



Technical requirement

- 1.All parts (including purchased parts and outsourced parts) entering the assembly must be inspected.
- 2.Before assembly, check and remove the sharp corners, burrs and foreign matters of the parts, and ensure that the seals are not scratched during installation.
- 3.Fasteners with specified tightening torque must be tightened with torque wrench.
- 4.The outer ring of the bearing shall be in good contact with the semi-circular hole of the open bearing seat and the bearing cover, and the bearing seat shall rotate flexibly and stably by hand after the installation of the rolling bearing symmetrical to the center.
- 5.The joint surface of shaft and hole shall be closely fitted without axial clearance.
- 6.The center of the V-shaped guide roller and the center of the swing arm pin must be on the same horizontal plane.

34	GB/T68-2000	Countersunk screw M10 x 12	1	8.8Grade		
33	GB894. 2-86	Circlip B40 for shaft	1	65Mn		
32	JBZQ4349-1997	Double-hole shaft end retaining ring Ø1	1	Q235A		
31	GB/T6170-86	Nut M8	4	8		
30	GB/T 5782-86	Bolt M8x55	4	8.8		
29	GB/T1096-2003	Key 16x70	1	45		
28	GB/T5783-86	Bolt M8x20	2	8.8		
27	GB/T 93-87	Grommet 8	2	65Mn		
26	GB/T5783-2000	Bolt M6x16	4	8.8Grade		
25	GB/T93-1987	Elastic washer 6	4	65Mn		
24	JBZQ4349-1997	Double-hole shaft end retaining ringØ1	1	Q235-A		
23	GB/T1096-2003	Key 18x268	1	45		
22	GB/T 5782-86	Bolt M12x70	8	8.8		
21	GB/T 93-87	Grommet 12	8	65Mn		
20	GB/T 1096-2003	Key C12x39	1	45		
19	JBZQ4606	Felt collar 53x74x8	2	Semicourse wool felt		Outsourcing
18	JBZQ4606	Felt collar 44x61x8	1	Semicourse wool felt		Outsourcing
17	JB/T7940.1-95	Oil cup M10x1	2	Finish product		Outsourcing
16	GB/T276-94	Ball bearing 6008Z	2	40X68-15		Outsourcing
15	GB/T297-94	Tapered roller bearing 30210	2	50X90-21.5		Outsourcing
14	HNGK70207.2.1.15	Axle sleeve	1	Seamless pipe20		
13	HNGK70207.2.1.14	Spindle spur gear60x3	1	45		
12	HNGK70207.2.1.13	Spur gear3M-60Z	1	45		
11	HNGK70207.2.1.12	guard 1	1	Q235-A		
10	HNGK70207.2.1.11	Pin 1	1	45		
9	HNGK70207.2.1.9	Lever	1	Q235A		
8	HNGK70207.2.1.8	Roller	1	45		
7	HNGK70207.2.1.7	Roll shaft	1	ZG275-485H		
6	HNGK70207.2.1.6	Distance sleeve	2	Seamless pipe 20		
5	HNGK70207.2.1.5	Penetrating cover	2	Q235-A		
4	HNGK70207.2.1.4	Stifle	1	Q235-A		
3	HNGK70207.2.1.3	Penetrating cover	1	Q235-A		
2	HNGK70207.2.1.2	Bearing cover	2	45		
1	HNGK70207.2.1.1	Roll rack	1	ZG270-500		
No.	Drawing No.	Name	Qty.	Material		Remarks

				HNGK70207.2.1.00		
				Active roller assembly		
				共 1 张	单重 (kg)	比例
				第 1 张		1:2
				底图编号		
				山西海创智能科技有限公司		
设计	文件号	签字	日期			
设计师	左工	所长				
主任设计师		绘图员				
成套主任		审图				
校核		日期	2023/2/20			

审核	日期
签字	日期
底图编号	
旧版图号	
材料备注	