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Second edition
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Plain bearings — Thin-walled half bearings with or without flange —

Part 2: Measurement of wall thickness and flange thickness

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ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 123, *Plain Bearings*, Subcommittee SC 5, *Quality analysis and assurance*.

This second edition cancels and replaces the first edition (ISO 3548-2:2009), which has been technically revised. The main changes compared to the previous edition are as follows:

— the term “flange thickness” has been introduced in Clause 3;

— Table 1 has been updated;

— several figures have been revised;

— a new Table 3 “Thin walled half bearings with flange — Distance to measuring position a_{ch}” has been introduced.

A list of all parts in the ISO 3548 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user’s national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Plain bearings — Thin-walled half bearings with or without flange —

Part 2: Measurement of wall thickness and flange thickness

1 Scope

This document specifies in accordance with ISO 12301 the checking of the wall-thickness of thin-walled half bearings with or without flange and describes the necessary checking methods and measuring equipment.

It applies to a maximum bearing diameter of 150 mm. It can be applied to a bigger diameter, provided that there is an agreement between the supplier and the user.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 3548-1, *Plain bearings — Thin-walled half bearings with or without flange — Part 1: Tolerances, design features and methods of test*

3 Terms and definition

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at http://www.iso.org/obp

— IEC Electropedia: available at http://www.electropedia.org/

For the purposes of thisdocument, the following definitions apply:

3.1
wall thickness
s_3
radial distance between the opposing measuring points at the inner and outer cylindrical surfaces

Note 1 to entry: See Figure 1.

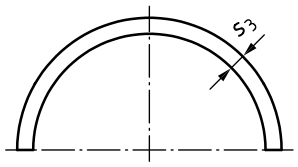

Figure 1 — Wall thickness, s_3, of a half bearing

3.2
measuring point
agreed point established to facilitate agreement on checking

Note 1 to entry: The establishment of measuring points (lines) does not preclude the need to comply with dimensional specifications in other areas.

3.3
measuring line
agreed line established to facilitate agreement on checking

Note 1 to entry: The establishment of measuring lines does not preclude the need to comply with dimensional specifications in other areas.

3.4
tolerance
range between the upper specified limit and the lower specified limit

3.5
flange thickness
axial distance between the opposing measuring points at the inside and the outside surface of flange

4 Symbols and units

For the purposes of this document, the symbols and units are those given in Table 1.

Table 1 — Symbols and units

Symbol	Description	Unit
a_{ch}	distance to measuring position	mm
a_9	minimum height of transition	mm
$a_{ch,fl}$	radial distance to measuring position from flange outside edge	mm
B	width	mm
B_{fl}	flange width	mm
C_i	inner chamfer width	mm
D_0	nominal outside diameter	mm
e_B	eccentricity of bore centre to outside diameter centre	mm
F_{pin}	measuring pin load	N
H	distance to measuring position from bearing parting line	mm
s_a	wall thickness at angle α	mm
s_{fl}	flange thickness	mm
s_3	wall thickness at crown	mm
u	wall thickness reduction at angle α_2	mm
x_1	centre point of nominal outside diameter	—
x_2	centre point of eccentric bore	—
α	angle to measuring position	°
α_2	angle to measuring position from parting line	°
M1, M2	measuring line	—

5 Purpose of checking

In order to ensure the required bearing clearance, and consequently, the operational efficiency of the plain bearing unit, keep to the wall thickness tolerances specified in ISO 3548-1.