

IDLER ROLLER - DATA SHEET

Sl. No.	Item Description	Specification
1	Carrying Idlers 152.4 x 670 x 30.15 as per IS : 8598, 1987, Latest Revision	
1.1	Steel tubes for Idler shell	ERW pipe (confirming to IS: 9295, (YST-210)-1983, Latest Revision) Nominal Dia. 152.4 mm , Length 670+/-1 mm Nominal Thickness : 4.5 mm without negative thickness. Maximum radial run out ± 0.8 mm (TIR 1.6 mm as per IS : 8598-1987) Preferred Make : TATA / SAIL / JINDAL / NEZONE / UTKARSH / PSST
1.2	Tolerance Limit	± 0.5 mm tolerance along face width.
1.3	Spindle	The spindle shall be made of EN-8/C-40/C-45 BRIGHT BAR AS PER BS:970-1983/IS:1570-1979. The bearing portion of the spindle shall be ground to ($\Delta\Delta\Delta$) finish
1.4	Bearings	The bearings shall be deep groove ball bearing 6206-Z (C3 clearance) Make : SKF / FAG L10 Bearing Life Shall be > 40,000 hrs
1.5	Bearing Housing	The bearing Housing shall be made of Extra deep drawn quality CRCA Sheet, as per IS : 1079 Minimum Sheet Thickness : 3.15 mm Bearing housing edge shall be atleast 5 mm inwards of idler edge The bearing shall be press fit. The interference fit over race shall be M7. The bearing housing shall be welded carefully to avoid distortion
1.6	Circlip	External Circlip as per IS : 3075, Material: A30/Spring Steel (Heavy Duty)
1.7	Seals - Inner & outer labyrinth, - Inner back seal & - Rain Cap	The idlers shall be provided with multi labyrinth seals to prevent ingress of dust & moisture into the bearing housing. Seal Material : Nylon-6
1.8	Lubrication	The bearings shall be packed with Lithium based grease with water repellent & high flash point characteristics. Sealed for Life.
1.9	Dust Cover/End Cap (outer Seal)	Shall be made of Extra deep drawn quality CRCA Sheet, 0.8mm thick, as per IS : 513 (Galv.)
1.1	Interchangeability	The idlers shall be made with close tolerance to have 100% interchangeability
1.11	Painting	Thorough cleaning of the surface Painting of two coats of Light Grey Zinc Chromate as per IS : 2074 / IS 12744 Followed by two coats of Synthetic enamel paint as per IS : 2932 (epoxy content 15-18% by wt.) Dry film thickness per coat > 35 μ mm, Total DFT > 120 μ mm The temperature resistance of the paint shall be > 120 °C Colour : Smoke Grey (RAL 692) / Air Craft Grey (RAL 693)
12.1	Marking	Embossing / Punching on each idler on Outer cover (OPGC 2019 C), Letter Size about 10 mm