




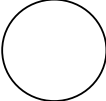
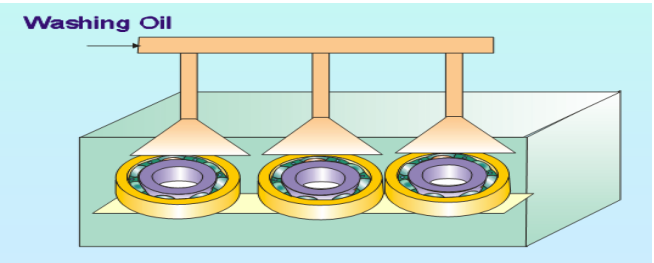
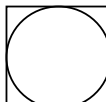
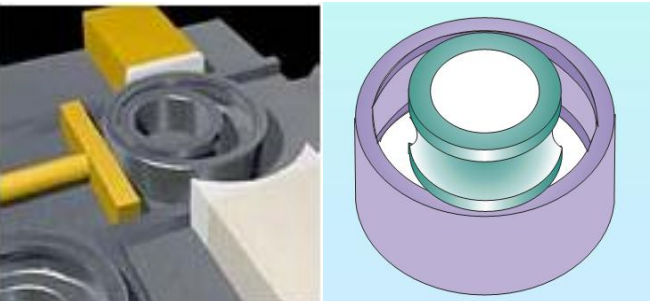
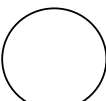
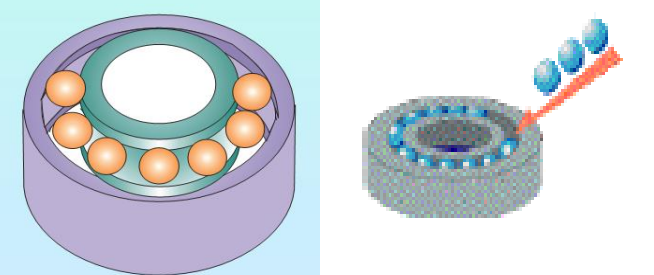
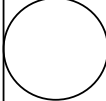

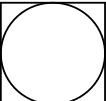
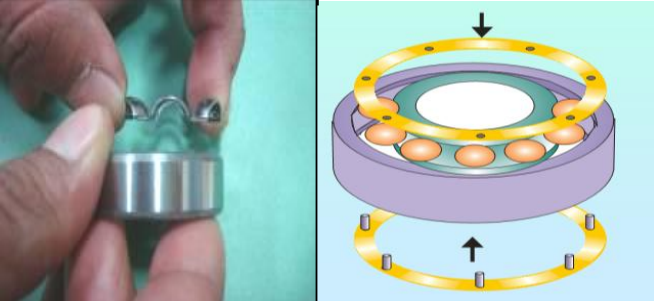


| DEEP-GROOVE-BALL-BEARINGS FLOW CHART | | Transportation  Storage  Operation  Operation & inspection  Inspection  | | |
|---|--|--|--|----------------------|
| S.no. | OPERATION DESCRIPTION | Main Assly Flow | PICTURE | Open issues/ Remarks |
| INNER & OUTER & ASSY. | | | | |
| 1 | ULTRASONIC WASHING |  |  | |
| 2 | TRACK DIA CHECKING & PARING OF I/R & O/R |  |  | |
| 3 | BALL FILLING |  |  | |
| 4 | BALL SPACING & CHECKING |  |  | |
| 5 | CAGE ASSY. & RIVET BALL MISSING CHECKING |  |  | |







DEEP-GROOVE-BALL-BEARINGS
FLOW CHART



| S.no. | OPERATION DESCRIPTION | Main Assly Flow | PICTURE | Open issues/ Remarks |
|-------|-----------------------|-----------------|---------|----------------------|
|-------|-----------------------|-----------------|---------|----------------------|

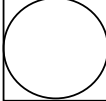
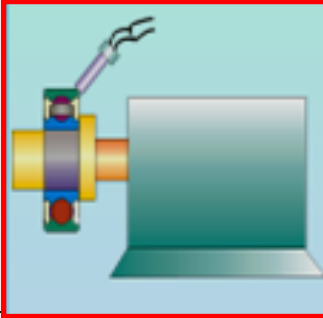

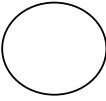


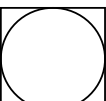

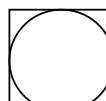


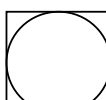


INNER & OUTER & ASSY.







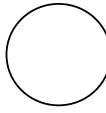
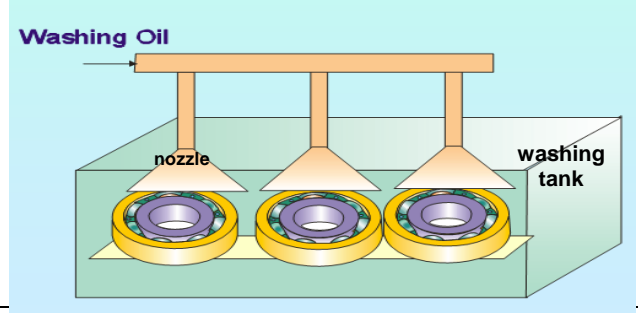


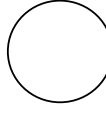







| | | | | |
|----|--|--|--|--|
| 6 | DEMAGNETISING | | | |
| 7 | WASHING | | | |
| 8 | AUTO I/R & O/R DIA INSPECTION + SENSIVITY CHECKING | | | |
| 9 | RADIAL CLEARANCE CHECKING | | | |
| 10 | WASHING | | | |

| | | | | | | | |
|---|--|----------------|--|------------------------|---|------------|---|
| DEEP-GROOVE-BALL-BEARINGS FLOW CHART | | Transportation |  | Storage |  | Assembly |  |
| | | Operation |  | Operation & inspection |  | Inspection |  |

| S.no. | OPERATION DESCRIPTION | Main Assly Flow | PICTURE | Open issues/ Remarks |
|-------|-----------------------|-----------------|---------|----------------------|
|-------|-----------------------|-----------------|---------|----------------------|

INNER & OUTER & ASSY.

| | | | | |
|----|------------------------------|---|--|--|
| 11 | NOISE TESTING |  |   | |
| 12 | LASER MARKING |  |   | |
| 13 | AUTO CENTRIFUGAL DRYING M/C |  |  | |
| 14 | GREASING |  |   | |
| 15 | SHELDING & DUST SEAL FITTING |  |   | |

| DEEP-GROOVE-BALL-BEARINGS FLOW CHART | | Transportation  Storage  Assembly  Operation  Operation & inspection  Inspection  | | |
|---|------------------------------|---|---|----------------------|
| S.no. | OPERATION DESCRIPTION | Main Assly Flow | PICTURE | Open issues/ Remarks |
| INNER & OUTER & ASSY. | | | | |
| 16 | OILING |  |  | |
| 17 | VISUAL INSPECTION |  |  | |
| 18 | WRAPING & PACKING |  |  | |
| 19 | DESPATCH ASSURANCE |  |  | |
| 20 | DELIVERY TO FINISH WAREHOUSE |  |  | |
| 21 | SHIPMENT |  |  | |