



ACB
ATLANTIC CUSTOM BEARINGS

Rodamiento rodillos cilíndricos cruzados **ACB 391902**

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Application: *PHOENIX line turning table bearing*



Operation Features:

Load capacity for forged rings up to 12 Tons

Speeds from 0-125rpm

Hydraulic oil lubricant ISO 46

Operates 24/7

Exposed to high impact loads during setting of rings.

Promedio de vida del rodamiento: 18 meses aprox. Tipología del fallo.



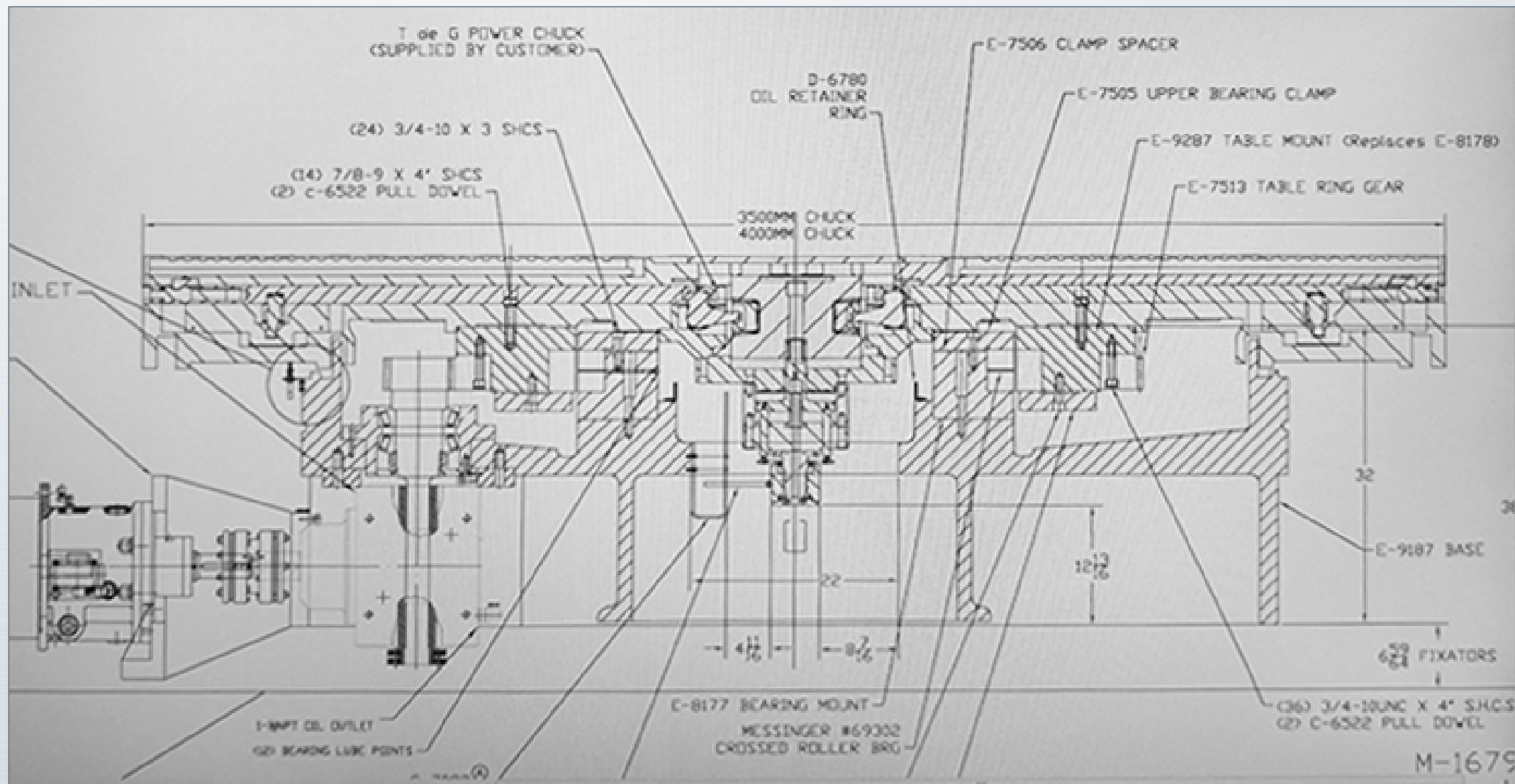
Fractura longitudinal de los rodillos.

