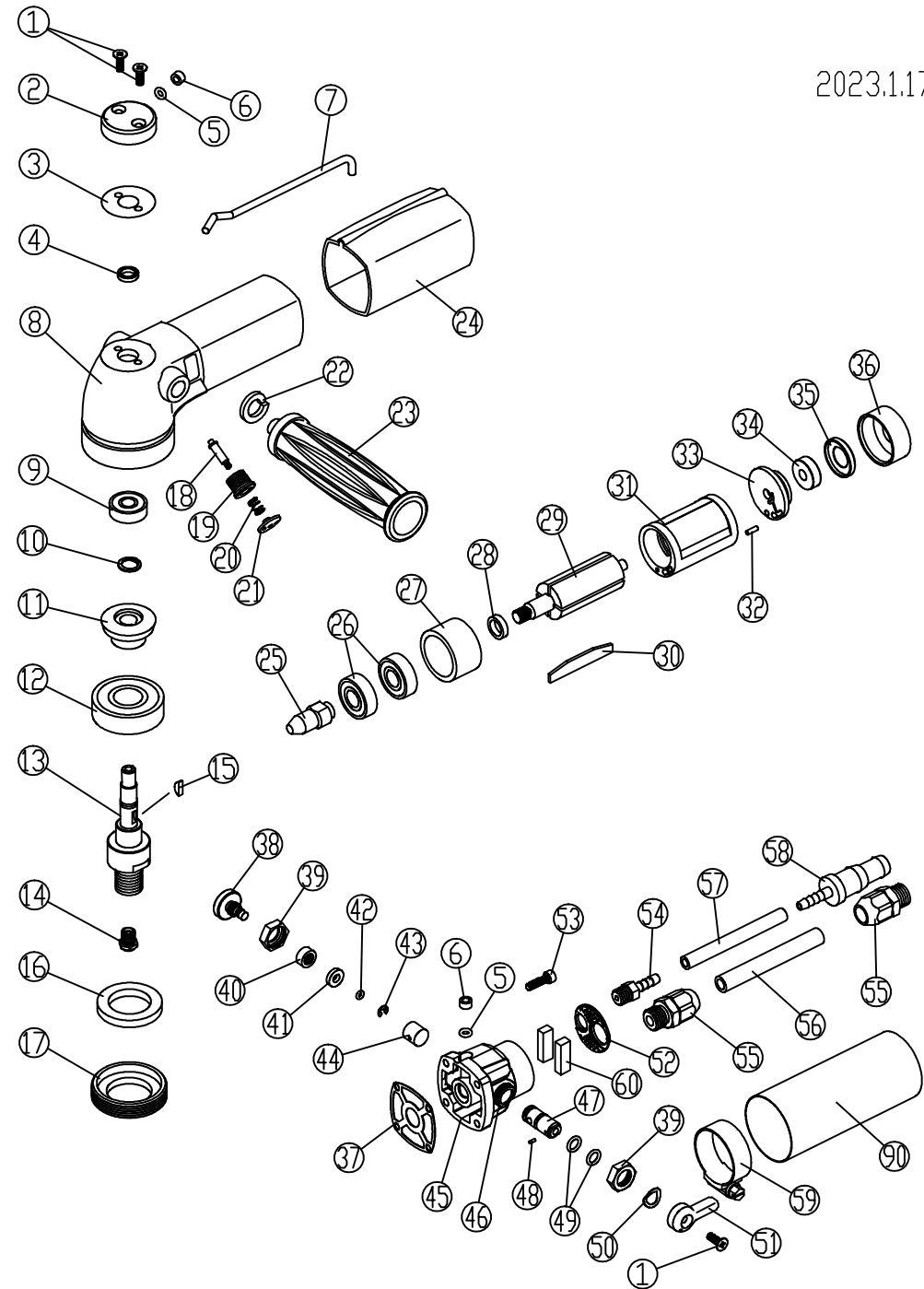
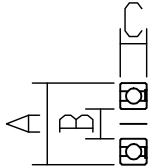
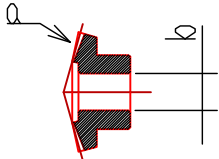
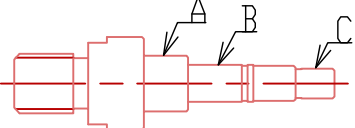
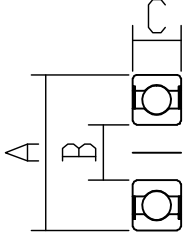
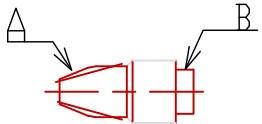
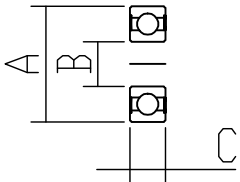
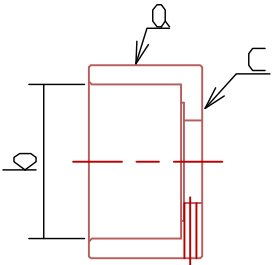


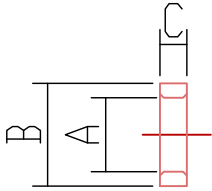
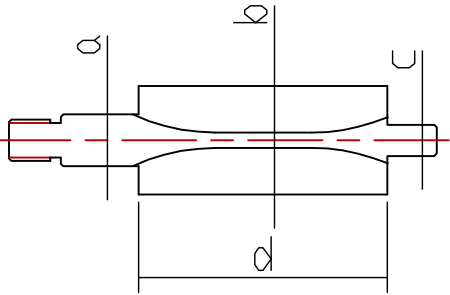
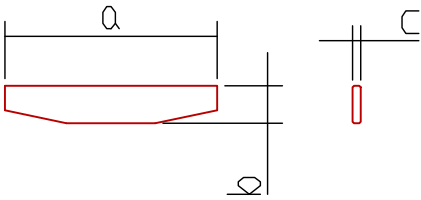
# WS 6 Repair Guide

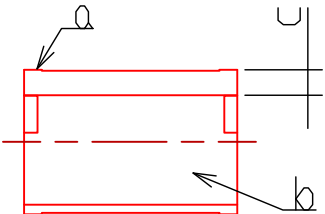
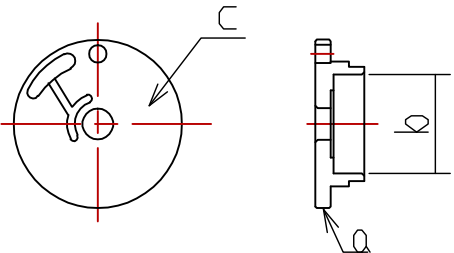
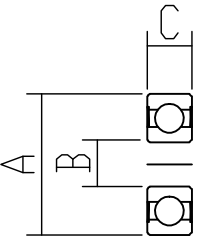
2023.1.17作成



Parts	Checkpoint 1	Checkpoint 2	Repair method												
<p>⑨ Bearing 608ZZ</p> 	<p>a. Check whether the inner and outer rings are spinning in a vortex</p> <p>b. Check whether there is wear and burn on the inner and outer circumference</p> <table border="1" data-bbox="678 395 1032 576"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>22</td> <td>-0.05</td> </tr> <tr> <td>B</td> <td>8</td> <td>+0.05</td> </tr> <tr> <td>C</td> <td>7</td> <td>-0.10</td> </tr> </tbody> </table>		standard size	Limits of use	A	22	-0.05	B	8	+0.05	C	7	-0.10	<p>a In case the inner and outer rings are not spinning smoothly.</p> <p>b1. In case there is wear on the inner and outer circumference.</p> <p>b2. In case there is burn on the inner and outer circumference.</p>	<p>a. Parts Replacement</p> <p>b1. Above the limit value, replace parts</p> <p>b2. Polish with paper</p>
	standard size	Limits of use													
A	22	-0.05													
B	8	+0.05													
C	7	-0.10													
<p>⑪ Bevel Gear</p> 	<p>a. Check whether there is chips or wear on the gear teeth</p> <p>b. Check there is wear, burn.</p> <table border="1" data-bbox="678 727 1032 863"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>1.0</td> <td>-0.3</td> </tr> <tr> <td>B</td> <td>φ 10</td> <td>+0.03</td> </tr> </tbody> </table> <p style="text-align: right;">Tooth tips</p>		standard size	Limits of use	A	1.0	-0.3	B	φ 10	+0.03	<p>a1. In case there is scratches,</p> <p>a2. In case there is wear</p> <p>b1. In case there is wear</p> <p>b2. In case there is burn</p>	<p>a1. Parts Replacement</p> <p>a2. Above the limit value, replace parts</p> <p>b1. Above the limit value, replace parts</p> <p>b2. Polish with paper</p>			
	standard size	Limits of use													
A	1.0	-0.3													
B	φ 10	+0.03													
