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Specification of M.S Clamps for 18 dia hose pipes of Duomatic (Part no. M18)			



**RESEARCH DESIGNS AND STANDARDS ORGANISATION
Manak Nagar, Lucknow-226011**

Track Machine and Monitoring Directorate

**SPECIFICATION NO.TM/HM/6/563
SPECIFICATION OF M.S CLAMS FOR 18 DIA HOSE PIPES OF DUOMATIC
(PART NO. M18)**

DTM-I	EDTM	Page 1 of 3
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SPECIFICATION OF M.S CLAMS FOR 18 DIA HOSE PIPES OF DUOMATIC (PART NO. M18)

- 1.0 Scope:** This specification covers the dimensional, functional and material requirements with testing criteria of M.S clamps for 18 dia hose pipes of Duomatic machine. 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.
- i) IS:2062-1992 Specification of Steel for general engineering purpose.
 - ii) IS:77-1976 - Linseed oil for paints – specification.
 - iii) Drg. No. RDSO/TM/13/24 M.S clamps for 18 dia hose pipes of Duomatic.
- 3.0 Functional Requirement:** M.S clamps for 18 dia hose pipes of Duomatic is used for provides leakage prove clamping to hydraulic pipe with pump/motors. All surfaces meant for machining shall be finished as mentioned in the Drg. No. RDSO/TM/13/24
- 4.0 Dimension & Tolerance:** Dimensions and tolerances of the M.S clamps shall be as mentioned Drg. No. RDSO/TM/13/24
- 5.0 Material:** The M.S Clamps shall be made from Mild steel of grade A or B conforming to IS: 2062-1992 having minimum tensile strength 410 MPa i.e. 410 N/mm sq. with minimum percentage elongation of 23.
- 6.0 Manufacturing Process:** M.S Clamps shall be made by forging or machining process from plate /billet of specified material.
- 7.0 Marking:** Month and year of manufacture and manufacturer's code/ identification shall be engraved /embossed on the non-functional surface of M.S Clamps.
- 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 used for manufacturing of the component conforms to the Mild Steel Grade A or B of IS:2062-1992 as mentioned in para 5.0.

DTM-I	EDTM	Page 2 of 3
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- iv) Any deviations in the test result from the requirement of the specification and drawing shall be the cause of rejection.

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

DTM-I	EDTM	Page 3 of 3
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