



Designation: F2246 – 06 (Reapproved 2022)

Standard Specification for Bearing, Roller, Needle: Thick Outer Ring With Rollers and Cage¹

This standard is issued under the fixed designation F2246; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This specification covers needle roller bearings having thick outer rings, with rollers and cages.

1.2 The bearings being specified are intended to be used with hardened shafts (HRC58-65; see Test Methods E18). For use with unhardened shafts, bearings should be used in conjunction with inner bearing ring MS51962 as specified in Specification F2431 and shown as MS500072 bearing assemblies in Specification F2430.

1.3 The use of recycled materials that meet the requirements of the applicable material specification without jeopardizing the intended use of the item is encouraged.

1.4 Bearings designed to this specification are intended for use in applications requiring high radial load with minimal angular shaft misalignment.

1.5 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

NOTE 1—This specification contains many of the requirements of MS51961 which was originally developed by the Department of Defense and maintained by the Defense Supply Center Richmond.

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

¹ This specification is under the jurisdiction of ASTM Committee F34 on Rolling Element Bearings and is the direct responsibility of Subcommittee F34.04 on Automotive/Industrial Bearing.

Current edition approved Jan. 1, 2022. Published August 2022. Originally approved in 2003. Last previous edition approved in 2013 as F2246 – 06(2013). DOI: 10.1520/F2246-06R22.

2. Referenced Documents

2.1 ASTM Standards:²

E18 Test Methods for Rockwell Hardness of Metallic Materials

F2430 Specification for Bearing, Roller, Needle: Assembly (Thick Outer Race)

F2431 Specification for Ring Bearing, Inner: For Needle Roller Bearing with Thick Outer Ring

2.2 ANSI Standard:³

ANSI B46.1 Surface Texture (Surface Roughness, Waviness, and Lay)

2.3 SAE Standards:⁴

SAE J-404 Chemical Compositions of SAE Alloy Steels

**SAE AMS-STD-66 Steel: Chemical Composition and Hard-
enability**

2.4 Military Standards:⁵

MIL-STD-130 Identification Marking of U.S. Military Property

MS500072 Bearing, Roller, Needle: Assembly (Thick Outer Race)

MS51961 Bearing, Roller, Needle: Thick Outer Ring with Rollers and Cage

MS51962 Ring Bearing, Inner: For Needle Roller Bearing with Thick Outer Ring

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

⁴ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001.

⁵ Available from DLA Document Services, Building 4/D, 700 Robbins Ave., Philadelphia, PA 19111-5094, <http://quicksearch.dla.mil>.

2.5 American Bearing Manufacturers Association Standard:⁶

ABMA 18.1 Needle Roller Bearings Radial, Inch Design

2.6 International Organization for Standardization Standards:⁷

ISO 492 Rolling Bearings—Radial Bearings—Tolerances

ISO 3096 Rolling Bearings—Needle Rollers—Dimensions and Tolerances

ISO 5593 Rolling Bearings—Vocabulary

3. Terminology

3.1 *Definitions*—For definitions of terms used in this specification, refer to ISO 5593, Rolling Bearings—Vocabulary.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *average life (L_{50})*—for a radial roller bearing, the number of revolutions that 50 % of a group of bearings will complete or exceed before the first evidence of fatigue developments.

3.2.1.1 *Discussion*—The average life is approximately five times the rating life.

3.2.2 *basic dynamic load rating (C_r)*—for a radial roller bearing, that calculated, constant radial load that a group of apparently identical bearings with stationary outer rings can theoretically endure for a rating life of one million revolutions of the inner ring.

3.2.2.1 *Discussion*—Since applied loading as great as the basic dynamic load rating tends to cause local plastic deformation of the rolling surfaces, it is not anticipated that such heavy loading would normally be applied.

3.2.3 *basic static load rating (C_{or})*—for a radial roller bearing, that uniformly distributed static radial load which produces a maximum contact stress at the center of the most heavily loaded rolling element contact of 580 000 psi (4000 Mpa).