<p>⑬ Spindle</p> 	<p>Check whether there are burn, wear</p> <table border="1" data-bbox="667 962 1037 1137"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>φ 15</td> <td>-0.02</td> </tr> <tr> <td>B</td> <td>φ 10</td> <td>-0.05</td> </tr> <tr> <td>C</td> <td>φ 6</td> <td>-0.05</td> </tr> </tbody> </table>		standard size	Limits of use	A	φ 15	-0.02	B	φ 10	-0.05	C	φ 6	-0.05	<p>In case there is wear</p> <p>In case there is burn</p>	<p>Above the limit value, replace parts</p> <p>Polish with paper</p>
	standard size	Limits of use													
A	φ 15	-0.02													
B	φ 10	-0.05													
C	φ 6	-0.05													
<p>⑨ Bearing 6302ZZ</p> 	<p>a In case the inner and outer rings are not spinning smoothly.</p> <p>b. Check whether there is wear and burn on the inner and outer circumference</p> <table border="1" data-bbox="674 1358 1048 1536"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>42</td> <td>-0.05</td> </tr> <tr> <td>B</td> <td>15</td> <td>+0.05</td> </tr> <tr> <td>C</td> <td>13</td> <td>-0.10</td> </tr> </tbody> </table>		standard size	Limits of use	A	42	-0.05	B	15	+0.05	C	13	-0.10	<p>a In case the inner and outer rings are not spinning smoothly</p> <p>b. In case there is wear on the inner and outer circumference.</p> <p>c. There is burn on the inner and outer circumference.</p>	<p>a. Parts Replacement</p> <p>b. Above the limit value, replace parts</p> <p>c. Polish with paper</p>
	standard size	Limits of use													
A	42	-0.05													
B	15	+0.05													
C	13	-0.10													

Parts	Checkpoint 1	Checkpoint 2	Repair method												
<p data-bbox="100 236 365 288">②5 Pinion gear</p> 	<p data-bbox="598 256 1137 373">a. Check whether there is chips or wear on the gear teeth b. Check there is wear, burn.</p>	<p data-bbox="1198 261 1491 440">a1. In case there is chips a2. In case there is wear b1. In case there is wear b2. In case there is burn</p> <table border="1" data-bbox="1184 451 1556 587"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>1.0</td> <td>-0.3</td> </tr> <tr> <td>B</td> <td>φ 10</td> <td>-0.03</td> </tr> </tbody> </table> <p data-bbox="1563 501 1671 536">Tooth tips</p>		standard size	Limits of use	A	1.0	-0.3	B	φ 10	-0.03	<p data-bbox="1693 256 2123 440">a1. Parts Replacement a2. Above the limit value, replace parts b1. Above the limit value, replace parts b2. Polish with paper</p>			
	standard size	Limits of use													
A	1.0	-0.3													
B	φ 10	-0.03													
