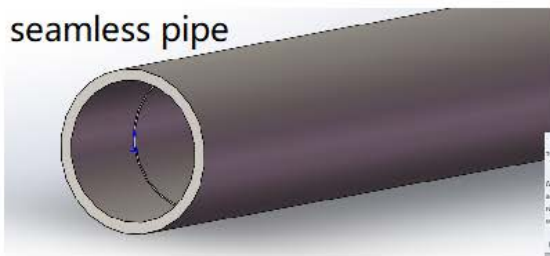


Steel Roller Production Process

Material: 1020, C45, 4340, S355j2, S.S.etc.

seamless pipe



annealing if necessary

(boring inside tube)

turning outside and inside at both ends

static balancing

interference assembly
0.15% magnitude of interference

welding

turning

grinding

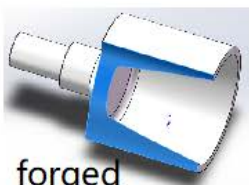
dynamic balancing

coating

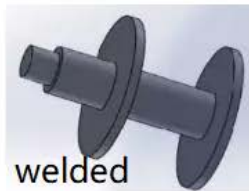
(paint, chrome etc.)

final inspection

packaging



forged



welded



First Article Report

Part Name	ROLLER HELIX BELT KAA OLUK	Rev.#	3	Iss
Part Number	DC114-20001	Rev.#	3	Issp
Drawing #	FL 52185	Rev.#	3	Prv
Requester	Shandong C&P			Prv
Method	Hongshun 5x			Prv
Supplier	Hongshun Fu Mechanical Parts Co., Ltd.			Prv
File Name	file:0027460-00001			Prv
MPO File Name	NA			

Specs	Unit	Tol	Meas	Dev
Dim1	Zone	Normal	+Tol	-Tol
NOTE 1	S1A8			
NOTE 2	S1A8			
NOTE 3	S1A8			
NOTE 4	S1A8			
NOTE 5	S1A8			
NOTE 6	S1A8			

