

**Corrigendum-02 for Tender No.- ITPS/Unit 3 & 4/19-20/136, dtd.16/08/2019
Tender for Supply of Spare Idlers & Idler Stands at CHP-2 (Two Parts)**

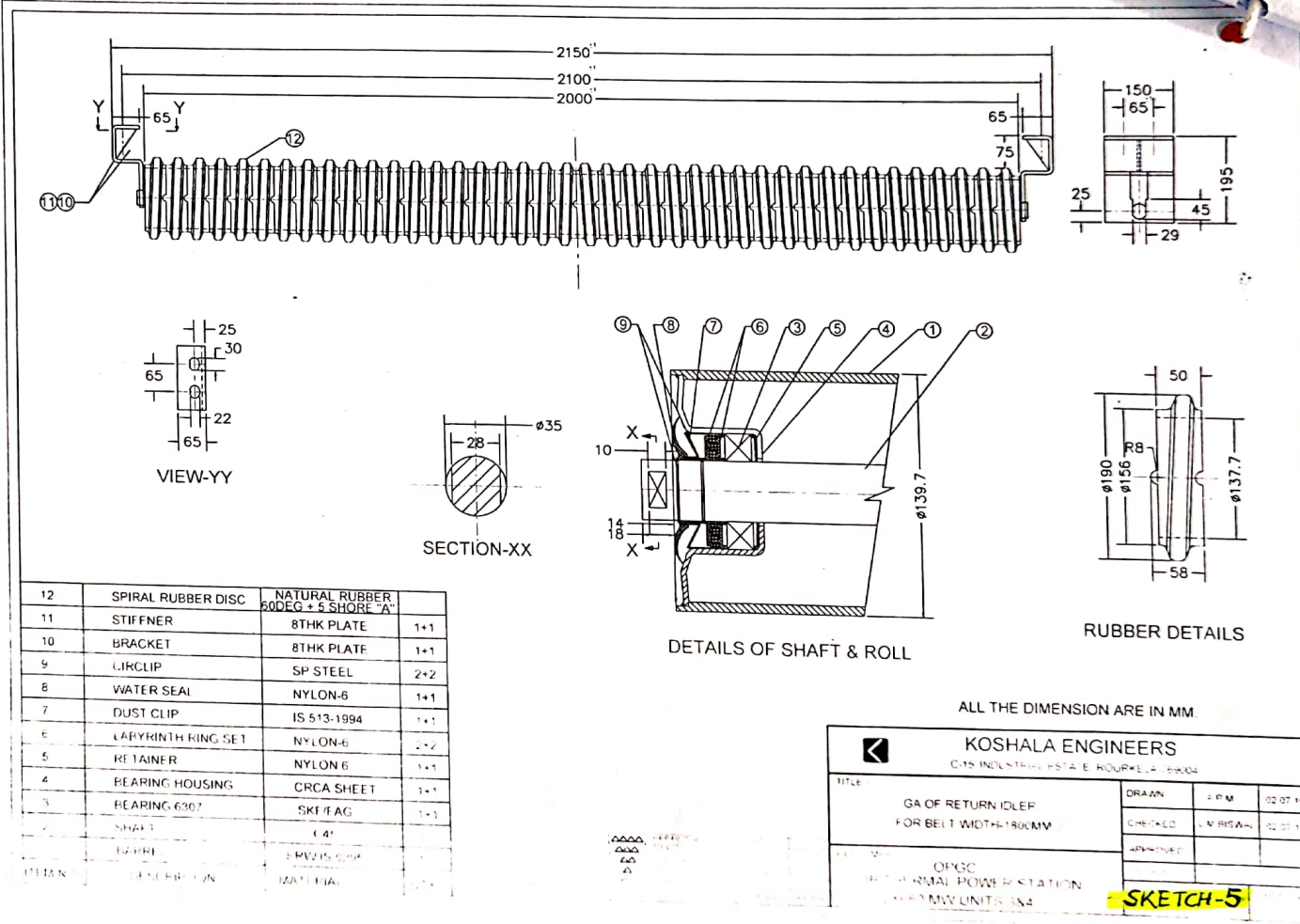
Sl. No.	Clause No. / Page No.	Existing	Amended
1	IDLER ROLLER - DATA SHEET (Annexure-1)	SI No.5 (Refer Sketch - 4, Item - 4) Non Magnetic Carrying Idlers 152.4 x 670 x 22 as per IS : 8598, 1987, Latest Revision	SI No.5 (Refer Sketch) Non Magnetic Carrying Idlers 152.4 x 670 x 22 as per IS : 8598, 1987, Latest Revision (revised copy enclosed along with sketch) Additional sketch mentioned below
5	Corrigendum- I	Bid Submission Date : 24.02.2020	Bid Submission Date : 20.06.2020
All other terms & condition of RFP: ITPS/Unit 3 & 4/19-20/136 dt.16/08/19) will remain unchanged.			

