



RETRACED FROM DRG. No. M45-0468F TO M45-0472F
FOR HISTORY OF REVISIONS PLEASE REFER ORIGINAL DRAWING NOW NTI.

S.K. Bhattacharya
(S.K. BHATTACHARYA) (J.P. SINGH)
DGM-PLD (N.K. JHA)
DGM-PLD

TECHNICAL INSTRUCTIONS

1. THESE IDLERS SHALL BE OF LIFE SEAL DESIGN WITHOUT ANY NEED FOR RE-GREASING.
2. BEARING SHALL BE OF SEIZE RESISTANT TYPE BBIB 420206 (30x62x14) OF 'SKF' OR EQUIVALENT OF 'FAG', 'TIMKEN', 'NTN', 'NSK', 'KOYO' & 'SNR' MAKE.
3. DIMENSIONS GIVEN IN THE DRAWING SHALL BE STRICTLY ADHERE TO & NO DEVIATION SHALL BE PERMITTED.
4. RADIAL RUN-OUT OF THE IDLER SHALL NOT BE MORE THAN 0.5 mm AT ANY POINT ALONG THE SHELL LENGTH.
5. ROLLER SHOULD ROTATE FREELY AND SMOOTHLY BY HAND ON ITS AXIS.
6. MAXIMUM PERMISSIBLE LATERAL MOVEMENT OF ROLLER IS 0.5 MM.
7. BLANK SPACE WITHIN SHIELD, LABYRINTH SET, HOUSING COVER AND BUSH SHALL BE FILLED UP WITH LITHIUM BASED LUBRICATING GREASE *of specified make*
8. THE NAME OF THE MANUFACTURER TO BE EMBOSSED AS SHOWN IN END VIEW OF THE DRAWING.
9. THE CONCENTRICITY OF BEARING HOUSING W.R.T. PIPE TO BE MAINTAINED AS SHOWN.
10. THE CHEMICAL COMPOSITION OF 45C8 IS: 7283-92 WILL BE AS PER IS 1570(PART-2/SEC-1)-1979
11. BEARING MUST NOT BE HEATED PRIOR TO MOUNTING & MUST ON NO ACCOUNT BE WASHED

TABLE

MELT WIDTH	TYPE	DIMENSIONS			SPINDLE		PIPE		ASSEMBLY	
		L	L1	L2	DRG.NO.	WT.KG	DRG.NO.	WT.KG	DRG.NO.	WT.KG
1600	BB-R-17-2	1800	1820	1870	M45-0477D	11.12	M45-0482D	35.24	M45-0472F	49.20
✓ 1400	BB-R-16-2	1600	1620	1670	M45-0476D	9.62	M45-0481D	31.32	M45-0471F	43.78
✓ 1200	BB-R-15-2	1400	1420	1470	M45-0475D	8.23	M45-0480D	27.4	M45-0470F	38.47
1000	BB-R-14-2	1150	1170	1220	M45-0474D	6.52	M45-0479D	22.51	M45-0469F	31.87
800	BB-R-13-2	950	970	1020	M45-0473D	5.81	M45-0478D	18.60	M45-0468 F	27.25

DRG.NO.	POS. NO.	DESCRIPTION	QTY.	UNIT	TOTAL WT. IN KG.	MATERIAL	REMARKS
-	-	WELD METAL	-	-	0.020	M.S.	
M45-0466 B	13	END CAP	2	0.500	1.000	CI FG200 IS:210-93	
IS:2155-82	12	SNAP HEAD RIVET #6	2	0.008	0.016	HR BAR IS:148-82	
M45-0465	11	BUSH	2	0.006	0.012	NYLON-6	
M45-0464 B	10	HOUSING COVER	2	0.039	0.078	ORA EN SHEET IS:513-86	
M45-0463 B	9	OUTER LABYRINTH	2	0.015	0.030	NYLON-6	
M45-0462 A	8	INNER LABYRINTH	2	0.016	0.032	NYLON-6	
IS:2507-75	7	CIRCLIP LIGHT A30	2	0.012	0.024	BOC6 IS:2507-75	
BBIB 420206	6	SEIZE RESISTANT BALL BEARING 30x62x14	2	0.180	0.360	STD	SEE TI-2
M45-0467 E	5	DUST COVER	2	0.004	0.008	NYLON-6	
M45-0460 C	4	SHIELD	2	0.012	0.024	NYLON-6	
M45-0459 A	3	BEARING HOUSING	2	0.63	1.26	ORA EN SHEET IS:513-86	
SEE TABLE	2	PIPE (ERW)	1	SEE TABLE	SEE TABLE	YSE 240 IS:9295-93	
SEE TABLE	1	SPINDLE	1	SEE TABLE	SEE TABLE	45C8 IS:7283-92	

DRG.NO.	POS. NO.	DESCRIPTION	QTY.	UNIT	TOTAL WT. IN KG.	MATERIAL	REMARKS
-	-	BOTTOM ROLLER ASSY.	1	SEE TABLE	ASSLY.	-	11 SEE TABLE

BOKARO STEEL PLANT	
SHOP	CD&BPP, RMHP, SP & BF
UNIT	BOTTOM ROLLERS
DESCRIPTION OF DRAWING	BOTTOM ROLLER #152.4mm
DRAWN	K.K.SINGH
CHECKED	J.P.SINGH
SUBMITTED	J.SINGH
RECOMMENDED	C.P.MISTRY
APPROVED	
DATE	OCT.-97
JOB NO.	8730
M45-0468F TO M45-0472F	

AGREED TO
(Signature)
(BB RAM, DGM/HM(M))

RECOMMENDED BY
(Signature)
(S.MOHAN, GM(MECH))

APPROVED
(Signature)
(K.D.TRIVEDI, GM(M&U))

REVISIONS			
DATE	SYMB	NAME	SIGN.