.18	1°20'
25	43.5	1°	27.5	48	1°30'	30.2	56	1°50'
25	47	45'	27.5	53	1°20'	30.4	35.19	1°25'
25.15	45.61	1°2'	27.55	56	1°	30.55	54.11	48'
25.2	44.12	1°7'	27.7	51	1°5'	30.6	53.11	50'
25.33	50	0°51'	27.8	40.114	6°42'	30.7	57	50'
25.4	30.19	1°45'	27.97	31.93	1°30'	30.8	60.3	55'
25.5	45	1°5'	28	32.632	5°10'	30.96	62	55'
25.6	45	1°25'	28	46	1°15'	31	57.5	1°

圆锥滚子
Tapered Roller



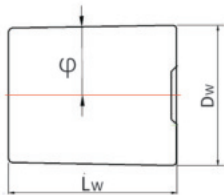
圆锥滚子外形尺寸

Tapered Roller Overall Dimension

单位Unit : μm

直径 D _w	长度 L _w	角度 φ	直径 D _w	长度 L _w	角度 φ	直径 D _w	长度 L _w	角度 φ
31	70	50'	34.21	78.5	36'	37.15	42	1°15'
31.1	53.2	1°15'	34.3	38.37	2°20'	37.36	37.5	1°
31.2	36	1°20'	34.5	42	1°20'	37.45	46.66	1°
31.3	56	57'	34.6	60	1°1'	37.6	50	1°20'
31.42	41	1°	34.782	65.6	1°	37.9	50	1°
31.5	58	1°5'	34.8	70.2	1°20'	38.05	74.62	42'
31.62	34	1°45'	34.86	65	45'	38.1	65	1°15'
31.7	56.5	2°	34.9	45	1°25'	38.1	74.62	42'
31.8	56.5	58'	34.9	59	1°30'	38.2	78	56'33"
31.96	53	1°15'	35	57	56'	38.3	47	1°27'
32	36	1°15'	35	60	1°	38.3	69.14	50'
32	54	1°17'	35	64.5	1°25'	38.4	45.18	1°5'
32.1	39.15	1°5'	35.1	44	1°30'	38.4	72	1°24'
32.2	48	1°12'	35.2	60	50'	38.7	70.74	1°25'
32.47	65	53'	35.4	42	1°10'	38.8	62	1°7'
32.8	43.5	1°6'	35.4	76	0°45'	39	62	46°40"
32.8	60.3	50'	35.5	67	57'	39.1	42.22	1°17'
32.9	41	43'	35.6	56.4	1°	39.3	63.76	1°30'
33	42.5	1°19'30"	35.7	41.16	1°1'	39.42	71	43'
33	78	7°45'	35.7	55.17	1°6'	40.8	53	3°30'
33.15	65.5	50'	35.75	45	1°10'	41	65	1°55'
33.15	70.12	50'	35.8	44	1°12'	41	78	1°10'
33.35	45.09	1°19'	35.86	69	1°50'	41.6	66.5	1°18'
33.419	52.5	45'	36.3	49.19	1°12'	41.9	50.4	1°40'
33.6	59.5	1°	36.4	59	45'	41.91	65	1°10'
34	41	45'	36.4	62	1°15'	42.1	76.17	0°57'
34	51.38	9°17'	36.5	72.3	1°	42.2	59	1°3'
34	78	1°15'	36.65	67.5	1°42'	42.4	75	1°
34.1	68	55'	37	67	1°	42.5	60	52°50"

