

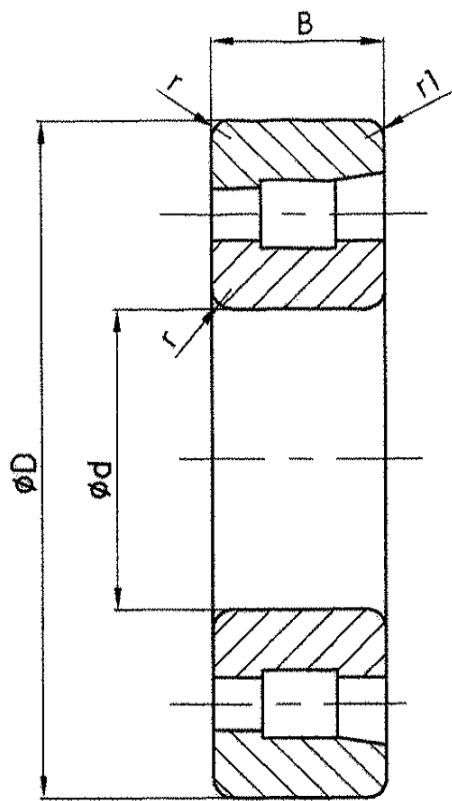
| BEARING DESIGNATION | ød | øD | B | r | r1 | LIMIT DEVIATIONS IN MICRON AS PER GOST-520-71. | | | | | CLASS OF ACCURACY (GOST ETY-500) | EQUIVALENT BEARING | | |
|---------------------|----|-----|----|-----|-----|--|-------|----------------|-------|----------------------------|----------------------------------|--------------------|---------------------------------------|---|
| | | | | | | DIAMETER OF 'd' CYLINDRICAL HOLE | | WIDTH OF RING. | | VARIABLE WIDTH OF RING UP. | | | RADIAL RUN OUT OF ROLLING TRACK, Max. | RUN OUT OF FACE IN RELATION TO HOLE SIZE. |
| | | | | | | LOWER | UPPER | LOWER | UPPER | | | | | |
| @ 12308 | 40 | 90 | 23 | 2.5 | 2.5 | -12 | 0 | -120 | 0 | 20 | 15 | 20 | 0 | HMT/NF-308 |
| * 92412 Ж | 60 | 150 | 35 | 3.5 | 3.5 | -15 | 0 | -150 | 0 | 25 | 20 | 25 | 0 | SKF/NUP412/M/C3 |

* ALTERNATE BEARING FOR 92412 Ж IS SKF/NUP412/M/C3.
 AUTHORITY:- CQA(HV), AVADI LETTER NO. 98704/04/ID-COORD/ALT.COM.
 DATED: 17-03-2007.

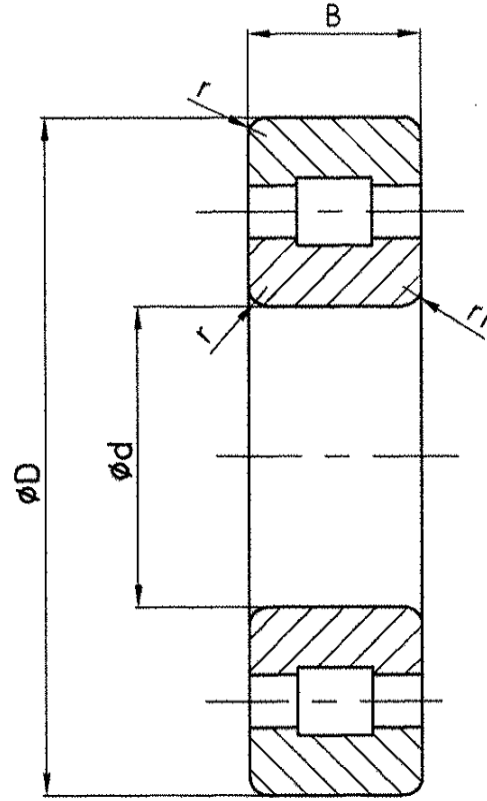
@ ALTERNATE BEARING FOR 12308 IS HMT/NF-308,
 AUTHORITY:- CQA(HV), AVADI,
 LETTER NO. 98704/04/ID-COORD/
 ALT.COM.
 DATED: 17-03-2007.

