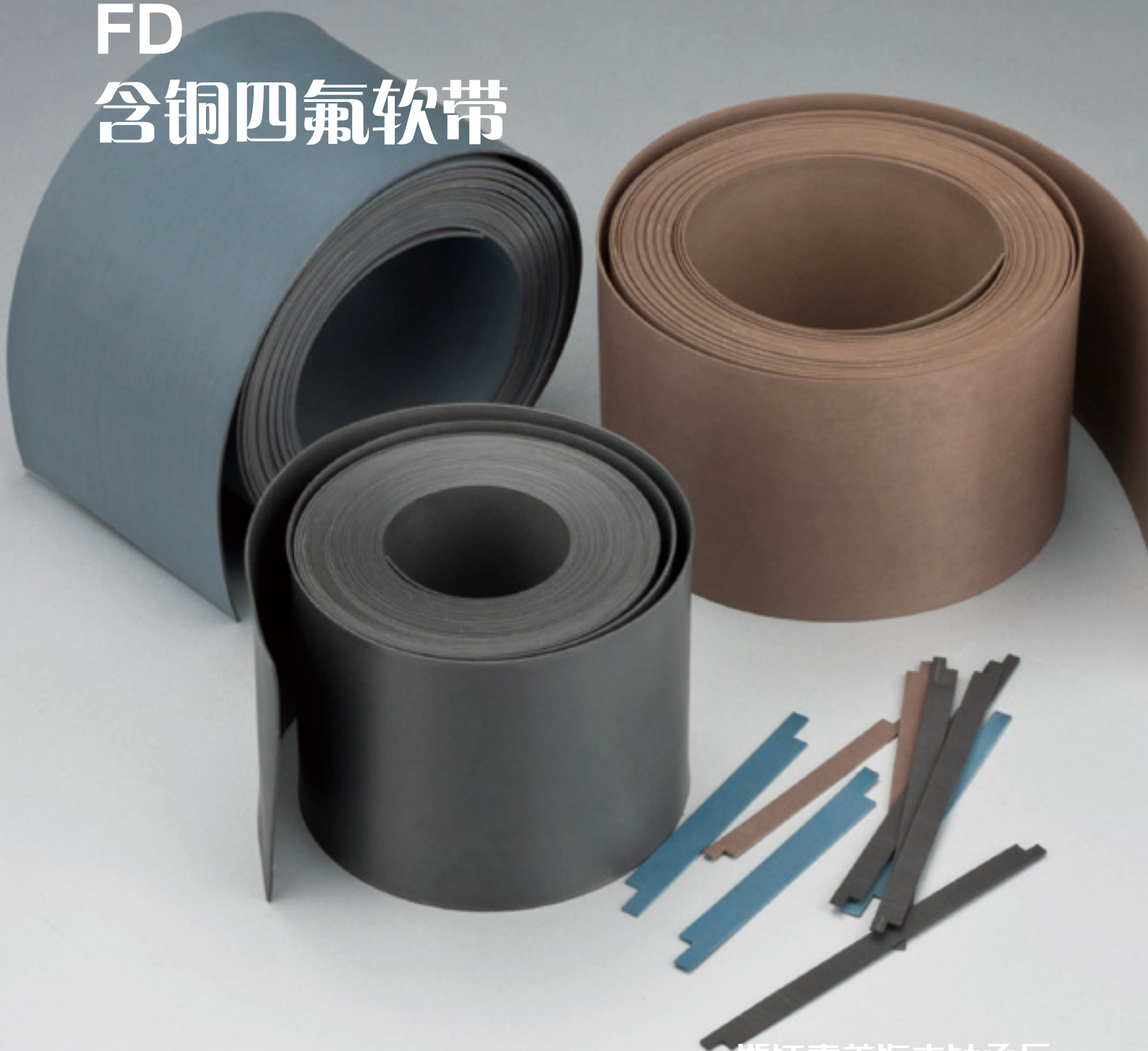


FD 含铜四氟软带





公司简介 INTRODUCTION

嘉善海丰轴承厂（HFB）是一家专业从事轴承设计生产的实体企业，位于浙江嘉善县，地处长三角都市经济圈，与上海、苏州、杭州接壤，地理位置优越，交通便利。

公司生产的产品主要产品SF-1系列无油润滑轴承，SF-2系列边界润滑轴承，FZ系列钢球保持架，JDB系列固体润滑轴承，JF系列双金属轴承，FB系列青铜卷制轴承系列等多个系列产品。