<p data-bbox="100 651 465 703">②6 Bearing 6000ZZ</p> 	<p data-bbox="598 671 1137 879">a. Check whether the inner and outer rings are spinning in a vortex b. Check whether there is wear and burn on the inner and outer circumference</p>	<p data-bbox="1160 671 1664 887">a In case the inner and outer rings are not spinning smoothly. b1. In case there is wear b2. In case there is burn</p> <table border="1" data-bbox="1205 895 1599 1075"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>φ 26</td> <td>-0.03</td> </tr> <tr> <td>B</td> <td>φ 10</td> <td>+0.03</td> </tr> <tr> <td>C</td> <td>8</td> <td>-0.10</td> </tr> </tbody> </table>		standard size	Limits of use	A	φ 26	-0.03	B	φ 10	+0.03	C	8	-0.10	<p data-bbox="1697 676 2145 887">a, Parts Replacement b1. Above the limit value, replace parts b2. Polish with paper</p>
	standard size	Limits of use													
A	φ 26	-0.03													
B	φ 10	+0.03													
C	8	-0.10													
<p data-bbox="100 1152 376 1204">②7 front plate</p> 	<p data-bbox="598 1173 1111 1366">a. Check whether there is corrosion or scratches on outer circumference. b. Check whether the bearing is loose. c. Check whether there is burn, scratches, dent</p>	<p data-bbox="1167 1173 1646 1358">a. In case there is corrosion, scratches b. In case the bearing is loose c. In case there is burn, scratches, dent</p> <table border="1" data-bbox="1205 1369 1599 1506"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>a</td> <td>32.5</td> <td>-0.03</td> </tr> <tr> <td>b</td> <td>26</td> <td>+0.03</td> </tr> </tbody> </table> <p data-bbox="1256 1517 1518 1549">c The limit of dent -0.04</p>		standard size	Limits of use	a	32.5	-0.03	b	26	+0.03	<p data-bbox="1675 1173 2145 1366">a. within the limit value, Polish with paper b. Parts Replacement c. within the limit value, Polish with paper</p>			
	standard size	Limits of use													
a	32.5	-0.03													
b	26	+0.03													

Parts	Checkpoint 1	Checkpoint 2	Repair method															
<p data-bbox="107 240 454 292">28 Rotor spacer</p> 	<p data-bbox="607 244 1124 284">Check whether there is burn, scratches, wear</p>	<p data-bbox="1167 252 1626 292">In case there is scratches, burn</p> <p data-bbox="1167 304 1514 344">In case there is wear</p> <table border="1" data-bbox="1189 368 1630 547"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>A</td> <td><math>\phi 10</math></td> <td>+0.03</td> </tr> <tr> <td>B</td> <td><math>\phi 13.9</math></td> <td>-0.03</td> </tr> <tr> <td>C</td> <td>3.6</td> <td>-0.03</td> </tr> </tbody> </table>		standard size	Limits of use	A	$\phi 10$	+0.03	B	$\phi 13.9$	-0.03	C	3.6	-0.03	<p data-bbox="1688 260 1946 300">Polish with paper</p> <p data-bbox="1688 308 2130 347">Above the limit value, replace parts</p>			