Sl. No.	Item Description	Specification
5	(Refer Sketch - 2)	Non Magnetic Carrying Idlers 152.4 x 670 x 22 as per IS : 8598, 1987, Latest Revision
5.1	Steel tubes for Idler shell	ERW pipe (confirming to IS: 9295, 1983, Latest Revision) Idler Tube material shall be SS - 304 Nominal Dia. 152.4 mm , Length 1000 mm (Shaft Length 1036 mm) nominal Thickness : 4.85 mm Maximum radial run out \pm 0.8 mm (TIR 1.6 mm as per IS : 8598) Preferred Make : TATA / SAIL / JINDAL / NEZONE / UTKARSH / PSST
5.2	Spindle	The spindle shall be made of EN-9 / BS - 970 / 45 C8, IS : 1570 material The bearing portion of the spindle shall be ground to ($\Delta\Delta\Delta$) finish
5.3	Bearings	The bearings shall be deep groove ball bearing 6206 Z (C3 clearance) Make : SKF / FAG
5.4	Bearing Housing	The bearing Housing shall be made of Extra deep drawn quality CRCA Sheet, as per IS : 513 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
5.5	Circlip	External Circlip as per IS : 3075, Material Spring Steel (Heavy Duty)
5.6	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
5.7	Lubrication	The bearings shall be packed with Lithium based grease with water repellent & high flash point characteristics. Sealed for Life.
5.8	Dust Cover (outer Seal)	The Bearing Housing shall be made of Extra deep drawn quality CRCA Sheet, as per IS : 513 (Galv.)
5.9	Interchangeability	The idlers shall be made with close tolerance to have 100% interchangeability
5.11	Marking	Embossing / Punching on each idler on Outer cover (CHP 2) Letter Size about 10 mm
5.12	Dimensional tolerances	The dimensional tolerances shall be as per IS : 2102 (Part - 1)
5.13	Friction Factor	The friction Factor shall be within 0.015 (as per BIS : 11592, 2000)

Note :-

The successful bidder shall submit QAP for approval by the purchaser (Typical QAP is attached for ready reference)
The bidder shall also take exact dimensions of the idlers to avoid any fitment issue.

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ITEM NO.	DESCRIPTION	MATERIAL	QTY
12	SPIRAL RUBBER DISC	NATURAL RUBBER 60DEG + 5 SHORE "A"	
11	STIFFNER	8THK PLATE	1+1
10	BRACKET	8THK PLATE	1+1
9	CIRCLIP	SP STEEL	2+2
8	WATER SEAL	NYLON-6	1+1
7	DUST CLIP	IS 513-1994	1+1
6	LABYRINTH RING SET	NYLON-6	2+2
5	RETAINER	NYLON 6	1+1
4	BEARING HOUSING	CRCA SHEET	1+1
3	BEARING 6307	SKF FAG	1+1
2	SHAFT	4"	
1	ROLLER	BRWIS 6307	

ALL THE DIMENSION ARE IN MM.

