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Specification of Spacer Ring for Vibration Shaft (Part no.DL23.108)			



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SPECIFICATION NO. TM/HM/6/206 REV- 2

SPECIFICATION OF SPACER RING FOR VIBRATION SHAFT
(Part no. DL23.108)

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- 1.0 Scope:** This specification covers the dimensional, functional and material requirements with testing criteria of Spacer ring for vibration shaft of DUO/CSM/UNI Tamping 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 updated corrections/amendments, shall be available for reference at manufacturer's works.
- i) BS 970 (Pt-II)-1970—Specification of direct hardening alloy steel.
 - ii) IS: 77-1976 - Linseed oil for paints - specification.
 - iii) RDSO Drg. No. TM / 0520 REV- 2 - Spacer ring for vibration shaft
- 3.0 Functional requirement:** Function of Spacer ring for vibration shaft is to maintain the distance over vibration shaft assembly. It is provided as a distance piece in bushes and bearing of vibration shaft. All surfaces meant for machining shall be finished as mentioned in the drawing no. TM/ 0520 REV- 2.
- 4.0 Dimension & Tolerance:** Dimensions and Tolerances of Spacer ring for vibration shaft shall be as mentioned in RDSO drawing no. TM/ 0520 REV-2.
- 5.0 Material:** The Spacer Ring for vibration shaft shall be made from Steel of Grade 817M40 (EN 24) conforming of BS: 970 Pt-II Specification of direct hardening alloy steel.
- 6.0 Manufacturing Process:** Spacer ring for vibration shaft shall be made by forging and machining process.
- 7.0 Heat Treatment:** Heat treatment of each component shall be done by flame hardening method to achieve hardening upto 32±2 HRC.
- 8.0 Marking:** Month and year of manufacture and manufacturer's code / identification shall be engraved / embossed on the non-functioning surface of Spacer ring for vibration shaft.

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9.0 Inspection and Acceptance Criteria:

- i) Each component 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 direct hardening alloy steel of grade 817M40 (EN 24) as mentioned in Para 5.0.
- iv) Manufacturer shall also produce a test result of chemical property/ analysis report of plate/raw material used for manufacturing of the component.
- v) Minimum one no or 2 % sample of the Spacer ring 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 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.

10.0 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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