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**Rolling bearings — Needle roller
bearings, dimension series 48, 49
and 69 — Boundary dimensions and
tolerances**

**AMENDMENT 1: Tolerances for shaft
raceway**

*Roulements — Roulements à aiguilles, séries de dimensions 48, 49 et
69 — Dimensions d'encombrement et tolérances*

AMENDMENT 1: Tolérances du chemin de roulement de l'arbre



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The committee responsible for this document is ISO/TC 4, *Rolling bearings*, Subcommittee SC 5, *Needle, cylindrical and spherical roller bearings*.

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Rolling bearings — Needle roller bearings, dimension series 48, 49 and 69 — Boundary dimensions and tolerances

AMENDMENT 1: Tolerances for shaft raceway

Page 1, Scope

Add the following sentence at the end of the scope: "Recommended values for the tolerances for shaft raceways for needle roller bearings without inner ring are given in Annex A."

Page 8, Clause 7

Insert the following new Annex A after Clause 7.

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Annex A (informative)

Tolerances for shaft raceways for needle roller bearings without inner ring

A.1 General

Proper function of needle roller bearings without inner rings depends on the shaft raceway supplied by the user. This annex shows suggested tolerances for shaft raceway.

Table values are informative only. In all cases, users should check the installed bearing clearance.

A.2 Raceway hardness and case-hardened depth

The shaft raceway is hardened and finish ground; surface hardness is minimum 670 HV (58 HRC).

In the case of using case hardening bearing steel, case-hardened depth of raceway is minimum of 0,3 mm to 0,8 mm, depending on bearing size, rolling element diameter, shaft heat treatment method and load condition. If in doubt, consult the bearing manufacturer for specific advice. Case-hardened depth should be in accordance with ISO 2639:2002, 3.1.

A.3 Tolerances for shaft raceways

Table A.1 shows suggested tolerances for shaft raceways for needle roller bearings without inner ring.