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Specification of Bush for Corner Roller of BCM (Part no.64.08.5048)			



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SPECIFICATION NO. TM/HM/6/546

**SPECIFICATION OF BUSH FOR CORNER ROLLER OF BCM
(Part no. 64.08.5048)**

DTM-III	EDTM	Page 1 of 3
Prepared By:	Issued By:	

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1.0 Scope: This specification covers the dimensional, functional and material requirements with testing criteria of Bush for corner roller of BCM. This specification may be treated as provisional subject to modifications based on service performance.

2.0 Reference documents: Following documents have been referred to in this specification. Full sets of relevant drawings and the referred codes/ specifications, duly incorporating the up-dated corrections/ amendments, shall be available for reference at manufacturer's works.

- iii) BS 970-Part-II Direct hardening alloy steel specification.
- ii) IS:77-1976 – Linseed oil for paints – specification.
- iii) RDSO Drg. No. RDSO/TM/19/23 – Bush for corner roller of BCM.

3.0 Functional requirement: It is provided between bearing and corner roller pin for fixing corner roller and guide to grease the bearing. All surfaces meant for machining shall be finished as mentioned in the drawing no. RDSO/TM/19/23.

4.0 Dimension & Tolerance: Dimensions and tolerances of the Bush for corner roller of BCM shall be as mentioned in RDSO drawing no. RDSO/TM/19/23.

5.0 Material: The Bush for corner roller of BCM shall be made from Direct hardening alloy steel of Grade 817M40(EN24) conforming to BS: 970 Part-II.

6.0 Manufacturing Process: Bush for corner roller of BCM shall be made by either machining from billet of specified material or by forging or machining process.

7.0 Marking: Month and year of manufacture and manufacturer's code / identification shall be engraved / embossed on the non-functioning surface of Bush for corner roller of BCM.

8.0 Inspection and Acceptance Criteria:

- i) Each components offered by manufacturer shall be checked visually for their surface finish, freedom from defects like porosity, cracks, improper edges etc. Machined surface shall be checked by any suitable pneumatic or electronic equipment.
- ii) The component found suitable after visual inspection, shall be checked for their dimensions as per relevant drawing.
- iii) Supplier shall produce the certificate that the raw material use for manufacturing of the component conforms to direct hardening alloy steel of

DTM-III	EDTM	Page 2 of 3
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Grade 817M40(EN24) conforming to BS: 970 Part-II Direct hardening alloy steel as mentioned in Para 5.0.

- iv) Manufacturer shall also produce a test result of chemical property/ analysis report of billet/raw material used for manufacturing of the component.
- v) Minimum one no or 2 % sample of the component randomly picked up out of each lot of consignment and shall be subjected to chemical composition test. The consignee shall test the material for chemical composition at his laboratory or get the material tested in a reputed (NABL accredited or accredited by other international body like APLAC, MRA, ILAC etc) laboratory having proper facilities for testing. Before sending the samples for testing, the same shall be duly sealed and secret coding shall be done.
- vi) Any deviations in the test result from the requirement of the specification and drawing shall be the cause of rejection of the component.

9.0 Packing and Protection: Each component shall be protected with one coat of boiled linseed oil conforming to IS: 77-1976 (linseed oil for paint) and shall be packed in cardboard case.

DTM-III	EDTM	Page 3 of 3
Prepared By:	Issued By:	