圆锥滚子
Tapered Roller



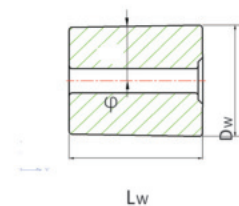
圆锥滚子外形尺寸

Tapered Roller Overall Dimension

单位Unit : μm

直径 D _w	长度 L _w	角度 φ	直径 D _w	长度 L _w	角度 φ	直径 D _w	长度 L _w	角度 φ
42.7	75.2	47°24"	46.2	66	1°55'	50	57.14	2°57'
42.8	57.2	3°45'	46.4	70	1°14'	50.4	97	1°25'
43	54	57'	46.5	52	4°	50.5	55.8	1°15'
43.1	59	58'	46.5	88	57'	50.8	71.1	29°48"
43.2	49.75	1°18'	46.6	60	45'	50.9	66	1°18'
43.3	50	1°5'	46.8	89.5	46°30"	51	59	1°20'
43.6	110	45'	46.8	98	50'	51	66	1°35'
43.8	54	2°40'	46.962	65	7°	51.58	57.2	2°
44	65	48'	47	60	1°30'	51.582	89.2	2°
44	92	1°15'37"	47.1	89.5	44°5"	51.7	60	50'
44.3	63.14	43'	47.15	52	1°55'	51.8	69	50'
44.5	73.5	45"	47.4	68.16	46'	52	66	1°8'
44.6	54	1°	47.6	48.46	2°12'	52.4	82	1°25'
44.6	60	1°	47.8	66.1	0°3'	52.6	53	3°
44.6	80	55'	47.963	87	0°48'	52.8	78.3	2°30'
44.6	100	1°16'	48	60	1°15'	52.85	85	50'
44.7	49	43°12"	48	90.19	0°55'	52.89	64.23	1°
44.7	81	1°6'	48.3	104	1°16'	52.9	98.5	0°58'
44.9	65	0°48'	48.4	65	1°5'	53.6	75	1°10'
45	65.737	3°45'	48.6	51.19	55'	53.7	69	1°
45	81.18	0°55'	48.6	72	1°10'	53.8	107.2	56°50"
45.1	77.5	2°	48.82	56	47'	54	58	1°5'
45.2	62	1°22'	48.96	88	1°	54	66	2°31'
45.5	52.8	1°25'	49	65	1°30'	54	96.2	1°50'
45.75	68	1°30'	49.3	59	1°13'	55	76	34°55"
45.9	69	58'	49.486	58.73	1°50'	55.3	100	1°31'
46	64	45'	49.5	73	1°45'	56	75	1°1'
46	100	1°18'	49.7	95.71	56°50"	56	86	1°
46.2	49.3	1°29'	49.8	52	48'	56.3	65.5	2°30'

圆锥滚子 Tapered Roller



圆锥滚子外形尺寸
Tapered Roller Overall Dimension

单位Unit: μm

直径 D_w	长度 L_w	角度 φ	直径 D_w	长度 L_w	角度 φ	直径 D_w	长度 L_w	角度 φ
57.6	64	2°43'	69.7	88	3.24°			
57.8	70	1°5'	69.89	89.3	1°32'			
58.2	75	1°3'	70.1	103	1°46'			
58.4	122	1°37'	71.2	124.31	59'			
58.5	62	2°35'	72	78	2°40'			
59.3	89.56	2°10'	72.8	70.59	1°30'			
59.4	68.79	1°8'	73.2	71.3	2°15'			
59.9	114.3	46°35''	75	88.3	1°43'			
60	90.22	0°51'	76.1	123.35	1°3'			
60.2	101.36	1°22'	76.4	80.58	1°45'			
60.3	74	1°45'	76.5	177.76	8°15'			
60.8	74.02	1°57'	77	92	1°45'			
61	95.47	1°45'	77.1	95.5	1°30'			
61	112	58'	77.9	110	1°5'			
61.7	82	1°20'	79.3	87	2°10'			
62.2	109	1°	80	108.5	1°45'			
62.5	118	7°10'	82.7	86.5	1°40'			
63	70	1°49'	83	86.5	1°40'			
63.8	106.48	1°44'	85	95	1°10'			
63.9	75	1°20'	86.5	140	6°30'			
64.52	120	59'	88	110	1°30'			
64.9	78.5	1°45'	93.5	120	1°31'			
65.1	97	1°20'	93.6	124	1°5'			
65.5	68.36	1°15'	99.3	125.69	1°35'			
65.9	80	1°15'	102.5	113.3	1°12'			
66	83.7	10°13'	103.15	140	1°18'			
67.059	94	1°10'	105.71	170.2	1°55'			
68.6	68.6	1°15'	133.83	154.2	1°2'			
68.8	92.58	1°55'	9					

除以上规格产品，我公司可定制直径 $\phi 11\text{mm} \sim \phi 200\text{mm}$ ，长度 $\leq 250\text{mm}$ 滚子，具体咨询CHG技术部门。

In addition to the above specifications products, our company can customize the diameter $\phi 11\text{mm} \sim \phi 200\text{mm}$, length $\leq 250\text{mm}$ roller, consult CHG technical department for details.



我们一直在努力
Several decades,
we've been working hard for our customers!