产品广泛应用于冶金、汽车、矿山、石油、化工、电机电器、船舶、印刷、机械、水利、模具、铁路机车等领域。

欢迎广大海内外客户与我们洽谈业务，我们将竭诚为您提供一流的产品，一流的服务。

Jiashan Haifeng bearings Co., Ltd, is specialized in manufacturing sliding bearing. Our main products are: SF-1(DU) self-lubricating bearings, SF-2(DX) boundary self-lubricating bearings, JF bi-metal bearings, JDB cast bronze with solid lubricants bearings, FB090 bronze bearings, FZ ball retainer, FR PTFE tape, FD bronze powder with PTFE tape, FU sintered bronze bearings etc.

We can supply products with stable quality, and has won the trophy and certificate authorities. It is widely used in hydraulic elements, automobile, Metallurgical Mines, Ocean Station Vessel, Industrial Machinery, Petroleum Industry Machinery, Textile machine, lifting appliance, Printing, foods and Construction Machinery etc.

We are committed to supplying products of the highest quality and providing a comprehensive and professional service.

FD-1 含铜四氟软带

Copper PTFE soft strip

该产品是以聚四氟乙烯为主要原料，填充铜粉等耐磨材料，经模具压制烧结而成，具有良好的耐磨性，摩擦系数低，在有润滑油和无油润滑条件下都能正常使用。产品被广泛应用于汽车减震器，汽车活塞环。

FD-1 Copper PTFE soft strip as main material is made of filling copper powder and wear resistance material pressing and agglomeration, it has low wear resistance and low friction, it can work with or without oil. The products have been widely used in automobile shake absorber and piston rings.



※技术参数：Technical Data

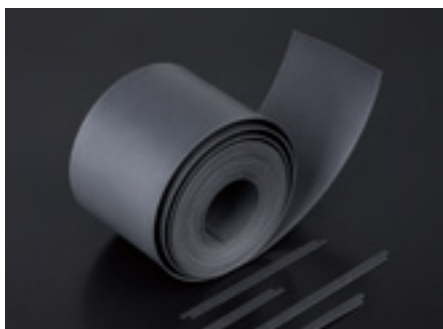
性能指标 Performance index		数据 Data
最大承载 P Max Load Capacity	静载 Static load	80N/mm ²
	动载 Dynamic load	40N/mm ²
最高线速度 V Max Sliding Speed		1.5m/s
抗拉强度 Tensile Strength		18N/mm ²
延伸率 Extension Rate		100%
摩擦系数 μ Friction coefficient		≤ 0.25
使用温度 Working temperature		-100℃ ~ +250℃
热膨胀系数 Coefficient of thermal expansion		$8 \times 10^{-5}/K$

FD-2 含石墨四氟软带

Graphite PTFE soft strip

该产品是以聚四氟乙烯为主要原料，填充石墨等耐磨材料，经模具压制烧结而成，具有良好的韧性，耐磨性。产品被广泛应用于汽车减震器。

Graphite PTFE soft strip with PTFE as main material is made though filling wear proof material such as graphite though polishing, pressing and agglomeration, it has good tenacity and wearing performance. The products have been widely used in automobile absorber.



※技术参数：Technical Data

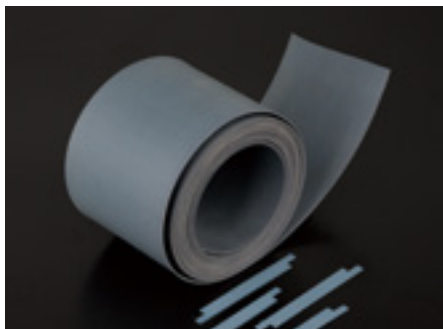
性能指标 Performance index		数据 Data
最大承载 P Max Load Capacity	静载 Static load	80N/mm ²
	动载 Dynamic load	40N/mm ²
最高线速度 V Max Sliding Speed		1.5m/s
抗拉强度 Tensile Strength		13.2N/mm ²
延伸率 Extension Rate		200%
摩擦系数 μ Friction coefficient		≤ 0.25
使用温度 Working temperature		-100℃ ~ +250℃
热膨胀系数 Coefficient of thermal expansion		$8 \times 10^{-5}/K$

FD-3 改性四氟软带

Modified PTFE soft strip

该产品是以聚四氟乙烯为主要原料，填充特殊的耐磨材料，经模具压制烧结而成，具有良好的耐磨性，耐冲击性及密封性能。产品被广泛应用于加油机流量泵，或密封环使用。

FD-3 modified soft strip is based on PTFE and filled into specific lubricant through a combination of mold pressing and sintering. It is of high wear resistance; good anti impact ness and good performance in airproof. at present it is widely applied in flow pump of the greasing machinery and ring seal etc.