La fractura nace y se propaga desde el agujero central del rodillo



Tapones de Nylon se deforman.

Plano de ensamble mesa rotatoria torno línea Phoenix



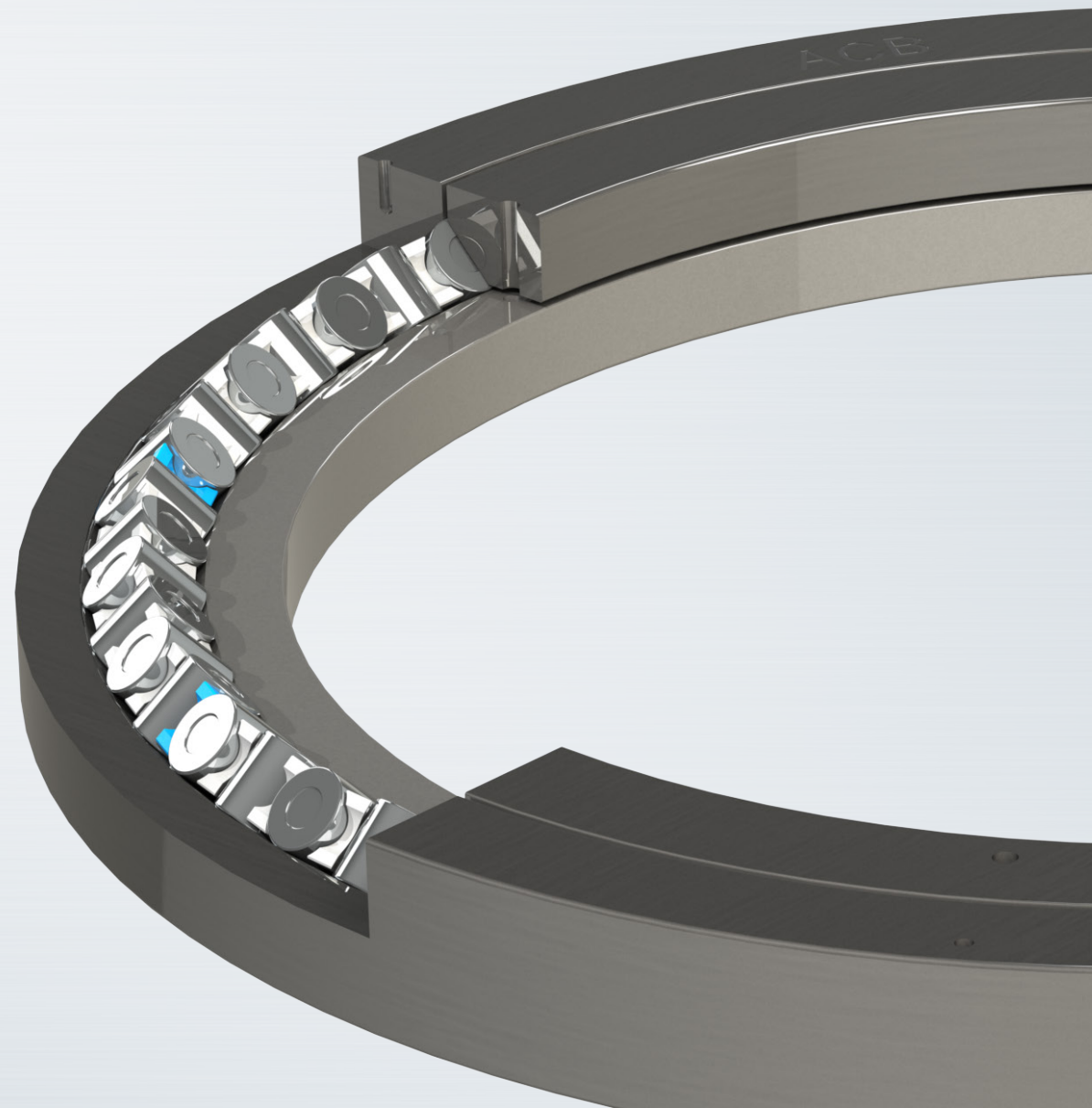
Aros y rodillos forjados de acero para rodamientos de cementación y alta pureza

