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中国认可  
国际互认  
检测  
TESTING  
CNAS L3370

# 检验报告

## INSPECTION REPORT

No. A34915F202510215

产品名称: 球型支座  
Sample Spherical Bearing  
Description:

委托单位: 衡水京通工程橡胶有限公司  
Applicant: HENGSHUI JINGTONG RUBBER CO., LTD

检验类别: 型式检验  
Inspection Category: Type Inspection

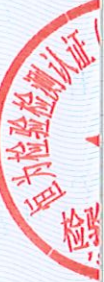
国家工程橡胶产品质量检验检测中心(河北)

恒为检验检测认证(河北)集团有限公司



National Engineering Rubber Products Quality Inspection and Testing Center (Hebei)  
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防伪码: P6F8PV





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1	竖向压缩变形 Vertical compressive deformation	%	$\leq 1$	1# 0.9 2# 0.9 3# 0.9	合格 Qualified
2	盆环径向变形 Radial deformation of basin ring	%	$\leq 0.5$	1# 0.1 2# 0.1 3# 0.1	合格 Qualified
3	(1#-2#) 转动力矩 Rotational torque (for samples 1#-2#)	N·m	<99240	61447	合格
4	(1#-2#) 摩擦系数 Friction coefficient (for samples 1#-2#)	/	$\leq 0.03$	0.01	合格 Qualified
5	水平承载力 Horizontal bearing capacity	/	$\geq 400\text{kN} \times 1.2$ 变形应恢复 Under a load of $\geq 400\text{kN}$ multiplied by a factor of 1.2, the deformation shall recover.	1# 480kN 变形恢复 1# 480kN Deformation Recovery 2# 480kN 变形恢复 2# 480kN Deformation Recovery	合格 Qualified
6	1#、2# 组装高度Assembled height	mm	$115 \pm 2$	1# 115 2# 116	合格 Qualified
7	涂层厚度Coating thickness	$\mu\text{m}$	$\geq 200$	1# 304 2# 289	合格 Qualified

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8	上支座板不锈钢板 平面度Flatness of the stainless steel plate of the upper bearing plate	mm	$\leq 0.12$	1# 0.06 2# 0.08	合格 Qualified
9	1#、2# 组装后上下支座板 的平行度 Parallelism of the upper and base bearing plate after assembly	mm	$\leq 0.82$	1# 0.7 2# 0.6	合格 Qualified
10	上支座板焊接后不 锈钢板与基层钢板 密贴程度Tightness between stainless steel attached to the upper plate and base bearing plate	/	焊接后不锈钢板 与基层钢板应密 贴。 After welding, the stainless steel plate and the base layer steel plate shall be in close contact.	1#、2#经敲击不锈钢 与基层钢板密贴 For 1# and 2#, the stainless steel and base layer steel plate are in close contact after tapping.	合格 Qualified

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11	上下支座板外观缺陷 Surface defects of upper and lower support plates		/	表面应平整，不应有未焊透、裂缝、夹渣、气孔等缺陷。 The surface shall be flat and shall be free from defects such as incomplete penetration, cracks, slag inclusions and porosity.	1#、2#表面平整，无未焊透、裂缝、夹渣、气孔等缺陷。 1# and 2#: Surfaces are flat, free from defects such as incomplete penetration, cracks, slag inclusions and porosity.	合格 Qualified
12	1#、2#	直径 Diameter	mm	$410^{+1.2}_0$	1# 410.5 2# 410.4	合格 Qualified
13		厚度 Thickness	mm	$7^{+0.4}_0$	1# 7.1 2# 7.2	合格 Qualified
14		外露高度 Exposed height	mm	$3^{+0.3}_0$	1# 3.1 2# 3.2	合格 Qualified
15		组装间隙 Assembly clearance	mm	0~+0.5	1# 0.2 2# 0.2	合格 Qualified