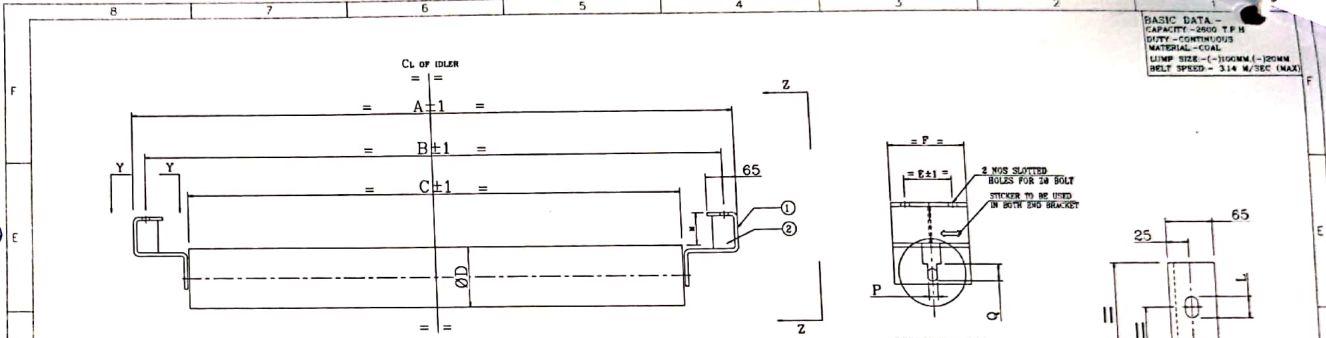
KOSHALA ENGINEERS
 C-15 INDUSTRIAL ESTATE, ROURKELA - 769004

TITLE	GA OF RETURN IDLER FOR BELT WIDTH-1800MM	DRAWN	S.P.M.	02.07.19
CHECKED	S.M.BISWA	APPROVED		02.07.19
PROJECT		OPGC REGIONAL POWER STATION 1380 MW UNITS 3&4		

SKETCH-5

Page 09 of 11

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BASIC DATA -
 CAPACITY - 2600 T P H
 IDTY - CONTINUOUS
 MATERIAL - COAL
 BELT SIZE - C-1000MM (1200MM)
 BELT SPEED - 314 M/SEC (MAX)

SI NO	MATERIAL CODE	B/W	A	B	C	M ²	ØD	F	E	P	Q	L	SHAFT DIA.	SHAFT DIA. AT BEARING	BRG NO	BRG MAKE	WT OF ROTATING PARTS (KG)	NO OF IDLER ASSEMB	ZØ BOLT	TOTAL QTY
1	564700050 514267	1800	2150	2100	2000	75	152.4	150	65	29	45	30	35.15	35	6207-2	SKF/FAG/NBC	37.5	63	M20	1019 SETS

ALL STRUCTURAL MATERIAL IS OF IS:2062,GR-A		
1800	PL 8TH	PL 8TH
BW	BRACKET(1)	STIFFNER(2)

BILL OF MATERIALS

- NOTE:-**
- ALL DIMENSIONS ARE IN MM U.S.
 - TUBE THICKNESS WILL BE 4.5MM WITHOUT NEGATIVE TOLERANCE.
 - ALL IDLER TUBE MATERIAL ERW AS PER IS:9295,(YST-210)-1983.
 - BEARING LIFE IS 30000 WORKING HOURS, <B-10>
 - BEARING SIZE 6207-Z C3 CLEARANCE AND (MAKE-SKF/FAG/NBC).
 - FRICTION FACTOR MAX 0.015 AS PER IS 11592-2000.
 - IDLER ARE DUST PROOF, WATER PROOF & WEATHER PROOF.
 - ALL IDLER ARE MANUFACTURE AS PER IS:8598-1987.
 - SHAFT MATERIAL EN-8/C-40/C-45 BRIGHT BAR AS PER BS:970-1983/IS:1570-1979.
 - TOTAL INDICATOR READING -TIR-ON IDLER OD, WHEN ROTATED TO CHECK RUNOUT AS PER IS:8598-1987.
 - PAINTING WILL BE AS PER CONTRACT SPECIFICATION:GID-208-ME-ECS-SA-4515-REV-2. TESTING AND INSPECTION WILL BE DONE AS PER APPROVED QAP.
 - SEALING -GREASE PACKED AND SEALED FOR LIFE LITHIUM BASE GREASED TO BE USED.
 - IDLERS ARE DROP IN TYPE & ROLLS CAN BE REMOVED WITHOUT DISMANTLING THE BRACKET FROM THE CONV. STRUCTURE.
 - ALL ROLLS ARE INTERCHANGEABLE FOR THE SAME BELT WIDTH.
 - IDLERS ARE PROVIDED WITH MULTI LABYRINTH SEALING.
 - ALL FILL T WELD ARE 4MM (MINIMUM).
 - FOR CROSS SECTION DRAWING OF ROLL ASSY. PLEASE REFER DRG. NO-AMPS/BGR/15-16/FRIR-04-REV-0-SHEET-4.
 - ALL SHARP CORNERS TO BE GROUND SMOOTH.
 - ALL THE FINISHING TO BE DONE AS PER IS:8598-1987.
 - For Idler Schedule, refer Annexure-A, Shi 10 of 10

NOTES -

SPECIAL NOTE -

SHEET 6 of 10

REV	REV DT	DETAIL OF REVISION	BY	CHKD	APP	RELEASD	DATE	REASON FOR REV

(amps) amps engineering & equipments pvt.ltd
 Jamshedpur

CUSTOMER - BGR ENERGY SYSTEMS LTD

PROJECT - 1B THERMAL POWER STATION
 2 X 660 MW UNITS 3 & 4

DESCRIPTION - GA OF RETURN IDLER
 FOR 1800 MM BELT WIDTH.