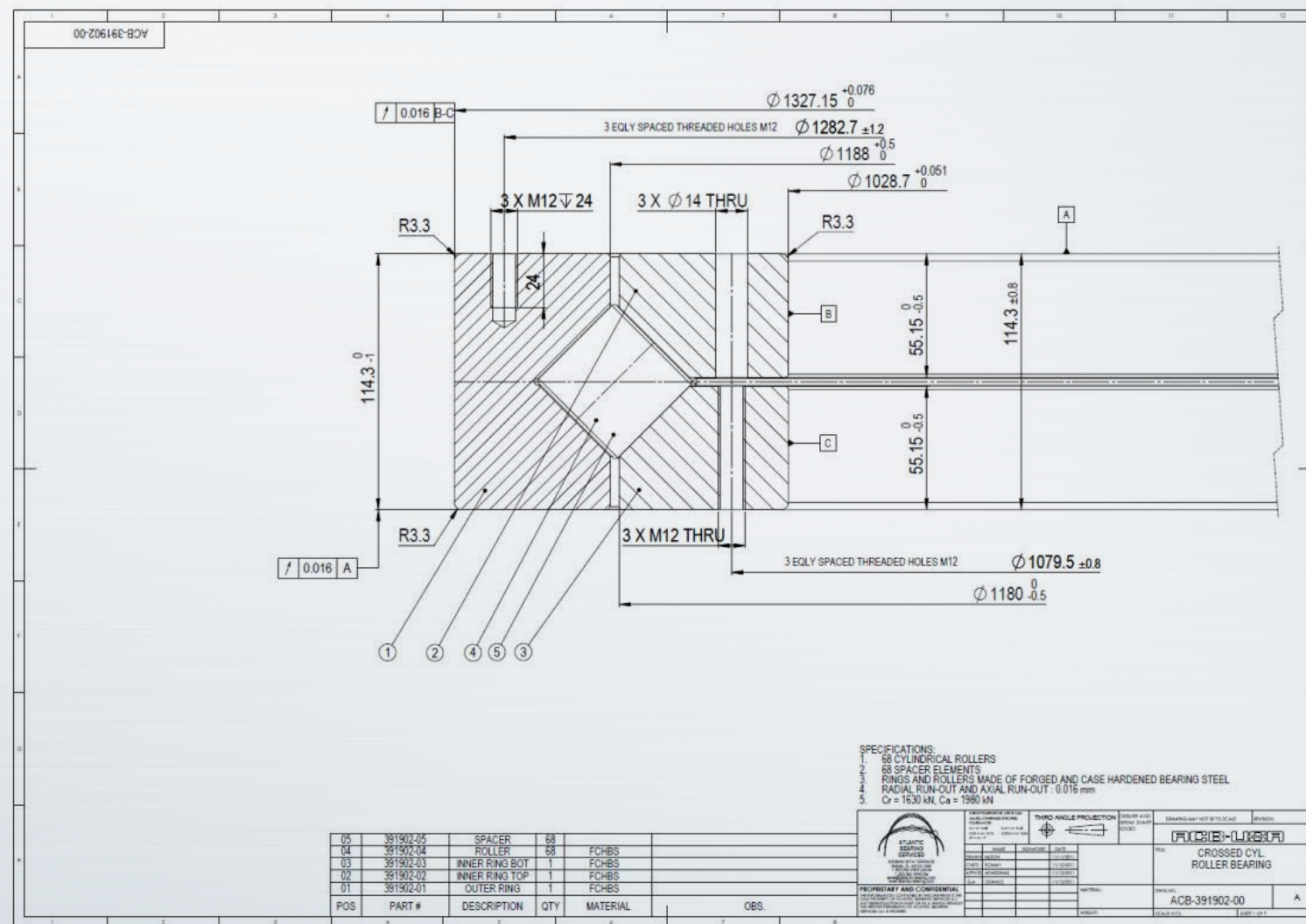
Caminos de rodadura con super acabado

Rodillos cilíndricos sólido sin agujeros, con perfil optimizado de mayor diámetro y longitud para máxima capacidad de carga

Diseño especial de pestañas en los aros para reducir la fricción y favorecer la formación de la película de lubricante

Clase de precisión P5 Separadores de plástico de ingeniería de alta resistencia mecánica, bajo coeficiente de fricción y diseño optimizado.