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16	1#、2#	储脂槽排列 Grease groove arrangement	/	排列方向应与主滑移方向一致 The arrangement should be consistent with the main sliding	1#、2# 与主滑移方向一致 1#, 2#: Consistent with the main sliding direction	合格 Qualified
17		储脂槽尺寸 Grease groove dimension	mm	8±1	1# 8 2# 8	合格 Qualified
18		聚四氟乙烯板 PTFE plate	外观质量 Surface quality	/	板材表面应光滑，不应有裂纹、气泡、分层；不应有影响的机械损伤等缺陷；不应夹带任何杂质。 The plate surface shall be smooth, free from cracks, bubbles and delamination; free from defects such as service-affecting mechanical damage; and free from any entrained	1#、2#表面光滑，没有裂纹、气泡、分层；没有影响的机械损伤；没有夹带任何杂质。 1# and 2#: Surfaces are smooth, free from cracks, bubbles and delamination; free from service-affecting mechanical damage; and free from any entrained impurities.

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19	1#、2# 不锈钢板厚度 Thickness of stainless steel plate	mm	$2 \pm 0.1$	1# 2.0 2# 2.0	合格 Qualified
20	球面轮廓度 Spherical profile tolerance	mm	$\leq 0.2$	1# 0.093 2# 0.098	合格 Qualified
21	水平承载力 Horizontal bearing capacity	/	$\geq 1000\text{kN} \times 1.2$ 变形应恢复 Under a load of $\geq 1000\text{kN}$ multiplied by a factor of 1.2, the deformation shall recover.	1200kN变形恢复 1200kN Deformation Recovery	合格 Qualified
22	2# 组装高度 Assembled height	mm	$260 \pm 3$	261	合格 Qualified
23	3# 涂层厚度 Coating thickness	$\mu\text{m}$	$\geq 200$	310	合格 Qualified
24	上支座板不锈钢板平面度 Flatness of stainless steel plate on upper support plate	mm	$\leq 0.24$	0.16	合格 Qualified
25	3# 组装后上下支座板的平行度 Parallelism between upper and lower support plates after assembly	mm	$\leq 1.6$	0.9	合格 Qualified

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26	上支座板焊接后不锈钢板与基层钢板密贴程度Tightness between stainless steel attached to the upper plate and base bearing plate		/	焊接后不锈钢板与基层钢板应密贴 After welding, the stainless steel plate and the base layer steel plate shall be in close contact.	经敲击不锈钢与基层钢板密贴 The stainless steel and base layer steel plate are in close contact after tapping.	合格 Qualified
27	3#	上下支座板外观缺陷Surface defects of upper and lower support plates		表面应平整，不应有未焊透、裂缝、夹渣、气孔等缺陷。 The surface shall be flat and shall be free from defects such as incomplete penetration, cracks, slag inclusions and porosity.	表面平整，无未焊透、裂缝、夹渣、气孔等缺陷。 Surfaces are flat, free from defects such as incomplete penetration, cracks, slag inclusions and porosity.	合格 Qualified
28	聚四氟乙烯板 PTFE plate	直径 Diameter	mm	$800^{+1.8}_0$	800.8	合格 Qualified
29		厚度 Thickness	mm	$7^{+0.7}_0$	7.2	合格 Qualified
30		外露高度 Exposed height	mm	$3^{+0.5}_0$	3.1	合格 Qualified

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31	3#	组装间隙 Assembly clearance	mm	0~+0.8	0.3	合格 Qualified
32		储脂槽尺寸 Grease groove dimension	mm	8±1	8	合格
33		外观质量 Surface quality	/	<p>板材表面应光滑，不应有裂纹、气泡、分层；不应有影响使用的机械损伤等缺陷；不应夹带任何杂质。</p> <p>The plate surface shall be smooth, free from cracks, bubbles and delamination; free from defects such as service-affecting mechanical damage; and free from any entrained impurities.</p>	<p>表面光滑，没有裂纹、气泡、分层；没有影响使用的机械损伤；没有夹带任何杂质。</p> <p>Surfaces are smooth, free from cracks, bubbles and delamination; free from service-affecting mechanical damage; and free from any entrained impurities.</p>	合格 Qualified