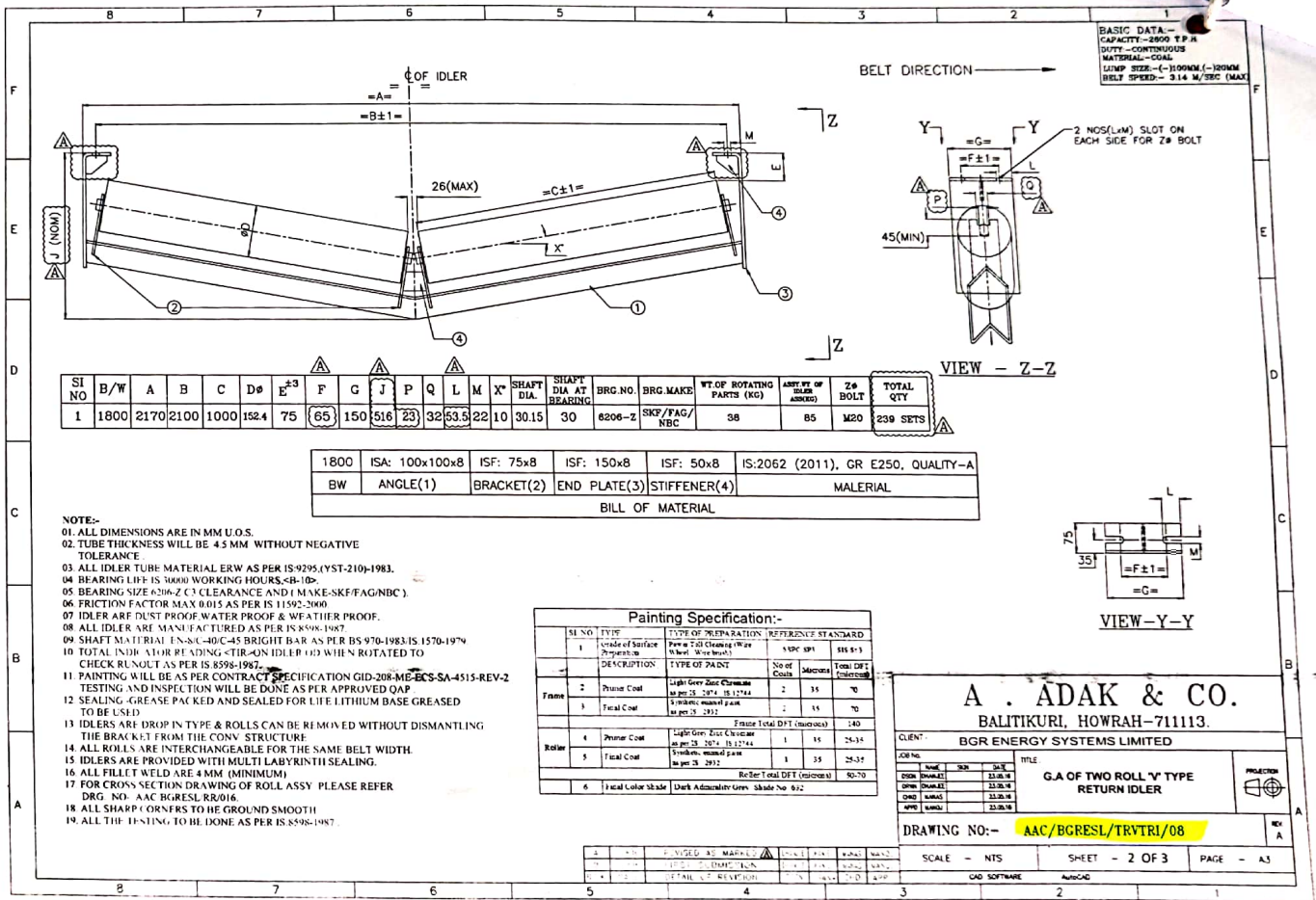
SCALE NTS **DRW BY** ABUZER ANMARI **DT -** 11/09/2015

DRAWING NO AMPS/BGR/15-16/FRIR-04 **REV C**

Sl. No	TYPE	TYPE OR PREPARATION	REFERENCE STANDARD
1	Coat of Surface Preparation	Prep. Job. Number 90 04 Prep. Job. No. 1000	IS:8001-1997 IS:8001-1997
2	Primer Coat	Primer Coat	IS:8001-1997
3	Paint Coat	Paint Coat	IS:8001-1997