Rodamientos rodillos cilíndricos cruzados ACB 391902

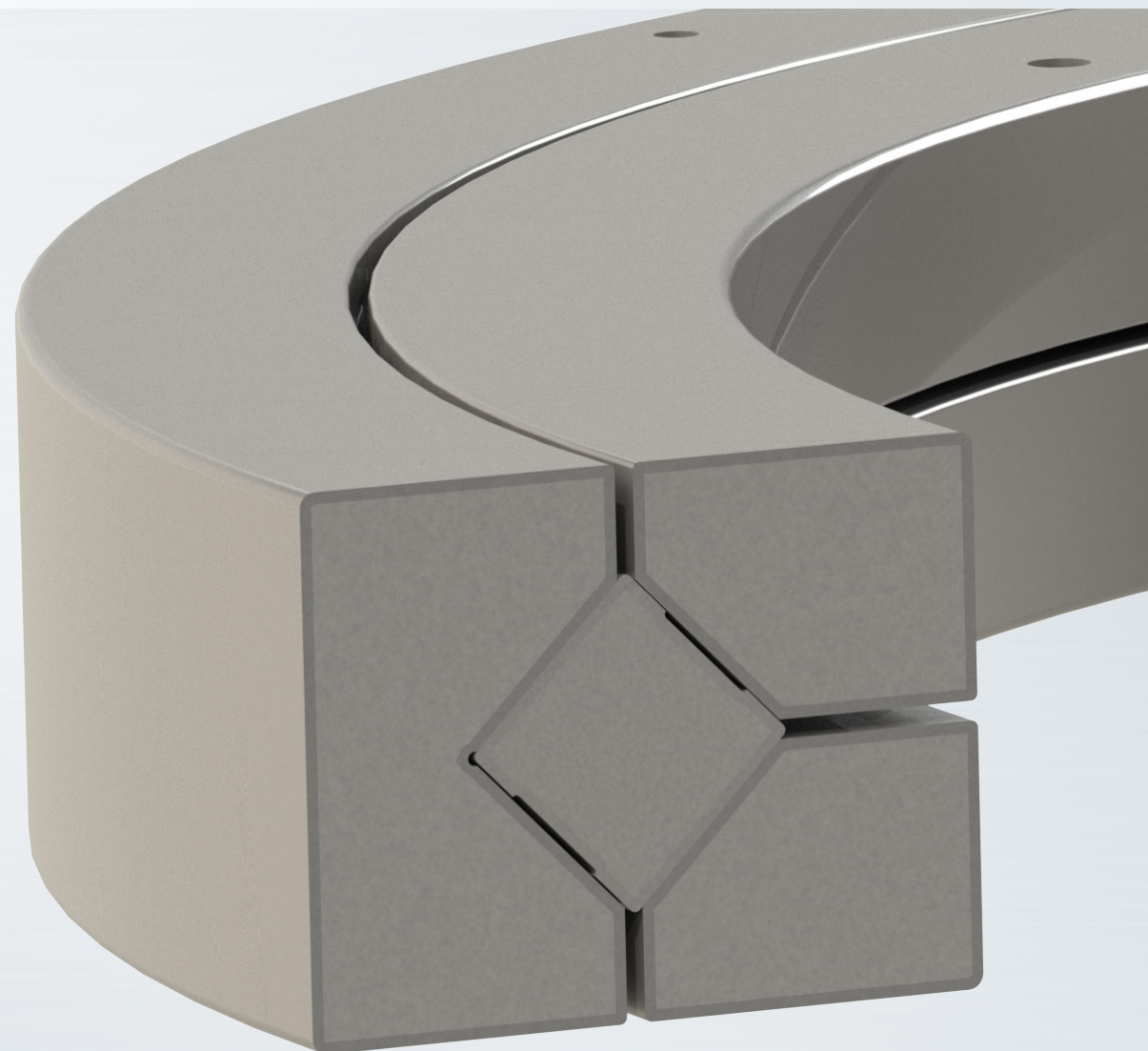
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