	standard size	Limits of use																
A	$\phi 10$	+0.03																
B	$\phi 13.9$	-0.03																
C	3.6	-0.03																
<p data-bbox="107 624 304 675">29 Rotor</p> 	<p data-bbox="607 651 1124 691">Check whether there is burn, scratches, wear</p>	<p data-bbox="1167 667 1626 707">In case there is scratches, burn</p> <p data-bbox="1167 715 1491 754">In case there is wear</p> <table border="1" data-bbox="1196 786 1626 1010"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>a</td> <td><math>\phi 10</math></td> <td>-0.03</td> </tr> <tr> <td>b</td> <td><math>\phi 21</math></td> <td>-0.1</td> </tr> <tr> <td>c</td> <td><math>\phi 6</math></td> <td>-0.03</td> </tr> <tr> <td>d</td> <td>48</td> <td>-0.1</td> </tr> </tbody> </table>		standard size	Limits of use	a	$\phi 10$	-0.03	b	$\phi 21$	-0.1	c	$\phi 6$	-0.03	d	48	-0.1	<p data-bbox="1688 659 1912 699">Polish with paper</p> <p data-bbox="1680 707 2145 746">Above the limit value, replace parts</p>
	standard size	Limits of use																
a	$\phi 10$	-0.03																
b	$\phi 21$	-0.1																
c	$\phi 6$	-0.03																
d	48	-0.1																
<p data-bbox="107 1118 291 1169">30 Vane</p> 	<p data-bbox="607 1121 1124 1161">Check whether there are chips, cracking, wear.</p>	<p data-bbox="1182 1129 1648 1169">In case there are chips, cracking</p> <p data-bbox="1182 1177 1451 1217">In case there is wear</p> <table border="1" data-bbox="1193 1281 1637 1465"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>a</td> <td>47.8</td> <td>-0.5</td> </tr> <tr> <td>b</td> <td>8.4</td> <td>-0.5</td> </tr> <tr> <td>c</td> <td>1.8</td> <td>-0.2</td> </tr> </tbody> </table>		standard size	Limits of use	a	47.8	-0.5	b	8.4	-0.5	c	1.8	-0.2	<p data-bbox="1680 1137 1957 1177">a. Parts Replacement</p> <p data-bbox="1680 1185 2145 1225">b. Above the limit value, replace parts</p>			
	standard size	Limits of use																
a	47.8	-0.5																
b	8.4	-0.5																
c	1.8	-0.2																

Parts	Checkpoint 1	Checkpoint 2	Repair method												
