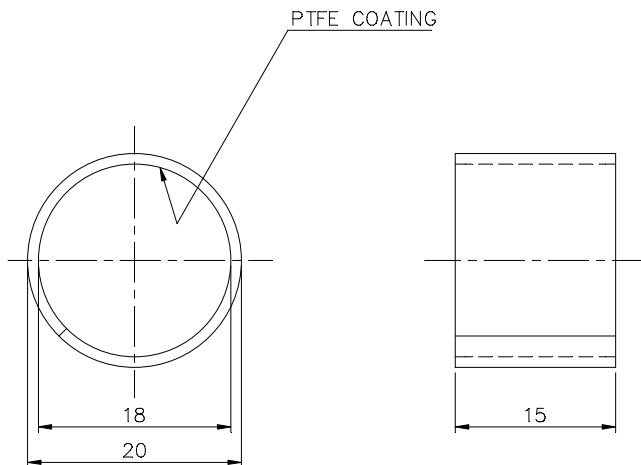


1759029/2023/HEP-SWM20961



NOTES: -

1. INNER SURFACE OF THE BUSH IS COATED WITH PTFE. THE BUSH IS NOT PERMITTED TO BE REAMED.
2. THE INNER DIA. OF THE BUSH IS SIMULTANEOUSLY THE NOMINAL DIA. OF THE RELEVANT SHAFT. HOLE TOLERANCE OF THE SHAFT-h9.
3. THE OUTER DIA. OF THE BUSH IS SIMULTANEOUSLY THE NOMINAL DIA. OF THE RELEVANT HOUSING. TOLERANCE OF THE HOLE-h7
4. THIS IS PROPRIOTORY ITEM OF M/s KARL-SCHMIDT-GMBH NECKAR SLUM/WURLT, WEST-GERMANY.

STYLE NO.: - BP 9099436530

MATERIAL: -

Cu Sn8

35211001657-R02-S01		SN60844-422121		REF. DRG. NO.	
SIGN. & DATE		INVENTORY NO.		REV.	
DATE		DATE		DATE	
REV. 02		REV. 01		REV. 01	
DATE 5.11.03		DATE 30.4.96		DATE 30.4.96	
ALTERED		ALTERED		ALTERED	
CHECKED		CHECKED		CHECKED	
APPROVED		APPROVED		APPROVED	
DRAWING REDRAWN.		DRG. RETRACED.		DRG. RETRACED.	
ST. NO. CHANGED TO BP NO.		MATL. SPECN. ADDED.		MATL. SPECN. ADDED.	
(DCA.20218)		(DCA : 07683)		(DCA : 07683)	
ADDITIONAL INFORMATION		STATUS OF DRAWING		DISTRIBUTION OF PRINTS	
OC -1		SWGR -3		TCX -1	
mRikn dk i-dkj ;k		xk-gd@fj;kstuk dk uke		TYPE OF PRODUCT OR	
NAME OF CUSTOMER/PROJECT		V.C.B		HAKjr gsoh bysfDV&dYl fyfeVsM	
HAKsiky		BHARAT HEAVY ELECTRICALS LTD.		BHOPAL	
P.PARE		MZG/GMK		RKG	
20.11.85		21.11.85		21.11.85	
vis_ M&kbZax dk lanHAZ		REF. TO ASSY. DRG.		3 521 10 01556	
en d- ITEM NO.		012		001	
en_ la; k		NO. OF		ITEM	
vksjs[A d- DRAWING NO.		3 521 10 01657		02	
i="B d- SH. No. 01		i="Bksa dh la; NO. OF SH. 01			

