

Title (en)

METHOD FOR PRODUCING THE ROLLING ELEMENTS OF A BALL ROLLER BEARING

Title (de)

VERFAHREN ZUR HERSTELLUNG DER WÄLZKÖRPER EINES KUGELROLLENLAGERS

Title (fr)

PROCÉDÉ DE FABRICATION DES CORPS DE ROULEMENT D'UN ROULEMENT À ROULEAUX SPHÉRIQUES

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Abstract (en)

[origin: WO2010069817A1] The invention relates to a method for producing the rolling elements of a ball roller bearing, wherein the rolling elements are designed as ball rollers (1), wherein substantially the following method steps are performed in order to produce said ball rollers: A) cutting off unfinished sections (7) at a defined length from a round wire having a defined diameter, B) compression molding ball roller blanks (8) having end face depressions (4, 5) in the form (9) of a die tool (10), C) grinding the ball roller blanks (8) to the desired final dimensions in a ball grinding machine. According to the invention, the cut-off unfinished sections (7) have a volume by which during compression molding thereof an approximately tangential raceway transition (11) from one ball roller half to the other ball roller half and material fibers (12) extending under the running surfaces (6) of the ball rollers (1) parallel or approximately parallel to said running surfaces (6) arise. In addition, the ball roller blanks (8) are ground to the final dimensions thereof in a horizontal ball grinding machine (13) loaded exclusively with ball roller blanks (8) of the same size.

IPC 8 full level

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