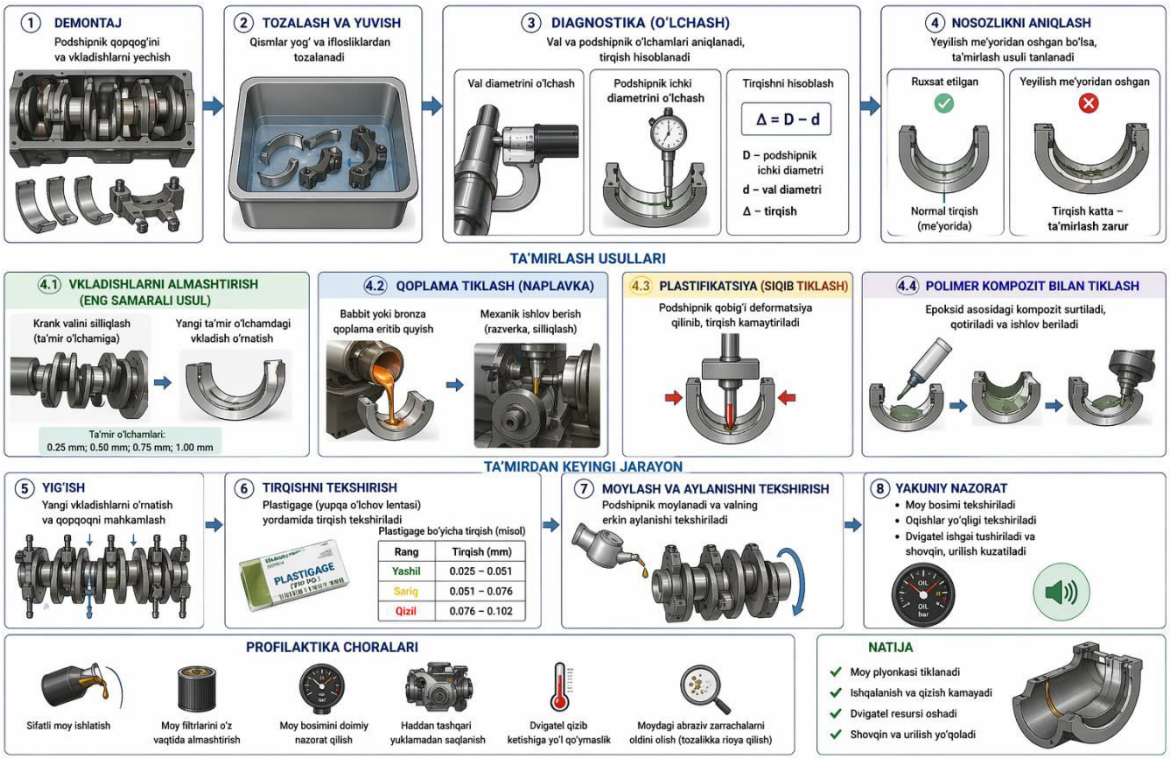
YEYILGAN SIRPANISH PODSHIPNIKLARNI TA’MIRLASH USULI

prof. Musabekov Z.E., mag. Urakov Xumoyun
Toshkent davlat texnika universiteti,
Tel.: +998 77 340 62 77

Sirpanish podshipniklari (vkladishlar) — bu val bilan bevosita ishqalanishda ishlaydigan tayanch element bo‘lib, ular tirsakli val tayanchlari, shatun podshipniklari, taqsimlash vali tayanchlarida qo‘llaniladi. Yeyilish natijasida tirqish ortadi, moy plyonkasi buziladi, qizish va shovqin paydo bo‘ladi.



1-rasm. Yeyilgan sirpanish podshipniklarni ta’mirlash texnologiyasi

Asosiy sabablar quyidagilar, moylash tizimi nosozligi, moy bosimining pasayishi, nopok moy (abraziv zarrachalar), yuklamaning ortishi, notekis yuk taqsimoti. Metall urilish ovozi, moy bosimining pasayishi, dvigatel qizishi mikrometr yordamida val diametrini o‘lchash, ichki diametrni indikator bilan aniqlash, tirqishni hisoblash:

$$\Delta = D - d$$

Bu yerda:

Δ— tirqish , D — podshipnik ichki diametric, d — val diametri

Standart yoki ta’mir o‘lchamdagi vkladish qo‘yiladi tirsak vali silliqlanadi (0.25; 0.5; 0.75 mm)

Babbitt yoki bronza qoplama qayta quyiladi - murakkab texnologiya-maxsus uskunalar talab etadi, mexanik ishlov beriladi.

Polimer kompozit bilan tiklash, zamonaviy usul kichik yeyilishlarda samarali. Sirpanish podshipniklarning yeyilishi dvigatel ishonchliligiga jiddiy ta’sir qiladi. Eng samarali ta’mirlash usuli — valni silliqlash va yangi vkladish o‘rnatish hisoblanadi. Zamonaviy texnologiyalar esa resursni yanada oshirish imkonini beradi.

Sirpanish podshipniklarning yeyilishi qayta tiklash jarayonlari:
Eski babbitni eritib olib tashlash, podshipnik qizdiriladi eski babbit metall eritilib chiqariladi, babbitt past haroratda eriydi, shu sababli bu jarayon oson amalga oshadi, tozalash va tayyorlash metall yuzalar yog‘ va kirlardan tozalanadi, bu yangi babbit qatlamining mustahkam yopishishini ta’minlaydi yangi babbit quyish eritilgan babbit maxsus qolip yoki to‘g‘ridan-to‘g‘ri podshipnikka quyiladi ba’zan markazlash uchun val o‘rnatiladi bu eng muhim bosqich — qatlam bir tekis bo‘lishi kerak mexanik ishlov, ichki diametr ishlov berilad kerakli tirqish hosil qilinadi, podshipnik val ustida moy plyonkasi bilan ishlashi uchun aniq o‘lcham kerak yig‘ish va prirabotka podshipnik yig‘iladi past yuklama va moy bilan ishlatib moslashtiriladi bu jarayon ish yuzasini tekislaydi va resursni oshiradi muhim texnologik nuqtalar babbitt — yumshoq qotishma u valni himoya qiladi.

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