



BSI Standards Publication

Plain bearings — Quality assurance of thin-walled half bearings — Selective assembly of bearings to achieve a narrow clearance range

National foreword

This British Standard is the UK implementation of ISO 13778:2017. It supersedes BS ISO 13778:1999, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee MCE/12, Plain bearings.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

© The British Standards Institution 2017
Published by BSI Standards Limited 2017

ISBN 978 0 580 92912 0

ICS 21.100.10

Compliance with a British Standard cannot confer immunity from legal obligations.

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 30 April 2017.

Amendments/corrigenda issued since publication

Date	Text affected
------	---------------

INTERNATIONAL STANDARD

ISO
13778

Second edition
2017-03-15

Plain bearings — Quality assurance of thin-walled half bearings — Selective assembly of bearings to achieve a narrow clearance range

*Paliers lisses — Assurances qualité des demi-coussinets minces —
Assemblage sélectif des paliers pour obtenir un jeu faible*



Reference number
ISO 13778:2017(E)
Documents
Document Sharing Hub
© ISO 2017



COPYRIGHT PROTECTED DOCUMENT

© ISO 2017, Published in Switzerland

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

Contents

Page

Foreword	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Housing swell and thermal expansion	2
5 Measurement and identification	2
5.1 Housings and journals.....	2
5.2 Bearings.....	2
6 Suggested schemes for fitting	3
6.1 General.....	3
6.2 Scheme 1: Standard application, without grading.....	3
6.3 Scheme 2: Grading of bearings.....	4
6.4 Scheme 3: Grading of bearings and journals or housings.....	4
6.5 Scheme 4: Unmixed bearings (Matrix scheme).....	5
6.6 Scheme 5: Mixed bearings (Matrix scheme).....	6
6.7 Scheme 6: Mixed bearings (fine matrix).....	6