

First Generation Wheel Hub Unit Shaft Assembly Line

Inner/outer ring feeding machine→ Inner ring inner diameter/groove diameter detection and sorting machine→ Outer ring detection and sorting machine→ Inner and outer ring matching and ball loading machine→ Axial clearance detection machine→ Cleaning machine→ Drying machine→ Vibration detection machine →Grease cloth torque detection machine→ Finished product skipping detection machine (radial)→Laser marking machine→ Atomization oil coating machine→ Material conveying machine

参数 Parameter	
高度 H	≤50mm
外径 OD	≤100mm
重量 PW	≤5kg/set
节拍 CT	≤18s
Accuracy 测量精度	游隙测量20次重复精度≤3μm <i>Measuring the clearance after 20 repeated cycles, repeating a curacy ≤ 3μm</i>
	内外圈滚道分选测量20次重复精度≤1.5μm <i>Measuring Raceways sorting after 20 repeated cycles, repeating a curacy ≤ 1.5μm</i>
	跳动测量20次重复测量误差为±2.5μm <i>Runout measurement after 20 repeated cycles error: ± 2.5μ m</i>