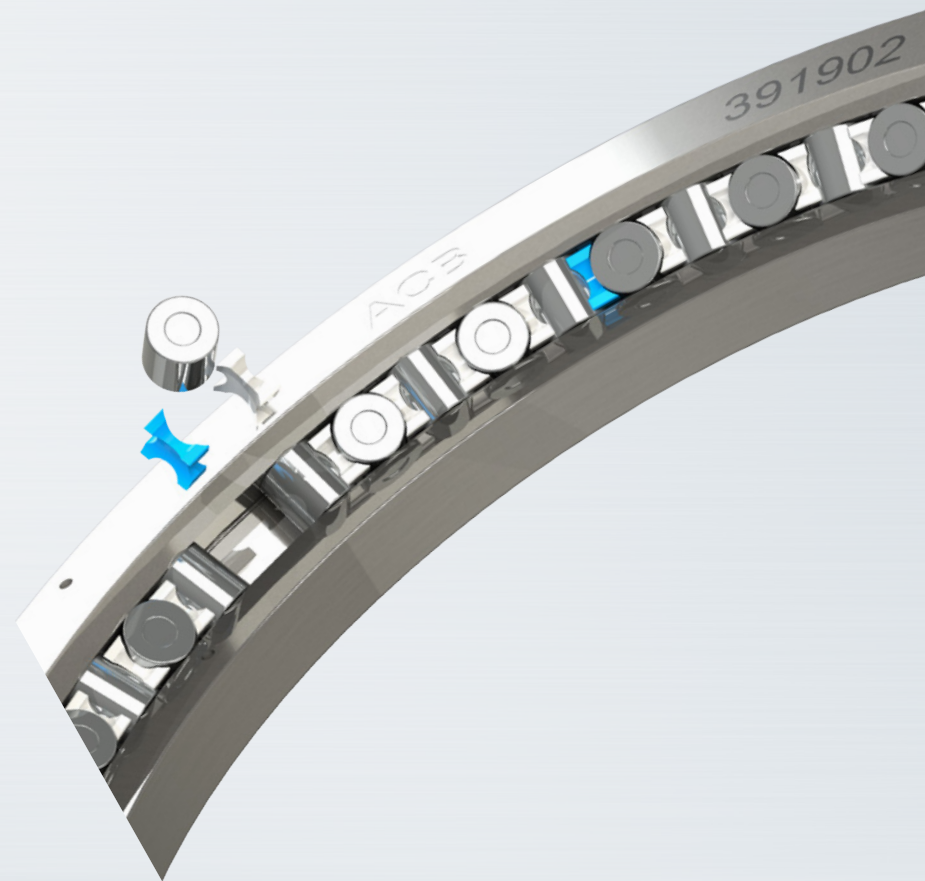
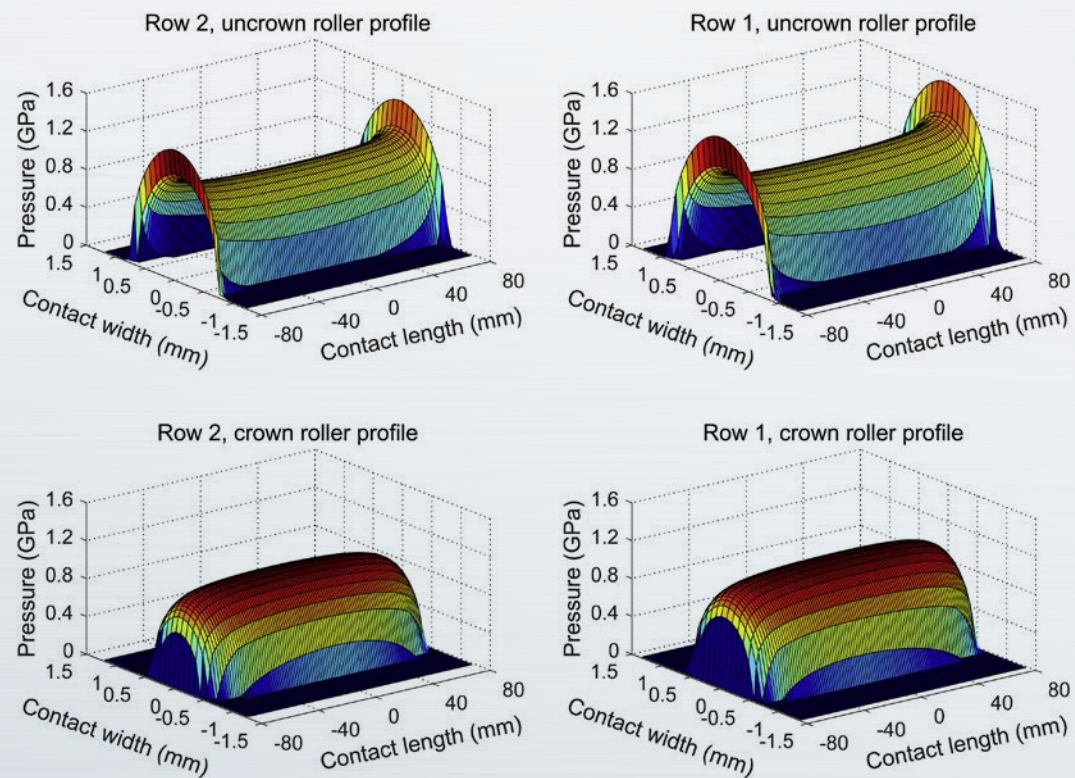
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