

Specefication No. RDSO/M&C/RP-179/2020 (Revision 2.0)

**Government of India
Ministry of Railways**

Indian Railway Standard Specification for
**Ultra-High Molecular Weight – High Density Polyethylene (UHMW –
HDPE) components, (Revision-2.0)**

**M&C Directorate
Research Designs & Standards Organization
Lucknow - 226011**

0. FOREWORD :

- 0.1** This specification is issued under fixed serial No. RDSO/M&C/RP-179/2020 (Revision 2.0), the final number indicates the year of adoption as standard or in case of revision, the year of last revision.
- 0.2** This specification was first adopted in year 1993 and has been revised mainly for incorporating quality control practices. A code of practice for quality control and inspection of rubber and plastic components (Appendix 'A') is incorporated to ensure satisfactory process and quality control at the works of the manufacturers.
- 0.3** This specification is intended to cover the technical provisions relating to materials, constructions and tests, and does not include all the necessary provisions of the contracts.
- 0.4** For the purpose of deciding whether a particular requirement of this standard is complied with, the final value observed or calculated, expressing the results of a test or analysis, shall be rounded off in accordance with the IS:2:1960 (Reaffirmed 2016). The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.
- 0.5** This specification contained a code of practice for quality control and inspection of rubber & plastic components (Appendix 'A') to ensure satisfactory process and quality control at the works of the manufacturers. The provisions of this code shall be applicable for all the rubber & plastic components being used on the railways.

1. SCOPE

- 1.1** This specification covers the requirements and methods of sampling and tests for Ultra High Molecular Weight – High Density Polyethylene (UHMW – HDPE) components of rolling stock and track and other railway equipment.

2. REQUIREMENTS

2.1 Material :

- 2.1.1** UHMW – HDPE conforming to the requirements stipulated in this specification shall be used in the manufacture of components. Unless otherwise specified the color of the material shall be its natural color.

2.2 Construction, Workmanship and Finish:

- 2.2.1** The component shall be as per the relevant drawing and shall be manufactured by press sintering or extrusion process as applicable. The surface finish of the components shall be smooth and free from voids, porosities, blisters, laminations and any other surface defects.

2.3 Conditioning / Annealing :

The components shall be conditioned /annealed by manufacturers adopting a suitable process.

2.4 Dimensions and Tolerances :

- 2.4.1** Dimensions and tolerances of the components shall be as per the relevant drawings.

2.5 Physical Properties of UHMW-HDPE :

<u>SL. No.</u>	<u>Properties</u>	<u>Value</u>	<u>Method of Test</u>
1.	Specific gravity	0.945 ± 0.005	ASTM D-792
2.	Melt flow index (I5) at 190°C (g/10 min)	0.01 max. or no flow	ASTM D-1238 – 62T
3.	Tensile Strength* at break (MPa), min	35.0	ASTM D-638
4.	Elongation at break* (%), min	350	ASTM D-638
5.	Hardness (Shore D), min	65	ASTM D-2240
6.	Melting Point (°C)	135 to 140	BS: 2782
7.	Ash content (%), max	0.25	Conventional method at 600° to 800°C

* Speed of testing 100 mm/min

3. **SAMPLING, CRITERIA FOR CONFORMITY :**

3.1 **Tests**

3.1.1 The tests shall constitute type tests and acceptance tests.

3.1.2 **Type tests:**

The type tests shall be conducted for all the requirements including acceptance tests as laid down in this specification and are mandatory for product approval or approval of manufacturers. However, approving/purchasing authority reserves the right to repeat the tests at their discretion at a certain time interval.

3.1.3 **Acceptance Test :**

The acceptance test shall constitute the following:-

- a) Visual Observation
- b) Dimensional Check
- c) Specific gravity
- d) Melting Point
- e) MFI (I5)
- f) Ash content

3.1.4 The lot shall consist 100 numbers (or 1000 nos when the quantity ordered/offered exceeds 1000 nos) or part thereof.