759029/2023/HEP-SWM20961		<div><div></div><div>PRODUCT STANDARD SWITCHGEAR ENGINEERING DIVISION</div></div>		SG 12706 REV.01	
				PAGE 1 OF 3	
		SPECIFICATION FOR DU(B) – BUSH			
		Drg No. 35211001657 item 001 Style No.ST 943653			
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited It must not be used directly or indirectly in any way detrimental to interest of Co.		1. Application:			
		The DU(B) - Bush is used in closing spring assembly of Vacuum Circuit Breaker operating mechanism. The application of the bush is for maintenance free operation at location of inadequate lubrication and corrosion protection is of prime importance.			
		2. Type :			
		The DU(B) - Bush is a plain dry bearing with bronze (cusn8) strip backing and PTFE coating on its inner surface. The construction of the DU (B) - Bush is as shown in fig:			
				PTFE Layer (5 to 30um) Tin Bronze Impregnated layer (0.2 to 0.35 mm) Bronze (cusn8) backing Effective wall (t) Thickness (0.980 to 1.005mm)	
		The Dimensions of the bush are:			
		1) d1 = 18 mm 2) d2 = 20 mm L = 15+ 0.25 mm Weight= 7 gms.			
		Tolerences for d2 corospond to values given in DIN 1494 part I. The method out lined in DIN 1494 part 2 should be used to check these tolerance.			
		The inner diameter of the bush is the nominal diameter of the relevant shaft ; Tolerance of the shaft is h8 (- 0.016) (- 0.034).			
		1) The outer diameter of the bush is the nominal diameter of the relevant housing hole ; Tolerance of the housing hole is H7 (+ 0.000) (+ 0.021)			
		REV.	01	PRINTS TO :-	
		ALTD.	SMM	SWM(P)	
		APPD.	VR	QCX	
		DATE.	13.10.95	HVD	
				MCD	
				APPROVED –	
				VVN	
				PREPARED	ISSUED
				SMM	RKJ
				DATE	
				09.09.93	

* The inner surface of the bush is coated with a fine layer of PTFE, hence no reamining operation is permitted on this surface.

As illustrated below, the bush is inserted into its housing with the aid of a conventional stepped mandrel preferably made from case hardened mild steel. Care must be taken to insert the bush squarely into the housing to avoid damage to the lining material. A slight lead in chamfer should be machined in the housing and a slight smear of oil applied to the OD of the bush to assist the fitting operation. Recommended arbor and chamfer dimensions are given in illustration below.



- Confirm the markings on the bush and its dimensions as per the drawing.
- This being a special bearing bush item, and is procured from reputed / established sources, no tests at BHEL are required. Supplier's Test Certificate / Guarantee certificate for originality of the item is sufficient for acceptance.

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PRODUCT STANDARD

SWITCHGEAR ENGINEERING DIVISION

SG 12706 REV.01

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APPROVED MAKES & THEIR SUPPLIER

- M/s Karl Schmidt Gmbh
NECKARSLUM/ WURTT
(Germany)
- Type : MB 1815 DU (B)
M/s Glacier Metal company Ltd.
ALPERTON, WEMBLEY
MIDDLESEX (England)
Telx : 926381 Phone : 01-997-6611

- Type P_A1 - 18.15 (Mat Cusn8)
M/s ERMA WERKE
Maschinenfabrik Gmbh
Johann - Ziegler - StraBe 13-15
P.O. - 1269
D-8060 DACHAU (Germany)

Ph : 08131/ 2803-0 Fax : 08131/ 2803 - 59

Telex: 526617 erfib d

Gram : ERMA - DACHAU Germany

Indian agent

M/s Sun Trading Co.

218 sector 18A,

CHANDIGARH - 160 018

Ph : 0091-172-27206, Fax : 0091-172-43633

Telex: 395 565 SUN X IN

- Type ; GLY PG 1820 15 F *
(* This is a steel strip backed bush)

M/s Skefko India Bearing Co. Ltd,

P.O. BOX. 2202

Mahatama Gandhi Memorial Building,

Netaji Subhash Road

BOMBAY - 400 002

Ph : 022-313567, Fax : 022-2619934

Telex: 011-84721

Gram : SKEFKO, BOMBAY

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