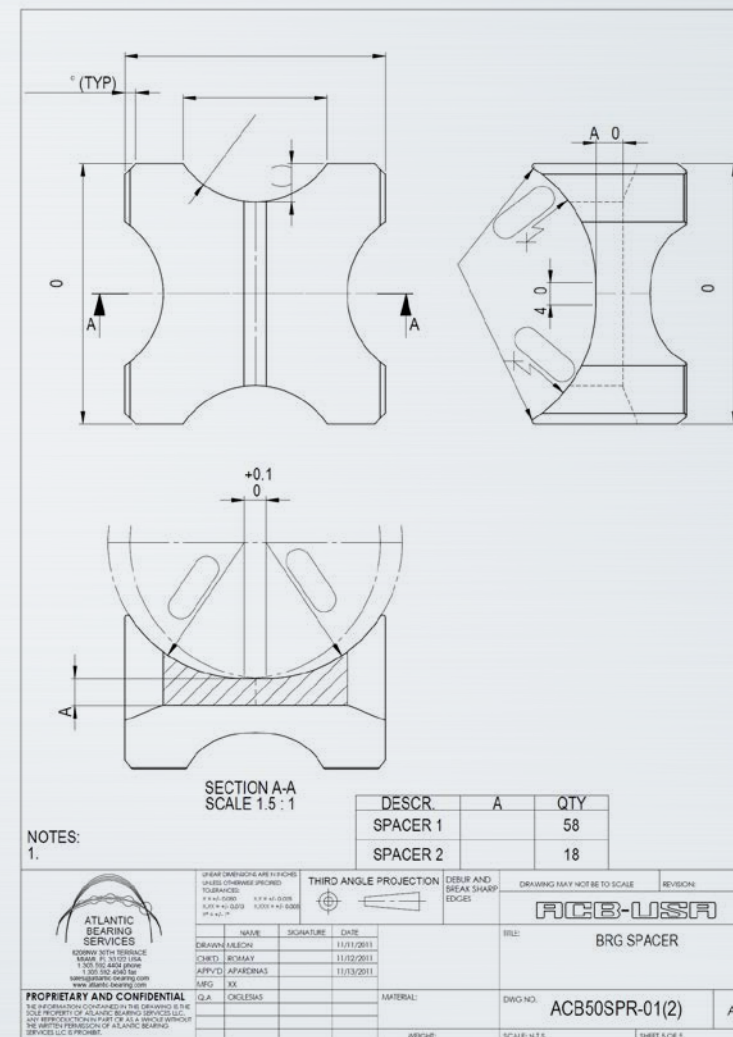
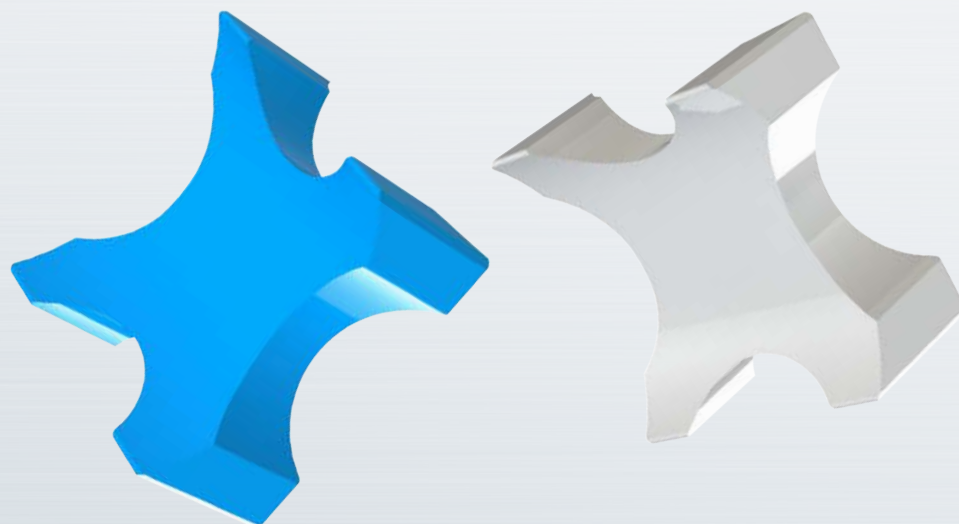
Análisis de Elemento Finito (FEM)

