

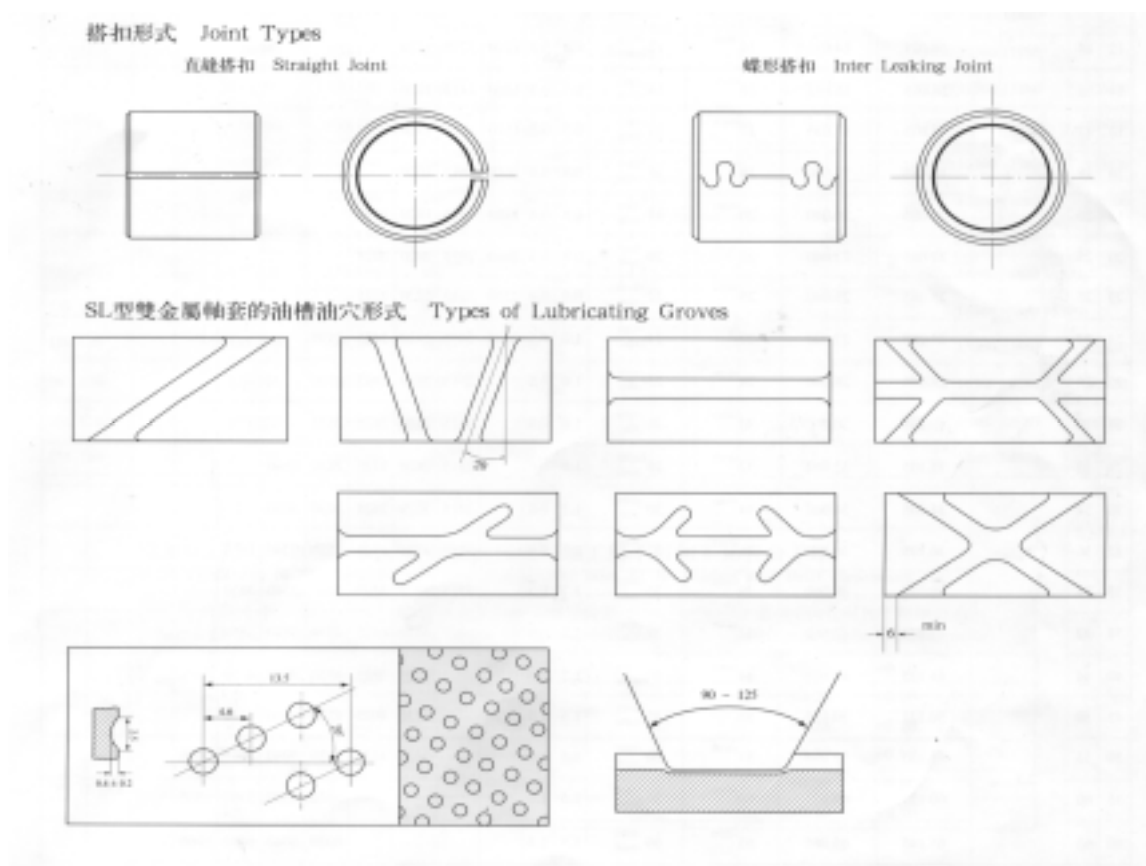
MSB-JF 双金属轴套 JF Bimetal Bushing

该产品是以优质低碳钢为基体，表面烧结铅锡青铜合金，经数次高温烧结和致密轧制而形成的铜、钢一体的双金属带材。

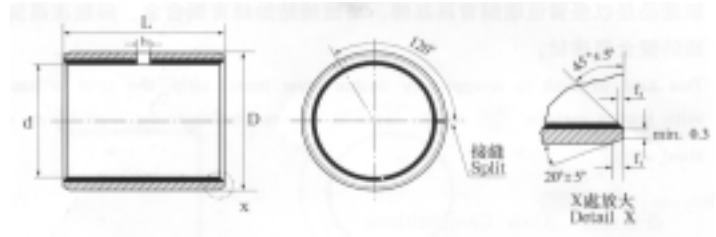
This kind of bush is wrapped by bimetal strip, the strip is based on steel backing and incorporated with bronzed surface. The bronze layer is sintered twice under high temperature and calendered firmly onto the steel strip.