3.1.5 The number of samples to be selected from the lot for acceptance test shall be as under:-

- | | | |
|----|---------------------|---|
| a) | Visual Observation. | |
| b) | Dimensional Check. | Min 10 or 1 % of the lot whichever is higher. |
| c) | Specific gravity | |
| d) | Melting point | 3 Nos. (Destructive tests as required) |
| e) | MFI (I5) | |

- 3.1.6 Each sample undertaken for acceptance tests shall conform to the requirements as laid down in this specification. Should any one of the test samples fails to meet the requirements of acceptance tests, double the number of samples from the same lot shall be drawn for retesting. Should any of the retested samples fail, the entire lot shall be rejected.
- 3.1.7 In case of non-compliance in regard to dimensional check (clause 3.1.3 b) the manufacturer shall be permitted to segregate the lot in respect of dimensions and re-offer.
- 3.1.8 In the event of rejection of the entire lot after retesting of the samples, the lot offered shall be made unusable in presence of purchasing / inspecting authorities.

4. **MARKING**

- 4.1 Each component shall be marked as moulded with the following legends on the portion shown in the relevant drawings.
- a) Manufacture's name/Initial/Trade mark
 - b) Year of manufacture
 - c) Drawing number

5. **PACKING**

- 5.1 The components shall be securely packed in stout wooden boxes to avoid any damage in transit.

Note: The tests specified under clause no. 2.5 shall be conducted on finished components wherever practicable or from the test specimens prepared under identical conditions using the same material.

6. "Firm should comply Make in India policy and Public Procurement (Preference to Make in India) order -2017 under this specification" and subsequent amendment done time to time.

APPENDIX 'A'

CODE OF PRACTICE FOR QUALITY CONTROL AND INSPECTION OF RUBBER AND PLASTIC COMPONENTS

A.1 THE SYSTEM

A.2 RECORDS, TESTS & SAMPLING:

A.2.1 The manufacturer shall furnish the Purchasing/Inspecting authorities the detail of tests and inspection records and other relevant records as required under the quality control systems in force. These records and reports shall be maintained by the Competent Technical Authority of the manufacturers and shall be open to examine by the Purchasing/Inspecting authorities at all reasonable time. The Purchasing/Inspecting authorities at their discretion may draw samples of materials used in manufacture and products at any stage of production for conforming tests either at the works of the manufacturers or in an approved laboratory. In case the samples do not conform to the requirements of the specification double the number of samples from the same lot/batch shall be drawn for re-tests. Should any one of the re-test a sample does not conform to the requirements, the entire lot/batch shall be rejected.

A.3 APPROVED MANUFACTURERS:

A.3.1 The manufacturer should have complete manufacturing and quality control facilities as per the specification at their works.

A.3.2 For reasonable quality assurance, it is desirable that the components are procured from manufacturers approved by Research Designs & Standards Organization (RDSO), Lucknow or by any other agency as assigned by the Purchasing Authority, based on evaluation of the components as per the specification, manufacturing and quality control facilities and quality assurance programme. However, such approval does not guarantee the supply of consistent quality of material/components and therefore every lot offered shall be subjected to inspection and testing as per the specification.

A.3.3 The approved manufacturers shall be subjected to periodical re-appraisal (periodicity for each component shall be assigned by the approving authority). In case of withdrawal of any manufacturing and quality control facilities provided at the time of approval of the component produced at the time of re-appraisal are not conforming to the specification, the manufacturers are liable to be withdrawn from the approved list. The approving authority reserves the right to withdraw the manufacturers from the approved list without assigning any reason.

A.3.4 The consignee may also periodically arrange testing if so desired, at RDSO or in an approved laboratory for confirmatory tests within six months from the date of receipt of the supplies, in their original packing. In case of samples do not conform to the specification, the consignee may at their discretion suspend the manufacturer for further supply and the fact brought to the notice of approving/inspecting authorities for appropriate action.
