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**Železniške naprave - Ohišja ležajev kolesnih dvojic - Kotalni ležaji (vključno z dopolnilom A1)**

Railway applications - Axleboxes - Rolling bearings

Bahnanwendungen - Radsatzlager - Wälzlager

Applications ferroviaires - Boîtes d'essieux - Roulements

**Ta slovenski standard je istoveten z: EN 12080:2017+A1:2022**

**ICS:**

21.100.20	Kotalni ležaji	Rolling bearings
45.040	Materiali in deli za železniško tehniko	Materials and components for railway engineering

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**EN 12080:2017+A1**

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**Railway applications - Axleboxes - Rolling bearings**

Applications ferroviaires - Boîtes d'essieux -  
Roulements

Bahnanwendungen - Radsatzlager - Wälzlager

This European Standard was approved by CEN on 19 June 2017 and includes Amendment 1 approved by CEN on 6 June 2022.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
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**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

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## European foreword

This document (EN 12080:2017+A1:2022) has been prepared by Technical Committee CEN/TC 256 “Railway Applications”, the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by March 2023, and conflicting national standards shall be withdrawn at the latest by March 2023.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document includes Amendment 1 approved by CEN on 6 June 2022.

This document supersedes A1 EN 12080:2017 A1.

The start and finish of text introduced or altered by amendment is indicated in the text by tags A1 A1.

The main changes with respect to the previous edition are listed below:

- A1 The use of conditioning for polymer cages is no longer mandatory and is specified in 4.2
- A clarification of deviations in marking of cylindrical roller bearings is new in 11.2 and 11.3
- The inspection plan for inclusion content in 12.1 (footnote h in Table 3) has been made clearer and now also includes specifications for sample preparations
- The sensor definition in C.3 is now more relevant
- Conditioning can now be performed also at the bearing manufacturer (see D.2.4)
- The sample frequency for polymeric cages in D.3.1.1 is now more relevant and the terms “Approval” and “Series” are better defined
- Table D.1 has been renamed for clarity and the requirements for “Viscosity index” and “Length of glass fibres” have been relaxed to be more relevant
- The requirement for “Mechanical test for material approval” in Table D.1 have been changed so that it is clear that the Charpy impact test is on “un-notched” samples and made according to the relevant norm, the requirement for the “Bending strength on the test specimen” is changed and a clarification on how “Thermal ageing in grease or oil bath” is performed has been added
- Footnote d in Table D.1 now allows for use of inspection certificate 3.1 and a new footnote “h” is added to specify sampling frequency
- ISO 15512 can be used for moisture content determination in D.3.2 and a clarification on the use of desiccator is added
- In D.3.4.3 some additions are made on how to address burrs on the edge and outside of functional areas
- D.3.5 is rewritten to address “void clusters” and Figure D.1 is replaced
- The Annex ZA has been revised to take into account EU Directive (EU) 2016/797 A1

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This document has been prepared under a Standardization Request given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s) / Regulation(s).

For relationship with EU Directive(s) / Regulation(s), see informative Annex ZA, which is an integral part of this document.

Any feedback and questions on this document should be directed to the users' national standards body. A complete listing of these bodies can be found on the CEN website.

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## Introduction

This standard is part of a set of standards: EN 12080, EN 12081 and EN 12082.

This European Standard has been drawn up with the purpose of aiming at optimum performance in rail transportation. Performance implies a certain quality level of the vehicle running gear, which every railway undertaking may require, notably by imposing procedures in approval and requesting the existence of a quality assurance system for the supply of rolling bearings intended for rolling stock operating on its network or other networks in Europe.

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## EN 12080:2017+A1:2022 (E)

## 1 Scope

This European Standard specifies the quality parameters of axlebox rolling bearings supporting the load of the vehicle, required for reliable operation of trains on European networks. It covers metallurgical and material properties as well as geometric and dimensional characteristics. It also defines methods for quality assurance and conditions for approval of the products.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 10204:2004, *Metallic products - Types of inspection documents*

EN 12081:2017, *Railway applications - Axleboxes - Lubricating greases*

EN 12082:2017, *Railway applications - Axleboxes - Performance testing*

EN 13018:2016, *Non-destructive testing - Visual testing - General principles*

EN 15663:2017, *Railway applications - Definition of vehicle reference masses*

EN ISO 178:2010, *Plastics - Determination of flexural properties (ISO 178:2010)*

EN ISO 179-1:2010, *Plastics - Determination of Charpy impact properties - Part 1: Non-instrumented impact test (ISO 179-1:2010)*

EN ISO 307:2007, *Plastics - Polyamides - Determination of viscosity number (ISO 307:2007)*

EN ISO 683-17:2014, *Heat-treated steels, alloy steels and free-cutting steels - Part 17: Ball and roller bearing steels (ISO 683-17:2014)*

EN ISO 1172:2003, *Textile-glass-reinforced plastics - Prepregs, moulding compounds and laminates - Determination of the textile-glass and mineral-filler content - Calcination methods (ISO 1172:1996)*

EN ISO 1183-1:2012, *Plastics - Methods for determining the density of non-cellular plastics - Part 1: Immersion method, liquid pycnometer method and titration method (ISO 1183-1:2012)*