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34	3# 不锈钢板厚度 Thickness of stainless steel plate	mm	$2 \pm 0.1$	2.0	合格 Qualified
35	球面轮廓度 Spherical profile tolerance	mm	$\leq 0.24$	0.106	合格
36	屈服强度 $R_{eH}$ Yield strength $R_{eH}$	MPa	$\geq 270$	292	合格 Qualified
37	抗拉强度 $R_m$ Tensile strength $R_m$	MPa	$\geq 500$	522	合格 Qualified
38	伸长率 $A_5$ Elongation at break $A_5$	%	$\geq 18$	24	合格 Qualified
39	断面收缩率 $Z$ Reduction of area $Z$	%	$\geq 25$	49	合格 Qualified
40	冲击吸收功 $A_{KV}$ Impact absorption energy $A_{KV}$	J	$\geq 22$	62 (KV <sub>2</sub> )	合格 Qualified
41	C	%	$\leq 0.40$	0.18	合格 Qualified
42	Si	%	$\leq 0.60$	0.20	合格 Qualified

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43	铸钢件 Mn	%	≤0.90	0.34	合格 Qualified	
44	Cast Steel Part	P	≤0.035	0.013	合格 Qualified	
45		S	≤0.035	0.015	合格 Qualified	
46	密度Density	g/cm <sup>3</sup>	2.14~2.2	2.17(浸渍 法)(Immersion method)	合格 Qualified	
47	拉伸强度Tensile strength	MPa	≥30	31	合格 Qualified	
48	扯断伸长率 Elongation at break	%	≥300	396	合格 Qualified	
49	聚四氟 乙烯板 PTFE plate	球压痕硬度H132/60 Ball indentation hardness (H132/60)	MPa	23~33	28	合格 Qualified
50	初始静摩擦系数 (23℃) Initial static friction coefficient (23℃)	/	≤0.012	0.008	合格 Qualified	

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51	聚四氟 乙烯板 PTFE plate 动摩擦系数 (23℃) Dynamic friction coefficient (23℃)	/	$\leq 0.005$	0.003	合格 Qualified
52	聚四氟乙烯板与钢板的剥离 强度 Peel strength between polytetrafluoroethylene (PTFE) and steel plate	kN/m	$\geq 5$	10	合格
53	规定塑性延伸强度 $R_{p0.2}$ Yield strength at 0.2% non- proportional extension $R_{p0.2}$	MPa	$\geq 205$	264	合格 Qualified
54	不锈钢 板 Stainl ess Steel Plate 抗拉强度 $R_m$ Tensile strength $R_m$	MPa	$\geq 515$	555	合格 Qualified
55	断后伸长率A Elongation after fracture	%	$\geq 40$	42	合格 Qualified
56	硬度 (HV) Hardness (HV)	/	$\leq 220$	182 (HV10)	合格 Qualified

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57	不锈钢板 Stainless Steel Plate	C	%	≤0.08	0.02	合格 Qualified
58		Si	%	≤0.75	0.39	合格 Qualified
59		Mn	%	≤2.00	1.36	合格 Qualified
60		S	%	≤0.030	0.008	合格 Qualified
61		P	%	≤0.045	0.029	合格 Qualified
62		Cr	%	16.00~18.00	17.43	合格 Qualified
63		Ni	%	10.00~14.00	10.59	合格 Qualified
64	硅脂 (5201-2) Silicone Grease (5201-2)	外观Appearance	/	乳白色或浅灰色半透明脂状物，不应带有任何机械杂质。 A translucent, milky-white or light gray waxy substance, free from any mechanical impurities.	乳白色半透明脂状物，无机械杂质。 A milky-white, translucent, lipid-like substance free of mechanical impurities.	合格 Qualified
65		油离度 Oil bleeding	%	≤8.0	2.2	合格 Qualified
66		挥发物含量 Volatile content	%	≤2.0	1.5	合格 Qualified
67		燃烧性 Combustibility	/	自熄 self-extinguishing	自熄 self-extinguishing	合格 Qualified