合金成份 Alloy Compositions

型号	合金牌号	Cu	Pb	Sn	Zn
JF800	Cu ₈₀ Pb ₁₀ S ₁₀	80	10	10	/
JF750	Cu ₇₀ Pb ₁₀	75	24	1	/
JF720	Cu ₇₅ Pb ₂₂ S ₃	72	24	4	/



MSB-JF-800, JF-750, JF-720 轴套标准尺寸
Standard Series of Bushes 800 , 750 , 720



d	D	壁厚 Wall Thickness	GO	NO.GO	座孔H7 Housing bore	轴径 Journal Diameter	f ₁	f ₂	长度L _{±0.40}											
									10	15	20	25	30	40	50	60	80	90	100	
10	12	0.03	12.057	12.035	12 ^{+0.018}	10 ^{-0.013 -0.028}	0.5	0.3	1010	1015	1020									
12	14		14.075	14.035	14 ^{+0.018}	12 ^{-0.016 -0.034}	0.5	0.3	1210	1215	1220									
14	16		16.075	16.035	16 ^{+0.018}	14 ^{-0.016 -0.034}	0.5	0.3	1410	1415	1420									
15	17		17.075	17.035	17 ^{+0.018}	15 ^{-0.016 -0.034}	0.5	0.3	1510	1515	1520									
16	18		18.085	18.040	18 ^{+0.018}	16 ^{-0.016 -0.034}	0.8	0.4	1610	1615	1650									
18	20		20.085	20.040	20 ^{+0.021}	18 ^{-0.016 -0.034}	0.8	0.4	1810	1816	1820	1825								
20	23	1.5 _{±0.030}	23.085	23.040	23 ^{+0.021}	20 ^{-0.020 -0.041}	0.8	0.4	2010	2015	2020	2025								
22	25		25.085	25.040	25 ^{+0.021}	22 ^{-0.020 -0.041}	0.8	0.4	2210	2215	2220	2225								
24	27		27.085	27.040	27 ^{+0.021}	24 ^{-0.020 -0.041}	1.0	0.5	2410	2415	2420	2425	2430							
25	28		28.085	28.040	28 ^{+0.021}	25 ^{-0.020 -0.041}	1.0	0.5		2515	2520	2525	2530							
26	30	2.0 _{±0.035}	30.105	30.060	30 ^{+0.021}	26 ^{-0.020 -0.041}	1.0	0.5		2615	2620	2625	2630							
28	32		32.105	32.060	32 ^{+0.025}	28 ^{-0.020 -0.041}	1.0	0.5		2815	2820	2725	2830	2840						
30	34		34.105	34.060	34 ^{+0.025}	30 ^{-0.020 -0.041}	1.2	0.6		3015	3020	2825	3030	3040						
32	36		36.105	36.060	36 ^{+0.025}	32 ^{-0.025 -0.050}	1.2	0.6		3215	3520	3025	3230	3240						
35	39		39.105	39.060	39 ^{+0.025}	35 ^{-0.025 -0.050}	1.2	0.6		3515	3521	3525	3530	3540	3550					
38	42		42.105	42.060	42 ^{+0.025}	38 ^{-0.025 -0.050}	1.2	0.6			3820	6525	3830	3840	3850					
40	44	44.105	44.060	44 ^{+0.025}	40 ^{-0.025 -0.050}	1.2	0.6			4020	3825	4030	4040	4050						
45	50	2.5 _{±0.040}	50.125	50.075	50 ^{+0.025}	45 ^{-0.025 -0.050}	1.5	1.0			4520	4025	4530	4540	4550					
50	55		55.125	55.075	55 ^{+0.030}	50 ^{-0.025 -0.050}	1.5	1.0			5020	4525	5030	5040	5050	5060				
55	60		60.125	60.075	60 ^{+0.030}	55 ^{-0.030 -0.060}	1.5	1.0					5530	5540	5550	5560				
60	65		65.145	65.085	65 ^{+0.030}	60 ^{-0.030 -0.060}	1.5	1.0					6030	6040	6050	6060				