THIS SKETCH ALONG WITH ALL DETAILS IS AN ABSTRACT BASED ON GOST-8328-75

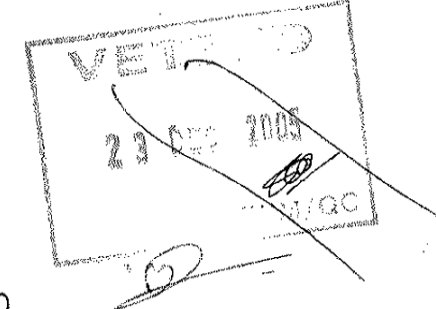
| ELEMENT | CHEMICAL COMPOSITION | |
|---------|----------------------|-------------|
| | STEEL Ш X 15 | SAE 52100 |
| % C | 0.95 - 1.05 | 0.95 - 1.10 |
| % Si | 0.17 - 0.37 | 0.20 - 0.35 |
| % Mn | 0.20 - 0.40 | 0.25 - 0.45 |
| % Cr | 1.30 - 1.65 | 1.30 - 1.60 |
| % S | 0.02 MAX | 0.025 MAX |
| % P | 0.027 MAX | 0.025 MAX |
| % Ni | 0.30 MAX | ---- |
| % Cu | 0.25 MAX. | ---- |
| % Ni+Cu | 0.50 MAX | ---- |



TYPE: 12308
 WITH SINGLE-RIMMED
 OUTER RING



TYPE: 92412 Ж
 WITH SINGLE-RIMMED INNER
 RING AND FLAT THRUST RING



ALT. MATL:- SAE 52100
 AUTH:- CQA(HV) LETTER NO. 98704/04/ID-CO-ORD/ALT COM
 DATED 03.05.2005

HARDNESS: RC 61-65

NOTES:-

- BEARING SHOULD BE FREE FROM CRACKS, CORROSION AND ALSO GRINDING BURRS IN THE SHAPE OF SPOTS OF SECONDARY HARDENING AND SECONDARY TEMPERING.
- BEARING PARTS SHOULD BE DEMAGNETISED.
- SURFACE QUALITY IS INSPECTED BY NON-DESTRUCTIVE METHODS.
 SURFACE QUALITY MAY BE CHECKED WITHOUT THE USE OF MAGNIFYING DEVICES.
- ABSENCE OF SHRINK HOLES MAY BE CHECKED ON DISCS, CUT FROM TWO ENDS OF A ROD OR BUNDLE, BY THE MAGNETIC METHOD.

इन आरेखणों तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक की लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण या इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नहीं कराई जानी चाहिए।

THE COPYRIGHT OF THESE DRAWINGS AND ALL ATTACHMENTS THERE TO BELONGS TO THE INDIAN ORDNANCE FACTORIES, MINISTRY OF DEFENCE, GOVT. OF INDIA THEY SHOULD NOT BE COPIED, REPRODUCED IN ANY WAY OR THE INFORMATION CONTAINED THEREIN MADE AVAILABLE TO UNAUTHORISED PERSONS WITHOUT THE WRITTEN PERMISSION OF THE DIRECTOR OF ORDNANCE FACTORIES.

मूलमाप व अन्वयोजन
 NOMINAL SIZE & FIT

विचलन
 DEVIATION

| RADIAL ROLLER BEARINGS | | Ш X 15 | GOST 801-78 | परिमाणु | अभ्यक्ति |
|--|-------------------|-----------------------------|-------------------------------|------------|--|
| संख्या | विवरण | पुर्जा क्र. | पदार्थ | मानक | परिमाणु |
| NO.OFF | DESCRIPTION | PART NO. | MATERIAL | STANDARD | DIMENSIONS |
| | सामान्य सहिष्णुता | | * Alternate Bearing added | | |
| | रेखिक परिमाण | | @ Alternate Bearing added. | | |
| | रेखिक परिमाण | | b) OR UPTO DATED ON. 1.7.2011 | | |
| | 0-6 | ±0.1 | | | |
| | 6-30 | ±0.2 | | | |
| | 30-120 | ±0.3 | | | |
| | 120-315 | ±0.5 | | | |
| | 315-1000 | ±0.8 | | | |
| | 1000-2000 | ±1.2 | | | |
| कोणिक परिमाण | संख्या | संबंधित पुर्जा क्र. | सूचक | संशोधन | 2005 |
| ANGULAR DIMENSION | NO.OFF | DRG. NO. OF ASSOCIATED PART | INDEX | ALTERATION | DATE |
| 1-10 | ±1' | | | | |
| 10-50 | ±30' | | | | |
| 50-100 | ±20' | | | | |
| > 100 | ±10' | | | | |
| RADIAL ROLLER BEARINGS TRANSMISSION GEAR UNIT CODE-45 / T-90 & T-72 | | | | | मापमान SCALE NTS |
| मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH | | | | | आरेखित DRAWN 20.09.05 जाँचा CHECKED 23.12.05 अनुमोदित APPROVED 23.12 |
| द्वारा बदला REPLACED BY | | | | | हेतु बदला REPLACED FOR |
| कार्यालय OFFICE D.O | | | | | आरेखण क्र. DRAWING NO. MPF/IGB/8328 |