※技术参数：Technical Data

性能指标 Performance index		数据 Data
最大承载 P Max Load Capacity	静载 Static load	80N/mm ²
	动载 Dynamic load	40N/mm ²
最高线速度 V Max Sliding Speed		1.5m/s
抗拉强度 Tensile Strength		20N/mm ²
延伸率 Extension Rate		250%
摩擦系数 μ Friction coefficient		≤ 0.25
使用温度 Working temperature		-100℃ ~ +250℃
热膨胀系数 Coefficient of thermal expansion		$8 \times 10^{-5}/K$



※ 通用外径检验方法 (ISO3547-2: 1999 Test B) :

Common test method of outside diameter (ISO3547-2: 1999 Test B:

轴套用手压入环规通端 (最大用力250N) , 通过

Press the bushes into the GO ring gauge and then push them through with hand pressure

(maximum force 250N)

轴套用同样方法与同样力, 压入环规止端, 不通过

On the other hand with the same force, It shall not be possible for them to go into the

NOGO ring gauge



※ 通用的内径检验方法 (ISO3547-2: 1999 Test C) :

Common test method of inner diameter test (ISO3547-2: 1999 Test C) :

检验内径, 轴承压入环规, 塞规通端通过用较小力, 塞规止端通不过用力最大不超过250N。

To check the inner diameter, the bush is to be press into a ring gauge. The GO plug gauge shall be inserted by a minimum effort. The NOGO Plug gauge shall not be insert by mutual pressure (maximum force 250N)

(注意: 当轴承压入环规, 轴承外径可能会被永久减小)

Note: When the bush is pressed into the ring gauge, It is possible that There will be a permanent reduction in the outside diameter)

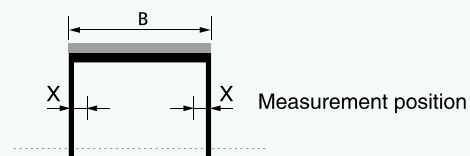


※ 通用的壁厚测量方法:

Common method of wall thickness measurement:

轴承的壁厚测量一点、二点、三点, 在轴向上依据轴承高度尺寸

The wall thickness is measured at one, two or three positions axially according to the bearing dimensions.



B[mm]	X[mm]	measurement position
$B \leq 15$	$B/2$	1
$15 < B \leq 50$	4	2
$50 < B \leq 90$	6 and $B/2$	3
$B > 90$	8 and $B/2$	3

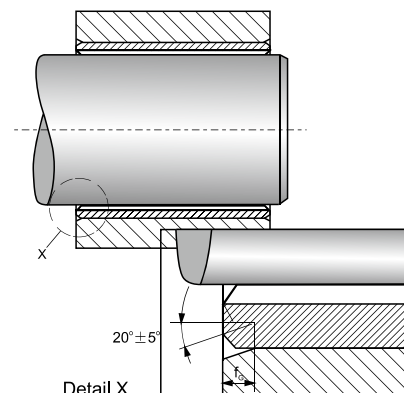
轴承安装设计 Design of Bearing Arrangement

※直套 Cylindrical Bushes

座孔被倒角 $f_G \times 20^\circ \pm 5^\circ$ ，使衬套压入座孔变的更加容易。

The housing bore should have a chamfer $f_G \times 20^\circ \pm 5^\circ$, The chamfer makes it easier to press the bushes into the housing.