MSB-JF-800, JF-750, JF-720 轴套标准尺寸

Standard Series of Bushes 800 , 750 , 720

d	D	壁厚 wall Thickness	GO	NO.GO	座孔H7 Housing Bore	轴径f7 Journal Diameter	f ₁	f ₂	长度L _{±0.040}										
									10	15	20	25	30	40	50	60	80	90	100
65	70	2.5 _{-0.040}	70.145	70.085	70 ^{+0.030}	65 ^{-0.030} -0.060	1.5	1.0					6530	6540	6550	6560			
70	75		75.145	75.085	75 ^{+0.030}	70 ^{-0.030} -0.060	1.5	1.0					7030	7040	7050	7060	7080	7080	
75	80		80.145	80.085	80 ^{+0.035}	75 ^{-0.030} -0.060	1.5	1.0					7530	7540	7550	7560			
80	85		85.145	85.085	85 ^{+0.035}	80 ^{-0.030} -0.060	1.5	1.0					8040	8050	8060	8080			
84	90	3 _{-0.045}	90.165	90.100	90 ^{+0.035}	84 ^{-0.036} -0.071	1.8	1.2					8440	8450	8460	8480			
89	95		95.165	95.100	95 ^{+0.035}	89 ^{-0.036} -0.071	1.8	1.2					8940	8950	8960	8980			
94	100		100.165	100.100	100 ^{+0.035}	94 ^{-0.036} -0.071	1.8	1.2						9450	9460	9480	9490		
99	105		105.185	105.115	105 ^{+0.035}	99 ^{-0.036} -0.071	1.8	1.2						9950	9960	9980	9990		
104	110		110.185	110.115	110 ^{+0.035}	104 ^{-0.036} -0.071	1.8	1.2						10450	10460	10480			
109	115		115.185	115.115	110 ^{+0.035}	109 ^{-0.036} -0.071	1.8	1.2						10950	10960	10980			
114	120		120.185	120.115	120 ^{+0.040}	114 ^{-0.036} -0.071	1.8	1.2						11450	11460	11480			
119	125		125.205	125.130	125 ^{+0.040}	119 ^{-0.036} -0.071	1.8	1.2						11950	11960	11980			
123	130	3.5 _{-0.050}	130.205	130.130	130 ^{+0.040}	123 ^{-0.043} -0.083	2	1.5						12350	12360	12380			123100
128	135		135.205	135.130	135 ^{+0.040}	128 ^{-0.043} -0.083	2	1.5						12850	12860	12880			128100
133	140		140.205	140.130	140 ^{+0.040}	133 ^{-0.043} -0.083	2	1.5						13350	13360	13380			133100
138	145		145.205	145.130	145 ^{+0.040}	138 ^{-0.043} -0.083	2	1.5							13860	13880			138100
143	150		150.235	150.150	150 ^{+0.040}	143 ^{-0.043} -0.083	2	1.5							14360	14380			143100
148	155		155.235	155.150	155 ^{+0.040}	148 ^{-0.043} -0.083	2	1.5							14860	14880	14890		
153	160		160.235	160.150	160 ^{+0.040}	153 ^{-0.043} -0.083	2	1.5							15360	15380	15390		
158	165		165.235	165.150	165 ^{+0.040}	158 ^{-0.043} -0.083	2	1.5							15860	15880			158100
163	170		170.255	170.170	170 ^{+0.040}	163 ^{-0.043} -0.083	2	1.5							16380	16380			163100
168	175		175.255	175.170	175 ^{+0.046}	168 ^{-0.043} -0.083	2	1.5							16860	16880			168100
173	180	180.255	180.170	180 ^{+0.046}	173 ^{-0.043} -0.083	2	1.5							17360	17380			173100	

MSB-JF800、750、720钢-铜铅合金轴套内孔可加工与不可加工见表公差厚

Wall Thickness of Machinable and Non-machinable bore of JF Bushes and their clearances

公称尺寸 Nominal Thickness	系列B内孔不可加工壁厚公差 Tolerances Series B(non-machinable)	系列C内孔可加工壁厚公差 Tolerances Series B(machinable)
1	-0.025	+0.025 +0.10
1.5	-0.030	+0.025 +0.10
2	-0.035	+0.025 +0.10
2.5	-0.040	+0.030 +0.10
3	-0.045	+0.030 +0.10
3.5	-0.050	+0.030 +0.10