

ISO 9001:2008	Document No: TM/HM/6/346	Version No:0.0	Date effective: 27/07/2015
Specification of Guide Bush of Roller Clamp lifting Cylinder of DGS machine (Part no.HZ06.063.036)			



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**SPECIFICATION NO. TM/HM/6/346  
(Provisional)**

**SPECIFICATION OF GUIDE BUSH OF ROLLER CLAMP LIFTING CYLINDER OF DGS  
MACHINE  
(Part no HZ06.063.036)**

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Prepared By:	Issued By:	

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### SPECIFICATION OF GUIDE BUSH OF ROLLER CLAMP LIFTING CYLINDER OF DGS MACHINE

(Part no HZ06.063.036)

- 1.0 Scope:** This specification covers the dimensional, functional, and material requirements with testing criteria of the Guide Bush of Roller Clamp lifting Cylinder of DGS machine. This specification may be treated as provisional subject to modifications based on service performance.
- 2.0 Reference Document:** Following Document and specification have 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) IS: 2062-1992: Specification of steel for general engineering Purpose.
  - ii) IS: 77- 1976: Linseed oil for paints specifications.
  - iii) Drawing No: RDSO/TM/04/14. Guide Bush of Roller Clamp lifting Cylinder of DGS machine
- 3.0 Functional Requirement:** The Guide bush is provides in Roller clamp lifting cylinder sleeve of DGS machine. Functional pressure in cylinder tube is 160 Kg / cm<sup>2</sup> hydraulic pressure. All surfaces meant for machining shall be finished as mentioned in the Drg. No. RDSO/TM/04/14.
- 4.0 Dimensions and Tolerance:** Dimension and tolerance of Roller clamp cylinder complete with Fork head of DGS machine shall be as mentioned in drawing no. RDSO/TM/04/14.
- 5.0 Material:** The Guide bush shall be made of mild steel of grade A or B Conforming to IS: 2062-1992 having minimum tensile strength 410Mpa i.e.410 N/ mm<sup>2</sup> with minimum percentage elongation of 23.
- 6.0 Manufacturing Process:** Guide bush shall be made by machining from plate or 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 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.
  - iii. Supplier shall produce the certificate that the raw material use for manufacturing of the component conforms to the IS: 2062-1992 as mentioned in para 5.0.
  - iv. Any deviation in the test result shall be the cause of rejection.

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**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 card board case

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