



STANDARD  
JIG AND TOOL ENGINEERING

TL 10128

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SIGN & DATE

SUPERSEDES  
INVENTORY No.

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GUIDE PILLAR 'D'	CAGE O.D. 'D <sub>1</sub> '	D <sub>2</sub>	CAGE THICKN ESS'S	d	h	L	l	m	n	t	t <sub>1</sub>	t <sub>2</sub>	BALL DIA d <sub>b</sub>	R	CODE NO WEIGHT Kg.
28	33.2	32	2.2	3.1	1.8	65	52.5	2.9	1.6	7.5	-	5	3	30°	01 0.09
28	33.4	32	2.4	3.1	1.8	43	30	3.4	1.6	6	-	5	3	30°	02 0.07
30	35.4	33	2.3	3.1	1.8	71	58	3.4	1.6	6	-	5	3	30°	03 0.10
32	37.4	35.5	2.3	3.1	1.8	89	76	3.15	1.85	1.6	-	5	3	30°	04 0.20
40	47.3	45.5	3.3	4.1	2.4	105	89.6	4.55	1.85	-	11.2	5	4	30°	05 0.32
50	59.3	57	4.2	5.1	3.1	130	112	4.85	2.15	-	14	6	5	24°	06 0.67
70	81.2	78.5	5.2	6.1	3.8	138	117.6	5.75	2.65	-	16.8	6	6	20°	07 1.24
100	115.2	111	7.2	8.1	5.8	160	134.4	5.45	4.15	-	22.4	8	8	20°	08 1.5
															09

NOTES:—

- \* 1. THE TOLERANCE ON THE 'S' AND 'D' IS TAKEN CLASS - IV
- \* 2. ENSURE INTERFERENCE FIT OF 0.010 TO 0.025 BETWEEN BALLS OF CAGE, BUSH AND GUIDE COLUMN.
3. SEPARATOR SHALL BE ASSEMBLED WITH BALL FROM ONE BATCH.
4. BALLS FIXED IN SEPARATORS (CAGES) SHOULD BE FREELY ROTATE IN HOLES AROUND CENTRE & SHOULD NOT FAIL OUT OF THEM.
5. THE SURFACE OF THE COMPONENTS OF THEIR UNIT SHOULD NOT HAVE SCRATCHES & OTHER DAMAGES.
6. CONSTRUCTION & DIMENSION OF SEPARATOR BODY SHALL BE AS PER DRG. GIVEN ABOVE.
7. CONSTRUCTION & DIMENSION OF BALL AS PER IS: 2898-1976.
8. SURFACE FINISH FOR SEPARATOR BODY SHOULD NOT LESS THAN 1.6  $\sqrt{\text{mm}}$
9. MATERIAL FOR
  - (a) BALL ROLLING BEARING STEEL IS: 4398-67; 103 Cr2  
HARDNESS HRC 63 $\pm$ 3 & FINISH GROUND & POLISHED.
  - (b) BRASS Cu Zn 37 AS PER CPS- AA 12101.

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