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68	硅脂 (5201-2)	腐蚀性 Corrosiveness	/	无蚀斑 No corrosion spots	无蚀斑 No corrosion spots	合格 Qualified
69	Silicone Grease (5201-2)	防水密封性 Waterproof sealing performance	/	氯化钴试纸不返红色 Cobalt chloride test paper does not turn red	五片氯化钴试纸均未返红色 Five cobalt chloride test strips did not turn red	合格 Qualified
以下空白 Blank below						

## 注 意 事 项

1. 检验报告无“检验检测专用章”和骑缝章无效。
2. 检验报告无主检、审核、批准人签字无效。
3. 检验报告涂改无效。
4. 复制检验报告未重新加盖“检验检测专用章”和骑缝章无效。
5. 对检验报告若有异议，应于收到检验报告或结果通知十五日内向检验机构或有关部门书面提出，逾期提出无效。
6. 委托方将样品送到检验机构检验时，样品及其信息的真实性由委托方负责，检验机构仅对样品检验结果的准确性负责。



邮寄地址：河北省衡水市高新区橡塑路12号

邮政编码：053000

联系电话：0318-2143001

传 真：0318-2142339

检验地址：本单位检验活动涉及七个地址，具体为：

地址1：河北省衡水市高新区橡塑路12号（检验一、二、三、四区）；

地址2：河北衡水市桃城区邓庄乡武家庄村（检验五区）；

地址3：河北衡水市北方工业园区橡塑路16号（检验六区）；

地址4：河北省衡水桃城区北方工业基地园区东路9号（检验八区）；

地址5：河北衡水市北方工业园区橡塑路5号（检验七区）；

地址6：河北省衡水市冀州区高新技术产业开发区南区迎宾路南侧纬一路东侧（检验十五区）；

地址7：河北省衡水市高新区北方工业园区工业大街88-8号（检验十六区）。

## Notes

1. The report is invalid without “Inspection and Testing Stamp” and the seal perforation.
2. The report is invalid without signatures of teater, anditor or approver.
3. The report is invalid if altered.
4. The duplicated inspection report is invalid without the “Inspection and Testing Stamp” and the re-seal on the perforation.
5. If you have any objections to the inspection report, please proposed in writing to the inspection agency or relevant department within 15 days of receiving the report or natification result.
6. When the client sends samples to the inspection agency, the client is responsible for only the authenticity of the sample and its information, the agency is only responsible for the accuracy of the sample inpection results.

**Mailing Address:** No. 12 Xiangsu Road, High-tech Zone, Hengshui City, Hebei Province, China

**Post Code:** 053000

**Tel:** 0318-2143001

**Fax:** 0318-2142339

**Inspection address:** The inspection activities of the unit involve seven addresses, specifically:

Addr. 1: No. 12, Xiangsu Road, High-tech Zone, Hengshui City, Hebei Province, China.  
(Inspection Area 1, 2, 3 and 4)

Addr. 2: Wujiazhuang, Dengzhuang, Taocheng District, Hengshui City, Hebei Province, China.  
(Inspection Area 5)

Addr. 3: No. 16, Xiangsu Road, North Industrial Zone, Hengshui City, Hebei Province, China.  
(Inspection Area 6)

Addr. 4: No. 9, East Road, North Industrial Base Zone, Taocheng District, Hengshui City, Hebei Province, China. (Inspection Area 8)

Addr. 5: No. 5, Xiangsu Road, North Industrial Zone, Hengshui City, Hebei Province, China.  
(Inspection Area 7)

Addr. 6: South of Yingbin Road and east of Weiyi Road, South District, High-tech Industrial Development Zone, Jizhou District, Hengshui City, Hebei Province, China.  
(Inspection Area 15)

Addr. 7: No. 88-8, Industrial Street, Northern Industrial Park, High-tech Zone, Hengshui City, Hebei Province, China. (Inspection Area 16)