EN ISO 1183-2:2004, *Plastics - Methods for determining the density of non-cellular plastics - Part 2: Density gradient column method (ISO 1183-2:2004)*

EN ISO 2639:2002, *Steels - Determination and verification of the depth of carburized and hardened cases (ISO 2639:2002)*

EN ISO 3059:2012, *Non-destructive testing - Penetrant testing and magnetic particle testing - Viewing conditions (ISO 3059:2012)*

EN ISO 3451-1:2008, *Plastics - Determination of ash - Part 1: General methods (ISO 3451-1:2008)*

EN ISO 6507-1:2005, *Metallic materials - Vickers hardness test - Part 1: Test method (ISO 6507-1:2005)*

EN ISO 6508-1:2016, *Metallic materials - Rockwell hardness test - Part 1: Test method (ISO 6508-1:2016)*

EN ISO 6508-2:2015, *Metallic materials - Rockwell hardness test - Part 2: Verification and calibration of testing machines and indenters (ISO 6508-2:2015)*

EN ISO 6508-3:2015, *Metallic materials - Rockwell hardness test - Part 3: Calibration of reference blocks (ISO 6508-3:2015)*

EN ISO 9934-1:2016, *Non-destructive testing - Magnetic particle testing - Part 1: General principles (ISO 9934-1:2016)*

EN ISO 9934-2:2015, *Non-destructive testing - Magnetic particle testing - Part 2: Detection media (ISO 9934-2:2015)*

EN ISO 9934-3:2014, *Non-destructive testing - Magnetic particle testing - Part 3: Equipment (ISO 9934-3:2015)*

EN ISO 11357-3:2013, *Plastics - Differential scanning calorimetry (DSC) - Part 3: Determination of temperature and enthalpy of melting and crystallization (ISO 11357-3:2011)*

ISO 281:2007, *Rolling bearings — Dynamic load ratings and rating life*

ISO 492:2014, *Rolling bearings — Radial bearings — Geometrical product specifications (GPS) and tolerance values*

ISO 4967:2013, *Steel - Determination of content of non-metallic inclusions - Micrographic method using standard diagrams*

ISO 15512:2016, *Plastics — Determination of water content*

ASTM E45:2014, *Standard Test Methods for Determining the Inclusion Content of Steel*

### 3 Terms and definitions

For the purposes of this document, the following terms and definitions apply (see also Annex G for more information).

#### 3.1

##### **customer**

railway undertaking, rolling stock manufacturer, Entity in Charge of Maintenance (ECM) or buyer of railway rolling stock or subassemblies, or their representative

#### 3.2

##### **railway undertaking**

organization or its representative, whatever status it has, which is responsible for the registration of rolling stock

#### 3.3

##### **manufacturer**

manufacturer of axlebox rolling bearings produced under their responsibility

#### 3.4

##### **network**

infrastructure, on which any railway undertaking can operate rolling stock

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**3.5****axlebox (assembly)**

assembly consisting of the following major components: rolling bearing(s)/cartridge bearing, rolling bearing grease, seal(s) and box housing

Note 1 to entry: Further components, e.g. bearing sleeve, housing cover(s), axle end cap components and fasteners may also be part of the assembly. This depends on axlebox type and design (see Annex G).

**3.6****bearing sleeve**

component of box housing which contains rolling bearing(s), grease and sealing

**3.7****housing cover**

component which retains the bearing in the housing or bearing sleeve

**3.8****axle end cap components**

components which secure the rolling bearing axially on the journal

**3.9****rolling bearing**

bearing, operating with rolling motion between the parts supporting load and moving in relation to each other

**3.10****cartridge bearing**

rolling bearing with two or more rows of rolling elements within a self-contained unit, greased and equipped with integral seals

**3.11****ring**

annular part of a rolling bearing incorporating one or more raceways with rolling element contact

**3.12****rolling elements**

cylindrical, tapered or convex rollers or balls

**3.13****cage**

component, which partly surrounds the rolling elements and moves with them

**3.14****grease**

semi-solid lubricant, which consists of a thickener and additives dispersed in a lubricating oil

**3.15****seal**

component that protects the bearing(s) against ingress of water and dust and retains the grease in the rolling bearing(s)

**3.16****box housing**

structural component which contains rolling bearing(s), seal(s) and grease

**3.17****rolling bearing type**

designation of the rolling bearing or cartridge bearing according to the shape of the rolling elements (e.g. tapered roller bearing, cylindrical roller bearing, and spherical roller bearing)

**3.18****rolling bearing design**

designation of a specific rolling bearing or cartridge bearing design within a rolling bearing type (e. g. WJ/WJP 130x240x80 P.C3), bearing design is a subset of a bearing type

**3.19****ribs and thrust collars**

annular component of a rolling bearing transmitting axial forces (separate from the bearing inner or outer rings) in contact with the rolling element end face in cylindrical roller bearings

**4 Technical specification****4.1 General requirements**

The supply of a component or a service (rig tests, field test, calculations, etc.) shall be based on a comprehensive specification. This specification shall consist of all the information relevant for design and manufacture of the bearing describing the functional requirements over its complete life cycle and the interfaces with associated components and assemblies.