Page 10 of 11

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BASIC DATA:-
 CAPACITY-2000 T.P.H
 DUTY-CONTINUOUS
 MATERIAL-COAL
 LUMP SIZE-(100MM-180MM)
 BELT SPEED-314 M/SEC (MAX)

SI NO	B/W	A	B	C	D ϕ	E ± 3	F	G	J	P	Q	L	M	X ϕ	SHAFT DIA.	SHAFT DIA AT BEARING	BRG. NO.	BRG. MAKE	WT OF ROTATING PARTS (KG)	AMT OF BELT (MTRS)	Z ϕ BOLT	TOTAL QTY
1	1800	2170	2100	1000	152.4	75	65	150	516	23	32	53.8	22	10	30.15	30	6206-Z	SKF/FAG/NBC	38	85	M20	239 SETS

1800	ISA: 100x100x8	ISF: 75x8	ISF: 150x8	ISF: 50x8	IS:2062 (2011), GR E250, QUALITY-A
BW	ANGLE(1)	BRACKET(2)	END PLATE(3)	STIFFENER(4)	MATERIAL

BILL OF MATERIAL

- NOTE:-**
- ALL DIMENSIONS ARE IN MM U.O.S.
 - TUBE THICKNESS WILL BE 4.5 MM WITHOUT NEGATIVE TOLERANCE
 - ALL IDLER TUBE MATERIAL ERW AS PER IS-9295 (YST-210)-1983.
 - BEARING LIFE IS 30000 WORKING HOURS, C_3
 - BEARING SIZE 6206-Z C3 CLEARANCE AND MAKE-SKF/FAG/NBC
 - FRICTION FACTOR MAX 0.015 AS PER IS 11592-2000
 - IDLER ARE DUST PROOF WATER PROOF & WEATHER PROOF.
 - ALL IDLER ARE MANUFACTURED AS PER IS 8598-1987.
 - SHAFT MATERIAL EN-8C-40 C-45 BRIGHT BAR AS PER BS 970-1983 IS 1570-1979
 - TOTAL IDLER BEARING C_3 CLEARANCE AND MAKE-SKF/FAG/NBC
 - CHECK RESULT AS PER IS 8598-1987.
 - PAINTING WILL BE AS PER CONTRACT SPECIFICATION GID-208-ME-ECS-SA-4515-REV-2
 - TESTING AND INSPECTION WILL BE DONE AS PER APPROVED QAP
 - SEALING - GREASE PACKED AND SEALED FOR LIFE LITHIUM BASE GREASED TO BE USED
 - IDLERS ARE DROP IN TYPE & ROLLS CAN BE REMOVED WITHOUT DISMANTLING THE BRACKET FROM THE CONV. STRUCTURE
 - ALL ROLLS ARE INTERCHANGEABLE FOR THE SAME BELT WIDTH
 - IDLERS ARE PROVIDED WITH MULTI LABYRINTH SEALING.
 - ALL FILLT WELD ARE 4MM (MINIMUM)
 - FOR CROSS SECTION DRAWING OF ROLL ASSY PLEASE REFER DRG. NO. AAC/BGRESL/RR/016
 - ALL SHARP CORNERS TO BE GROUND SMOOTH
 - ALL THE FINISHING TO BE DONE AS PER IS 8598-1987

Painting Specification:-

SI NO	TYPE	TYPE OF PREPARATION	REFERENCE STANDARD
1	Primer Coat	Light Grey Zinc Chromate as per IS 2074 IS 1744	IS: 2074 IS 1744
2	Primer Coat	Light Grey Zinc Chromate as per IS 2074 IS 1744	IS: 2074 IS 1744
3	Total Coat	Light Grey Zinc Chromate as per IS 2074 IS 1744	IS: 2074 IS 1744
4	Primer Coat	Light Grey Zinc Chromate as per IS 2074 IS 1744	IS: 2074 IS 1744
5	Total Coat	Light Grey Zinc Chromate as per IS 2074 IS 1744	IS: 2074 IS 1744
6	Total Color shade	Dark Admiralty Grey Shade No 922	Refer Total DFT (microns)

A. ADAK & CO.
 BALITIKURI, HOWRAH-711113.

BGR ENERGY SYSTEMS LIMITED

CLIENT: **G.A OF TWO ROLL 'Y' TYPE RETURN IDLER**

DRAWING NO:- **AAC/BGRESL/TRVTRI/08**

SCALE - NTS SHEET - 2 OF 3 PAGE - A3

Page 11 of 11