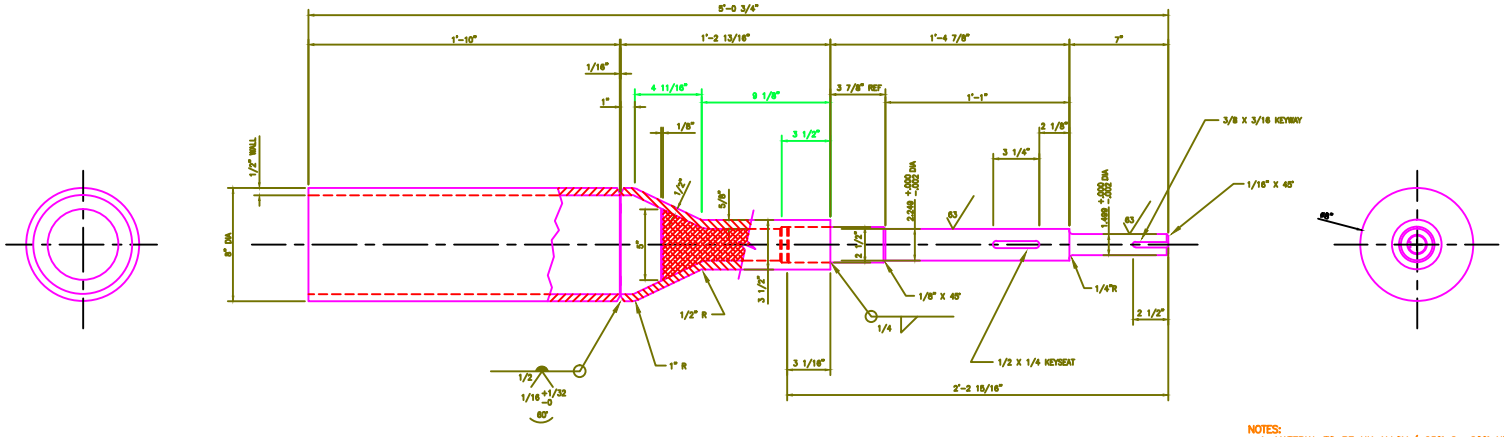
BILL OF MATERIAL

ITEM	REQ'D	DESCRIPTION



FURNACE ROLL
MK N11-1 (45) REQD

NOTES:
1. MATERIAL TO BE HK ALLOY (25% Cr, 20% Ni). SURFACE TO BE "AS CAST".
2. SHAFT TO BE 1018 CARBON STEEL.
3. KEY TO BE 1045, VENDOR TO TAPE KEY TO SHAFT.
4. PRESS FIT SHAFT INTO TRUNNION AS REQUIRED (.001 MAX PRESS).
5. PACK TRUNNION WITH KAOWOOL AND SECURE IN PLACE WITH 5" DIA X 1/8" THK 304 STAINLESS DISK. WELD DISK SECURELY.
6. TURNED DIAMETERS TO BE CONCENTRIC TO EACH OTHER WITHIN .010 T.I.R.
7. TURNED SHAFT ENDS TO BE CONCENTRIC WITH ROLL BODY WITHIN .032 T.I.R.
8. USE 310 ROD FOR WELDING ALLOY.
9. STAMP EACH PIECE "HK" ON 1 1/2" DIA SHAFT END.

EL PERIMETRO DE LOS RODILLOS ES DE 25.132 PULGADAS PARA VERIFICAR MARCAS

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REFERENCE DRAWINGS

Metalsa
"Unidad como forma de vida"
Monterrey, Mexico

METALSA DWG. NO. 1191-N11

AUSTENITIZING FURNACE
FURNACE ROLL DETAIL
TRUCK RAIL Q & T LINE

REVISIONS

NO.	LOCATION	DESCRIPTION	DATE	BY
1				
2				
3				
4				
5				
6				

INDUSTRIAL FURNACES
FLINN & DREFFEIN ENGINEERING CO.
NORTHBROOK, ILLINOIS 60062

drawn by: MP CLAFFEY 6/24/98
checked by: R BUCHER 25 JUN 98
approved by:
Released For Construction:

scale: 3" = 1'-0"
DRAWING NO. 1191-N11