Rodillos cilíndricos sólidos sin agujeros, con perfil optimizado de mayor diámetro y longitud para máxima capacidad de carga

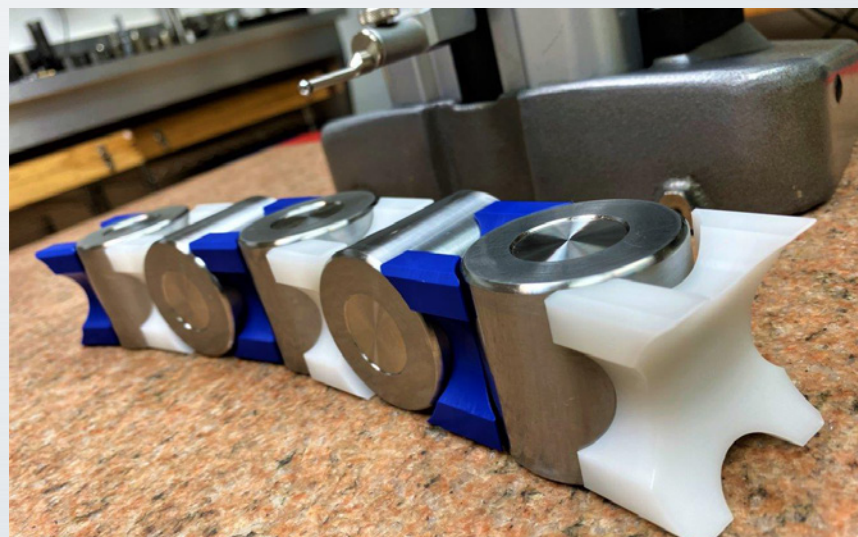


Separadores de plástico de ingeniería

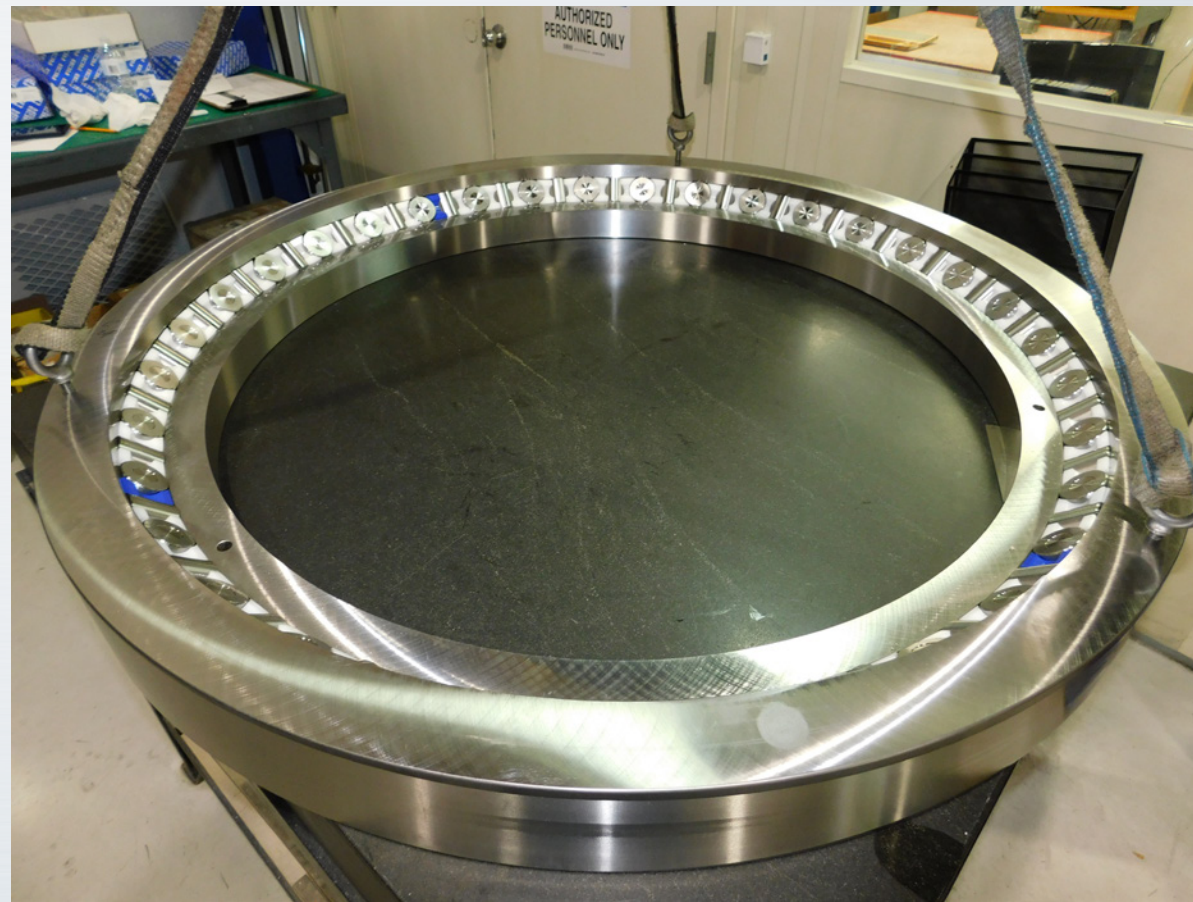
Separadores de plástico de ingeniería de alta resistencia mecanizada, bajo coeficiente de fricción y diseño optimizado para maximizar el espacio libre para grasa y facilitar la formación de la película lubricante