The design and validation process requires the integration of different disciplines and areas of expertise and the knowledge associated with them. Therefore, the specification shall include information defining the intended operating conditions, calculation and test parameters.

The following information shall be part of the approval process and be fully documented in the technical specification by either of the contracting parties. Both the requirements specified throughout this European Standard and the following documented requirements shall be satisfied before a claim of compliance with this European Standard can be made and verified.



**4.2 Technical specification content**

The technical specification shall contain at least the following information and requirements:

NOTE Usually the customer is responsible for items 1) to 6). Items 7) to 21) are usually subject to agreement between contracting parties.

- 1) interface drawing showing mounting conditions; all dimensions of the space available for the rolling bearings; dimensions, tolerances and materials of shaft and box housing;
- 2) load specification at least according to EN 12082;
- 3) ambient temperatures in operation;
- 4) if required, special steel composition, cleanliness and soundness class (see 7.1 and 10.2);
- 5) approval procedure type and conditions to be applied (see Clause 14 and Annex E);
- 6) special conditions for quality records and traceability (see 6.3 and Clause 13);
- 7) boundary dimensions and interface tolerances of the rolling bearing (see Clause 8);
- 8) type of coating and influence on boundary dimensions (see 6.4);

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- 9) internal clearance measurement process and clearance values before and after mounting (see Clause 8);
- 10) references to standards and special requirements (see Clause 7 and 10.2);
- 11) use of steel of special composition, manufacture or metallurgical quality (see 7.1);
- 12) soundness Class, 1 or 2, and the test methods to be used (see 10.2 and A.4.2);
- 13) type of heat treatment to be applied and methods of testing (see 6.2, 10.3, 10.4 and 12.2);
- 14) marking (see Clause 11);
- 15) inspection plan (see 12.1);
- 16) for cartridge bearings grease designation, quantity and distribution (see 15.1);
- 17) for non-sealed bearings, grease designation and compatibility with preservatives (see 15.2);
- 18)  selection of mechanical testing method for cages of polymeric material (see D.4.1) and selection if conditioning shall be used or not for polymer cages (see D.2.4) 
- 19) material data sheet for polymer cage material;
- 20) proof of batch release according to EN 12081 for traceability;
- 21) method for determining steel cleanliness.

**5 Quality systems**

The quality of workmanship and manufacturing shall be demonstrated to ensure the requirements of the technical specification are met.

NOTE 1 The manufacturer is responsible for this.

NOTE 2 Quality management system according to EN ISO 9001 is usually used.

NOTE 3 The system used for non-destructive testing staff is usually according to EN ISO 9712.

**6 Manufacture****6.1 Steel manufacturing**

The process of steel manufacture in mass production shall be such that the metallurgical characteristics are the same as those of the rolling bearings submitted for the approval procedure.

**6.2 Heat treatment**

The heat treatment processes for the rolling bearing components shall be such that the hardness values specified in 10.3 and/or 10.4 are respected. The heat treatment processes shall be such that all the rolling bearings produced in a production batch are treated uniformly.

The bearings shall be heat-treated to retain dimensional stability for one of the two following temperature categories:

- 150 °C

- 200 °C

The temperature category shall be given and documented in the Technical specification (Clause 4).

The bearings (inner and outer rings) shall be heat-treated to retain dimensional stability at least for operating temperatures up to 150 °C.

Inner rings of cylindrical roller bearings that are heated during mounting or dismounting shall be dimensionally stable up to 200 °C.

The retained austenite content for inner rings made of through-hardened rolling bearing steel must be:

- 150 °C:  $\leq 3.0$  % with a measuring accuracy of  $\pm 1$  %;
- 200 °C:  $\leq 2.0$  % with a measuring accuracy of  $\pm 1$  %.

For other steels, the retained austenite content must be defined in the course of the (type) approval procedure.

The inspection frequency of the retained austenite content is specified in Table 3 — Inspection plan, 12.1. The method of measurement of retained austenite is to be defined in the technical specification (Clause 4).

### 6.3 Traceability

For the manufacturing process a system of identification and traceability of finished products shall be set up and maintained. This system shall allow identification, of the following elements:

- Raw material for rings and rollers;
- Inspection certificate 3.1 in accordance with EN 10204 or equivalent. Minimum content:
  - $\square_{A1}$  Chemical analysis (all elements having content limitations according to ISO 683-17)  $\square_{A1}$ ;
  - Steel production method;
  - Microstructure (CN, CG, CZ);
  - Inclusion content (see 7.2.2);
- Polymeric cages:
  - Raw material (granulate material) + raw material manufacturer;
  - Inspection results; inspections at least in accordance with EN 12080, Annex D;
  - Manufacturer, manufacturer's mark, date of manufacture;
- Rolling bearing grease:
  - Name, manufacturer  $\square_{A1}$  ;  $\square_{A1}$
  - Inspection certificate 3.1 in accordance with EN 10204 or equivalent. The content of the certificate is according to EN 12081.
- Production locations of rings and rollers;