座孔直径 Housing bore diameter d_G	座孔倒角 Chamfer of housing f_G
$d_G \leq 30$	$0.8 \pm 0.3 \times 20^\circ \pm 5^\circ$
$30 < d_G \leq 80$	$1.2 \pm 0.4 \times 20^\circ \pm 5^\circ$
$80 < d_G \leq 180$	$1.8 \pm 0.8 \times 20^\circ \pm 5^\circ$
$d_G > 180$	$2.5 \pm 1.0 \times 20^\circ \pm 5^\circ$

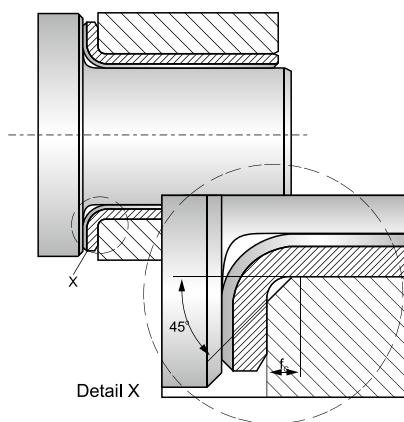


※翻边套 Flange Bushes

关于翻边套，从翻边套口到轴向转换组件必须考虑半径的转变，切面要有一个足够大的倒角。以防翻边套口聚集污垢后仍然可以支持轴向载荷部件的边缘。

The radius at the transition from the radial to the axial Component must be taken into consideration for flange bushes A sufficiently large chamfer must be provided on the housing to prevent the flanged bushes fouling in the area of the radius Sufficient support must be provided for the flange in applications With axial loading.

座孔直径 Housing bore diameter d_G	座孔倒角 Chamfer of housing f_G
$d_G \leq 10$	$1.2 \pm 0.2 \times 45^\circ \pm 5^\circ$
$d_G > 10$	$1.7 \pm 0.2 \times 45^\circ \pm 5^\circ$

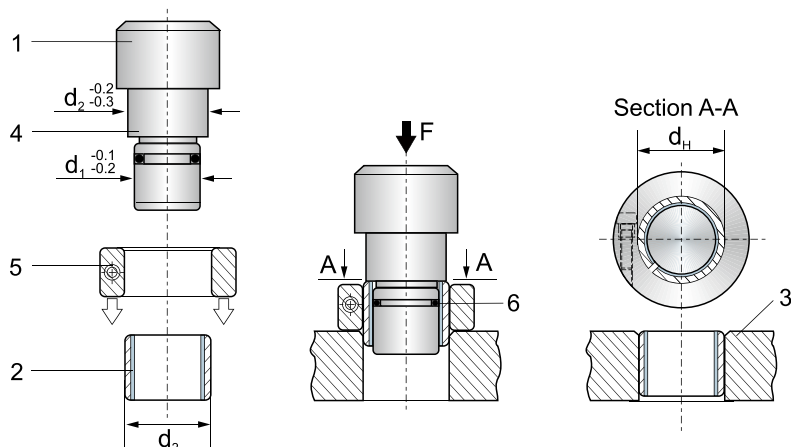


滑动轴承与座孔的装配

The installation of the sliding bushing and the housing

滑动轴承与座孔装配时，要保证轴承在座孔内不发生转动和轴向移动，又要使轴承外表面和座孔充分接触，一般应保证接触面大于85%，有利于承受载荷和传导摩擦热，采用较轻级的过盈配合，既要保证使用时，轴承不会在座孔内发生相对移动，又不会使轴承外径过盈量过大致使轴承内孔变形过大为有利于装配，轴承内外表面应涂以少量油或油脂，再将轴承均匀压入。

When installing the sliding bushing and the housing, make sure the bushing doesn't roate or move. The outside surface of the bushing must have a through contact with the housing, in peneral the connecting part must be over 85%, and this will be pood for the load pressure and the conduction of friction heat. Using surplus quantity loosely, that is when it is used the bushing does not move relatively and also the surplus quantity of the bushing outside diameter, will not be too big to cause serious distortion of the bushing inside hole, when installing, it is pood to lay a little lubricant, such as oil on the inside and outside surface of the bushing. then press bushing slowly.



$d \geq 55\text{mm}$

1. 芯轴 Pressing-in arbor
2. 轴承 Bushes
3. 座孔 Housing
4. 档边尺寸 Shoulder diameter
5. 辅助套 Auxiliary ring
6. O型圈 O ring

轴承 d_2	d_H
>55到100	$d_2 \begin{matrix} +0.28 \\ +0.25 \end{matrix}$
>100到200	$d_2 \begin{matrix} +0.40 \\ +0.36 \end{matrix}$
>200到305	$d_2 \begin{matrix} +0.50 \\ +0.40 \end{matrix}$



浙江嘉善海丰轴承厂

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