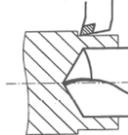
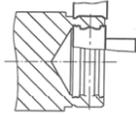
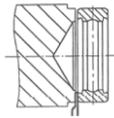
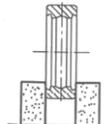
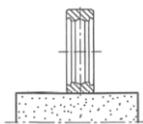
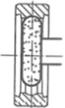


Bearings manufacturing steps

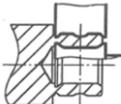
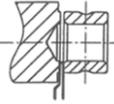
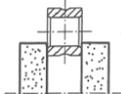
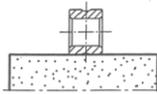
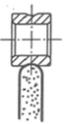
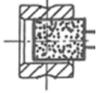
JESA.
bearing solutions

The manufacturing of a ball bearing is much more complex than we can imagine. Indeed, more than 25 operations are needed to produce them. JESA strives to reduce the number of operations by doing multiple operations on the same tailored machine to increase flexibility and reduce production time. Here are the operations that we perform every day in the production of a deep groove ball bearing.

OUTER RING

TURNING				GRINDING			
1 Material feed	2 external and internal \emptyset machining	3 external and internal machining to shape	4 Sawing	5 Hardening / heat treatment	6 Face planing	7 Centreless grinding of outside \emptyset	8 Raceway grinding
							

INNER RING

TURNING				GRINDING				
1 Material feed	2 external and internal \emptyset machining	3 external and internal machining to shape	4 Sawing	5 Hardening / heat treatment	6 Face planing	7 Centreless grinding of outside \emptyset	8 Raceway grinding	9 Inner \emptyset grinding
								

ASSEMBLY

1 Assemble the rings	2 Join the rings and insert the balls	3 Re-centre the inner ring	4 Spread the balls over 360°	5 Assemble the cage	6 Grease	7 Install the seals	8 Final inspection