Final QC Process Miami



Final QC Process Miami / Assembly



Final QC Process Miami / Packaging



Final QC Process Miami / Mounting Procedure



ATLANTIC BEARING SERVICES

Title: Precision Slewing Bearing ACB 391902
Mounting Procedure

Customer: RYASA

Issued: 05/29/20

Location: Miami

Doc.# SOP-010



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Final QC Process Miami / Mounting Procedure



Fig 1.5

Take one of the spacers white and place it between the tracks, then place one roller, then one spacer, then place the next roller, and so on, making sure to maintain the cross position, insert three blue rollers spaced at 120 degree. (Fig 1.6)

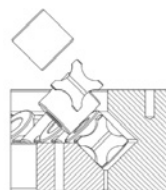


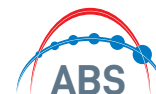
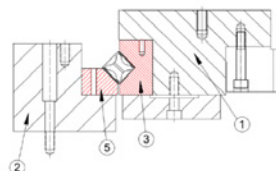
Fig 1.6

Continue to work round the bearing adding spacers and rollers alternatively until all the rollers have been fitted and there is a spacer between each roller and its neighbor. Slight pressure may be needed to insert the last spacer.

If the bearing is to be oil lubricated, the tracks and rollers should be lightly oiled. If grease lubricated, the bearing should be greased packed or (if grease replenishment points are provided) slightly greased.

2.5 Levelling and top inner race installation.

Check that the double outer race (3) is approximately parallel to the lower inner race (5). (Fig 1.7)

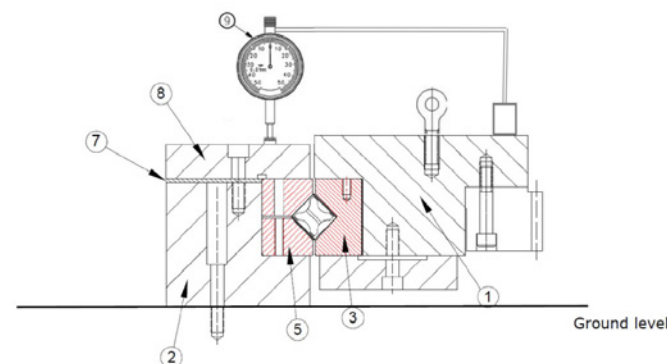


2.6.1 Adjustment clamp spacer segment width procedure

The only difference there with the previous method is that instead of using the suggested preload to define the adjustment segments width, an Initial End Play (IEP) should be considered.

$$\text{Thickness of adjustment clamp spacer segment TAS} = \text{ORF} + \text{IRF} + \text{W} - \text{HS} - \text{IEP}$$

Rotate the housing (1) until the dial indicator (9) is stabilized. Set the dial indicator (9) to zero. At this stage, the roller set "C" is seated properly by the weight of the housing (1) acting on the roller set "C".



Use adequate eyebolt and appropriate handling cranes to pull the housing (1) upwards until the bearing mount (2) is not in contact anymore with the ground reference.

Rotate the housing (1) until the dial indicator (9) stabilizes. Check and record the dial indicator (9) deviation. At this stage, the rollers set "A" should be seated correctly by the weight of the



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