



Hangzhou Fulai Mechanical Parts Co., Ltd.

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www.mechanical-oem.com

RUBBER COATING PROCESS

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Step 1: NR compound blending

Step 2: Rubber mixing





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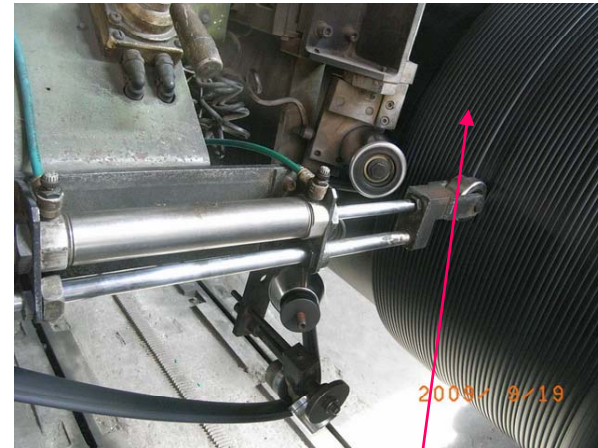
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Step 3: Rubber coating process



First lay coating



Second lay coating



Mixed
rubber

Rubber strip
injection

Coating
injection



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Step 4: Rubber curing process

As long as rubber is coated to rollers, and then it will be winded by strong strips in white.

Afterwards, rollers need to be steamed for curing in several hours.





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Step 5: Machining

CNC grinding machine
Dia.2m x Length 12m



Dynamic balancing machine
Length 12m / Max.loading 50T





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Step 6: Inspection

We will provide the inspection report attached for each rubber rollers.



Dimensional Evaluation Data Reporting Sheet

Submission No:		0							
Up No. / Tool #:									
Material Spec:		RUBBER							
.TOL	Inspection Method	INSPECTION RESULTS							
		Sample Number			Deviation from Nominal			Mean	UPI
		1	2	3	1	2	3		
0.01	千分尺	39.978			0.008			39.978	8%
0.01	千分尺	39.979			0.009			39.979	9%
0.00	百分表	0.010			0.010			0.010	2%
0.00	百分表	0.010			0.010			0.010	2%
0.03	千分尺	39.990			-0.010			39.990	0
0.00	百分表	0.010			0.010			0.010	2%
0.03	千分尺	69.985			-0.015			69.985	0
1.50	直径圈尺	179.600			-0.400			179.600	0
	直径圈尺	179.600			179.600			179.600	
	直径圈尺	179.580			179.580			179.580	
	直径圈尺	179.600			179.600			179.600	
	直径圈尺	179.620			179.620			179.620	
	直径圈尺	179.520			179.520			179.520	
	百分表	0.030			0.030			0.030	4%
	百分表	0.030			0.030			0.030	
	百分表	0.040			0.040			0.040	
	百分表	0.050			0.050			0.050	
	百分表	0.060			0.060			0.060	
	百分表	0.060			0.060			0.060	
3360	1.50	1.50	卷尺	3361.000			1.000	3361.000	6%
3856	0.00	0.50	卷尺	3855.500			-0.500	3855.500	0
ORE65	5.00	5.00	硬度仪						
NOTES				SAMPLE#1	SAMPLE#2	SAMPLE#3	Supplier		
				OK					