

PRODUCTION FLOW CHART DESCRIPTION

1. FORGING PROCESS

The very first step of the production flow chart is the acquisition of the steel bars which takes place according to RKB technical specifications and procedures.

Depending on the typology of bearings that are in production and on the related drawings, the steel gets selected. Afterwards, the bars are cut (or sawed) into pieces and then heated. The next step consists in the control of weight and temperature. The eligible sections are subsequently forged and rolled into rings. After that, the rings undergo a quality check and, the adequate ones, are consequently ready for annealing treatment.

2. TURNING PROCESS

After the annealing process, the rings undergo a further quality check and are then arranged for turning process. The forged rings are turned on a lathe (CNC lathe or universal lathe) leaving well defined allowances. All the related technical specification get checked, after which the turned rings proceed to heat treatment.

3. HEAT TREATMENT PROCESS

In function of the typology of product required and based on the category of steel, there are two different types of heat treatment. The bearing standard through hardening steel undergoes the related treatment. Carburizing steel, first of all, undergoes to carburizing process, gets checked, and then goes through hardening treatment. Following the hardening treatment, they undergo to tempering treatment, a further quality check and then they endure grinding process.

4. GRINDING PROCESS

The hardened rings go through rough grinding process and quality check, after which, additional tempering treatment is required. Subsequently, the next step is the finishing grinding process. All technical specification get checked and the eligible semi-finished items are sent to de-magnetization.

5. ASSEMBLY PROCESS

After deep cleansing all components, they are ready for assembly. Following assembly the bearings undergo a further deep cleansing and then, the next steps are marking and washing. A final quality check takes place and the adequate products are then ready for packaging procedures.



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