

*Please issue*  
*on*  
Government of India  
Ministry of Railways  
Research Designs and Standards Organisation

Manak Nagar, Lucknow-226011.

No. EL/2.2.48

Dated: April 1981.

SPECIAL MAINTENANCE INSTRUCTIONS NO. RDSO/EL-RS/SMI/78

Fitting of outer race bearing in the bearing housing.

1. OBJECT:

- 1.1 Railways have reported cases of bearing outer races revolving in their housings. Investigations have revealed that this defect is due to inadequate fits caused by incorrect machining of the bearing housing bores.
- 1.2 This SMI suggests a method for reclamation of such bearing housings. It may also be adopted in case of doubt re: accuracy of machining of the housing bores.

2. METHOD FOR RECLAMATION:

- 2.1 Clean the inner surface of the housing and ensure that it is free of oil and grease by use of "Locquic Primer T".
- 2.2 Clean the bearing thoroughly with kerosene and wipe out all traces of kerosene with fine cloth. Remove all traces of oil and grease on the outer surface of the bearing outer race by application of "Locquic Primer T".
- 2.3 Apply a thin film of Bearing Mount (Loc/147) Product No.601 evenly over the bearing outside surface and on the end shield bores.
- 2.4 Mount the bearing in the housing of the end shield and press it firmly into position.
- 2.5 Do not apply any grease to the bearing for four hours after applying Loctite to ensure that the Loctite resin is fully hardened.
- 2.6 Source of Procurement:

Name of products:

- i) Loctite bearing mount LOC/147 Product No.601 of M/s. Loctite Corporation.
- ii) "LOCQUIC PRIMER T",  
supplier: M/s. AEI CORP Pvt. Ltd, 10, Lall Bazar Street, Calcutta-700001.

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3. APPLICATION:

All auxiliary motors of Electric Rolling Stock.

4. AGENCY FOR IMPLEMENTATION:

4.1 Electric Loco Sheds, EMU Sheds and POH Shops.

4.2 Rewinding Shops of Railways in case rewinding is done by outside agencies (suitable clauses to be incorporated in the specifications for the Contract).

5. PERIODICITY OF IMPLEMENTATION OF THE SMI:


5.1 Whenever rewinding of auxiliary machines is done.

5.2 During annual overhaul of auxiliary machines.

5.3 During special repairs from the auxiliary machines.

6. DISTRIBUTION:

As per list attached.

  
(Kewal Kumar)  
for Director General/Elec.