

ISO 9001:2015	Document No: TM/HM/6/567	Version No:0.0	Date effective: 14/08/2024
Specification of Throtal for tamping unit up/down Cylinder of DUO, CSM, & T-Exp (Part no.HY40.73A)			



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**SPECIFICATION NO.TM/HM/6/567**

**SPECIFICATION OF THROTAL FOR TAMPING UNIT UP/DOWN CYLINDER OF  
DUO, CSM & T-EXP  
(PART NO. HY40.73A)**

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## SPECIFICATION NO. TM/HM/6/567

### SPECIFICATION OF THROTAL FOR TAMPING UNIT UP/DOWN CYLINDER OF DUO, CSM & T-EXP (PART NO. HY40.73A)

**1.0 Scope:** This specification covers the dimensional, functional, and material requirements with testing criteria of the Throtal for Tamping Unit up/down Cylinder of DUO, CSM & T-Exp 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 set of relevant drawings and the referred codes/specifications duly incorporating the updated corrections / amendments shall be available for reference at manufacturer's work.

- i) BS: 970 Part II Specification of direct hardening alloy steel.
- ii) IS: 77- 1976: Linseed oil for paints specifications.
- iii) Drawing No: RDSO/TM/17/24 Throtal for tamping unit up/down cylinder.

**3.0 Functional Requirement:** Throtal is provided in tamping unit up/down cylinder for control the hydraulic oil flow. All surfaces meant for machining shall be finished as mentioned in the Drg. No. RDSO/TM/17/24.

**4.0 Dimensions and Tolerance:** Dimension and tolerance of the Throtal shall be as mentioned in drawing no. RDSO/TM/17/24.

**5.0 Material:** The Throtal shall be made of steel grade 817M40 (EN24) conforming to BS: 970 Part- II Specification of direct hardening alloy steel.

**6.0 Manufacturing Process:** Throtal shall be made by either machining from bar/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-functional surface of each component.

**8.0 Inspection and Acceptance Criteria:**

- i) Each component offered by manufacturer shall be checked visually for their surface finish, freedom from defect 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 dimensional characteristics as per relevant drawing.

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- iii) Supplier shall produce the certificate that the raw material used for manufacturing of the component conforms to material specified as mentioned in Para 5.0.
- iv) Manufacturer shall also produce a test result of chemical property/ analysis report of raw material used for manufacturing of the component.
- v) Minimum one no or 2 % sample of 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.

**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.

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