<p><b>31 Cylinder</b></p> 	<p>a. Check whether there is corrosion or scratches on outer circumference.</p> <p>b. Check whether there is wavefront on the inner surface</p> <p>c. Check whether there is burn</p>	<p>a. In case there is corrosion or scratches on outer circumference</p> <p>b. In case there is wavefront on the inner surface.</p> <p>c. In case there is burn</p> <table border="1" data-bbox="1218 481 1615 616"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>a</td> <td>32.5</td> <td>-0.05</td> </tr> <tr> <td>c</td> <td>5.75</td> <td>-0.07</td> </tr> </tbody> </table>		standard size	Limits of use	a	32.5	-0.05	c	5.75	-0.07	<p>a. Polish with paper</p> <p>b. Parts Replacement</p> <p>c. Polish with paper</p>			
	standard size	Limits of use													
a	32.5	-0.05													
c	5.75	-0.07													
<p><b>33 Rear plate</b></p> 	<p>a. Check whether there is corrosion or</p> <p>b. Check whether the bearing is loose.</p> <p>c. Check whether there is burn, scratches, dent</p>	<p>a In case there is corrosion or scratches on outer circumference</p> <p>b. In case the bearing is loose</p> <p>c. In case there is burn, scratches</p> <table border="1" data-bbox="1223 900 1610 991"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>a</td> <td>32.5</td> <td>-0.05</td> </tr> </tbody> </table>		standard size	Limits of use	a	32.5	-0.05	<p>a Polish with paper</p> <p>b Parts Replacement</p> <p>c Polish with paper</p>						
	standard size	Limits of use													
a	32.5	-0.05													
<p><b>34 Bearing 626ZZ</b></p> 	<p>a. Check whether the inner and outer rings are not spinning smoothly</p> <p>b Check whether there is wear and burn on the inner and outer circumference.</p>	<p>a In case the inner and outer rings are not spinning smoothly</p> <p>b1. In case there is wear on the inner and outer circumference.</p> <p>b2. There is burn on the inner and outer circumference.</p> <table border="1" data-bbox="1240 1350 1632 1528"> <thead> <tr> <th></th> <th>standard size</th> <th>Limits of use</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>19</td> <td>-0.05</td> </tr> <tr> <td>B</td> <td>6</td> <td>+0.05</td> </tr> <tr> <td>C</td> <td>6</td> <td>-0.10</td> </tr> </tbody> </table>		standard size	Limits of use	A	19	-0.05	B	6	+0.05	C	6	-0.10	<p>a Parts Replacement</p> <p>b1 Above the limit value, replace parts</p> <p>b2. Polish with paper</p>
	standard size	Limits of use													
A	19	-0.05													
B	6	+0.05													
C	6	-0.10													