3.2.3.1 *Discussion*—For this contact stress, a total permanent deformation of roller element plus raceway occurs, which is approximately 0.0001 of the roller diameter.

3.2.4 *rating life (L_{10})*—for a radial roller bearing, the number of revolutions that 90 % of a group of bearings will complete or exceed before the first evidence of fatigue developments.

4. Ordering Information

4.1 When ordering parts in accordance with this specification, specify the following:

4.1.1 ASTM designation number, including year of issue,

4.1.2 Dash number (see Table 1),

4.1.3 Dimensions of roller bearings, including:

4.1.3.1 Bore diameter, in. (mm),

4.1.3.2 Outside diameter, in. (mm),

4.1.3.3 Width, in. (mm), and

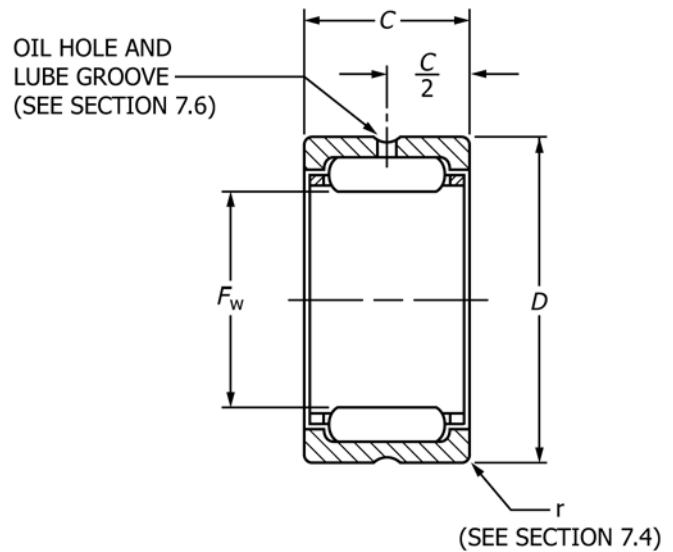


FIG. 1 Schematic Drawing—Roller Bearing

4.1.3.4 Radius, in. (mm),

4.1.4 Load rating, including basic static load rating, lb (N) and basic dynamic load rating, lb (N), and

4.1.5 Approximate limiting speed, rpm.

5. Materials and Manufacture

5.1 *Rollers*—Rollers shall be manufactured of steel, alloy, grade E50100, E51100 or E52100 in accordance with SAE AMS-STD-66 or SAE J-404.

5.2 *Rings*—Rings shall be manufactured of steel, alloy or carbon, carburizing grade 4620, 4720, 8620, 8720, or 1010-1020 in accordance with SAE AMS-STD-66 or SAE 51100 or SAE 52100 in accordance with SAE J-404.

5.3 *Cages*—Cages shall be manufactured of steel, brass, or bronze, or other material in accordance with manufacturer's standards.

6. Other Requirements

6.1 *Heat Treatment:*

6.1.1 *Rollers*—Rollers shall be through hardened to Rockwell HRC58-66 in accordance with Test Methods E18.

6.1.2 *Rings:*

6.1.2.1 Steel 4620, 4720, 8620, 8720, and 1010-1020 shall be case hardened to Rockwell HRC58-65, in accordance with Test Methods E18. Case depth shall be 0.025 in. (0.64 mm) minimum.

6.1.2.2 Steel SAE 51100 and SAE 52100 shall be through hardened to Rockwell HRC58-65, in accordance with Test Methods E18.

6.2 *Protective Coating:*

6.2.1 Bearings shall be furnished without plating.

6.2.2 Manufacturer shall coat bearings with rust preventive film.

6.3 *Lubrication*—Bearings shall be furnished without lubrication.

⁶ Available from Techstreet, 1327 Jones Drive, Ann Arbor, MI 48105.

⁷ Available from International Organization for Standardization (ISO), ISO Central Secretariat, Chemin de Blandonnet 8, CP 401, 1214 Vernier, Geneva, Switzerland, <https://www.iso.org>.